

USDA COMMODITY REQUIREMENTS

DPP4 DEHYDRATED POTATO PRODUCTS FOR USE IN EXPORT PROGRAMS

Effective Date: **04/25/08**

USDA COMMODITY REQUIREMENTS
DPP4
DEHYDRATED POTATO PRODUCTS
FOR USE IN EXPORT PROGRAMS

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Part 1 COMMODITY SPECIFICATIONS

Section 1.1 DEHYDRATED POTATO PRODUCTS REQUIREMENTS

- A. Quality of Dehydrated Potato Products
 - (1) The dehydrated potato products shall meet the requirements as specified in the Commercial Item Description (CID) for potatoes, white, dehydrated, A-A-20032F, dated December 20, 2002, which is available at <http://151.121.3.151/fqa/aa20032f.pdf> . Applicable sections of the CID will be for Type II – Mashed (precooked, rapid rehydrating), Styles A, B, C, and E; and Type VI.
 - (2) The potato products delivered shall have been packed during the latest season's pack or crop year.
 - (3) The solicitation shall specify the type, style and sizes of dehydrated potatoes.
- B. Fortification
Fortification of Vitamin A, iodine, or other micronutrient shall be when specified in the solicitation.

Section 1.2 QUALITY ASSURANCE

- A. Inspection shall be performed by an Agricultural Marketing Service (AMS) agent (hereinafter referred to as "USDA Grader"). Procedures to follow and a schedule of fees for this service may be obtained at <http://www.ams.usda.gov/fv/fvstand.htm>.
- B. Prior to sampling, the contractor shall furnish the USDA Grader with a list of codes and the approximate quantity per code. Inspection of products shall be performed not more than 90 days prior to shipment.
- C. Contractor shall provide scales suitable for random selection weighing.
- D. The quality, weight, and packaging of the product shall be evidenced by certificates issued by the USDA Grader.
- E. Contractor shall not ship the product unless informed by the USDA Grader that the containers and markings meet the Acceptable Quality Level (AQL) of the United States Standards for Condition of Food Containers.
- F. If the product fails to meet contract specifications on one or more factors on the first inspection, the Contractor may arrange with the USDA Grader for subsequent inspections. The inspections may be conducted at origin or a subsequent point of delivery if the provisions of Title 7 CFR 68.44 through 68.63 issued under the Agricultural Marketing Act of 1946, as amended, with respect to retest, appeal, and new inspections can be met. When subsequent inspections of

the product are made, the results of the last inspection will be used as the basis for payment under the contract.

- G. Contractors shall notify the Government immediately of lots that fail to meet contract requirements.

Section 1.3 QUALITY DISCOUNTS

Compliance with product specifications shall be based on samples tested by the USDA Grader. If a lot fails to meet these specifications with respect to sulfur dioxide and/or defects; but is acceptable under the following schedules, the contractor may tender such lot for delivery to the Government. The Government will then, at its option, accept the lot and the contract price shall be reduced in accordance with the following schedule:

Type of Deficiency	Test Results	Discounted Contract Price
Type II Mashed, Style A Granules (Average of specks on the surface of the product in 100 mm circle)	66 thru 70	\$0.01/lb.
	71 thru 80	\$0.02/lb.
	81 or more	Unacceptable
Type II Mashed, Flakes (Average discolorations and peel [Style B] per 100 grams. Defects are counted specs measuring over 1/16inch in any dimension.)	16 thru 20	\$0.01/lb.
	21 thru 25	\$0.02/lb.
	26 or greater	Unacceptable
Sulfur Dioxide	501 ppm or more	Fails/rejected
	100 – 199 ppm	\$0.01 per pound
	50 – 99 ppm	\$0.02 per pound
	0 – 49 ppm	Fails/rejected

Part 2 CONTAINER AND PACKAGING REQUIREMENTS

Section 2.1 GENERAL

This part provides the container specifications and packaging materials requirements used under this contract.

