

**METRIC**

**A-A-20143B**  
**January 5, 2012**  
**SUPERSEDING**  
**A-A-20143A**  
**January 5, 2000**

## COMMERCIAL ITEM DESCRIPTION

### TORTILLAS, TORTILLA CHIPS, TACO SHELLS, AND TOSTADA SHELLS

**The U.S. Department of Agriculture (USDA) has authorized the use of this Commercial Item Description (CID).**

**1. SCOPE.** This CID covers tortillas, tortilla chips, taco shells, and tostada shells, packed in commercially acceptable containers, suitable for use by Federal, State, local governments, and other interested parties.

#### **2. PURCHASER NOTES.**

##### **2.1 Purchasers *shall specify* the following:**

- Type(s), style(s) (types of raw materials), size(s), shape(s), enrichment type(s), product state(s), and cook state(s) desired (Sec. 3).
- When analytical requirements are different than specified (Sec. 6.1).
- When analytical requirements need to be verified (Sec. 6.3).
- Manufacturer's/distributor's certification (Sec. 9.3) or USDA certification (Sec. 9.4).

##### **2.2 Purchasers *may specify* the following:**

- Food Defense Section 9.1: Food Defense System Survey (FDSS) (Sec. 9.1.1), or Food Defense Addendum to Plant Systems Audit (PSA) (Sec. 9.1.2), or (Sec. 9.1.2 with 9.2.1).
- Manufacturer's quality assurance (Sec. 9.2 with 9.2.1) or (Sec. 9.2 with 9.2.2).
- Packaging requirements other than specified (Sec. 10).

**3. CLASSIFICATION.** The tortillas, tortilla chips, taco shells, and tostada shells shall conform to the types, styles (types of raw materials), sizes, shapes, enrichment types, product states, and cook states in the following list which shall be specified, in the solicitation, contract, or purchase order.

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**Types, styles, sizes, shapes, enrichments, product states, and cook states.**

- Type I** - Tortillas
- Type II** - Tortilla chips
- Type III** - Taco shells
- Type IV** - Tostada shells

- Style A** - Corn
- Style B** - Wheat
- Style C** - Wheat with spices and/or herbs (as specified by purchaser)
- Style D** - Wheat with raisin puree 1/
- Style E** - Other

1/ Tortillas only

- Size 1** - 5.1 cm (2 in) diameter 2/
- Size 2** - 7.6 cm (3 in) diameter 2/
- Size 3** - 11.4 cm (4-1/2 in) diameter 2/
- Size 4** - 12.7 to 15.2 cm (5 to 6 in) diameter 3/
- Size 5** - 14 cm x 8.9 cm (5-1/2 x 3-1/2 in) 2/
- Size 6** - 15.9 cm (6-1/2 in) diameter 2/
- Size 7** - 17.8 to 20.3 cm (7 to 8 in) diameter 3/
- Size 8** - 19.1 cm (7-1/2 in) diameter 2/
- Size 9** - 25.4 cm (10 in) diameter 3/
- Size 10** - 30.5 cm (12 in) diameter 3/
- Size 11** - Other

2/ Tostada shells

3/ Tortillas only

- Shape a** - Round 4/ 6/
- Shape b** - U-shaped 5/
- Shape c** - Triangular 6/
- Shape d** - Bowl/boat 4/ 7/
- Shape e** - Oval 4/ 7/
- Shape f** - Rectangle 4/ 7/
- Shape g** - Strips 6/
- Shape h** - Other

4/ Tortillas

5/ Taco Shells

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6/ Tortilla Chips

7/ Tostada Shells

**Enrichment type (i)** - Enriched 8/

**Enrichment type (ii)** - Unenriched 8/

8/ Wheat flour tortillas and tostada shells only.

**Product state (a)** - Shelf stable

**Product state (b)** - Extended shelf life 9/

**Product state (c)** - Refrigerated

**Product state (d)** - Frozen

9/ Style D tortillas only.

**Cook state (I)** - Table-ready 10/

**Cook state (II)** - Partially cooked 10/

10/ Tortillas only.

**4. MANUFACTURER'S/DISTRIBUTOR'S NOTES. Manufacturer's/distributor's products *shall meet* the requirements of the:**

- Salient characteristics (Sec 5).
- Analytical requirements: *as specified by the purchaser* (Sec. 6).
- Manufacturer's/distributor's assurance (Sec. 7).
- Regulatory requirements (Sec. 8).
- Quality assurance provisions: *as specified by the purchaser* (Sec. 9).

