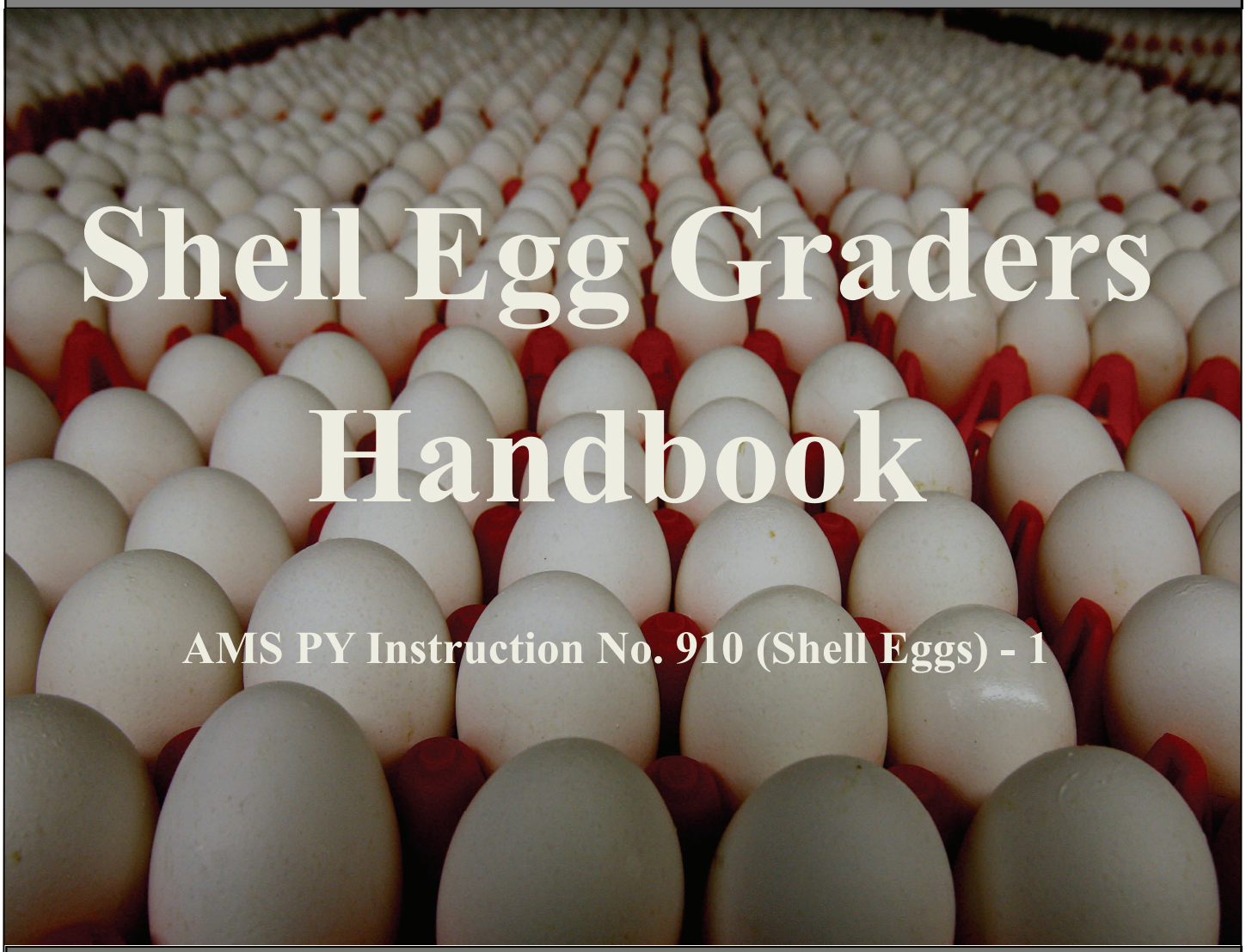
United States Department of Agriculture
Agricultural Marketing Service
Livestock, Poultry and Seed Program



Shell Egg Graders Handbook

AMS PY Instruction No. 910 (Shell Eggs) - 1

The USDA grademark assures that eggs are processed, packaged, and certified for grade and size under the continuous supervision of the United States Department of Agriculture

November 2012

Code of Ethics for Government Service

Any Person in the Government Service Should: Put loyalty to the highest moral principals and to country above loyalty to persons, party, or Government department..

Uphold the Constitution, laws and regulations of the United States and of all governments therein and never be a party to their evasion.

Give a full day's labor for a full day's pay; giving earnest effort and best thought to the performance of duties.

Seek to find and employ more efficient and economical ways of getting tasks accomplished.

Never discriminate unfairly by the dispensing of special favors or privileges to anyone, whether for remuneration or not; and never accept, for himself or herself or for family members, favors of benefits under circumstances which might be construed by reasonable persons as influencing the performance of governmental duties.

Make no private promises of any kind binding upon the duties of office, since a Government employee has no private word which can be binding on public duty.

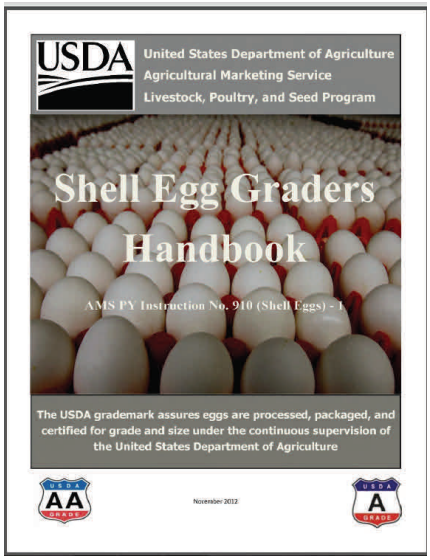
Engage in no business with the Government, either directly or indirectly, which is inconsistent with the conscientious performance of governmental duties.

Never use any information gained confidentially in the performance of governmental duties as a means of making private profit.

Expose corruption wherever discovered.

Uphold these principals, ever conscious that public office is a public trust.

(This Code of Ethics was agreed to by the House of Representatives and the Senate as House Concurrent Resolution 175 in the second Session of the 85th Congress. The code applies to all Government Employees and Office Holders.)



Congratulations, Don Dixon!

The Livestock, Poultry and Seed Program would like to recognize the efforts of Don Dixon, Regional Director, Poultry Grading Division, Little Rock, Arkansas for contributing to the design of the Shell Egg Graders Handbook cover.

SHELL EGG GRADERS HANDBOOK

Table of Contents

Page Number

Section 01 Introduction – Shell Egg Graders Handbook

I. Purpose 1

II. Authority 1

III. Policy 1

IV. Basis of Service 1

Section 02 Graders and Facility Requirements

I. Definition of Graders 1-2

A. Resident Federal-State Grader 1
B. Fee Grader 1
C. Grader-in-Charge (GIC). 1
D. Mechanical Segregation Systems 1-2
E. Designated Company Official Letter. 2

II. Duties of a Shell Egg Grader. 3-5

A. Biosecurity Requirements. 3
B. Company Quality Assurance Standards. 3-4
C. Safety. 4-5
D. Utilization of Stand-by Time. 5

III. Facilities and Equipment Required for Resident, Federal-State Graders. 5-8

A. To be furnished by the Plant 5-7
B. To be furnished by the Federal-State Supervisor. 7
C. Surveys. 7-8

Exhibit I Request Form to Utilize Mechanical Segregation Systems
Exhibit II QAD 103B Form, Plant Survey for Shell Egg Grading

Section 03 Shell Eggs Eligible for Grading

I. Eggs of Current Production. 1

II. Eggs Identified as Wholesome. 1

III. Eggs Eligible for Identification with the USDA Grademark. 1-4

A. Monitoring the Handling of Eggs Originating from Egg-Laying Flocks in an Environment Testing Positive for the Presence of Salmonella Enteritidis (SE) or Eggs from a Layer Flock Testing SE-Positive. 2-3
B. Diversion. 3
C. Company Notification of Egg Testing. 3-4
D. Positive-Egg Test Results. 4

IV. Cooperation with the Food and Drug Administration (FDA) Representatives or Other Government Agencies. 4-6

A. Plant Management's Responsibility. 5
B. Procedures to Follow When Product is Suspected of Being Adulterated Through Contaminated or Evident Tampering. . . . 5
C. Memorandum of Understanding (MOU) Between the Food and Drug Administration (FDA) and the Agricultural Marketing Service (AMS). 5
D. Reporting Tampering or Intentional Contamination. 6

V. Refrigeration of Shell Eggs from Production to Processing in Accordance with FDA Regulations. 6-7

A. Eggs Washed and Packaged for the Ultimate Consumer or Further Processed. 6-7

VI. Avian Disease Restrictions. 7

Exhibit I PY-32, Application for Service
Exhibit II Wholesomeness Certification
Exhibit III Interagency Referral Report, Report of Alleged Violation of the Federal Food Drug and Cosmetic Act-Shell Eggs

Section 04 Egg Packing and Packaging Materials

I. Case and Container Examination. 1

II. Definition of Packing Materials. 1-2

A. Fiber Cases. 1
B. Baskets. 1-2

C. Portable Racks (Bossies). 2
D. Palletized Primary Containers with Reinforced Corrugated Materials, Overwrapped with Film. 2

III. Standard Case Requirements. 2-3

IV. Definitions of Packaging Materials. 3

A. Filler Flats. 3
B. Cartons. 3

Exhibit I Case Strength Requirements

Section 05 Resident and Temporary Plant Grading Requirements

I. General. 1

II. Quality Assurance Inspector. 1

III. Extent of Examination of Daily Production Required. 1-3

A. Grade Labeled Product. 1
B. Lot Numbering Consumer Packages. 1
C. Expiration Dating (Domestic Market Policy). 1-2
D. USDA Plant Number, Lot Number, and Expiration Date Application. 2-3

IV. Use of the "Produced From" Labeling 3-5

A. Approval. 3-4
B. Verification Visits. 4
C. Record-Keeping. 4
D. Misuse of "Produced From" Labeling. 4-5
E. Cost. 5

V. Shell Egg Washing. 5-15

A. Procedures for Washing Eggs. 5-6
B. Alternative Shell Egg Washer Inspections. 6-8
C. Heat Exchanger. 8-9
D. Egg Oiler. 9-10
E. Water Potability Certification. 10-11
F. Iron Content Analysis. 11-12
G. Shell Egg Sanitizing. 12-13
H. Ultra-Violet Light for Disinfecting Shell Eggs. 13-14
I. Ozone Use as an Antimicrobial Agent. 14-15

VI. Approval of Compounds. 15-17

VII. Plant Sanitation. 17-21

A. Responsibility for Plant Sanitation. 17
B. Sanitation Inspection Standards. 17-18
C. Pre-Operative Sanitation Inspections. 18-20
D. Packaging Material Storage Areas. 20
E. Sanitation and Ambient Refrigeration of Transport Vehicles. . . 20-21

VIII. Cooling Facility Requirements. 21-23

A. Cooler Verification. 21
B. Thermometer Certification. 21-22
C. Refrigeration of Product. 22-23

IX. Surveillance Responsibilities – Resident, Temporary, and Fee Graders. . 23-26

X. Shipping of Non-Denatured Inedible Egg Products. 26

A. Responsibilities of Plant Management. 26
B. Origin Inspector Responsibilities. 26

Exhibit I Day of the Year Chart
Exhibit II Water Potability and Iron Certification Log
Exhibit III Notice of Guarantee for Approval of Compounds
Exhibit IV Chemical Compound Log
Exhibit V Pre-Operative Shell Egg Plant Sanitation Report
Exhibit VI Pre-Operative Shell Egg Plant Sanitation Report (Example)
Exhibit VII Guidance for Completing the Form PY-74, Sanitation Report
Exhibit VIII Shell Egg Surveillance Labeling

Section 06 Basics of Grading

I. Placement of Container. 1

II. Eggs to Grade 1-2

III. Items to Observe Continuously. 2

IV. Segregation of Eggs While Grading. 3

V. How to Replace Graded Eggs in the Sample Case. 3

VI. Weighing. 3-5

VII. Assignment of Grades. 5-8

A. Examples of Correct Grade Terminology. 5
B. Assigning a Consumer Grade. 6
C. Assigning a Nest Run Class. 6-8

Exhibit I Individual Egg Weight Table
Exhibit II Minimum Net Weight for Various Egg Containers

Section 07 Stationary Lot Grading Procedures

I. Lot Identification. 1

II. Size of Sample. 1

III. Reworking a Stationary Lot of Eggs. 1-2

IV. Consolidated Lot Grading – Institutional Gradings
(Includes Military Consignments). 2

V. Official Identification of Cases. 2-6

A. How and What to Stamp. 2
B. Types of Stamps to Use. 3-5
C. Computer Generated Stamps. 5-6
D. Eggs Not Processed Under USDA Supervision. 6
E. Eggs Processed Under USDA Supervision. 6

VI. Obliteration of Official Identification. 6

VII. Sealing Cases. 6-7

VIII. Identifying Lots of Improperly Labeled Eggs. 7

IX. Marking Individual Eggs. 7-8

A. Stamping Eggs. 7
B. Laser Etching (Marking Eggs). 7-8

X. Cooler Samples. 8-9

XI. Random Sample Selection – Stationary Lot Gradings. 9

XII. Repackaging Eggs Shipped from another Official Plant. 9-10

XIII. Consumer Grade-Labeled Product Which was not Officially Graded. . . 10-11

A. Protect the Consumer. 11
B. Notice of Verbal Request. 11
C. Complete Inventory. 11
D. Request Letter from Firm. 11
E. Notification of Resistance. 11
F. Form PY-518-1. 11