Section 2.2 CONTAINERS AND MATERIALS

- A. All containers and packaging shall be constructed to meet the requirements of the Food and Drug Administration (FDA) for safe contact with the packaged product. The contractor shall obtain and maintain documentation from the container or packaging material manufacturer to verify that the containers and packaging materials used in this contract were in compliance with the Government's regulatory requirements for safe contact with food products as required in the Master Solicitation, Part 3,

Section A, Number 3.

- B. Questions concerning the containers and materials should be directed to:**
USDA/FSA/DACO
Room 5755 – South Bldg, STOP 0551
1400 Independence Avenue SW
Washington, DC 20250-0551
ATTN: Packaging
- C. If the contractor purchases packaging and container ingredients from a foreign country and/or the package and container is manufactured in a foreign country, the package and container SHALL NOT display country of origin labeling. Phrases similar to but not inclusive of, “Made in [Name of Foreign Country.]” or “Product of [Name of Foreign Country.]” are strictly prohibited.**

Section 2.3 20-KILOGRAM MULTIWALL PAPER BAGS

- A. Twenty kilograms of product shall be packed in Pinch Bottom Open Mouth (PBOM) style multiwall paper bags. The use of recycled materials is not required if performance or food safety is jeopardized.**
- B. The bag shall have two inner walls of 60-pound nominal basis weight natural kraft paper and an outer third wall of 60-pound nominal basis weight wet strength paper in accordance with Uniform Freight Classification, Rule 40, Section 10, Tables A and B, as amended.**
- C. The bag shall have a inner plastic liner constructed of high density polyethylene (HDPE) film placed between the inner most ply of paper and the second ply of paper (number 2 position). The film liner shall:**
- (1) Be a minimum thickness of 0.5 mil. with a density of 0.914 to 0.929 g/cc. The film shall have a minimum impact resistance of 265g when tested in accordance with ASTM D-1709 Method A, as amended, Falling Dart.**
 - (2) The film liner shall be loose for the full length of the bag except around the bottom and top closure areas. At the top and bottom closure areas, the liner shall adhere to the inner-most paper ply (time lamination). The laminating adhesive shall be machine direction applied in narrow strips no longer than 4 inches from each end. The use of gravure lamination to bond the liner to the inner-most paper ply for the entire length of the bag is prohibited.**
 - (3) Not exceed a maximum average water vapor permeability of 0.65 grams per 100 square inches in 24 hours at 90 percent relative humidity and a temperature of 100°F plus or minus 5 degrees.**

- (4) Be manufactured to meet Food and Drug Administration requirements for food products (21 CFR 177.1520, as amended).
- D. Longitudinal seams of the outer wall of the bag shall be glued so that there is no more than 3/16-inch of unglued edge on the outer surface of the bag. The adhesives used in the longitudinal seams and pasted end closures shall be water resistant. Water resistant adhesive of outer ply longitudinal seams or pasted end closures shall be tested for resistance to water in accordance with TAPPI T456 (Wet Tensile Test), except as follows:

Cut test specimens 1-inch wide so that the longitudinal seam or pasted end closure runs perpendicular to and is centered relative to the long dimension of the specimen. The test specimen shall encompass all adhesive bonded areas included in fabricating the seam or end closure. In the case of multi-ply end closures, clamp all plies in the jaws of the tester. Immerse the specimens in not less than 1-inch of the distilled water for 24 hours. Run a wet tensile test. A test specimen fails the test if failure occurs with the separation of the seam or closure and less than 25% of the separated adhesive area shows fiber tear. Failure of more than 10% of the specimens shall be reported as failure of the adhesive.

