

INCH-POUND }

A-A-20155B  
December 17, 2002  
SUPERSEDING  
A-A-20155A  
November 16, 1992

### COMMERCIAL ITEM DESCRIPTION TUNA, CANNED, AND POUCH

The U.S. Department of Agriculture has authorized the use of this Commercial Item Description in lieu of Federal Specification PP-T-771b.

This Commercial Item Description (CID) covers canned/pouch tuna, packed in commercially acceptable containers, suitable for use by the Federal Government.

#### Salient characteristics

The canned/pouch tuna shall conform to one or more of the following forms, colors, packing media, seasoning/flavors, and salt/sodium levels as specified in the solicitation, contract, or purchase order. Canned tuna (and pouch tuna as applicable) shall meet the requirements of 21 CFR Part 161.190. Forms listed below pertain to canned tuna only. Pouch tuna shall be labeled Light Tuna or White Tuna (as appropriate), and no form (e.g., chunk) may be listed.

#### Forms (Canned Only)

Form I - Chunk  
Form II - Solid

#### Colors

Color A - Light  
Color B - White (Albacore)

**Beneficial comments, recommendations, additions, deletions, clarifications, etc. and any data which may improve this document should be sent to: Technical Services Branch, Seafood Inspection Program, NOAA - Fisheries, U.S. Department of Commerce, Room 10874, 1315 East-West Hwy, SSMC3, Silver Spring, MD 20910.**

FSC 8905/8940

DISTRIBUTION STATEMENT A. Approved for public release; distribution is unlimited.

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**Packing media.**

Packing media 1 – Water

Packing media 2 – Vegetable oil (except olive oil)

Packing media 3 – Olive oil

**Seasonings/Flavorings.** If used, shall be in accordance with 21 CFR Part 161.190 (a)(6), Standard of Identity for Canned Tuna.

**Salt/Sodium levels.**

Level a – Regular (no more than 1.5 percent salt)

Level b – No salt added (no sodium chloride added during processing)

Level c – Very low sodium (35 milligrams or less sodium per serving)

**Processing.**

Tuna shall be the only fish used and shall be in good condition; i.e., exposed surfaces shall be of a color and bloom typical of tuna which has been properly stored and handled. Cut surfaces and naturally exposed surfaces shall show no more than slight darkening or discoloration due to dehydration, aging, and/or microbial activity. No odors foreign to fresh tuna shall be present. Changes in color and odors characteristically associated with frozen tuna in excellent condition shall be acceptable. Frozen tuna shall show no evidence of having been defrosted and refrozen or other evidence of mishandling.

For Canned product only: Failure to meet pressed cake weight specified in the contract shall be basis for rejection of the entire lot.

**Analytical requirements.**

Chemical analyses shall be made in accordance with the Official Methods of Analysis of the AOAC INTERNATIONAL

<u>Test</u>	<u>Chapter, Number and Title</u>	<u>Official Method Numbers and Methods</u>
Salt	35, Fish and Other Marine Products	937.09 Salt (Chlorine as Sodium Chloride) in Seafood 976.18 Salt (Chlorine as Sodium Chloride) in Seafood 976.19 Salt (Chlorine as Sodium Chloride) in Seafood

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Sodium 35, Fish and Other Marine Products 969.23 Sodium and Potassium in Seafood  
 Histamine 35, Fish and Other Marine Products 977.13 Histamine in Seafood

Histamine Testing will be performed at the frequency to provide the same assurance as the methods recommended by the USFDA HACCP Guide.

#### Contractor's certification.

By submitting an offer, the contractor certifies that the product offered meets the specified salient characteristics and requirements of this CID; conforms to the producer's own specifications and standards, including product characteristics, manufacturing procedures, quality control procedures, and storage and handling practices; has a national or regional distribution from storage facilities located within the United States, its territories, or possessions; and is sold on the commercial market. The Government reserves the right to determine proof of such conformance prior to the first delivery from point of origin and any time thereafter, up to and including delivery at final destination, as may be necessary to determine conformance with the provisions of the contract.