XIV. Sampling and Grading Over-Wrap / Shrink-Wrap Product. 11-12

XV. Previously Graded Product Received and Held in Official Plant. 12

XVI. Handling of Officially Identified Eggs Rejected by USDA at Locations Other than Where Packed. 12-13

A. Eggs Rejected for Quality and/or Size. 12
B. Documentation of Rejection. 13
C. Product Re-handled at Location Other than Point of Rejection. . . 13
D. Supervisory Follow-up of Unsatisfactory Product. 13

XVII. Completion of Sample Selection Worksheet. 13-14

XVIII. Selecting the Sample. 14

XIX. Identifying Designated Samples. 14-21

A. Product on Pallets. 14-18
B. Product on Racks (“Bossies”). 19
C. Sampling Partial Pallets or “Racks”. 20
D. Combining Different Types (Sizes) of Packing or Shipping Containers. 21

Exhibit I Cooler Sample Worksheet
Worksheets 1-19

Section 08 On-line Sampling of Shell Eggs

I. General 1

II. Line Identity 1-2

III. Product Control 2-5

A. Designated Plant Employee 2
B. Sampling Intervals 2
C. Measurement 3
D. Identification System for Samples. 3-4
E. Overlapping. 4
F. Stacking Product. 4-5

IV. Sampling Frequency. 5-7

A. Determination Primarily by Volume. 5-6
B. Sampling Following a Retention. 6-7
C. Sampling Frequency Adjustments. 7
D. Assuring That Minimum Sampling Requirements are Met. 7

V. Recording and Evaluation of Sampling Results. 7-24

A. Forms. 7-8
B. Tolerances. 8-12
C. Carryover. 12-15
D. Completing Forms – Recording Results. 16-21
E. Totaling Results. 21
F. Completing the Reverse of Form PY-75. 22-24

VI. Retention Action. 24-32

A. Cumulative Sampling Results. 24-27
B. Use of Rejected or Retained Tag – Form PY-36. 27-29
C. Handling Retained Product. 29-30
D. Sampling Retained Product. 30-32

VII. Certificate Issuance for On-Line Sampled Shell Eggs (Form PY-210S). . 32-35

A. Option 1 – Certification with No Quality Percentages or Net Weight. 32-33
B. Option 2 – Certification with Quality Percentages and/or Net Weight. 33-35

VIII. Official Identification of Online Product 35

Exhibit I Form PY-75, Shell Egg Online Candling Record
Exhibit II Form PY-75A, Shell Egg Online Candling Record
Exhibit III Form PY-516, Product Retention Log
Exhibit IV Retained Product Transfer / Release Memorandum

Section 09 Special Gradings

I. Partial Gradings 1

II. Institutional Gradings – Contract Acceptance. 1

III. Specification Gradings 1-3

A. Specification Review and Approval Process 2
B. Certification of Specification Requirements 2-3

IV. Military or Other Special Gradings 3

V. Condition Inspection of Shell Eggs 3-4

A. Certification Covering Truck Damage 3
B. Certification Covering Frozen Egg Damage 4
C. Certification Covering Off-Odor Eggs or Otherwise

Contaminated Eggs. 4

VI. U.S. Grade A or AA Interior Quality for Egg Products. 4-5

VII. Kosher Certification of Shell Eggs 5-6

VIII. Certification of Shell Eggs as Fit for Human Consumption 6

IX. Certification of Organic Shell Eggs. 6-8

A. Examination of Accreditation and Certification Documents. . . 7
B. Responsibility. 7
C. Product Labeling Requirements. 7-8
D. Verification and Control. 8
E. Official Certification. 8

X. United Egg Producers (UEP) Certified. 8-9

XI. Recognized Organizations Certifying Animal Husbandry Practices for Egg-Laying Flocks. 9

XII. Cage-Free or Free-Range Egg Production Verification Procedures. . . . 9-11

XIII. Appeal Gradings. 11-12

A. Who Shall Perform the Appeal Grading. 11
B. Procedures for Appeal Grading. 11-12

XIV. Export Certification. 12

Exhibit I Form PY-33, Application for Specification Approval
Exhibit II Semi-Annual Cage-Free Layer Flock Verification Worksheet (Example)
Exhibit III Semi-Annual Cage-Free Layer Flock Verification Worksheet
Exhibit IV Recognized Certification Standards for Cage-Free Layer Flocks

Section 10 Certificate and Memorandum Preparation

I. Preparation and Distribution of Worksheets. 1-5

A. Guidelines Regarding Use. 1
B. Entries Required. 1
C. Egg Oiling. 1
D. Temperature. 2
E. Egg Color. 2
F. Defects. 2
G. Shortages. 2-3
H. Labeling. 3
I. Underweight Eggs. 3

J. Case Temperature. 3
K. B and B* Quality. 3-4
L. Dirties and Checks. 4
M. Leakers. 4
N. Damaged Containers. 4
O. Recording Results. 4
P. Conversion of Small Units. 4-5

II. Distribution 5

III. Preparation of Certificates. 5-7

A. Preparation of Form PY-210S, Shell Egg Grading Certificate. . .5
B. General Information Concerning Certificates. 5-6
C. "Void" Certificates. 6
D. Certificate Amendments. 6
E. Superseded Certificates. 6-7

IV. Certificate Distribution. 7

Exhibit I Shell Egg Grading Certificate Amendment
Exhibit II Example - Superseded Certificate

Section 11 Shell Egg Volume Report (Form PY-240S)

I. Purpose. 1

II. Responsibility. 1

III. Completion of Report. 1-5

A. General Information Section. 1-2
B. Administrative Volume Section (Resident Plants Only). 2
C. Acceptance Service Section. 2-5
D. Certification Statements Section. 5

IV. Distribution. 5

Exhibit I Form PY-240S
Exhibit II Country Groups

Section 12 Filing System, Forms, and Equipment

I. Shell Egg Graders Filing System 1-2

II. Additional Equipment, Unused Forms, and Instruction Storage . . . 2-3

III. Disposition Schedule for Grading Program Records 3

UNITED STATES DEPARTMENT OF AGRICULTURE
Agricultural Marketing Service
Livestock, Poultry and Seed Program / Poultry Grading Division
Washington, D.C. 20250

AMS-PY Instruction No. 910
(Shell Eggs)-1

ACTION BY: Federal-State Shell Egg Graders

SECTION 1: INTRODUCTION - SHELL EGG GRADERS HANDBOOK

I. Purpose

A. This Handbook contains detailed information and explanations concerning technical aspects of the voluntary shell egg grading program. It is a working tool for the use of supervisors and graders.

B. Supplemental sheets will be printed when revisions are made to the various sections of the Handbook. Instructions will accompany revised pages giving graders guidance regarding the filing of the respective changes. Changes which supersede this printing of any section of the Handbook will be printed in italics. File the Shell Egg Graders Revision Log behind the last page of the Table of Contents.

II. Authority

The authority for this instruction is contained in the:

- Regulations Governing the Voluntary Grading of Shell Eggs (7 CFR, Part 56)
- United States Standards, Grades, and Weight Classes for Shell Eggs (AMS 56)
- Agricultural Marketing Act (AMA) of 1946, as amended
- Egg Products Inspection Act (EPIA), (7 CFR, Part 57 Regulations Governing the Inspection of Eggs) providing the authority for the Shell Egg Surveillance Program

III. Policy

It is the responsibility of each grading supervisor and grader to maintain this Handbook and to file all changes and additions as they are received. Graders are required to fully understand all changes before filing. Plant management is to be provided a copy of this Handbook and all subsequent revisions.

IV. Basis of Service

Shell egg grading service is rendered in accordance with the shell egg regulations and standards described in part II above for class, quality, quantity, condition, or any combination thereof.

SECTION 2: GRADERS AND FACILITY REQUIREMENTS

I. Definition of Graders

A. Resident Federal-State Grader

A resident Federal-State grader may be either a Federal or State employee. Graders shall limit their activities to the official plant(s) at which they are stationed unless specifically assigned by their supervisor to perform grading service elsewhere. Graders are required to limit their activities to grading and related grading work as described in this Instruction and in their job description. The grader's primary responsibility is to accurately assign the correct grade and size to each lot to be graded. When requested by an applicant, the grader assigns class, quantity, and condition or any combination thereof.

B. Fee Grader

A fee grader is a Federal or State employee who is licensed and authorized to certify to interested parties the class, quality, quantity, or condition of shell eggs. Fee graders perform lot gradings in a designated area as assigned by their supervisor.

C. Grader-in-Charge (GIC)

In plants that require the services of more than one grader, the Federal-State supervisor will designate, in writing, one grader as the GIC who will be responsible for all official grading activities in the plant. All other graders in the plant will be informed concerning the authority of the GIC. The GIC will receive the mail, be the official point of contact between the grading service and the company, and assume the initiative in resolving any problems in connection with rendering grading service. He/she is responsible for assuring that other graders have access to all instructions. While the GIC maintains overall responsibility for the grading activities in multiple shift plants, each grader working independently will be responsible for the grading activities on his/her shift(s).

D. Mechanical Segregation Systems

Plant management may request to utilize mechanical segregation systems (checks, bloods, leakers, dirt detectors, or any combination thereof) by completing the USDA-AMS, Livestock, Poultry and Seed Program’s Request Form to Utilize Mechanical Segregation Systems, Exhibit I. The completed form will be submitted to the USDA grader or Federal-State supervisor for review. Upon receipt of the request form, the USDA grader or Federal-State supervisor is to confirm that the mechanical segregation component(s) are scheduled for installation or have already been incorporated into the system. The Federal-State supervisor shall confirm acceptability of the installation of the equipment and the company’s alternate procedures should the system malfunction.

If approved by the Federal-State supervisor or the Regional Office, plant management will agree to re-introduce trained employees to provide segregation at the point of the component malfunctioning. The Request Form to Utilize Mechanical Segregation Systems shall be filed in folder 2 of the Shell

Egg Grader's filing cabinet. The USDA grader is responsible for the continued monitoring of the function of the mechanical segregation component(s). Evidence of excessive checks, blood spots, or obvious dirty eggs in samples examined are an indication that the system is not functioning in a manner to meet the U.S. grade standards. Plant management must be advised to check the system and implement corrective action. When a malfunction of mechanical segregation system(s) occurs in an egg grading facility that is designed in a manner that does not allow accessibility for manual segregation, the packaging of eggs identified with the USDA grademark is not permitted until the mechanical system is repaired. Any failure to comply with the authorized agreement for use of the mechanical segregation component(s) will result in the termination of approval to utilize such systems.

E. Designated Company Official Letter

Plant management must provide the USDA Grader with a letter designating the company official(s) on each shift to contact for resolving problems in connection with rendering grading service. The designated company contact must be available at all times during an established shift. This letter must be prepared on company letterhead and signed by plant management. The designated letter is to be placed in file 2a of the Shell Egg Graders Filing System as listed in Section 12 of this Handbook.

An example is as follows:

August 31, 2012

Rohare's Egg Company
10553 Street Road
Anytown, MD 20220

TO WHOM IT MAY CONCERN:

We designate, Shannon Peterson, Production Manager, as the company employee required to furnish the USDA Grader and other voluntary grading service personnel with information necessary for rendering official grading service.

We designate the following company employees/titles for the USDA grader to notify when specific problems arise relating to the day-to-day grading activities:

- Susan Merr, Processing Room Supervisor
- Bob Wilson, Packaging Supervisor
- Jose Lombardozzi, Loading Supervisor
- Bucky Goldstein, Clean-up Supervisor

Sincerely,

_____
/s/ Christine Hansen
President, Rohare's Egg Company

II. Duties of a Shell Egg Grader

A grader's primary responsibility is to accurately assign the correct grade and size to each lot to be graded. When requested by the applicant, the grader shall assign the class, quantity, or condition, or any combination thereof. Federal employees are required to make appropriate entries on the Work Report, Form PY-101, at the end of each working day. State-employed graders are to follow their supervisors' instructions for preparing time and attendance reports.

A. Biosecurity Requirements

Biosecurity procedures established by egg producers and packers include a range of measures focusing upon reducing the risk of the transmission of avian disease and Salmonella Enteritidis (SE) in layer flocks to food safety. Recognizing that pet birds, waterfowl, seabirds, etc. are a vector for the transmission of avian disease and SE, current policy states that graders are to refrain from raising or working with small home flocks of poultry or possessing exotic birds.

When grading service is implemented at an egg grading facility that includes an associated egg production facility, plant management must provide a detailed description of any biosecurity measures/procedures to be followed at the processing plant by USDA representatives. The Food and Drug Administration's Regulations for the Prevention of SE in Layer Flocks identifies biosecurity as a major element of an egg producer's plan.

Consequently, the level of biosecurity may change depending on the status of a layer flock at the production site. These procedures shall be reviewed with the Federal-State supervisor for acceptance determination. Any impact upon providing grading service will be reviewed with plant management at this time. The review is to determine if the grading service can comply with the proposed biosecurity procedure (for example, a procedural change requiring grader's or supervisor's to not come into contact with any birds within the last three days prior to performing grading service at that facility).

When determined acceptable, the company biosecurity procedures will be placed in the USDA grader's files (file folder 2) for reference by graders performing relief grading service. All USDA representatives providing grading service at the processing plant will follow the accepted company biosecurity procedures.

B. Company Quality Assurance Standards

As quality and food safety factors receive further attention, national brand distributors, volume food buyers, grocery chains, etc., have requested that egg suppliers comply with the standards described by the Global Food Safety Initiative (GFSI). The egg processors have responded to these requirements through internal quality assurance and food safety programs GFSI standards. To assure conformance, egg processors employ an independent third-party auditor to verify the program meets established minimum requirements. An egg processor's quality assurance and food safety program may include specific requirements that exceed that identified in this handbook, and may also require USDA representatives working in the processing facility to sign a document confirming knowledge for continued conformance with these requirements. The Federal-State supervisor shall be responsible

for the review and acceptance of proposed quality assurance procedures requiring USDA graders as third-party contactors for grading service to follow stringent procedures exceeding USDA minimum standards. When an egg processor requests USDA representatives to sign a document relative to a company‘s quality assurance and food safety program, the document will be forwarded to the Regional Director and the National Office for review prior to acceptance.