Section 2.4 OUTER CLOSURE AND SEALS

- A. The bottom and top of the 20-kilogram bag shall be closed to provide a tight seal using hot-melt or thermoplastic adhesive applied in a single band along the top edge of the long side of the bag and extending downward at least 3/4 inches. The fold line on the manufacturer closure end shall be 1-3/4 inches plus or minus 1/4-inch. The fold line on the field closure end shall be 1-5/8 inches plus or minus 1/4-inch. Refer to section 3.1.M. for bag closure guide location bars.
- D. The outer wall of the bag shall be stepped at the bottom and top fold over flap, beyond all inner walls, in order to provide a positive seal over the ends of the inner walls so that there is no more than 3/16 inches unbonded edge beyond the adhesive line. The inner polyethylene film may be heat-sealed.

Section 2.5 PERFORMANCE TEST PROCEDURES

- A. All bags shall be capable of withstanding the following performance test for impact resistance:
 - (1) Ten filled and sealed bags shall each survive a single drop test on the butt and side on a shock machine that produces for each test a velocity change of 195 inches per second using a shock duration of .002 seconds without loss of product.
 - (2) Testing shall be conducted under standard temperature (73.4°F plus or minus 1.8°F) and relative humidity (50% plus or minus 2%) conditions.

- (3) Filled bags shall be placed in the conditioned atmosphere for sufficient time before the tests are conducted for the bag materials to reach equilibrium.
- (4) Bags submitted under this performance specification shall conform to all other applicable material, construction, and performance specifications.

B. Test Laboratories

Independent or private laboratories known to be capable of conducting the shock machine test described above are as follows:

Michigan State University School of Packaging East Lansing, MI 48824-1223 (517) 355-9580 http://packaging.msu.edu/	Lansmont Corporation 1287 Reamwood Sunnyvale, CA 94089 (408) 734-9724 Lansmont Corporation 6539 Westland Way, Suite 24 Lansing, MI 48917 (888) 526-7666 www.lansmont.com
Rutgers University Packaging Science and Engineering Dept. P.O. Box 909 Piscataway, NJ 08854 (201) 932-3679	Ten-E Packaging Services, Inc. 1666 County Road 74 Newport, MN 55055 (651) 459-0671 www.ten-e.com

Section 2.6 SEAL PEEL TEST

- A. The contractor shall perform periodic seal peel tests on the filling end of multiwall paper bags to determine whether the paper plies are adequately adhered. The seal peel test shall be performed at every start up and a minimum of every hour during commodity packing operations. The seal peel test shall demonstrate tear of paper fiber (fiber tear) for all paper plies. The contractor shall maintain records of seal peel test results for review by the Government.
- B. The seal peel test shall be performed as follows:
 - (1) Run an empty bag through the sealing unit.
 - (2) Cut bag approximately 3 to 8 inches below the seal.
 - (3) Cut both gussets along the center crease to the top of the bag end.
 - (4) Spread bag to expose poly liner.
 - (5) Check inside plastic liner along the closure and gussets to determine

that the liner is heat-sealed. Pinholes, no larger than 1/8 inch in diameter, are allowable in the closure.

- (6) Grip inside fold at center of the bag end.
- (7) Pull apart sides of the bag end at the center, separating seals. (If the seal is good, fibers shall completely cover adhesive. If the seal is poor, glossy adhesive will show).

- C. The contractor's seal peel test records shall include the following information for each test: date, time, employee's name, product, contract number, railcar number, and result of the test. The result of the test shall be reported as either "good seal" or "poor seal", "insufficient fiber tear", as applicable. The contractor shall take corrective action if the seal peel test indicates a poor seal and shall retest until a good seal is achieved.