#### Regulatory requirements.

The delivered product shall comply with all applicable Federal and State mandatory requirements and regulations relating to the preparation, processing, packaging, labeling, storage, distribution, and sales of the product in the commercial marketplace. All deliveries shall conform in every respect to the applicable provisions of the Federal Food, Drug, and Cosmetic Act and regulations promulgated thereunder. All products shall also meet with the provisions of Regulations found in CFR 50, Subchapter G -- Processed Fishery Products, Processed Products Thereof, and Certain Other Processed Food Products, Part 260, Inspection and Certification.

#### Quality assurance

Compliance with this CID shall be determined by the U.S. Department of Commerce, Seafood Inspection Program (USDC). USDC will determine the degree of inspection and supervision necessary to assure specification compliance. The cost of all services performed by USDC agents involving examination, supervision, official documentation, and related service shall be borne by the contractor.

The canned and pouch tuna shall be inspected by the USDC under Type I continuous inspection or lot inspection and in accordance with this CID and contract requirements.

External examination for condition of containers will be conducted using the U.S. Standards for Condition of Food Containers (7 CFR Part 42) and Performance Specification Packaging of Food in Flexible Pouches, MIL-PRF-44073F. All tests required under paragraph 4.1.1, Table I "of the latter document" be certified by a Certificate of Compliance from the vendor.

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For paragraph 4.2, Examination of pouches, use Table II and Table III and all footnotes. Inspection level II, Major A Defects AQL 1.00, Major B Defects AQL 2.5, Minor Defects 4.00.

Paragraph 4.3.8, Commercial Sterility test will be certified by a Certificate of Compliance.

Internal examination for condition of containers shall be in accordance with USDC policies and procedures. Assurance of can and pouch requirements may be based on the acceptance of a certificate of conformance.

Sampling for inspection and determination of acceptability shall be done in accordance with provisions set forth in American National Standard, ANSI/ASQC Z 1.4-1993.

Defects found during inspection shall be classified in accordance with Tables II through V at the inspection levels acceptable quality levels (AQL's) as shown below. AQL's shall be expressed in defects per hundred units. The lot size shall be expressed in cans or pouches.

**TABLE I. Inspection levels and acceptance numbers**

Table	Inspection level <sup>1/</sup>	AQL	
		Major	Minor
II	S3	—	4.0
III	S3	—	10.0
IV	S3	1.0	10.0
V	S2	1.5	6.5

<sup>1/</sup> Sample shipping containers shall be selected randomly on a proportionate basis from not less than 90 percent of the codes listed in a lot. In the event that the referenced levels result in a sample size that is too small to provide for sampling 90 percent of the codes in a lot, a level sufficiently large to accommodate this requirement shall be selected. Not more than one primary container per shipping container shall be examined for the defects within the tables listed in Table I.

The sample unit for USDC Inspection is the contents of one can or pouch. For sampling purposes, the maximum lot size will be the quantity of product produced on a single line during an eight hour production shift. The lot size may be reduced by the USDC inspector if necessary. If a plant operates two or more lines under inspection simultaneously, the products from each line will be inspected as separate lots. Also, if a plant wishes to extend the processing day beyond a normal eight hour shift, the product produced after the end of the eight hour shift will be inspected as a new lot. For labeling and identification purposes, production lots shall be numbered in sequence. For purposes of lot identification, in addition to the requirements contained in 21 CFR part 113, a code change will be necessary when a shift concludes or a new shift begins.

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If a plant operates more than one line under inspection, it may be necessary to assign an inspector to each line. This is to enable the inspector to have sufficient time to perform a sanitation inspection, examination for product characteristics, condition of container examination, etc. and still have sufficient time to observe the materials being processed to ensure their suitability for processing.