Recognizing that USDA daily inspection and grading records reflect the sanitary conditions and the quality of a significant volume of product packaged in a plant, a company representative may request authorization for an auditor to review related official records such as the Form PY-74 and PY-75. The review (not copying) by an auditor of official documents related to quality assurance and sanitation completed by the USDA grader may be authorized by the Federal-State supervisor under the provisions that such records will not leave the facility and be returned to the USDA grader for filing by the end of the established tour of duty. The Regional Office will be advised of all company requests for review of official documents related to quality assurance and sanitation.

C. Safety

Observance of safety rules is an essential duty of each grader. Common attributes of an egg processing facility include the use of chemical compounds, potentially slick processing room floors, floor drains, electrical equipment, and moving conveyors, and forklifts. The USDA grader shall be aware of the conditions in the work area during processing. When a hazard is observed, report it at once to plant management and document the conditions observed. If correction is not satisfactorily completed, report the matter to your supervisor. For your own personal safety, you should:

1. Wash hands thoroughly before and after handling product.

2. Wash away at once any harmful materials which may come in contact with your eyes or mouth.

3. Keep hands away from eyes.

4. Report to plant management all wounds or infections observed for proper treatment.

5. Write down the names of any witnesses to an accident for possible future reference.

6. Remember, at all times, that you are working in surroundings in which accidents can and do occur. When a personal injury occurs, contact your supervisor immediately.

7. Wear helmets and hearing protection as determined by your supervisor.

8. Wear protective gloves and eye protection when monitoring the concentration level of sanitizing solutions and water treatment compounds. Corrective eyewear may be worn as eye protection if the grader is comfortable that adequate protection for

the eyes is provided.

9. Utilize safe lifting techniques as outlined in training resources provided by the Agency.

10. When determined necessary by the Federal-State supervisor, the company shall provide a device to transport samples to and from the candling booth. For example, an acceptable cart to move sample cases of eggs from palletizing area or storage to the candling booth.

D. Utilization of Stand-by Time

During periods of time when plants are not in operation, contact your supervisor. The graders are to utilize standby time for review of instructions and to provide necessary training for other licensed personnel and themselves. All reports, records, indexes, and filing are to be brought up to date. If all grading and administrative work is up to date, the grader is required to do one of the following:

1. Remain at the plant during scheduled duty hours.

2. Upon approval from the supervisor, take annual leave if departing the vicinity of the plant.

When it is known that the plant will not operate for 1 or more days, graders are required to contact their immediate Federal-State supervisor to determine if any temporary reassignment is available. Federal-State supervisors may, at their discretion, request notification of less than full-day standby for resident graders.

Notification may be done by memorandum, if time permits, or when immediate situations occur, telephone contact or an electronic means of notification at the company's expense shall be utilized. In the case of a State-Trust State, the grader shall notify their supervisor of the stand-by time situation, and be guided by the state's instruction.

Refer to PR-1, in the General Index for complete instructions.

III. Facilities and Equipment Required for Resident Federal-State Graders

A. To Be Furnished by the Plant: [7 CFR 56.17 and 56.76(b)]

1. Booth Requirements

a. A candling booth adequately darkened, reasonably close to the work area, and of sufficient size to accommodate two individuals, two candling lights, and other grading equipment.

b. Two candling light(s) designed to provide high intensity light to allow recognition of defects in the content of an egg. The manufacturer or brand of

candling light will not be specified. All candling lights shall be maintained in accordance with the manufacturer's instructions including use of the proper bulb type and replacement parts. Recognizing that advanced technology and design of egg candling lights is available, the use of bright lights, such as Light Emitting Diodes (LED) lights in a candling unit is acceptable. Graders must be familiar with adjusting, focusing, and cleaning the candling light.

c. A digital or electronic individual egg scale capable of being balanced and checked for accuracy at the time of grading. These scales must be graduated in $^{1}/_{10}$-ounce increments or less. Plants packing product based on metric weights must provide individual egg scales graduated in 1-gram or less increments.

d. A digital or electronic scale, graduated in $^{1}/_{4}$-ounce or less increments, capable of weighing the lightest and heaviest consumer packages packed in the plant.

e. A scale graduated in $^{1}/_{4}$-pound or less increments for weighing shipping containers.

f. Test weights sufficient in size to verify the accuracy of the lightest and heaviest unit of measurement weighed on any given scale located in the plant.

g. An accurate metal stem thermometer.

h. Plastic-coated paper plates or other similar type disposable plates to correlate the candled and broken out appearance of eggs. The plates shall be plain and without background designs.

i. If deemed necessary by the Federal-State supervisor, a cart or method of conveyance for the transportation of samples to and from the candling booth.

j. Test kits for checking the concentration level of the solution used for sanitizing eggs and monitoring the concentration level of potable water treatment compounds in plants having chlorinators. The kit must be designed for testing the compound being used.

For example: Several quaternary ammonium compounds are approved for use as a sanitizing agent. Instructions to convert titration kit results to the equivalent concentration of active chlorine in the solution must be provided. The manufacturer of the test kit is usually the best source of the equivalency table.

Note: Plant management is responsible for furnishing protective equipment including, general purpose gloves and safety glasses to all shell egg graders monitoring the

strength of potable water treatment compounds and shell egg sanitizing solutions. Alternatively, plant employees may be trained to perform the testing under the direct supervision of the grader.

2. Office Requirements

   a. An acceptable flashlight and batteries to perform pre-operative sanitation inspections in poorly lighted areas where additional lighting is required.

   b. Desk and separate four drawer filing cabinet. The desk and/or filing cabinet are to be equipped with an acceptable locking device. Adequate environmentally-controlled office space located in close proximity to the processing plant free from any recognized safety hazards.

   After grading service is inaugurated for resident plants, it is the responsibility of the resident grader to determine that the facilities and operating procedures which were approved are maintained.

B. To Be Furnished by the Federal-State supervisor:

1. Grading certificates, worksheets, and other required forms.

2. Complete set of instructions and indexes.

3. Official grading stamps.

4. USDA identification emblem to be worn by the grader.

5. LincPass card or official identification card (site badge).

6. Government locks for the files.

7. File folders for the grader's records.

8. USDA office sign

C. Surveys

Before service may be inaugurated, the Federal-State supervisor or the assistant Federal-State supervisor shall perform a survey of plant facilities at all resident and temporary plant locations. A Plant Survey for Shell Egg Grading, QAD 103B Form, is to be completed and submitted to the National Office for approval. (Exhibit II). All plant facilities and equipment must be approved before service may be rendered (7 CFR 56.75 and 56.76).

A key component of the survey focuses upon verification that plant management has an established company rodent and pest control program or a service contractor. Recognizing that rodent and pest

control is also pertinent to maintaining compliance with the Federal Food, Drug and Cosmetics Act, Federal-State supervisors shall review, on a quarterly basis, the effectiveness of a company's rodent and pest control program. Records or observation of an increase in the frequency of dead pests in the traps; increased evidence of feces or other rodent activity; or no corrective action documented are evidence that a company's pest control program (either, in-house or by a 3rd party) is not being performed and implemented as schedule.

If a deficiency is recorded regarding application of the program in the immediate processing plant by company personnel or the service contractor and the corrective action with assessment of that action are not recorded, the program is failing to demonstrate compliance on a continuing basis.

When the program fails to demonstrate compliance, plant management will be notified in writing requesting a detailed response to the deficiencies and the actions to be implemented to prevent recurrence. The implementation and its effectiveness will be assessed during a subsequent visit to the establishment. When the proposed corrective actions presented by plant management do not provide comprehensive measures or the program is not effective as witnessed by rodent activity or pest infestation in the immediate processing area, the Federal-State supervisor will contact the Regional Office for guidance to address compliance.

USDA-AMS, Livestock, Poultry and Seed Program

REQUEST FORM TO UTILIZE MECHANICAL SEGREGATION SYTEMS

This form serves as a request to participate in the Livestock, Poultry and Seed Program's pilot program for replacing authorized graders with electronic equipment for the identification and removal of restricted class eggs.

I/We _____ request the use of electronic equipment for identification and removal of restricted class shell eggs from officially identified product and thereby eliminating the requirement for authorized graders. I/We have the equipment necessary to remove:

(Circle as applicable): Checks Leakers Dirties Bloods

I/We will maintain the equipment to proper operating parameters. I/We will abide by the USDA graders request to re-introduce trained graders should there be a malfunction with our equipment based upon results of examination indicating an increase in significantly out of grade product.

In the event of a malfunction of the mechanical segregation system when trained employees are not available or the design of the equipment does not allow access for manual segregation, I agree to suspend packaging of shell eggs identified with the USDA grademark.

This procedure will be utilized at the shell egg processing plant listed below.

The program will be implemented on (date): _____.

Plant Name and Address: **Plant Number**: _____

Firm Representative: _____
(Print Name) (Title)

_____
(Signature) (Date)

Federal-State Supervisor: _____
(Signature) (Date)

Retain current copy in file folder 2 of the Shell Egg Graders files.

PLANT SURVEY FOR SHELL EGG GRADING

INSTRUCTIONS: *Mark an "X" in appropriate blocks (If "No", explain in the "Remarks" section on page 2).*

NAME AND ADDRESS OF PLANT *(City, State and Zip)*	DATE SURVEYED *(Month, Day, Year)*	PLANT NUMBER
	☐ INITIAL SURVEY ☐ RE-SURVEY *(Explain in Remarks)*	☐ RESIDENT ☐ TEMPORARY

I. BUILDINGS, PREMISES, AND STORAGE AREAS		**YES**	**NO**	**N/A**
A.	Buildings of sound construction and in good repair.			
B.	Floors, walls, and ceilings reasonably smooth and readily cleanable.			
C.	Covered floor drains provided where needed.			
D.	Use of moisture impervious materials where appropriate.			
E.	Packing and packaging storage areas clean, dry, and adequate.			
F.	Adequate ventilation, heating, and cooling provided in areas where needed.			
G.	Adequate precautions taken to prevent the entrance of rodents and pests. Established rodent and pest control program in place.			
H.	Outside premises free of trash, rubbish, weeds, and surplus equipment.			
I.	Outside premises adjacent to processing areas are properly graded and well drained.			
J.	Satisfactory system for daily removal and accumulation of refuse provided.			
II. WASHING, GRADING, AND PACKING OPERATIONS AND EQUIPMENT TYPE OF WATER SUPPLY: MUNICIPAL_____ WELL_____				
A.	Potable water supply with an iron content of less than 2 parts per million.			
B.	Water Chlorinators provided and functioning properly, if required.			
C.	Processing areas maintained in a clean and sanitary condition.			
D.	Processing equipment sanitarily designed and constructed to facilitate cleaning.			
E.	Washers, heat exchangers (as approved), nozzles, brushes, and compartments maintained in a clean and sanitary condition.			
F.	Wash water temperature maintained at or above the required minimum.			
G.	Accurate thermometers are available for checking wash water temperature.			
H.	Prewetting water temperature maintained at or above the required minimum.			
I.	Waste water from washers discharged directly to drains.			
J.	Steam and vapors generated from the washing operation continuously exhausted directly to the outside of the building.			
K.	Sanitizer spray system functioning properly by providing an adequate spray at the required temperature and concentration levels.			
L.	Alternate sanitizing/disinfecting process, e.g. Ultra-Violet lighting or Ozone application utilized according to the requirements in the shell egg grader instructions. Technical information and certification documents on file.			
M.	Egg drying equipment clean, sanitary, and adequate to dry the maximum volume of washed eggs.			
N.	Egg oiling equipment sanitarily designed, clean, and functioning properly. Oil filtered, if applicable, and free of off odors or obvious contamination.			
O.	Mass scanning, scales, and packing equipment and conveyors clean and sanitary.			
P.	Mass scanning area adequately darkened for accurate quality determinations.			
Q.	Required approvals on file for utilization of mechanical segregation systems (checks, bloods, leakers, dirt detectors) and equipment acceptable.			
R.	Benches, shelves, and platforms subjected to moisture constructed of metal or moisture impervious materials.			

III. TOILET AND HANDWASHING FACILITIES	YES	NO	N/A
A. Toilet and hand washing facilities operational and adequate in number.			
B. Toilet facilities properly vented to the outside of the building.			
C. Restrooms maintained in a clean and sanitary condition with hot and cold running water provided.			
D. Restrooms provided with soap, sanitary towels, or other hand drying equipment.			
E. Signs posted advising employees to wash their hands before returning to work.			
F. In new or remodeled construction, toilet rooms shall not open directly into processing rooms.			
IV. SHELL EGG COOLING FACILITIES			
A. Processed egg coolers capable of cooling eggs in accordance with the Regulations.			
B. Humidifying equipment available to maintain an appropriate relative humidity.			
C. All cooler rooms maintained in a sanitary condition and free from odors and mold.			
D. Accurate thermometers, hygrometers, or other recording devices provided in all coolers.			
V. STORAGE AND USE OF CHEMICALS AND COMPOUNDS			
A. Use only approved pesticides, rodenticides, and insecticides according to manufacturer's instructions.			
B. Use only approved egg detergents and sanitizing compounds according to manufacturer's instructions.			
C. Only approved egg oils and inks used in shell eggs processing operations.			
D. Chemical compounds stored in separate areas from edible food products.			
VI. FACILITIES AND EQUIPMENT PROVIDED TO GRADER			
A. Facilities			
1. Sufficient office space that is adequately lighted, heated, and cooled.			
2. Internet connectivity, telephone, office desk and chair.			
3. Four drawer file cabinet with a proper security locking device.			
4. Two-person candling booth located in close proximity to processing area.			
B. Equipment			
1. Two hand candling lights with approved case light and cart to transport samples.			
2. Electronic digital individual egg scale graduated in 1 /1 0 ounce or less increments and test weights for calibrating.			
3. Electronic digital consumer package scale graduated in 1/4 ounce or less increments and test weights for calibrating.			
4. Bulk scales for weighing shipping containers graduated in 1/4 pound increments or less and test weights for calibrating. (Test weights not to exceed 25 lbs., two may be necessary.)			
5. Accurate metal stem pocket thermometer and break-out plate(s) for quality correlations.			
6. Hand-held flashlight and batteries.			
7. Test kit for verifying the strength of the sanitizing spray.			
VII. SAFETY AND HEALTH			
A. Safety Review and Sound Check performed.			
B. All safety and health hazards observed have been reported to plant management and corrected.			