PART 3 MARKING REQUIREMENTS

Section 3.1 MARKINGS

- A. The bags shall be marked in the color specified in the markings exhibits. Any markings not shown on the exhibits shall be printed in blue. When printed on the bag, the colors blue and red shall match the Pantone Matching System (PMS) chart numbers 280 and 200, respectively, to the extent practicable.
- B. All dimensions are approximate. Unless otherwise specified, all characters shall be in normal block print.
- C. The US Flag shall be 5 inches high and 9 inches in total width, on the front and back of the applicable bag, see exhibits.
- D. The letters USA shall be Univers black (75) oblique, or Helvetica extra bold with 70% scaling and -70 tracking or equivalent to match the style as shown in the exhibits. The letters USA shall be 4 3/4 inches high and 9 3/4 inches in total width. The three stripes adjacent USA shall be 1 inch high and must extend to the edge of the panel.
- E. The USAID vertical identity, including the logo, brand name, and tagline, shall be printed in the same style as shown in the markings exhibits, sized approximately 7 1/2 inches high and 9 3/8 inches in total width. The USAID logo shall be 4 1/4 inches in diameter. The USAID brand name shall be 2 inches in height. The tagline "FROM THE AMERICAN PEOPLE" shall be 1/2 inches in height, see exhibits. The USAID vertical logo is available to download at <http://www.usaid.gov/branding/downloadsweb.html>.
- F. The USDA logo shall be 4 1/2 inches high and 6 1/2 inches in total width, see exhibits.
- G. The commodity name shall be 1 1/4 inch print. Immediately below the

commodity name on the front and back panels, insert additional commodity description in 5/8 inch print, if applicable.

- H. The contract number and the statement "NOT TO BE SOLD OR EXCHANGED" shall be 5/8 inch print. The net weight, bag dimensions, and the Standard Marking Requirements (SMR) or Language Marking Requirements (LMR) number shall be centered at the bottom of the bag in 1/2 inch print. See exhibits. The contractor shall obtain a waiver, in writing, from the Government to print the contract number using on-line printing on filled bags.
- I. The letters or symbols used in the language markings for LMR-1, LMR-3 and LMR-4, LMR-5, LMR-7, and LMR-8 should be sized approximately 1 5/8 inches. The language markings for LMR-2 and LMR-6 should be sized to fit. See exhibits.
- J. Lot numbers, production codes or any other means of identification required to meet the traceability requirement shall be printed as small as possible, yet legible.
- K. Gussets. The USAID identity shall be 2 ¾ inches in height and 8 ½ inches in total width and be printed in both gussets. The letters USAID shall be 1 ¾ inches high and the tagline 'FROM THE AMERICAN PEOPLE' shall be 3/8 inches high, as shown in applicable exhibits.
- L. Gussets. The letters USA shall be 3 inches in height and be printed in both gussets, as shown in applicable exhibits.
- M. Bag Closure Guide Location Bars (BCGL) shall be printed on the front panel of all multi-wall paper bags, as shown in the exhibits. The BCGL bars shall be plainly visible, approximately one inch in length, printed in blue in two parallel rows evenly spaced over the entire width of the bag. The BCGL bars are to be used as visual quality control verification. Visually identifying two bars or no bars on the bag would indicate a bag closure failure. Visually identifying one bar would indicate a proper bag closure. (Exhibits A & B)

Section 3.2 MARKING DESCRIPTIONS

The Government shall furnish required markings within two business days after the date of the contract. The procurement of containers should be deferred for at least two business days after the date of the contract.

The following standard marking requirements may be requested under the contract:

Standard Marking Requirement #1 (SMR-1)

USAID – Distribution

Front: US Flag, the commodity name, the words "NOT TO BE SOLD OR EXCHANGED," USAID logo, contract number, net weight, dimensions, "SMR-1". See exhibit SMR-1, front.

Back: Identical. See exhibit SMR-1, back.

Standard Marking Requirement #2 (SMR-2)

FAS - Distribution

Front: USA with stripes, the commodity name, the words "NOT TO BE SOLD OR EXCHANGED," USDA logo, contract number, net weight, dimensions, "SMR-2". See exhibit SMR-2, front.

Back: Identical. See exhibit SMR-2, back.

Standard Marking Requirement #3 (SMR-3)

USAID – Monetization

Front: US Flag, the commodity name, USAID logo, contract number, net weight, dimensions, "SMR-3". See exhibit SMR-3, front.

Back: Identical. See exhibit SMR-3, back.