The contractor shall obtain a USDC Certificate of Inspection which state(s) the product meets all requirements of this CID.

**TABLE II Examination for net weights 1/ 2/ 3/**

Category	Defect
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Minor

201	A 7-ounce or less can or pouch – more than ¼ ounce under specified net weight. Over 7-ounce to 13-ounce can or pouch – more than ½ ounce under specified weight. A 43-ounce pouch– more than 1 ounce under specified net weight. A 66.5 ounce can – more than 1 ounce under specified net weight.
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1/ Failure of lot average net weight to meet specified net weight shall be basis for rejection of entire lot.

2/ Report results to the nearest 0.1 ounce.

3/ Net weight for pouch product will be determined as follows:

    Weigh sealed pouch.

    Empty contents into tray, make sure all tuna is removed.

    Clean and dry the pouch.

    Weigh the empty pouch

    Deduct the weight of the empty pouch from the weight of the sealed pouch, and record as net weight.

**TABLE III Examination for vacuum requirements (not required for pouch)**

Category	Defect
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Minor

201	Vacuum less than 1 inch 1/
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1/ Military agencies which have special operational requirements which require higher vacuum should specify this in the contract.

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TABLE IV. Product defects

Category		Defect																									
<u>Critical</u>	<u>Major</u>		<u>Minor</u>																								
1		Flesh showing evidence of true honeycombing or the presence of flavors and/or odors of decomposition such as, but not limited to, sour and rancid, or other flavors and odors of decomposition. <u>1/</u>																									
	101	Presence of objectional flavors or odors such as, but not limited to, burnt, scorched, overcooked, stale, or other objectionable flavors or odors. <u>2/</u>																									
	102	Presence of objectionable foreign materials such as, but not limited to, rust, wood, hair, dirt, or insects or insect parts either singly or in combination. <u>3/</u>																									
	103	Form, color, or packing media, not as specified in contract																									
	201	Presence of any prominent bruise(s), blood clot(s), or piece(s) of gills or viscera pieces over ¼ inch in any dimension. <u>4/</u>																									
	202	Presence of number of undesirable fish parts of an objectionable size exceeding those shown below: <u>5/</u>																									
		<table border="1"> <thead> <tr> <th><u>Net Weight</u></th> <th><u>Skin</u></th> <th><u>Scales</u></th> <th><u>Vascular Tissue</u></th> <th><u>Bone</u></th> </tr> </thead> <tbody> <tr> <td>7 ounces or less</td> <td>2</td> <td>2</td> <td>1</td> <td>1</td> </tr> <tr> <td>over 7 ounces to 13 ounces</td> <td>2</td> <td>4</td> <td>2</td> <td>2</td> </tr> <tr> <td>43 ounces</td> <td>3</td> <td>6</td> <td>3</td> <td>3</td> </tr> <tr> <td>66.5 ounces</td> <td>4</td> <td>8</td> <td>4</td> <td>4</td> </tr> </tbody> </table>	<u>Net Weight</u>	<u>Skin</u>	<u>Scales</u>	<u>Vascular Tissue</u>	<u>Bone</u>	7 ounces or less	2	2	1	1	over 7 ounces to 13 ounces	2	4	2	2	43 ounces	3	6	3	3	66.5 ounces	4	8	4	4
<u>Net Weight</u>	<u>Skin</u>	<u>Scales</u>	<u>Vascular Tissue</u>	<u>Bone</u>																							
7 ounces or less	2	2	1	1																							
over 7 ounces to 13 ounces	2	4	2	2																							
43 ounces	3	6	3	3																							
66.5 ounces	4	8	4	4																							

1/ These are regarded as critical defects and their finding will be basis for rejection of the entire lot

2/ Do not include flavors and odors of decomposition.

3/ Presence of chemicals, glass, or metal particles, animal excreta, or similar extraneous material which could harmfully affect or contaminate the product (critical defects) shall be basis for rejection of the entire lot.