**5. SALIENT CHARACTERISTICS.**

**5.1 Processing:** The tortillas, tortilla chips, taco shells, and tostada shells shall be prepared in accordance with current good manufacturing practices (21 Code of Federal Regulations (CFR) Part 110).

**5.2 Food Security.** The tortillas, tortilla chips, taco shells, and tostada shells should be processed and transported in accordance to the Food and Drug Administration's (FDA's) *Guidance for Industry: Food Producers, Processors, and Transporters: Food Security Preventive Measures Guidance.*

<http://www.fda.gov/Food/GuidanceComplianceRegulatoryInformation/GuidanceDocuments/FoodDefenseandEmergencyResponse/ucm083075.htm>. This guidance identifies the kinds of

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preventive measures food manufacturers, processors, or handlers may take to minimize the risk that food under their control will be subject to tampering or other malicious, criminal, or terrorist actions. The implementation of enhanced food security preventive measures provides for the security of a plant's production processes and includes the storage and transportation of pre-production raw materials, other ingredients and postproduction finished product.

**5.3 Ingredients.** The Style A (corn) tortillas, tortilla chips, taco shells, and tostada shells shall consist of ground corn which has been treated with lime, water, or corn masa flour and/or preservatives. The Style A (corn) tortillas, tortilla chips, taco shells, and tostada shells may contain optional ingredients. The Style B and C (wheat flour) tortillas and tostada shells shall contain wheat flour, water, leavening agents, salt, preservatives, and dough conditioners. The Style B and C (wheat flour) tortillas and tostada shells may contain optional ingredients. The Style D (wheat flour) tortillas shall contain wheat flour, water, oil, raisin puree, salt, and leavening agents and shall not contain preservatives, dough conditioners, and aluminum. Styles A, B, C, and E shall contain mold inhibitors in appropriate amount as allowed by the Federal Food, Drug, and Cosmetic Act and regulations promulgated thereunder.

**5.4 Finished product.** Unless otherwise specified in the solicitation, contract, or purchase order, the tortillas shall be baked or fried in non-animal fat cooking oils or FDA approved fat replacers. The tortilla chips shall be baked or fried, and the taco shells and tostada shells shall be deep fried in non-animal fat cooking oil or FDA approved fat replacers.

**5.4.1 Appearance and color.** When prepared in accordance with label directions for use, the tortillas, tortilla chips, taco shells, and tostada shells shall have the appearance and color typical of the products. There shall be no foreign color to the products. The delivered tortillas, tortilla chips, taco shells, and tostada shells shall not be crushed or damaged. There shall not be an excessive amount of breakage (more than 20 percent).

**5.4.2 Odor and flavor.** The tortillas, tortilla chips, taco shells, and tostada shells when prepared in accordance with label directions for use shall have a characteristic odor and flavor typical of the appropriate product. There shall be no foreign odors or flavors such as, but not limited to, oxidized, stale, rancid, burnt, tallowy, or other objectionable odors or flavors.

**5.4.3 Texture.** The tortillas, tortilla chips, taco shells, and tostada shells shall have a characteristic texture of the type specified in the solicitation, contract, or purchase order.

**5.4.4 Partially cooked tortillas.** The partially cooked corn and wheat tortillas shall be table-ready after no more than 15 minutes additional cooking.

**5.4.5 Enrichment.** When enriched, the wheat flour tortillas shall have the enrichment ingredients evenly distributed in the finished product.

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**5.4.6 Foreign material.** All ingredients shall be clean, sound, wholesome, and free from evidence of rodent or insect infestation.

**5.5 Shelf life.** Unless otherwise specified in the solicitation, contract, or purchase order, the tortillas, tortilla chips, taco shells, and tostada shells shall meet the following requirements:

**5.5.1 Shelf stable.** The Styles A, B, C, and E tortillas, tortilla chips, taco shells, and tostada shells shall have at least one-third of the manufacturer's stated "best by date" or "sell by date" remaining when accepted by the purchaser.

**5.5.2 Extended shelf life.** The Style D tortillas shall have a five year shelf life, from date of manufacture, when stored at 26.7°C (80°F).