Standard Marking Requirement #4 (SMR-4)

FAS or USAID - Monetization

Front: USA with stripes, the commodity name, contract number, net weight, dimensions, "SMR-4". See exhibit SMR-4, front.

Back: Identical. See exhibit SMR-4, back.

Language Marking Requirement #1 (LMR-1)

USAID – Distribution for North Korea

Front: US Flag, the commodity name, the words "NOT TO BE SOLD OR EXCHANGED," USAID logo, contract number, net weight, dimensions, and "LMR-1.". See exhibit LMR-1, front.

Back: US Flag, the commodity name, North Korean language panel, and "LMR-1" only. See exhibit LMR-1, back.

Language Marking Requirement #2 (LMR-2)

USAID – Distribution for Afghanistan, with Pashtu and Dari

Front: US Flag, the commodity name, the words "NOT TO BE SOLD OR EXCHANGED," USAID logo, contract number, net weight, dimensions, and "LMR-2." See exhibit LMR-2, front.

Back: US Flag, the commodity name, Pashtu and Dari language panel, and "LMR-2" only. See exhibit LMR-2, back.

Language Marking Requirement #3 (LMR-3)

USAID – Distribution for South Africa Region

Front: US Flag, the commodity name, the words "NOT TO BE SOLD OR EXCHANGED," USAID logo, contract number, net weight, dimensions, and "LMR-3." See exhibit LMR-3, front.

Back: US Flag, the commodity name, English language panel, and "LMR-3" only. See exhibit LMR-3, back.

Language Marking Requirement #4 (LMR-4)

USAID – Distribution for Iraq with Arabic

Front: US Flag, the commodity name, the words "NOT TO BE SOLD OR EXCHANGED," USAID logo, contract number, net weight, dimensions, and "LMR-4." See exhibit LMR-4, front.

Back: US Flag, the commodity name, Arabic language panel, and "LMR-4" only. See exhibit LMR-4, back.

Language Marking Requirement #5 (LMR-5)**FAS – Distribution for North Korea**

Front: USA with stripes, the commodity name, the words "NOT TO BE SOLD OR EXCHANGED," USDA logo, contract number, net weight, dimensions, and "LMR-5." See exhibit LMR-5, front.

Back: USA with stripes, the commodity name, North Korean language panel, and "LMR-5" only. See exhibit LMR-5, back.

Language Marking Requirement #6 (LMR-6)**FAS – Distribution for Afghanistan, with Pashtu and Dari**

Front: USA with stripes, the commodity name, the words "NOT TO BE SOLD OR EXCHANGED," USDA logo, contract number, net weight, dimensions, and "LMR-6." See exhibit LMR-6, front.

Back: USA with stripes, the commodity name, Pashtu and Dari language panel, and "LMR-6" only. See exhibit LMR-6, back.

Language Marking Requirement #7 (LMR-7)**FAS – Distribution for South Africa Region**

Front: USA with stripes, the commodity name, the words "NOT TO BE SOLD OR EXCHANGED," USDA logo, contract number, net weight, dimensions, and "LMR-7." See exhibit LMR-7, front.

Back: USA with stripes, the commodity name, English language panel, and "LMR-7" only. See exhibit LMR-7, back.

Language Marking Requirement #8 (LMR-8)**FAS – Distribution for Iraq with Arabic**

Front: USA with stripes, the commodity name, the words "NOT TO BE SOLD OR EXCHANGED," USDA logo, contract number, net weight, dimensions, and "LMR-8." See exhibit LMR-8, front.

Back: USA with stripes, the commodity name, Arabic language panel, and "LMR-8" only. See exhibit LMR-8, back.

Section 3.3 EMPTY BAG DIMENSIONS

- A. All bags shall be marked with the empty dimensions as follows:

Gusseted Bags	Face Width X Gusseted Width X Finished Length
Flat Tube Bags	Face Width X Finished Length

- B. The bag dimensions shall be centered at the bottom of the bag, as small as possible, yet legible.