REMARKS:

SURVEY MADE BY (*Signature*):	**APPROVED** *(Regional Director or Designee)*:	**DATE:**

SECTION 3: SHELL EGGS ELIGIBLE FOR GRADING

I. Eggs of Current Production

Eggs of current production, means shell eggs that are no more than 21 days old (date of the final gather from layer house) are eligible for grading in accordance with the U.S. Standards, Grades and Weight Classes for Shell Eggs, AMS 56.

For example: Completion of the gathering of eggs at 4:00 p.m. on Monday, August 23, 2012, will be identified with the production date 08-23-2012 representing the first day of the 21 days.

II. Eggs Identified as Wholesome

Eggs identified as wholesome are defined as shell eggs that have not been contaminated or adulterated. Any eggs on the premises of an official plant that are contaminated or adulterated must be properly segregated, identified, and controlled by plant management. This includes eggs identified through a condition inspection for quality (sensory/organoleptic examination) such as the odor of smoke or residual chemical odor, mold, and the following:

A. Eggs tested positive for the presence of Salmonella Enteritidis (identified as adulterated).

B. Eggs that have been recalled by the packer as a result of contamination of the product.

III. Eggs Eligible for Identification with the USDA Grademark

The applicant requesting service is responsible for presenting only eggs that are wholesome and unadulterated for grading in accordance with minimum quality standards for identification with the USDA grademark. In signing the Application for Service, Form PY-32, (Exhibit I), or a State-Trust State's Application for Service, with the attached Wholesomeness Statement, plant management for a shell egg processing facility agrees to notify the USDA grader of any contaminated or adulterated (chemical, physical, or biological agents) shell eggs in the plant and assure proper identification, segregation, and inventory control of such product. This includes eggs originating from a layer flock that tests positive for the presence of Salmonella Enteritidis (SE). Additionally, plant management must inform USDA of any company recalls, eggs subject to a market withdrawal, or any recalled eggs received at the plant and procedures for control of such eggs.

The USDA grader and Federal-State supervisor will review the detailed description and implementation of the identification, segregation, and the inventory control for eggs detained by the company. When the company's detention procedures are determined inadequate for control of such product, the USDA grader will retain the product following procedures outlined in Section 8, item VI. B, C.

When conducting shell egg grading service at a non-official plant, the applicant must sign the Wholesomeness Certification worksheet (Exhibit II), for each day's certification activity or grading

certificate covering the lot certified. The Wholesomeness Certification worksheet will be attached to the grader's file copy of the Shell Egg Grading Certificate, Form PY-210S, issued.

A. Monitoring the Handling of Eggs Originating from Egg-Laying Flocks in an Environment Testing Positive for the Presence of Salmonella Enteritidis (SE) or Eggs from a Layer Flock Testing SE-Positive

The Food and Drug Administration's (FDA) regulations for the Prevention of Salmonella Enteritidis in Shell Eggs during Production, Storage, and Transportation requires shell egg producers to generate food safety information that may impact an egg processor's eligibility to use the USDA grademark. The FDA has identified fresh shell eggs that test positive for SE as adulterated, requiring treatment to destroy the microorganism.

The FDA regulations require egg producers to monitor the layer house environment. When these monitoring procedures require testing of eggs for the presence of SE, the producer/processor is responsible for notifying the USDA grader of the date of collection of the eggs for testing, identity of the house(s) involved, and the date test results are received. The processor may package eggs from the layer house(s) being tested, but any product identified with the USDA grademark must be controlled until the facility presents negative test results.

The FDA regulations require egg producers to test the layer house environment for the presence of SE. When an environmental sample result is positive for SE, the producer/processor must:

1. Inform the USDA grader of the identity and location of the layer house flock(s) and the date laboratory results were received.

2. If plant management acknowledges the receipt of eggs from a layer house flock with a SE-positive environment, the USDA grader is to request the following information:

    a. If management will elect to test the eggs for the presence of SE in accordance with FDA regulations to determine if production from the identified layer house flock(s) can continue to be marketed to the table egg market?

    b. If management is not going to test the eggs, will the eggs be diverted for treatment to destroy SE for the remainder of the production cycle of the layers?

    c. Will any eggs from the identified layer flock(s), enter the official processing plant? If plant management confirms that the eggs will be stored in the plant, a copy of the company's segregation plan shall be reviewed with and remain accessible by the USDA grader to aid in monitoring the segregation process.

    d. If management elects to depopulate the layer flock(s) and proceed with the cleaning and disinfecting of the layer house, what is the estimated date of depopulation?

Upon obtaining the above information, the USDA grader will notify (by telephone) the immediate supervisor and provide relevant information reported by plant management regarding the identified layer flock(s), (approximate number of layers, identity, and location), and plant management's decision on handling the affected eggs.

B. Diversion

When eggs from a layer house(s) have been determined positive for the presence of SE, are diverted for the remainder of the flock's production cycle, the pallet, case, or other shipping container must be legibly and conspicuously labeled with the following statement:

"Federal law requires that these eggs must be treated to achieve at least a 5-log destruction of Salmonella Enteritidis or processed as egg products in accordance with the Egg Products Inspection Act, 21 CFR 118.6 (f)."

If plant management elects to divert eggs from a layer house with SE-positive environment, the USDA grader(s) must monitor and verify the plant's segregation plan assures that, when required, the eggs designated for diversion are not commingled with eggs eligible for packing and distribution, in commerce.

C. Company Notification of Egg Testing

A company may elect to test eggs from the identified flock(s) in accordance with FDA regulations. When the USDA grader receives notification of a negative-egg test result from an identified flock(s):

1. Confirm through company records the date in which the negative-egg test results were received.

2. Release for distribution into commerce all of the detained eggs identified with the USDA grademark back to the time and date of collection of egg samples to be tested.

Note: Eggs packed in containers that are not identified with the USDA grademark packaged during the period while awaiting egg test results may be distributed in commerce in accordance with the referenced FDA regulations. If egg test results are SE-positive, the egg packer must issue a market recall of eggs packaged and distributed subsequent to the collection of the samples for egg testing.

A company may elect to continue testing eggs from the identified flock(s) in accordance with FDA regulations by conducting a total of 4 consecutive tests taken not more than 2 weeks apart. When the company elects to continue the testing of eggs, the grader will request the following information and follow the guidance below:

3. Company management will provide notification to the USDA grader of the date of collection of eggs for each consecutive test.

4. The USDA grader will follow the procedures outlined above, in C.1 and C.2 until four consecutive, negative-egg test results are achieved

5. When additional testing of the identified flock (s) is conducted in accordance with the requirements stated in the FDA regulations or in accordance with a State SE monitoring program, company management must notify the USDA grader of the sample collection date for control of eggs as outlined above.

D. Positive-Egg Test Results

Eggs testing SE-positive must be diverted for treatment (breaking for pasteurization, hard cooking, or other FDA-approved process). Additionally, in accordance with the regulations,

1. All eggs testing SE-positive must be labeled as stated below in accordance with FDA regulations.

   "Federal law requires that these eggs must be treated to achieve at least a 5-log destruction of Salmonella Enteritidis or processed as egg products in accordance with the Egg Products Inspection Act, 21 CFR 118.6 (f)."

2. All eggs from a layer flock(s) with an SE-positive test result entering an official shell egg facility must be labeled and controlled as stated in the company's procedures to assure the adulterated eggs are not commingled with other eggs determined eligible to be identified with the USDA grademark. When the company elects to conclude the production cycle and depopulate the identified layer flock(s), the USDA grader must be notified and the information recorded on the company's control records.

Additional guidance may be provided by the Federal-State supervisor to address detailed control procedures at each official facility testing eggs originating from a layer house with an SE-positive environment as provided in the referenced FDA regulations.

IV. COOPERATION WITH THE FOOD AND DRUG ADMINISTRATION (FDA) REPRESENTATIVES OR OTHER GOVERNMENT AGENCIES

The Food and Drug Administration (FDA) maintains jurisdiction for the production and processing of shell eggs in accordance with good manufacturing practices to assure that the product is safe for human consumption. Therefore, FDA officials may visit shell egg plants to observe operations and collect market survey samples for a variety of analysis.

When an FDA representative visits a plant the grader shall cooperate, to the extent possible without neglecting required grading and certification duties. If the FDA representative is introduced, exchange official identification and contact information. If the grader is invited to accompany the FDA representative during a tour of the egg processing facility, the grader will determine if it is feasible. The grader shall inform the FDA representative of availability to review observations or any deficiency to be included in a report relative to sanitary conditions and processing of shell eggs. The grader will not be present during FDA discussions with plant management.

The grader will immediately (same day) instruct the Federal-State supervisor of the visit from the FDA representative(s), providing all relative contact information and comments regarding the egg processing plant. Visits to an in-line egg production facility focusing solely on the egg production

must also be reported. This information will be forwarded to the National Office by the Regional Office as soon as practical.

A. Plant Management's Responsibility

Plant management at an official shell egg plant is responsible for notifying the USDA grader whenever contaminated or adulterated shell eggs are present in the official shell egg plant. Any shell eggs identified as contaminated or adulterated must be properly labeled and controlled by plant management. This includes shell eggs originating from a layer house with a positive environment for Salmonella Enteritidis (SE) or eggs testing positive for the presence of SE. Failure to control, detain and/or notify the grader of the presence of contaminated or adulterated shell eggs in the official plant will constitute a violation of the regulations.

B. Procedures to Follow When Product Is Suspected of Being Adulterated, Through Contaminated or Evident Tampering

Graders shall be alert for any possible product contamination, either accidental or intentional. Although processors may have extensive preventative and security measures in place, graders may encounter product that may be suspected of or found to be contaminated. Contamination may be from various sources such as:

- **Chemical Agents** - Agents usually delivered as airborne droplets, liquids, aerosols, or solids. Additionally, these agents can include toxic industrial chemicals such as pesticides, rodenticides, and heavy metals.

- **Biological Agents** – Agents that are generally in the form of bacteria, toxins, viruses, and parasites and are usually delivered through liquids, aerosols, or solids.

- **Physical Agents** - Materials that could cause adverse health effects if consumed. Examples include bones or hard-like materials, glass fragments, and metal pieces or filings.

After review by applicable parties, the Federal-State supervisor will provide the grader guidance in determining what further action is to be taken.

C. Memorandum of Understanding (MOU) Between the Food and Drug Administration (FDA) and the Agricultural Marketing Service (AMS)

In accordance with the MOU between the agencies, AMS graders and Shell Egg Surveillance Inspectors will report the observation of the violation of the Federal Food Drug and Cosmetic Act (FFDCA) that reflect a high risk or probable contamination while conducting grading or inspection activities. When graders encounter evident instances of adulteration or contamination, the affected product shall be retained to prevent further distribution in marketing channels. Upon review of the information provided additional guidance for contacting the FDA District Office and further guidance for the grader will be provided to the Federal-State supervisor. The detailed information and observations regarding such an incident will be reported immediately to the Federal-State supervisor and plant management. The Federal-State supervisor will complete the Interagency Referral Report (Exhibit III) and submit the report through the Regional Office to the National Office for electronic transmission to FDA.

D. Reporting Tampering or Intentional Contamination

When graders encounter probable instances of contamination or evident tampering, the identified shell eggs will be retained. The grader will contact the Federal-State supervisor to provide detailed information pertaining to the incident. The Federal-State supervisor will report the information through the Regional Office to the National Office Staff. Upon receipt of information relative to final disposition of the retained product the information will be forwarded to the National Office. In instances of tampering or intentional contamination, the Federal-State supervisor is to notify FDA and the Office of Inspector General (OIG) by calling their local district offices or their 24-hour emergency numbers:

FDA: 1-866-300-4374 or (301) 796-8240

OIG: (202) 447-7257

V. Refrigeration of Shell Eggs From Production to Processing in Accordance with FDA Regulations

The FDA Regulations for the Prevention of Salmonella Enteritidis in Shell Eggs during Production, Storage, and Transportation establish the ambient refrigeration requirements for egg producers with 3,000 or more layers. The following is a list of principal points defined in these regulations.

A. Eggs Washed and Packaged for the Ultimate Consumer or Further Processed

1. Nest run eggs that are not processed within 36 hours from the time of lay (date and time of final gathering) must be refrigerated at 45˚Fahrenheit or less during storage and transport.

2. The ambient refrigeration requirements in item 1 apply to:

   a. Surplus or culled eggs originating from breeder flocks or hatcheries.

   b. Restricted eggs segregated at a grading station for further processing at an official egg products plant.

   c. Loose packed, graded eggs held for reprocessing and repackaging into containers for sale to the ultimate consumer or diverted/traded as breaking stock.

3. Refrigerated nest run eggs may be equilibrated up to 36 hours at room temperature prior to washing and grading to reduce the risk of thermal cracks. Only nest run eggs may be equilibrated at room temperature prior to processing.