**5.5.3 Refrigerated.** The fresh tortillas, taco shells, and tostada shells shall be in the cooler within six hours after baking and refrigerated to a maximum of 7.2°C (45°F). Unless otherwise specified in the solicitation, contract, or purchase order, the tortillas, taco shells, and tostada shells shall have at least one-third of the shelf life left when accepted by the purchaser and shall not have exceeded 7.2°C (45°F) at any time during storage and delivery.

**5.5.4 Frozen.** The fresh tortillas, tortilla chips, taco shells, and tostada shells shall be in the freezer within 6 hours after baking and frozen to a maximum of -17.8°C (0°F). The age (from time of packaging) of the frozen tortillas, tortilla chips, taco shells, and tostada shells shall not exceed 90 days at time of delivery or exceed -12.2°C (10°F) during storage and delivery at destination. The tortillas, tortilla chips, taco shells, and tostada shells shall show no evidence of freezer burn, discoloration, and thawing or refreezing.

## **6. ANALYTICAL REQUIREMENTS.**

**6.1 Analytical requirements.** Unless otherwise specified in the solicitation, contract, or purchase order, analytical requirements for the tortillas, tortilla chips, taco shells, and tostada shells shall meet the following:

**6.1.1 Moisture content.** The moisture content of the tortillas, tortilla chips, taco shells, and tostada shells shall not exceed:

Corn tortillas	50.0 percent
Wheat tortillas	50.0 percent
Tortilla chips	7.0 percent
Taco shells	7.0 percent
Tostada shells	7.0 percent

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**6.1.2 Water activity ( $a_w$ ).** When  $a_w$  requirements are specified in the solicitation, contract, or purchase order for Style D tortillas, the  $a_w$  shall not be greater than 0.85 when measured at 25°C (77°F).

**6.2 Product verification.** When USDA verification of analytical requirements is specified in the solicitation, contract, or purchase order, analytical testing shall be performed on a composite sample. The composite sample shall be 0.45 kg (1 lb) and be prepared from subsamples drawn from randomly selected containers. Subsamples shall be a minimum of one bag/box and shall contain the appropriate numbers of bags/boxes to yield a 0.45 kg (1 lb) sample when composited.

**6.3 Analytical testing.** When specified in the solicitation, contract, or purchase order, analyses shall be made in accordance with the following Official Methods of Analysis of the AOAC International:

<u>Test</u>	<u>Method</u>
Sample preparation	925.09
Moisture	925.09
$a_w$	978.18

**6.4 Test results.** The test results for moisture content shall be reported to the nearest 0.1 percent. The test result for  $a_w$  shall be reported to the nearest 0.01. Any result not conforming to the analytical requirements shall be cause for rejection of the lot.

**7. MANUFACTURER'S/DISTRIBUTOR'S PRODUCT ASSURANCE.** The manufacturer/distributor shall certify that the prepared tortillas, tortilla chips, taco shells, and tostada shells provided shall meet the salient characteristics of this CID, conform to their own specifications, standards, and quality assurance practices, and be the same prepared tortillas, tortilla chips, taco shells, and tostada shells offered for sale in the commercial market. The purchaser reserves the right to require proof of conformance.

**8. REGULATORY REQUIREMENTS.** The delivered tortillas, tortilla chips, taco shells, and tostada shells shall comply with all applicable Federal, State, and local mandatory requirements and regulations relating to the preparation, packaging, labeling, storage, distribution, and sale of the tortillas, tortilla chips, taco shells, and tostada shells within the commercial marketplace. Delivered tortillas, tortilla chips, taco shells, and tostada shells shall comply with all applicable provisions of the Federal Food, Drug, and Cosmetic Act; the Fair Packaging and Labeling Act; and regulations promulgated thereunder. The tortillas, tortilla chips, taco shells, and tostada

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shells shall comply with the allergen labeling requirements of the Federal Food, Drug, and Cosmetic Act.

**9. QUALITY ASSURANCE PROVISIONS.** *Purchaser shall specify 9.3 or 9.4; purchaser may specify 9.1 with 9.1.1, or 9.1 with 9.1.2, or 9.2 with 9.2.1, or 9.2 with 9.2.2.*

**9.1 Food Defense.** When required in the solicitation, contract, or purchase order, a Food Defense System Survey (FDSS) shall be conducted by USDA, AMS, Processed Products Division (PPD). Food Defense requirements include a documented and operational food defense plan that provides for the security of a plant's production processes and includes the storage and transportation of pre-production raw materials and other ingredients and postproduction finished product. The plan shall address the following areas: (1) food security plan management; (2) outside and inside security of the production and storage facilities; (3) slaughter, when applicable, and processing, including all raw material sources; (4) shipping and receiving; (5) storage; (6) water and ice supply; (7) mail handling; (8) personnel security; and (9) transportation, shipping, and receiving.