Section 3.4 CONTAINERS WITH INCORRECT MARKINGS

- A. Any labels, bags, cans, can lids, cases, or any other type of packaging (hereinafter referred to as "containers") displaying incorrect markings may be used under a Government contract provided that the incorrect markings are obliterated and correct markings are applied in a permanent manner with approval of the contracting officer.
- B. The appearance of containers in commercial or other channels either filled or unfilled bearing markings identifying the containers as part of a Government contract may cause the Government expense in determining whether commodities have been diverted from authorized use and in answering inquiries. The contractor shall take all necessary action to prevent the appearance in commercial or other channels of containers and container materials bearing any markings required under a Government contract, including those held by the contractor or others; e.g., overruns, misprints, etc. The contractor shall ensure that any container from a Government contract that appears in commercial or other channels shall have all markings required under this contract permanently obliterated.

SMR-1

FRONT

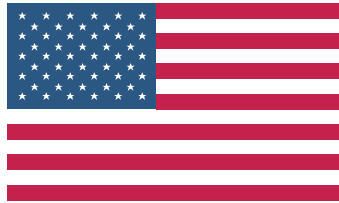


SMR-1

BACK







DEHYDRATED POTATO FLAKES

NOT TO BE SOLD OR EXCHANGED



USAID
FROM THE AMERICAN PEOPLE

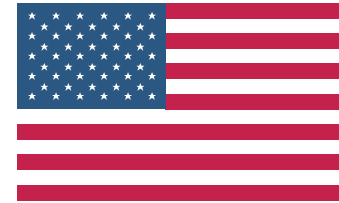
CONTRACT ABCD01234

NET WEIGHT: 20 kg, 44.092 lbs.

18 x 5 x 41

SMR-3

USAID
FROM THE AMERICAN PEOPLE



DEHYDRATED POTATO FLAKES



USAID
FROM THE AMERICAN PEOPLE

CONTRACT ABCD01234

NET WEIGHT: 20 kg, 44.092 lbs.

18 x 5 x 41

SMR-3

USAID
FROM THE AMERICAN PEOPLE

SMR-4

FRONT



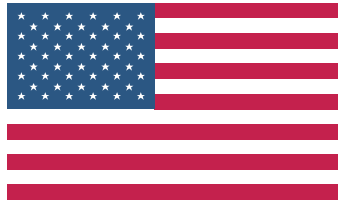
SMR-4

BACK



LMR-1

FRONT



DEHYDRATED POTATO FLAKES

NOT TO BE SOLD OR EXCHANGED



USAID
FROM THE AMERICAN PEOPLE

CONTRACT ABCD01234

NET WEIGHT: 20 kg, 44.092 lbs.

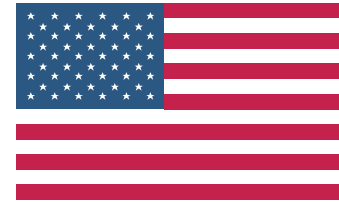
18 x 5 x 41

LMR-1

USAID
FROM THE AMERICAN PEOPLE

LMR-1

BACK

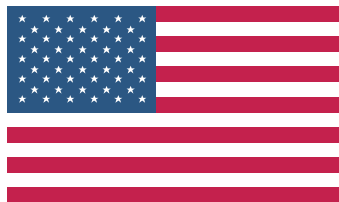


DEHYDRATED POTATO FLAKES

미국에서
보내온 선물

LMR-1

USAID
FROM THE AMERICAN PEOPLE



DEHYDRATED POTATO FLAKES

NOT TO BE SOLD OR EXCHANGED



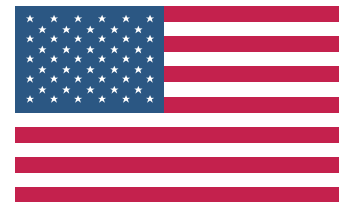
USAID
FROM THE AMERICAN PEOPLE

CONTRACT ABCD01234

NET WEIGHT: 20 kg, 44.092 lbs.