Note: The equilibration time is not a cumulative period. For example: When nest run eggs are removed from refrigerated storage to an unrefrigerated area (processing room) awaiting processing, but then returned to a refrigerated storage area 10 hours later, the equilibration period is terminated for the lot of nest run eggs.

When the equilibration period for a lot of eggs has been terminated, that lot cannot be brought out to the processing room for the equilibration process again. The lot must be immediately placed on the line for processing/reprocessing or for packaging only. Product brought out into the processing room is limited to a pallet at a time and must be actively transferred to the grading machine.

If product is brought out for placement on the grading machine for processing/reprocessing or packaging, and is not actively transferred to the grading machine, it is no longer eligible to be processed/reprocessed or packaged into USDA grademarked product. At this point, if the company/facility elects to process/reprocess or package the pallet of eggs into non-USDA grademarked product, the grader is to allow them to do so; however, the grader shall notify their immediate supervisor, who shall complete the FDA, Interagency Referral Report (Exhibit III).

It is recommended that the USDA grader review these requirements with plant management to assure that the eggs remain eligible for grading.

The resident grader is not required to specifically monitor the egg processing plant's conformance with these FDA regulatory refrigeration requirements. However, if nonconformance is evident, contact the Federal-State supervisor. The Federal-State supervisor will provide guidance regarding refrigeration nonconformance and the eligibility of the eggs to be identified with the USDA grademark at the official plant. Additionally, the Federal-State supervisor will complete the FDA, Interagency Referral Report for submission to the National Office.

VI. Avian Disease Restrictions

In the event of the detection of a highly pathogenic avian disease in egg-laying flocks in the United States, State and Federal veterinary service officials may establish restrictions to control potential transmission and eradicate such disease.

If detection is confirmed, officials with the Animal and Plant Health Inspection Service (APHIS), USDA, will identify the geographical area involved and define any restrictions regarding the movement and use of eggs originating from the identified layer flock(s). APHIS officials will notify the National Office with detailed information and instructions that will be distributed to all impacted shell egg graders.

Exhibit I

REPRODUCE LOCALLY. *Include form number and edition date on all reproductions.* **OMB APPROVED - NO. 0581-0127**

U.S. DEPARTMENT OF AGRICULTURE
AGRICULTURAL MARKETING SERVICE
POULTRY PROGRAMS

APPLICATION FOR SERVICE

According to the Paperwork Reduction Act of 1995, an agency may not conduct or sponsor, and a person is not required to respond to a collection of information unless it displays a valid OMB control number. The valid OMB control number for this information collection is 0581-0127. The time required to complete this information collection is estimated to average 15 minutes per response, including the time for reviewing instructions, searching existing data sources, gathering and maintaining the data needed, and completing and reviewing the collection of information.

The U.S. Department of Agriculture (USDA) prohibits discrimination in all its programs and activities on the basis of race, color, national origin, age, disability, and where applicable, sex, marital status, familial status, parental status, religion, sexual orientation, genetic information, political beliefs, reprisal, or because all or part of an individual's income is derived from any public assistance program. (Not all prohibited bases apply to all programs.) Persons with disabilities who require alternative means for communication of program information (Braille, large print, audiotape, etc.) should contact USDA's TARGET Center at (202) 720-2600 (voice and TDD). To file a complaint of discrimination, write to USDA, Director, Office of Civil Rights, 1400 Independence Avenue, S.W., Washington, D.C. 20250-9410, or call (800) 795-3272 (voice) or (202) 720-6382 (TDD). USDA is an equal opportunity provider and employer.

In accordance with the applicable provisions of the regulation issued by the Agricultural Marketing Service, U.S. Department of Agriculture, application is hereby made for the furnishing of the service(s) checked below to be performed at the plant specified:

"X"	VOLUNTARY SERVICE REQUESTED	TYPE OF SERVICE	REGULATIONS APPLICABLE TO SERVICE REQUESTED
	SHELL EGG GRADING SERVICE	☐ Resident ☐ Non-Resident ☐ Temporary	Grading of Shell Eggs (7 CFR Part 56)
	POULTRY OR RABBIT GRADING SERVICE	☐ Resident ☐ Non-Resident ☐ Temporary	Voluntary Grading of Poultry Products and Rabbit Products (7 CFR Part 70)

NAME, ADDRESS, TELEPHONE NUMBER, AND FAX NUMBER OF PLANT *(Street and No., City, State, and ZIP Code)*

PLANT NUMBER

CERTIFICATION: I agree to comply with the terms and conditions of the regulations applicable to the service(s) requested (*including but not limited to such instructions governing such service as may be issued, from time to time, by the Agricultural Marketing Service).* I also agree to notify the Agricultural Marketing Service of any contaminated or adulterated (chemical, physical, or biological agents) shell eggs in the processing plant and to assure identification and segregation of such product. This notification includes shell eggs that have tested positive for *Salmonella Enteritidis* (SE) or shell eggs from houses determined positive for the presence of SE, or any shell eggs that have been recalled or subject to any recall. I also agree to provide the AMS grader detailed information pertaining to the method of identification and segregation required of any shell eggs that have been determined to be contaminated, or adulterated, including eggs from an identified layer flock that tests positive for the presence of SE. I hereby acknowledge receipt of a copy of Public Law 84-272 (7 U.S.C. 1622(h)) and the regulations under which this application is made.

NAME (*As shown on your income tax return*)

ADDRESS OF APPLICANT *(Street and No., city, State, and ZIP Code)*

NAME OF APPLICANT (*If different from above*)

E-MAIL ADDRESS:

EMPLOYER IDENTIFICATION NUMBER (EIN) _____ (is a 9 digit number assigned to sole proprietorships, corporations, partnerships, estates, trusts, and other entities for filing and reporting purposes).

DATE

SIGNATURE OF APPLICANT

APPLICATION GRANTED

(FOR USE BY USDA, Agricultural Marketing Service)

DATE	TITLE	BY *(Signature)*

*No member of or delegate to Congress, or Resident Commissioner, shall be admitted to any benefit that may arise from this service unless derived through service rendered a corporation for its general benefit.

United States Department of Agriculture

Agricultural Marketing Service

Room 3935-S, STOP 0258
1400 Independence Avenue
Washington, DC 20250-0258

Wholesomeness Certification

- ☐ **Resident Service**
- ☐ **Temporary Service**
- ☐ **Fee Grading Service**

In accordance with the applicable provisions of the Regulations Governing the Voluntary Grading of Shell Eggs (7 CFR 56) issued by the Agricultural Marketing Service (AMS), U.S. Department of Agriculture, I agree to notify the AMS grader of any contaminated or adulterated (chemical, physical, or biological agents) or potentially contaminated or adulterated shell eggs in the processing plant and to assure required identification and segregation of such product. This notification includes shell eggs that have tested positive for Salmonella enteritidis (SE), shell eggs from houses determined positive for the presence of SE, or any shell eggs that have been recalled or subject to any recall. I also agree to provide the AMS grader detailed information pertaining to the method of identification and segregation required of any shell eggs that have been determined to be contaminated, or adulterated, including eggs from an identified layer flock that tests positive for the presence of SE. Further, I certify that, to the best of my knowledge, none of the contaminants or adulterants described above exist in the shell eggs presented for USDA certification.

_____
Company Name and Address (Official Plant #)

_____
Signature and Title of Company Representative

_____
Date

Report of Alleged Violation of the Federal Food Drug and Cosmetic Act – Shell Eggs

1. Name and Address of Establishment: (City, State, Zip Code)	**2. Name of Reporting Employee:**	**5. Date of Alleged Violation:**
		6. Date Report Completed:
	3. Title of Reporting Employee:	**7. Establishment Identification Number:** **AMS Plant Number:** **EPIA Registrant Number:** **State Identification Number:**
	4. Name of Reporting Employee's Agency:	

DESCRIPTION OF ALLEGED VIOLATION

8. Facility Description: (i.e. Farm, warehouse, processing facility, manufacturing facility, etc.)

9. Violation Observation: (i.e. Who, What, Where, When, How, Significance, etc.)

10. List of Products Potentially Affected:

11. Description of Specific Location within a Facility Where Violation Occurred: (i.e. Dry Storage Room, Processing Line, Loading Dock, etc.)

12. Action Taken by Reporting Agency, if Applicable/Authorized: (i.e. USDA Retain Tag Numbers Used, Notification of Plant Management, etc.)

13. Additional Comments:

SECTION 4: EGG PACKING AND PACKAGING MATERIALS

I. Case and Container Examination

When grading eggs, the grader will observe the condition of the cases or containers and classify the material as new, good used, poor used, or worthless. Record on the memorandum the condition of the cases or containers and their size, such as 30-dozen or 15-dozen.

If the lot consists of more than one type or quality of case or containers, record the actual number of each type and quantity. If the applicant does not elect to place them into separate groups, describe the lot with each adjective that is applicable; for example, good or poor used fiber corrugated cases. Egg case description include the type of closure; for example, good used fiber corrugated cases, tops taped, or poor used fiber corrugated cases, tops glued**.** Eggs which are to be officially identified with the consumer grademark shall be packaged only in new or good used cases and packaging materials.

II. Definition of Packing Materials

A. Fiber Cases

- New: clean and rigid, shows no evidence of previous use.
- Good Used: clean and free from odors, excessive stains and mold, all seams secure, no torn material affecting construction, appearance of previous use that maintains its rigid construction.
- Poor Used**:** warped or sagging affecting rigid corrugation, stained, soiled, torn but free of odors and mold.
- Worthless**:** any case not meeting the above classifications.

B. Baskets

1. Wire

- New/Good Used**:** free of soiled areas and rust, may exhibit previous use characteristics but not affecting the construction for protection of egg cartons or flats during handling and shipping.
- Poor: rusty or heavily soiled, misshapen affecting the ability to protect egg cartons or flats during handling and shipping.

2. Plastic

- New/Good Used**:** free of soiled areas and unacceptable odors, may exhibit previous use characteristics but not affecting the construction for protection of eggs in cartons or flats during handling and shipping.

- Poor**:** heavily soiled, broken and unable to adequately protect egg cartons or flats during handling/shipping.

C. Portable Racks (Bossies)

- New/Good Used**:** free of soiled areas, rust, and unacceptable odors, may exhibit previous use characteristics but not affecting construction for protection of egg in cartons or flats during handling and shipping.

- Poor**:** broken unable to adequately protect egg cartons or flats during handling/shipping.

D. Palletized Primary Containers with Reinforced Corrugated Materials, Overwrapped with Film

1. Pallets

- New/Good Used: reasonably clean, unbroken, no evidence of adhering foreign material, no odors.

- Poor**:** dirty, broken, unacceptable odors, incapable of transporting eggs.

2. Reinforcement Corrugation

- New/Good Used**:** clean, free from odors, no evidence of moisture or excessive stains, and mold. All seams secure, no tears, appearance of one-time use that maintains its rigid construction.

- Poor: soiled, evidence of odor, mold, stained, tears.

3. Overwrap film

- Must be FDA-approved for food contact when used in direct or indirect contact with shell eggs. Plant management must present a Letter of Guarantee from the manufacturer to the grader stating that the film is FDA approved.

III. Standard Case Requirements

Each 30-dozen case shall be provided with liners held firmly in position in the center of the case to form two compartments. Alternate case designs may be approved by the National Office. When included as part of a contract acceptance specification, cases may be required to meet specified material and structural requirements by bearing a box manufacturers certification. The certification statement or stamp imprint on the corrugated material will show the burst strength (Mullen) test or comply with the edge crush test (ECT) value as shown in Exhibit I.

The following cases (which do not contain a liner in the center position) have been approved as an equivalent for use as a 30-dozen case:

- Single-wall case with a minimum of 55 pounds per inch, Edge Crush Test (ECT)
- Double-wall case with a minimum of 42 pounds per inch, Edge Crush Test (ECT)

IV. Definitions of Packaging Materials

A. Filler Flats

- New: clean shows no evidence of previous use.
- Good used: no odors, free of mold, rigid, capable of protecting eggs.
- Poor used: evidence of slight odor or moisture areas, and no mold, capable of protecting eggs.
- Worthless: does not meet above classifications.

B. Cartons

- New: clean shows no evidence of previous use.
- Good used: no odors, free of mold, rigid, capable of protecting eggs.
- Worthless**:** does not meet above classifications.

Exhibit I

Case Strength Requirements

Minimum Bursting Test Single Wall and Doublewall Board (lbs. Per sq. in.) or Minimum Puncture Test Triplewall Board (in. oz. Per in. of tear)	Minimum Edge Crush Test (ECT) (lbs. Per in. width)
Single Wall Corrugated Fiberboard Boxes	
125	23
150	26
175	29
200	32
250	40
275	44
350	55
Double Wall Corrugated Fiberboard Boxes	
200	42
275	48
350	51
400	61
500	71
600	82
Triple Wall Corrugated Fiberboard Boxes	
700	67
900	80
1100	90
1300	112

SECTION 5: RESIDENT AND TEMPORARY PLANT GRADING REQUIREMENTS

I. General

Resident shell egg graders are charged with the responsibility of determining the class, quality, quantity, and condition of each lot of product that management requests to be graded. In carrying out this responsibility, there will be variations in the grading services performed depending on the type of certification performed.

II. Quality Assurance Inspector

When a company elects to utilize a quality assurance inspector to monitor the quality of USDA grade-labeled product that is packaged during periods when a licensed grader is not on duty, refer to Q-1, QUALITY ASSURANCE INSPECTOR PROGRAM (QAI), located in the Supervisors/Resident Graders Shell Egg Index, for complete instructions.