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- 4/ Small blood spots, streaks, and bruises, characteristic of purse-seine caught tuna, are not considered defects.
- 5/ To classify as objectionable, fish parts must meet the following criteria: skin – piece over ½ inch in any dimension; scales – over ¼ inch in any two dimensions; vascular tissue – includes streaks and dark meat over ½ inch in any dimension; bone – any bone or cartilage which is not soft or does not become powdery under firm pressure of a hard object or which is over ½ inch in any dimension.

**TABLE V. Can interior enamel coating defects (cans only)**

Category		Defect
<u>Major</u>	<u>Minor</u>	
101		Missing
102		Blistered or softened areas which can be peeled by fingertip (not fingernail abrasion)
103		Internal rust stains
	201	Bare areas (other than scratches)
	202	Dirty, stained or smeared with foreign material

**Testing for salt content or sodium content.**

The composite for testing for salt content or sodium content shall be a composite of 24 ounces of product. The minimum number of sample units to use for deriving the composite for salt or sodium content is twelve sample units. The sample units shall represent all the codes selected for product evaluation. Equal amounts of product will be taken from each selected sample unit and from each code. If the sample size is too small to provide for sampling all codes, more sample units may be selected with less product taken from each can or pouch.

At least two tests from a composite sample shall be performed and the results averaged. Results of testing shall be reported to the nearest 0.1 percent.

Failure to meet salt/sodium levels specified in the contract of CID shall be basis for rejection of the entire lot.

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**Preservation, packaging, packing, labeling, and marking.**

The canned and pouch tuna shall be preserved, packaged, packed, labeled, and case marked in accordance with good commercial practice. Production codes shall appear on the outside of the master case. Commercial labeling and packaging, as may be augmented by the solicitation, contract, or purchase order, shall be acceptable. Shipping containers shall comply with the National Motor Freight Classification or Uniform Freight Classification, as applicable.

**For Department of Defense procurements (Only).****TABLE VI Packaging and packing requirements for can only**

Form	Color	Packing Media	Salt/Sodium Level	Can size	Net weight (ounces)	No. per case
II	A	1	a	603 x 408	66.5	6
I or II	A or B	1	a	307 x 109-110	6.125	48
I or II	A or B	1	a	401 x 202-206	12.25 - 13.0	24

**Packaging and packing requirements for pouch only**

Form	Color	Packing Media	Salt/Sodium Level	Net weight (ounces)	No. per case
N/A	A or B	1	a	43	6

The following requirements are applicable when specified by contracting officer.

A. Commercial packaging. The product shall be packaged in a metal can/pouch in accordance with Table VI and good commercial practice.

B. Commercial packing. The number of cans/pouches specified in Table VI shall be packed in fiberboard boxes complying with Uniform Freight Classification or National Motor Freight Classification.



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C. **Export packaging (cans only)** The product shall be packaged in a metal can in accordance with Table VI and with the following requirements: Timplated cans shall be made from not less than 0.20 pound per base box electrolytic timplate. The can shall be an open-top style, round, metal can with a welded side seam and compound-lined, double seamed ends. The entire inside area of the can shall be enameled. Can ends may be fabricated from ECCS plate, enameled inside and out. Two-piece cans are acceptable. Easy-open features are not acceptable.

D. **Export packing** The number of cans specified in Table VI shall be packed in a snug-fitting fiberboard box constructed, closed, and reinforced in accordance with Style RSC, Grade V3c, V3s, or V4s of ASTM-D-1975, and ASTM-D-5118. Tiered cans shall be separated with a full length and width fiberboard pad made of the same material as the box. Reinforcement shall be restricted to nonmetallic strapping or pressure-sensitive adhesive, filament-reinforced tape in accordance with the appendix of ASTM-D-1975, & ASTM-D-5118.