18 x 5 x 41
LMR-2

USAID
FROM THE AMERICAN PEOPLE



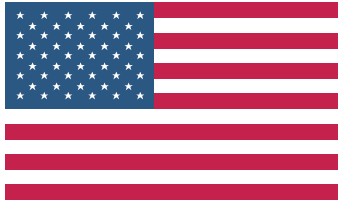
DEHYDRATED POTATO FLAKES

د امریکا د متحده ایالاتو
د خلکو سوغات

تحفهء مردم
ایالات متحده امریکا

LMR-2

USAID
FROM THE AMERICAN PEOPLE



**DEHYDRATED
POTATO FLAKES**

NOT TO BE SOLD OR EXCHANGED



USAID
FROM THE AMERICAN PEOPLE

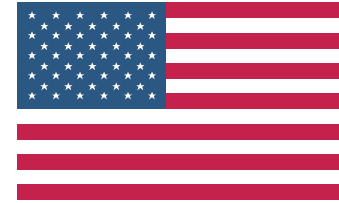
CONTRACT ABCD01234

NET WEIGHT: 20 kg, 44.092 lbs.

18 x 5 x 41

LMR-3

USAID
FROM THE AMERICAN PEOPLE



**DEHYDRATED
POTATO FLAKES**

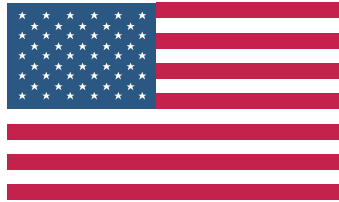
**Gift of the People of the
United States of America**

LMR-3

USAID
FROM THE AMERICAN PEOPLE

LMR-4

FRONT



DEHYDRATED POTATO FLAKES

NOT TO BE SOLD OR EXCHANGED



USAID
FROM THE AMERICAN PEOPLE

CONTRACT ABCD01234

NET WEIGHT: 20 kg, 44.092 lbs.

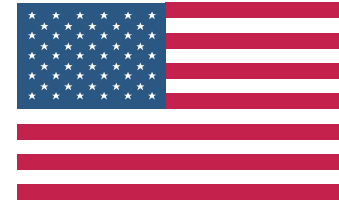
18 x 5 x 41

LMR-4

USAID
FROM THE AMERICAN PEOPLE

LMR-4

BACK



DEHYDRATED POTATO FLAKES

هدية من
الشعب الأمريكي

LMR-4

USAID
FROM THE AMERICAN PEOPLE

LMR-5

FRONT

USA

**DEHYDRATED
POTATO FLAKES**

NOT TO BE SOLD OR EXCHANGED

USDA

CONTRACT ABCD01234

NET WEIGHT: 20 kg, 44.092 lbs.

18 x 5 x 41

LMR-5

USA

LMR-5

BACK

USA

**DEHYDRATED
POTATO FLAKES**

미국에서
보내온 선물

LMR-5

USA

USA

**DEHYDRATED
POTATO FLAKES**

NOT TO BE SOLD OR EXCHANGED

USDA

CONTRACT ABCD01234

NET WEIGHT: 20 kg, 44.092 lbs.

18 x 5 x 41

LMR-6

USA

USA

**DEHYDRATED
POTATO FLAKES**

د امریکا د متحده ایالاتو
د خلکو سوغات

تحفهء مردم
ایالات متحده امریکا

LMR-6

USA



DEHYDRATED
POTATO FLAKES

NOT TO BE SOLD OR EXCHANGED



CONTRACT ABCD01234

NET WEIGHT: 20 kg, 44.092 lbs.

18 x 5 x 41

LMR-7

USA



DEHYDRATED
POTATO FLAKES

Gift of the People of the
United States of America

LMR-7

USA

LMR-8

FRONT



LMR-8

BACK



Bag Closure Guide Location