**9.1.1 FDSS.** When required in the solicitation, contract, or purchase order, a FDSS shall be conducted by USDA, AMS, PPD. The FDSS verifies that operators of food establishments have implemented measures to minimize the risk of tampering or other criminal actions against the food under their control. *(An AMS, FDSS verifies the participating company's adherence to the FDA's "Guidance for Industry - Food Producers, Processors, and Transporters: Food Security Preventive Measures Guidance.") For further information, see section 12.1.2 and 12.2.2.*

**9.1.2 Food Defense Addendum to Plant Systems Audit (PSA).** When required in the solicitation, contract, or purchase order, a Food Defense addendum shall be conducted by USDA, AMS, PPD auditors. This verifies that operators of food establishments have implemented measures to minimize the risk of tampering or other criminal actions against the food under their control. *(An AMS, FDSS verifies the participating company's adherence to the FDA's "Guidance for Industry - Food Producers, Processors, and Transporters: Food Security Preventive Measures Guidance.") For further information, see section 12.1.2 and 12.2.2.*

**9.2 Manufacturer's quality assurance.** When required in the solicitation, contract, or purchase order, the product manufacturer shall be required to provide evidence, by certificate, that the manufacturing plant has undertaken one of the following quality assurance measures within 12 months prior to providing a bid, or no later than 10 business days from the date of awarding of the contract. Failure to provide this documentation within the proper time frame may result in the contract being terminated for cause.

**9.2.1 Plant systems audit.** A plant systems audit (PSA) conducted by USDA, Federal Grain Inspection Service (FGIS), or other audit performed by a third party auditing service is required

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within 12 months prior to the date of the awarding of the contract. *(An USDA, FGIS PSA verifies the manufacturer's capability to produce products in a clean sanitary environment in accordance with 21 CFR Part 110 - Current Good Manufacturing Practice in Manufacturing, Packing, or Holding Human Food; and verifies that the manufacturer has in place an internal quality assurance program.)* (Perform with Food Defense addendum when required.)

**9.2.2 Plant survey.** A plant survey conducted by USDA, FGIS, or other survey performed by a third party auditing service is required within 12 months prior to the date of the awarding of the contract. *(An USDA, FGIS plant survey audit verifies that at the time of the survey, the manufacturer produces products in a clean sanitary environment in accordance with 21 CFR Part 110 - Current Good Manufacturing Practice in Manufacturing, Packing, or Holding Human Food.)*

**9.3 Manufacturer's/distributor's certification.** When required in the solicitation, contract, or purchase order, the manufacturer/distributor will certify that the finished tortillas, tortilla chips, taco shells, and tostada shells distributed meets or exceeds the requirements of this CID.

**9.4 USDA certification.** When required in the solicitation, contract, or purchase order that product quality and acceptability or both be determined, the USDA, FGIS, shall be the certifying program. FGIS inspectors shall certify the quality and acceptability of the tortillas, tortilla chips, taco shells, and tostada shells in accordance with FGIS procedures which include selecting random samples of the packaged tortillas, tortilla chips, taco shells, and tostada shells, evaluating the samples for conformance with the salient characteristics of this CID and other contractual requirements, and documenting the findings on official FGIS score sheets and/or certificates. In addition, when required in the solicitation, contract, or purchase order, FGIS inspectors will examine the tortillas, tortilla chips, taco shells, and tostada shells for conformance to the United States Standards for Condition of Food Containers in effect on the date of the solicitation.

**10. PACKAGING.** Preservation, packaging, packing, labeling, and case marking shall be commercial unless otherwise specified in the solicitation, contract, or purchase order.

**11. USDA INSPECTION NOTES. When Section 9.4 is specified in the solicitation, contract, or purchase order, USDA inspection personnel shall check for the following:**

- Salient characteristics (Sec. 5).
- Analytical requirements when specified in the solicitation, contract, or purchase order (Sec. 6.1). When USDA analytical testing is specified, FGIS inspection personnel shall select samples and submit them to the USDA, FGIS laboratory for analysis.
- Packaging requirements (Sec. 10 or as specified in the solicitation, contract, or purchase order).