III. Extent of Examination of Daily Production Required

A. Grade Labeled Product

Graders stationed in plants that pack consumer labeled eggs are to continuously examine product as it leaves the grading line. The amount of product the grader examines will vary depending on the quantity and quality of the product being graded. Refer to Section 8 of this Handbook, ON-LINE SAMPLING OF SHELL EGGS, for proper procedures to follow when online sampling.

B. Lot Numbering Consumer Packages

All cartons, overwraps, and other types of consumer packages bearing the USDA grademark require legible lot numbering on the consumer package. The lot number is the consecutive day of the year (Exhibit I) on which the eggs were packed; such as, 042, 155, etc. This number must have three digits. For numbers less than 100, the lot number is expressed as 009, 087, etc.

Alternate lot numbering systems may be approved by the Federal-State supervisor. For example, some companies use specific codes (Alpha-Numeric, Day/Month/Year format, Month/Day/Year format, MM/DD/YY format, etc.) , as long as the company explains the lot numbering system to the supervisor, and the alternative lot numbering system can be maintained in an acceptable fashion, it may be approved. A written description of the alternate lot numbering system must be presented to the resident grader for file folder 2. In plants where a shift normally works past midnight, the entire shift may elect to use the lot number corresponding to the day of the year on which the shift ends.

C. Expiration Dating (Domestic Market Policy)

Expiration dating on packaging material officially identified with the grademark is optional and is the responsibility of management. Expiration dates, company codes, etc., used by the packer or retailer for purposes such as stock rotation or inventory control, do not require departmental approval and may be used provided they are not misleading. However, the use of expiration dates requires an appropriate

qualifying prefix.

The regulations state, "Compliance with the regulations in this part shall not excuse failure to comply with any other Federal, or any State, or municipal applicable laws or regulations." Compliance with applicable State regulatory labeling requirements for use of an expiration date or stock rotation date is the responsibility of the distributor/packer.

Qualifying prefixes such as:

- EXP
- Expiration date
- Sell by
- Not to be sold after date on end of carton
- Purchase by
- Last sale date on end of carton or other similar language denotes stock rotation

The dates associated with these prefixes are to be calculated from the date the eggs are originally packed into the container and may not exceed 30 days including the day of pack.

Qualifying prefixes such as:

- Use before
- Use by
- Best before
- Best by
- Best if used by or other similar language generally indicates the maximum time frame for expected quality

The dates associated with these prefixes are to be calculated from the date the eggs are packed into the container and may not exceed 45 days including the day of pack.

D. USDA Plant Number, Lot Number, and Expiration Date Application

The USDA plant number, lot number, and expiration date, when applicable, must be correct and legible before the product leaves the plant. Graders are to constantly observe these items and obtain immediate correction when not in compliance. As a guide to determine acceptable legibility on consumer containers, the grader is to check ten containers in each sample, regardless of the number of eggs in each container. For example: If there are nine, 1-dozen cartons in a sample, the grader should select one additional carton to make a total of ten. If 6-egg pack, consumer containers are being sampled, the grader need check only ten containers, even though the 100-egg sample would require examination of 17 containers. For uniformity, the first ten, 6-egg packs should be used to determine acceptable legibility. Acceptance and rejection criteria are based on the following plans:

1. Accept – one container with information completely missing (10 percent).
   Reject – two containers with information completely missing (20 percent).

2. Accept – three containers with information partially missing (30 percent).
   Reject – four containers with information partially missing (40 percent).

3. Accept – one container with information which is completely missing and two containers with information partially missing (30 percent).

4. Reject – any product exceeding D.3 acceptable levels.

As a result, the plan allows:
- 10 percent missing
- 30 percent partially missing
- 30 percent in combination with not more than 10 percent completely missing

These tolerances apply to online and stationary lot sampling procedures. Acceptance and rejection of plant, lot number, and expiration date legibility is to be recorded on the Forms PY-75 and 75A, in the blank space beneath the Log Reference Number (See Example 1). A checkmark (√) shall be used to indicate an acceptable sample, while an "X" shall be used to indicate that the sample was rejected. Any reference regarding a rejection due to incorrect or illegible items must be explained in the comment log section of Form PY-75 or 75A.

Example 1

	U.S. GRADE & SIZE **AA Medium**									U.S. GRADE & SIZE **AA Medium**								
Brand	WD	WD																**Brand**
Exp	9/29	9/29																**Exp**
Mach	2	2																**Mach**
Time	0830	0900																**Time**
Log Ref #	1																	**Log Ref #**
	✘	✔																

IV. Use of the "Produced From" Labeling

Use of the wording "Produced From" in conjunction with the U.S. grademark, is limited to products derived from U.S. Grade AA or Grade A shell eggs for which there are no U.S. grade standards (e.g., pasteurized shell eggs or hard-cooked eggs). The following guidelines are to be used when monitoring the official grade identification of these types of products.

A. Approval

Applicants interested in utilizing the "Produced From" labeling must submit a written proposal to the applicable Federal-State supervisor. The proposal is to include the type(s) of product to be labeled and

the applicant's plan for controlling the use and labeling of officially identified product. After review by the Federal-State supervisor, the supervisor is to forward the request to the Regional Director and National Office for final review and approval. Upon approval, the Federal-State supervisor is to re-confirm all of the requirements with the applicant prior to any actual grade identification.

Additionally, labeling and/or packaging material bearing a pre-printed "Produced From" grademark requires approval by the National Office prior to use. Expiration dating and compliance with State regulations will be the responsibility of the applicant.

B. Verification Visits

To assure that only officially graded shell eggs are being used, the processing, packing, and packaging must be closely monitored. In plants with resident service, the Federal-State supervisor or assistant is to be present during the initial production period to monitor the process and verify compliance. The resident grader will conduct all subsequent monitoring and verification activities with oversight from the supervisor. In temporary or fee locations, plant management must notify the Federal-State supervisor each time the "produced from" labeling will be used or, alternatively, provide the supervisor with a projected production schedule. At these locations, compliance will be based on the applicant's established history of compliance as outlined in the following schedule:

> **Level 1 -** The Federal-State supervisor or assistant is to monitor and verify the process on the initial day of production. The supervisor or an assigned representative will conduct subsequent visits. At least one additional verification visit is to be conducted during the next 10 production days. If no discrepancies are noted, one visit is to be conducted for each 30 days of production until three consecutive satisfactory visits have been completed. Once this verification period has ended without any noted program non-conformance, monitoring may proceed to **Level 2.**
>
> **Level 2 -** The Federal-State supervisor or assigned representative is to conduct quarterly verification visits provided the applicant continues to meet all program requirements. If any nonconformance is noted during these visits, monitoring reverts back to **Level 1.** Misuse of the labeling will result in cancellation of the approval.

Each verification visit shall include a review of records, product inventory, processing procedures, packing, packaging, storage, and shipping practices to confirm that the applicant is following the protocol outlined in their approved plan.

C. Record-Keeping

Applicants shall maintain, and make available for review, all invoices or applicable Form PY-210S Grading Certificates covering product received, produced, and shipped. At a minimum, these records must include the name and address of original packer, amount received, quantity produced, brand names, lot numbers, quantity shipped and name and address of receivers. Records must be maintained for two (2) years.

D. Misuse of “Produced From” Labeling

The misuse of this labeling (i.e., placing such labels on product not “produced from officially graded”), constitutes a violation of the Agricultural Marketing Act (AMA). In addition, noncompliance with the requirements of the labeling program may also result in withdrawal of the applicant's privilege to identify product with the “Produced From” identification.

E. Cost

There will be no additional charge to resident plants when graders monitor product labeling during their normal grading activities. When graded product is shipped from official plants to other processing locations for re-packaging that are not under continuous USDA supervision, time and expenses associated in conducting the verification visits will be charged to the applicant at the current fee rate.

V. Shell Egg Washing

A. Procedures for Washing Eggs

The following procedures are to be followed when washing eggs: [7 CFR 56.76(f) 1-14]:

1. Pre-wetting by submersion is prohibited.

2. Pre-wetting of eggs with a pressurized spray system must use water at a temperature 20 degrees greater than the internal temperature of the egg.

3. Washer systems must be cleaned daily or more frequently as necessary.

4. On continuous type washers, the water must be changed once during each (approximately every 4 to 5 hours) shift, at the end of each shift, and/or more frequently if necessary.

5. Wash water must contain an approved cleaning compound and be at least 20° Fahrenheit warmer than the eggs with a minimum water temperature of 90° Fahrenheit. If wash water temperatures drop below the minimum requirements, immediate correction is required. Should corrections not be completed within 15 minutes, all official identification of product shall cease until it is corrected.

6. In plants with multiple washers in sequence, the water temperature must be the same or warmer as the egg progresses through the washers.

7. Final rinse water must be equal to or warmer than the wash water. If final rinse does not properly remove (soap, foam etc.) immediate corrective action must be taken or official identification withdrawn.

8. Machines that recirculate wash water shall have replacement water added continuously. Chlorine sanitizing rinse water may be used as part of the replacement water (this includes quaternary compounds or sanitizing compounds recognized as equivalent to the concentration level equal to that of active

chlorine). Iodine rinse water may not be used as replacement water, but must be discharged directly to a drain.

9. Waste water from washers shall be piped directly to a drain.

10. All eggs are to be reasonably dry before packaging.

Please Note: When the washing of eggs is interrupted for periods in excess of 15 minutes, with washing solution in the reservoir or being returned to the reservoir, the access lids on top of the washer shall be lifted to prevent negative impact on the eggs remaining on the conveyor inside the washer. Alternatively eggs can be removed from the conveyor inside the washer.

B. Alternative Shell Egg Washer Inspections

The washing solution reservoir is considered a component of the egg washing system and must be properly cleaned and inspected daily. Unsanitary conditions in the reservoir could contribute to the presence of spoilage microorganisms and pathogens. Section 56.3 of the Regulations Governing the Voluntary Grading of Shell Eggs provides for the authorization to conduct experimental work to assess new procedures and advanced technology. Based upon the authority contained in Section 56.3 of the regulations, Poultry Programs can consider a written request from plant management to reduce the frequency of USDA inspection of the egg washer system reservoir(s). The written request must describe in detail the performance-based program designed to consistently clean the washer reservoir, and the daily procedures performed by a designated company employee to verify cleanliness of the equipment, document observations, and record any corrective action. The Federal-State supervisor and the USDA grader shall be responsible for reviewing any request for an alternate frequency of inspection of the egg washer system.

1. Plant management must provide the Federal- State supervisor and the USDA grader, in writing, the company's Standard Operating Procedure (SOP) for cleaning and inspection of the egg washer reservoir. The SOP will describe the approximate concentration of the cleaning solution (amount of specified cleaning compound and water), the re-circulation time in the washer unit, the company personnel responsible for inspection and documentation of cleanliness, and the record(s) maintained. The submission from plant management shall also identify the level of the frequency of inspection (not to exceed monthly) requested.

2. The records maintained by plant management must demonstrate conformance on a continuing basis with the written SOP, document any corrective action required, and illustrate the initials of the company employee responsible for daily inspection and verification of the performance-based program. The records may consist of written documents or a combination of written and mechanical recordings. Any modifications to the SOP or recordkeeping process shall be immediately discussed with the USDA grader to assess if any additional USDA evaluation is necessary. The SOP and all company records related to this performance-based program to reduce the frequency of inspection of the washer

reservoir will be available for review upon request from a USDA representative. Any company records applicable to the cleaning and inspection of the subject equipment following the previous day's production must be available to the USDA grader prior to processing.

3. When approval is granted by the Federal-State supervisor to conduct experimental work for reducing the frequency of inspection of the washing solution reservoir, inspection by the USDA grader for cleanliness and continued conformance with the proposed SOP will be established at the levels outlined below to collect information.

   a. Initially, the USDA grader will confirm the cleanliness of washing solution reservoir while conducting the daily pre-operative inspection of the facility and equipment. Results of the inspection of the reservoir during the evaluation period(s) will be documented on the Form PY-74. When observing the completion of a satisfactory history of conformance with the company's proposed performance-based program for ten consecutive days of processing eggs, the Federal-State supervisor may authorize reducing the frequency of inspection of the washing solution reservoir to weekly USDA inspection.

      Information regarding the authorization to conduct experimental work, the company's performance-based program with the records for documentation, and the current level of evaluation/authorization to reduce the frequency of inspection of the washing solution reservoir shall be maintained in File Folder 2, for access by the relief grader.

      If unacceptable results are observed during the initial level of evaluation or the SOP described is not being followed, the company's experimental work has failed and will be terminated. Any requests to re-establish the experimental work will require plant management to submit to the Federal-State supervisor in writing substantive changes to the performance-based program or the defined SOP, as applicable.

   b. At an acceptable weekly level of inspection, the USDA grader shall verify cleanliness of the reservoir on a weekly basis. The USDA grader will review daily the records completed by plant personnel regarding the SOP defined in the performance-based program, the daily cleaning regimen defined for the washing solution reservoir, and documented results of the company's daily inspection of the equipment meet or exceed the minimum criteria stated in the company's procedures demonstrating continued compliance.

      Plant management may submit a request for approval to reduce the frequency of inspection of the reservoir to a monthly level upon establishing a satisfactory history of cleaning through eight consecutive weeks of processing.

If unacceptable results or other deficiencies are observed during the evaluation period, follow the guidance described in 3.a, above.

c. At an acceptable monthly level of inspection, the grader shall verify cleanliness of the reservoir on a monthly basis and continue to review daily records for the performance-based program generated by company personnel as stated in item 3.b, above. If a deficiency in the program or inspection records presents a recurring problem, the USDA grader will terminate the approval and contact their immediate supervisor for guidance.

Please Note: Reducing the frequency of inspection of the reservoir beyond a monthly level is not permitted.