E. **Unit loads (commercial and export)**. Shipping containers shall be arranged in unit loads in accordance with DSCP Form 3507. When unit loads are strapped, the strapping shall be limited to nonmetallic strapping, except for Type II, Class F loads.

F. **Labeling (commercial and export)**. Commercial labeling shall be acceptable.

G. **Marking (commercial and export)**. Marking of shipping containers and unit loads shall be in accordance with DSCP Form 3556.

Notes.

Purchasers should specify:

- Form (for can only)
- Color
- Packing media
- Salt/Sodium level
- Net weight
- Pressed weight
- Can /pouch and case size
- Labeling, packaging, and casing requirements if different from commercial practice.

Source of documents:

Sources of information for nongovernmental documents are as follows:

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Copies of the National Motor Freight Classification may be obtained from:

National Motor Freight Traffic Association, Inc., Agent  
National Motor Freight Classification  
American Trucking Associations, Inc., Traffic Department  
2200 Mill Road, Alexandria, VA 22314

Copies of the Uniform Freight Classification may be obtained from:

Uniform Classification Committee, Agent  
Uniform Freight Classification  
Uniform Classification Committee, Suite 1120  
222 South Riverside Plaza  
Chicago, IL 60606

Copies of the Official Methods of Analysis of the AOAC International may be obtained from:

AOAC International, Suite 500  
481 N. Frederick Ave.  
Gaithersburg, MD 20877-2417

Copies of the American Society for Testing & Materials may be obtained from:

ASTM International  
100 Barr Harbor Drive  
P.O. Box C700  
West Conshohocken, PA 19428-2959  
(610) 832-9585 or [www.astm.org](http://www.astm.org).

Sources of information for governmental documents are as follows:

Applicable provisions of the Federal Food, Drug, and Cosmetic are contained in 21 CFR parts 1-199. This three-volume set may be purchased from:

Superintendent of Documents  
U.S. Government Printing Office  
Washington, DC 20402-0001

Credit card (Master Charge or Visa) purchases may be made by calling the Superintendent of Documents on (202) 783-3238.

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**Copies of the United States Standards for Condition of Food Containers are available from:**

**Chairperson  
Condition of Container Committee  
Agricultural Marketing Service  
U.S. Department of Agriculture  
Room 2506, South Building  
P.O. Box 96456  
Washington, DC 20090-6456**

**Copies of the Regulations Governing Processed Fishery Products are available from:**

**Seafood Inspection Program  
NOAA - Fisheries  
U.S. Department of Commerce  
Room 10874  
1315 East-West Highway SSMC 3  
Silver Spring, MD 20910**

**Copies of DSCP Forms may be obtained from:**

**Commander,  
Defense Supply Center Philadelphia  
ATTN: DSCP-HXL  
700 Robbins Ave.  
Philadelphia, PA. 19111  
(215) 737-7772 or  
[www.dscp.dla.mil/subs/proserv/contref/dscpform.htm](http://www.dscp.dla.mil/subs/proserv/contref/dscpform.htm)**

**Civil agencies and other interested parties may obtain copies of this CID from:**

**General Service Administration  
Specifications Unit (3FB-WS)  
Room 6654  
7<sup>th</sup> and D Streets, SW  
Washington, DC 20407**

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Military activities should submit requests for copies of this CID to:

Standardization Documents Order Desk  
Building 4, Section D  
700 Robbins Ave.  
Philadelphia, PA 19111-5094

**MILITARY INTERESTS:**

Military Coordinating Activity:

Army – GL

**Custodians:**

Army – GL  
Navy – SA  
Air Force – 50

**Review Activities:**

Army – MD, TS  
Navy – MC  
DLA – SS

**CIVIL AGENCY COORDINATING ACTIVITIES:**

DOJ – BOP  
HHS – FDA, NIH  
USDA – FV  
VA – OSS

**PREPARING ACTIVITY:**

COM – NMF