**12. REFERENCE NOTES.**



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## 12.1 USDA certification contacts.

**12.1.1 Federal Grain Inspection Service.** For USDA, FGIS certification, contact the **Policies, Procedures, and Market Analysis Branch, Field Management Division, Grain Inspection, Packers and Stockyards Administration (GIPSA), STOP 3630, 1400 Independence Avenue, SW, Washington, DC 20250-3630, telephone (202) 720-0277, Fax (202) 720-1015, or via E-mail: [Andrew.S.Greenfield@usda.gov](mailto:Andrew.S.Greenfield@usda.gov).**

**12.1.2 Agricultural Marketing Service.** For USDA, AMS FDSS, PSA, or Plant Survey, contact the **Head, Inspection and Standardization Branch, PPD, Fruit and Vegetable Programs (FV), AMS, USDA, STOP 0247, 1400 Independence Avenue, SW, Washington, DC 20250-0247, telephone (202) 720-4693, Fax (202) 690-1527, or via E-mail: [albert.hoover@ams.usda.gov](mailto:albert.hoover@ams.usda.gov) or [chere.shorter@ams.usda.gov](mailto:chere.shorter@ams.usda.gov).**

**12.2 Analytical and physical testing and technical information.** For USDA, FGIS technical information on analytical testing, contact the **GIPSA, FGIS, National Grain Center, Technology and Science Division, Biotechnology and Analytical Services Branch, 10383 North Ambassador Drive, Kansas City, MO 64153-1377, telephone (816) 891-0444, or via E-mail: [Lynn.A.Polston@usda.gov](mailto:Lynn.A.Polston@usda.gov).** For USDA, FGIS technical information contact: **Policies, Procedures, and Market Analysis Branch, FGIS, GIPSA, USDA, STOP 3630, Washington, DC 20250-3632, telephone (202) 720-0277, Fax (202) 720-1015.**

## 12.3 Sources of documents.

### 12.3.1 Source of information for nongovernmental document is as follows:

Copies of the Official Methods of Analysis of the AOAC International may be obtained from: **AOAC International, 481 North Frederick Avenue, Suite 500, Gaithersburg, MD 20877-2417, telephone (301) 924-7077, (800) 379-2622, or on the Internet at: <http://www.aoac.org>.**

### 12.3.2 Sources of information for governmental documents are as follows:

Applicable provisions of the Fair Packaging and Labeling Act are contained in 16 CFR Parts 500 to 503, and the Federal Food, Drug, and Cosmetic Act are contained in 21 CFR Parts 1 to 199. These documents may be purchased from: **Superintendent of Documents, New Orders, P.O. Box 979050, St. Louis, MO 63197-9000. Credit card (Visa, MasterCard, Discover/NOVUS, and American Express) purchases may be made by calling the Superintendent of Documents on (866) 512-1800, (202) 512-1800 or on the Internet at: <http://www.gpo.gov/fdsys/browse/collectionCfr.action?collectionCode=CFR>.**

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Copies of Guidance for Industry - Food Producers, Processors, and Transporters: Food Security Preventive Measures Guidance is available online from: **FDA, Center for Food Safety and Applied Nutrition (CFSAN) on the Internet at:**

**<http://www.fda.gov/Food/GuidanceComplianceRegulatoryInformation/GuidanceDocuments/FoodDefenseandEmergencyResponse/ucm083075.htm>**.

Copies of this CID, the United States Standards for Condition of Food Containers, and beneficial comments, recommendations, additions, deletions, clarifications, etc. and any data which may improve this CID are available from and/or provided to: **Director, PPD, FV, AMS, USDA, STOP 0247, 1400 Independence Avenue, SW, Washington, DC 20250-0247, telephone (202) 720-9939, Fax (202) 690-1527, via E-mail: [FQASstaff@ams.usda.gov](mailto:FQASstaff@ams.usda.gov) or on the Internet at: <http://www.ams.usda.gov/FQAS>.**

### **CIVIL AGENCY COORDINATING ACTIVITIES:**

DOJ - BOP  
HHS - NIH, IHS  
USDA - FV  
VA - OSS

### **PREPARING ACTIVITY:**

USDA - FV

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