4. In certain geographical locations, water with an elevated alkalinity level may cause mineral deposits on exposed components within the egg washer. The daily cleaning regimen to remove soil may not be sufficient to completely remove these deposits. In official plants encountering a deposit of minerals on the egg washing equipment, the SOP must include an intensified program to remove these deposits. The degree of these conditions may require additional visual inspections of the reservoir by the USDA grader limiting the length of the period approved for a reduced frequency of inspection of the washing solution reservoir.

Failure of the company to comply with an USDA-accepted performance-based program to reduce the frequency of inspection of the washing solution reservoir, including recordkeeping elements, will result in termination of the USDA authorization to utilize the approved alternate inspection frequency.

C. Heat Exchanger

Installation of a heat exchanger(s) to maintain the washing solution temperature may be approved, subject to evaluation of construction materials and the ability to clean the equipment. The heat exchanger must be designed of material that is cleanable and will not corrode under the conditions of the intended use.

The washing solution contact surfaces must be properly cleaned and maintained in a sanitary condition. The heat exchanger must be designed to allow daily visual inspection of the interior washing solution contact surfaces. Inspection can be accomplished by removing the end caps or pipes connected to each end of heat exchanger housing and shining a bright light into the tubes. The interior of the tubes should be reasonably clean and free from evident foreign material.

Recognizing daily disassembly of the exchanger may be a burden for pre-operative inspection of equipment, plant management may request authorization for a reduced frequency of disassembly for inspection. The Federal-State supervisor and grader shall review the following information relative to equipment design, and disassembly for inspection of each unit when plant management proposes the

installation of a heat exchanger unit(s) as a component of the egg washing system.

1. Evaluate the materials used in the construction of the heat exchanger unit.

2. Determine that the installation design provides reasonable access for disassembly of the heat exchanger for inspection.

3. Daily inspection is required unless plant management requests an alternate inspection frequency.

Upon establishing a daily history that the cleaning procedures for the exchanger are acceptable, plant management may request authorization for a reduced frequency of inspection progressing from daily to a weekly, monthly and quarterly level when sanitation remains acceptable.

4. The following guidelines are provided to evaluate the request for reduced disassembly of the heat exchanger.

   a. Plant management shall provide a written description of the cleaning regimen including identity of cleaning compound(s), concentration of cleaning compounds in solution, and recirculation time throughout system.

   b. Plant management shall develop a daily log to documenting consistent application of the cleaning regimen verified by plant employee's initials on the log.

   c. When sanitary conditions are acceptable upon inspection, plant management may elect to progress to the next level for establishing a reduced frequency of disassembly for inspection of the unit. Extending the frequency beyond the quarterly level will require approval from the Regional Office.

Failure of plant management to maintain the daily log or sanitary condition of the unit will result in termination of authorization to employ a reduced frequency of disassembly for inspection of the heat exchanger. The grader will maintain a record of the frequency of disassembly of the heat exchanger in file folder 2, as information available for relief graders.

D. Egg Oiler

Ideally, the equipment should dispense the oil through sprayers, brushes, foam discs, etc. Other materials used to protect eggs, such as an oil saturated cloth, paper towel, or other devices that drip oil on to a belt, are questionable methods and must be evaluated by the supervisor and grader. These methods are to be approved only if the criterion is met to apply oil in order to cover the entire egg surface is met.

If a pressurized spraying system is used to apply the oil, the grader is to determine that the unit is functioning properly by inserting a piece of stiff paper or cardboard (test material) into the spray area for the approximate amount of time an egg would be exposed. This can be done through a side access panel or by laying the test material on the conveyor and allowing the material to pass under the sprayer

at normal operating speeds. The test material can then be examined for uniform dispersal of the oil. Eggs washed in a plant after an initial shell protecting must be shell protected again after washing in order to be so described.

When the system is not in use, the oil reservoir and any portion of the delivery system (pipes, flexible hoses, etc.) must be either drained of oil or protected to prevent cross contamination. For example: Ensuring closure of pipes, flexible hoses, or the oil reservoir.

E. Water Potability Certification

1. A satisfactory water potability certification is required of each resident and temporary plant to determine that all water used in the egg cleaning process is potable. Certification will be required annually for plants utilizing water from municipal supplies and semiannually for plants utilizing well water, including wells with chlorinators. A new sample must be submitted whenever the water source is changed or when equipment is added to treat the water system. Management is responsible to provide the concentration level of the approved sanitizing compound used, the frequency of monitoring each chlorinator, and maintain records to verify conformance.

2. Laboratories providing water potability certification must be authorized by either State or local authorities. Plants must obtain and provide the grader with a letter from the laboratory listing the appropriate authorizing agency under which certification is made or, alternatively, the authorization can be noted on the laboratory report.

3. Certificates of water potability must declare that the plant's water supply is potable, safe for drinking, or otherwise acceptable in this regard. Also acceptable are analyses certifying that the plant's water supply contains less than one colony forming unit (CFU) of coliform bacteria per 100 milliliters of water. Any water analyses showing results, either microbiological or chemical which the grader cannot interpret as satisfactory, is to be referred to the Federal-State supervisor and, if necessary, to the regional office to determine acceptability.

4. Graders or Federal-State supervisors, as applicable, are required to notify plant management when the water analysis is needed. Plant management must notify the grader of their intent to collect the water sample. Plant management or a state representative will draw the water sample (The grader will observe the collection of the sample) using sterile sample containers and the following aseptic sampling techniques:

The grader will observe the collected water sample is sealed and labeled to maintain sample integrity. The water sample must be stored under refrigeration (38°F - 40°F) if it is to be held for longer than 8 hours prior to shipment. **Do not freeze samples.** Samples will be submitted by the applicant at company expense to a State or locally approved certifying laboratory. Plant management is to provide graders or Federal-State supervisors copies of each laboratory report of water analysis within 10 working days from the date the sample was taken.

The Regional Director is to be notified when reports are not received within the specified time frame. Upon notification of an unacceptable water analysis, the grader will notify the Federal-State supervisor who will, in turn, notify the Regional Director. The Regional Director, or their designee, will advise plant management of the water potability requirements and that, if the resample is found unacceptable, a recommendation to suspend certification of shielded product will be forwarded to the Director, Poultry Grading Division. The grader is to notify the Federal-State supervisor when corrections cannot be made within 10 working days from the date the results were received.

Plant management is expected to rectify the problem and have the water source retested as soon as possible, not to exceed 5 working days from the date correction(s) is made. Corrective action may include, but not be limited to, the addition of chlorinators, water treatment systems, or changing the source of water. If the resample results are unsatisfactory, the Regional Director is to notify the Director, Poultry Grading Division, and provide a summary of the plant's current and past sampling history.

To assure that water samples are submitted at the required intervals, graders are required to document water potability certifications on the Water Potability and Iron Certification Log (Exhibit IV). The log is to be filed in folder "19" in the grader's official files of each resident and temporary plant. During each supervisory visit, Federal-State supervisors are to review the log to assure compliance with these guidelines.

A copy of a current water potability report is to be sent to the National Office attached to the final Plant Survey for Shell Egg Grading, Form PY-158. Additionally, a copy of the initial report is to be provided to the grader and filed accordingly. For subsequent reports, the applicant is to provide the original copy to the grader for filing in folder "19" in the grader's official files. The water potability reports are to be disposed of 2 years after the close of the fiscal year in which they were created.

In resident plants where water treatment systems are used, the grader is to verify weekly, as a minimum, that the system is operating and that a measurable amount of potable water treatment compounds, such as chlorine or quaternary ammonia, is being added. For temporary plants, the frequency of verifying treatment systems will be determined by the Federal-State supervisor. Plant management must provide the grader or Federal-State supervisor with a test kit designed to monitor low levels of the applicable potable water treatment compound.

Chlorine, or its equivalent, must not exceed concentrations above 4 parts per million (p/m) calculated as available active chlorine, in accordance with the EPA Safe Drinking Water Standards. Concentration amounts exceeding this level are to be reported to the applicant for correction.

F. Iron Content Analysis

1. Water with iron content in excess of 2 p/m is not to be used. If the iron content is in excess of 2 p/m, it must be de-ironized continuously. A laboratory test to determine the presence of iron in the water used is required. Water samples are to be drawn in the same manner as for potability. The sample will be submitted by the applicant at company expense to any State, commercial, municipal, university, or other laboratory.

2. The water sample size and type of sampling container submitted for iron analysis is dependent on the laboratory performing the analysis. The water sample may be used by the laboratory for both potability and iron analysis. The iron content analysis may also be shown on the potability report in lieu of a separate report.

3. Initial iron content reports shall be required for all new plants. Thereafter, annual reports will be required for all plants utilizing water from municipal supplies and semiannually for plants utilizing well water. A new sample shall be submitted any time the water source is changed. Graders are required to document the results of iron content analysis on the Water Potability and Iron Certification Log (Exhibit II). Graders are to contact a supervisor for guidance immediately upon receipt of an unsatisfactory report.

4. A copy of the initial iron content report is to be sent to the National Office attached to the final shell egg facility survey form. Copies of the initial report will also be provided to the grader and applicant. For subsequent reports, the original copy is to be filed by the grader with a copy to the applicant.

5. Analysis of the iron content of the water supply will be stated in either parts per million (p/m), milligrams per liter/gram (mg/l or mg/g), or microgram per liter (µg/l). When water analysis is reported in terms other than p/m, determine iron content level as follows:

   a. Analysis reported in milligrams per liter is equivalent to parts per million. For example, iron content of 1 mg/l converts to 1 p/m.

   b. Analysis reported in either milligrams per gram can be converted into parts per million by multiplying the reported number by one thousand. For example, iron content of .001 mg/g multiplied by 1000 converts to 1 p/m.

   c. Analysis reported in microgram per liter can be converted in parts per million by dividing the reported number by one thousand. For example, iron content of 1780 µg/l divided by 1000 converts to 1.78 p/m.

G. Shell Egg Sanitizing

1. All eggs are to be spray rinsed after washing with water having a temperature equal to, or warmer than, the temperature of the wash water and containing an approved sanitizing compound.

2. A clear water rinse is required after sanitizing with iodine.

3. Sanitizers shall maintain an effective concentration level of 100 to 200 maximum p/m of available chlorine or its equivalent. Iodine compounds shall

maintain concentration levels between 12.50 to 25 p/m of titratable iodine. The titration method is to be used two times per shift, per machine, to test the sanitizing solution. It is permissible to use litmus test strips at other times during the shift for informational purposes. Storage of titration kits and litmus test strips shall follow the manufacturer's guidelines to assure accuracy.

Protective equipment provided by plant management including, general purpose gloves and safety glasses are to be used by shell egg graders when monitoring the concentration of shell egg sanitizing solutions. Alternatively, plant employees may be trained to perform the testing under the direct supervision of the grader. The results are to be documented on the grader's worksheets, as applicable.

When test results indicate (company or USDA tests) that the minimum concentration level is not acceptable, plant management must take immediate corrective action. Failure to restore a minimum concentration level within 15 minutes will result in removal of official certification on product being packaged.

It is the responsibility of plant management to maintain sanitizing equipment in operating condition at all times. This may necessitate keeping an inventory of spare parts available to assure compliance with this requirement.

4. Quaternary ammonium compounds, when approved for the intended use, may be applied to eggs as a disinfectant/sanitizer for the surface of the shell. The concentration level applied must provide the equivalent of 100 to 200 p/m active chlorine. The test kit provided must be specific in determining the concentration level of the quaternary ammonium compound used (refer to the manufacturer's instructions). The manufacturer/distributor can assist plant management in providing appropriate concentration equivalent tables.

H. Ultra-Violet Light for Disinfecting Shell Eggs

1. Each shell egg processor electing to install the UV disinfection system is responsible for providing technical information and certification (letter of guarantee from the manufacturer) stating that the low pressure mercury lamp bulb used provides 90 percent emissions at a wavelength of 253.7 nanometers (2,537 angstroms equivalent). Proper disposal of the low pressure mercury lamp bulbs in accordance with applicable environmental laws is the responsibility of each processor utilizing UV irradiation.

2. The UV lamp bulb must be replaced based upon the recommended expected duration of function (life expectancy) stated in the manufacturer's specifications. Each processor must maintain a maintenance log for the UV disinfection system identifying the rotation of the UV lamp bulbs. In the event of a UV lamp bulb failure prior to reaching the recommended duration period, to prevent replacement of each bulb in the system at the end of the established

duration period, a processor may elect to maintain the dates of installation of each bulb in the UV disinfection system by recording the recommended life expectancy of each lamp bulb. The maintenance records for the UV disinfection system will be subject to review upon request from a USDA representative.

3. Only UV lamp bulbs coated to prevent potential contamination in the event of breakage of the low pressure mercury lamp may be used in the disinfection system.

4. To prevent optical damage to personnel working in plants utilizing the UV disinfection system, the safety procedures incorporated by the company requiring the unit be locked down in operating position prior to function must be maintained at all times. Any malfunction of these incorporated safety measures must be addressed immediately by the egg processor or use of the UV disinfection system in the official plant will be discontinued.

5. Recognizing that the UV emissions area is directly exposed to the product, the sanitation of the disinfection unit (both interior and exterior) must be maintained in an acceptable condition and is subject to preoperative inspection by the USDA grader assigned to the egg processing plant.

6. When used as an alternate for the application of a chemical sanitizer solution, the UV disinfection system must be installed downstream from the wash and rinse cycle chamber on the egg grading and packaging system. Additionally, the eggs must be reasonably dry when entering the UV disinfection system. Shell eggs treated with UV radiation as stated in the applicable FDA regulation and these provisions are eligible to be identified with the USDA grademark.

I. Ozone Use as an Antimicrobial Agent

1. **Application as a shell egg sanitizing agent** – Ozone, in an aqueous solution (ozone and water), must be maintained at a level ranging from 0.50 parts per million to a maximum level of 2.00 parts per million. The processor is responsible for providing a titration test kit to determine the equivalence with the required concentration of available active chlorine (100 to 200 parts per million) authorized for use to sanitize shell eggs. Residual aqueous solution of ozone and water may be recovered to the egg washer solution reservoir.

2. **Application to treat water for processing food** – when used as an antimicrobial agent to disinfect water in accordance with the National Safe Drinking Water (NSDW) Act, promulgated by the Environmental Protection Agency (EPA), the amount of ozone applied to the water system is dependent upon whether the source:

   a. Contains surface or previously treated water

   b. If filtered prior to disinfection

c. Any evidence of fecal contamination

Recognizing that the State retains discretionary authority to require modified monitoring, analytical, performance, reporting, and recordkeeping requirements, the USDA grader will rely on guidance issued to plant management by State authorities for the use of ozone to disinfect water for the processing of shell eggs.

When an ozone treatment system is located in an official egg processing facility, plant management will provide access, upon request of a USDA representative, to the State-accepted ozone disinfection procedures, and the monitoring and recorded data to demonstrate continued conformance. Records for the ozone treatment system must be retained by plant management as required by the applicable EPA regulations.

Observation of failure by plant management to comply with the required State procedures for use of ozone to disinfect water will require the USDA grader to contact the responsible Federal-State supervisor. The Federal-State supervisor will immediately contact the Regional Office and the National Office staff for guidance.

3. **Safety -** The USDA grader will observe plant personnel monitoring the concentration level of ozone in aqueous solution (injected into potable water) when used as a sanitizing agent. The concentration level will be monitored at the USDA frequency required for a shell egg sanitizing solution.

Ozone can cause extensive damage when in direct contact with human tissue. Therefore, plant management shall be responsible for collecting samples of the ozone solution to determine the concentration level to be applied as a sanitizing solution. The processor is responsible for compliance with applicable safety requirements, and installation design and handling practices as specified by OSHA and State regulations.

VI. Approval of Compounds

Only approved cleaning and sanitizing compounds may be used in official resident or temporary plants. To assure that only approved compounds are used for the purpose intended, plant management must provide the grader or Federal-State supervisor, as applicable, with a written guaranty stating that each compound used in the shell egg processing plant complies with Federal food laws and regulations, and can be legally used in the shell egg processing plant for the purpose intended. Responsibility for providing Letter of Guarantees rests with the firm whose name appears on the product as it is marketed to the plant. Letter of Guarantees must contain the following information:

A. Name and address of the manufacturer of the compound

B. Brand name or other means by which the compound is identified

C. Intended use of the compound; (specific application for shell eggs)

D. Statement that the compound complies with either:

1. The Federal Food, Drug, and Cosmetic Act;

2. Federal Insecticide, Fungicide, and Rodenticide Act;

3. The requirements of 21 CFR 110.35 (b) Substances Used in Cleaning and Sanitizing; Current Good Manufacturing Practice in Manufacturing, Packing, or Holding Human Food; or

E. Statement that, if used according to the instructions, the compound will have no adverse effect on the eggs being processed; and

F. Signature of an official representing the manufacturer of the compound.

As an option, plant management can provide the chemical manufacturer a copy of the Notice of Guarantee for Approval of Compounds (Exhibit III) to assist them in meeting the requirements. The reverse side of the notice list the common categories of compounds used in shell egg plants. In addition to the guaranties, the Material Safety Data Sheet (MSDS) for each compound used in the plant must be made available for review by the grader and/or supervisor. The grader or supervisor retains the authority to refuse specific compounds that they determine unsafe or may cause product adulteration.

Once approved, graders are required to document each compound being used on the Chemical Compound Log (Exhibit IV). The log and letters of guarantees are to be filed together in folder "2" of the graders' official files. Graders will periodically review the compounds used at their location to assure the log is current and accurate. During routine plant visits, supervisors are to review the chemical compound approval process to assure that the procedures outlined in this policy are being applied.

As an option, plant management may provide proof of official approval of a nonfood compound by accessing the National Sanitation Foundation (NSF) through the Internet at www.nsf.org. A printed copy of the product listing for each nonfood compound must be provided to the grader and is to be entered on the Chemical Compound Log.

When a USDA representative identifies that a nonfood compound is not approved for use for cleaning, de-staining, sanitizing, coating, marking shell eggs or treating water (water softener, chlorinators and boilers), and equipment lubricants used on indirect contact areas plant management shall be notified. If an unapproved nonfood compound is being used, all eggs identified with the USDA grademark exposed to the compound must be retained. Plant management must issue an immediate recall of any officially identified eggs shipped that were exposed to an unapproved nonfood compound.

When plant management continues to process and distribute non-officially identified eggs using the identified nonfood compound and/or product has been shipped, the grader will contact their immediate

supervisor.

The Federal-State supervisor shall prepare the Interagency Referral Report for transmission to the National Office. Additionally, the supervisor shall contact the District Office of the Food and Drug Administration to notify that agency of the risk of contamination of the eggs distributed in commerce. If plant management requests to remove the unapproved nonfood compound to continue processing eggs identified with the USDA grademark, the exposed equipment shall be cleaned prior to resuming operations.

VII. Plant Sanitation

Basic to all operations in food plants required by both the shell egg regulations and the Food and Drug Administration is the requirement that all processing be conducted so that the product will not be adversely affected, especially with respect to wholesomeness.

A. Responsibility for Plant Sanitation

Plant management, in both resident and temporary plants, is responsible for producing shell eggs under sanitary conditions. It is plant management's responsibility to assure that processing equipment and rooms are thoroughly cleaned each day and maintained in a sanitary condition during each operating shift. All buildings, rooms, premises, and other facilities shall be sanitarily maintained and in good repair.

Please Note: This requirement applies whether the plant is processing and packaging eggs identified with the USDA grademark or not.

Additional guidelines specific to temporary plants can be found in R-3, Records, in the Supervisors/Resident Graders General Index.

B. Sanitation Inspection Standards

Graders must be thoroughly familiar with the standards of sanitation and cleaning frequencies prescribed in the regulations, continually monitor product handling and general condition of equipment, and housekeeping throughout the facility, i.e. (floors, trash removal, etc.), to assure that acceptable sanitation is maintained, and identify sanitation problems requiring corrective action. Graders must be familiar with the normal operating problems and related unsanitary conditions typically associated with processing shell eggs in order to establish priorities for initiating corrective action. Graders must make well-reasoned decisions in obtaining correction of unsanitary conditions by taking into consideration the significance of the problem and the need for immediate action. The sanitation terms "critical," "noncritical," and "reasonably clean" are to be used when evaluating a plant's sanitation program as defined below:

4. Critical Sanitation Problems - Critical noncompliance conditions involve sanitation deficiencies that, if allowed to continue, present a high risk or will result in a detrimental effect to the product through direct contact or exposure with the unsanitary equipment or condition. Generally, any equipment downstream of the egg washer (wash and rinse cycle) with direct surface

contact with eggs is classified "critical". Critical sanitation issues that cannot be corrected prior to the start of operations due to the complexity of repair required must be corrected within 24 hours. If a facility will not be able to correct a critical area within 24 hours, plant management will contact the Federal-State supervisor for approval of an alternative timeframe

5. Noncritical Sanitation Problems - Noncritical conditions are sanitation deficiencies that are not likely to materially affect product quality but, when allowed to continue or combined with other noncritical conditions, may result in diminished product quality. These conditions do not normally require that certification of product be withheld but should be cleaned within a reasonable period of time. When the grader and plant management cannot reconcile a timeframe the grader will defer the issue to the Federal-State supervisor.

6. Reasonably Clean - The term "reasonably clean" is used in the regulations to describe conditions when less than complete cleaning is necessary or possible. By definition, this term means a state of cleanliness which will not obviously create a contamination hazard or visibly soil the product. For example: Grading and packing rooms should be thoroughly clean before the start of operations and kept reasonably clean during operations. Likewise, certain candling, weighing, and packing equipment cannot be wet cleaned. In such cases, this equipment is kept reasonably clean using brushes, scrapers, and compressed air, etc. The buildup of egg or the presence of visible mold growth would be unacceptable because a contamination hazard obviously exists. Sanitation deficiencies exceeding the standard of "reasonably clean" shall be handled as critical or noncritical depending on the conditions involved.

C. Pre-Operative Sanitation Inspections

Pre-operative inspections of equipment and facilities are to be completed at all official plants, resident and temporary, regardless of the type of grading performed. Graders will be responsible for conducting these pre-operative inspections prior to the startup of operations. For resident plants, pre-operative inspections are to be conducted on a daily basis and for temporary plants, conducted each day of official grading activity. Grading activities at temporary plants should be scheduled so that the pre-operative inspection can be completed prior to startup of operations. If scheduling cannot be adjusted accordingly, the temporary plant has the option to proceed with processing and, prior to official grading, cease processing, change the wash water, and complete a thorough cleaning of all critical items listed on the Form PY-74, Pre-Operative Shell Egg Sanitation Report (Exhibit V). After cleaning, the grader will conduct an inspection and determine if the equipment meets established sanitation requirements.

The time allotted for pre-operative inspections is to be determined by the Federal-State supervisor based on the condition of the plant, the number of processing machines, and the plant's sanitation history. As a guideline, 15 to 30 minutes prior to start-up should be appropriate. Upon approval by the Regional Director, additional time may be authorized when it is deemed necessary to assure sanitation compliance. Regardless of the time allotted, plants are to be billed for this additional time unless the grader's tour of duty can be adjusted to include the pre-operative inspection. When

conducting pre-operative inspections always start with the critical areas and as such the cleanest areas to minimize contamination first before inspecting the non-critical areas the following inspection sequence is suggested:

1. Washer compartments, nozzles, and brushes
2. Packing and packaging equipment
3. Mass scanning equipment, scales, and processed egg conveyers
4. Egg oiling equipment (if applicable)
5. Egg drying equipment
6. Pre-wash loaders, conveyers, and orientors
7. Processing rooms
8. Coolers and storage areas
9. Outside premises and refuse handling areas

Results of each pre-operative inspection are to be recorded on Form PY-74. All sanitation deficiencies are to be documented in the "Remarks" section of the form. List each specific deficiency, the management official contacted, the corrective action taken, and the time the action was taken. Items identified as noncritical on the Form PY-74 may be re-classified by the grader as critical when unsatisfactory conditions are of such magnitude as to constitute a serious health hazard or as a result of gross negligence. Graders are to discuss all non-compliances with the designated management official and request that they acknowledge the discussion by initialing the form. If the designated official refuses to initial the form, the grader is to document the individual's name on the form. Sanitation problems occurring during the production shift must be recorded when they are observed.

When a deficiency is a non-critical item that requires a significant amount of time to properly repair or completely correct but action has been taken to assure general sanitary conditions are maintained, the minimum corrective action and projected completion timeframe stated by plant management shall be recorded. When the corrective action is completed return to the initial documentation on the Form PY-74 to record closure of the non-conformance items.

Alternatively, a reference on the current Form PY-74 and corrective action can serve as appropriate documentation. In the event that plant management cannot complete the corrective action in accordance with the established timeframe, contact the immediate supervisor for guidance. Exhibits VI and VII explain the proper way to document sanitation deficiencies on the Form PY-74.

Please Note: If a specific, detailed sanitation violation occurs in the same location (the same item listed on the Form PY-74) for three consecutive days and presents a risk of cross contamination to the eggs, the violations must be documented and reported to the supervisor, who will report the violation through FDA's Interagency Referral Report worksheet (refer to Section 03, Exhibit III).

The following is an example of documentation for a detailed recurring violation:

Monday – Adhering material (Fecal) observed on product contact surface area of Packer Head # 5, clamshells. (Disposition - Plant management (Susan Manager) corrected the affected area prior to start up).

Tuesday – Adhering material (Fecal) observed on product contact surface area of Packer Head #5, clamshells. (Disposition - Plant management (Susan Manager) corrected the affected area prior to start up).

Wednesday – Adhering material (Fecal) observed on product contact surface area of Packer Head #5, clamshells. (Disposition - Plant management (Susan Manager) corrected the affected area prior to start up).

Observation of the violation on the third consecutive day is justification for reporting the sanitation violation through supervisory channels. The shell egg grader must advise plant management of the necessity for issuing the report. Documentation on official sanitation reports (description of detailed violation and name of plant management notified) must support this action.

A minimum of twice per year, Federal-State supervisors should accompany graders on pre-operative inspections to determine the thoroughness of the inspection and assure uniformity in applying inspection criteria. Additionally, supervisors are to review all sanitation reports completed since the previous visit to assess the plants overall sanitation compliance and determine if any additional action is needed. Plants with a continuous history of sanitation non-compliances are to be referred to the Regional Director who will consult with the Director, Poultry Grading Division, to determine any additional actions in accordance with the regulation.

10. Distribution

The Form PY-74 is to be distributed as follows:

a. Original copy in folder "4c" of the grader's official file

b. One copy to plant management (optional as approved)

c. One copy to appropriate supervisor (optional)

D. Packaging Material Storage Areas

All primary packaging material that comes into direct contact with the egg must be maintained in a sanitary condition at all times. Packaging must be kept off the floor and wrapped/covered to maintain sanitary conditions until it is prepared for immediate use.

E. Sanitation and Ambient Refrigeration of Transport Vehicles

Sanitation and ambient refrigeration of transport vehicles not covered by specifications are the

responsibility of the shipper. USDA graders are not responsible for certifying to the cleanliness or good repair of shipping vehicles unless required by a specification or export instruction. However, if during the course of the daily duties, improper or unsanitary conditions, or the loading of eggs on transport trailers without a refrigeration unit are observed in shipping vehicles, the grader should notify a responsible plant official. The grader should then document the situation including the name of the plant official notified on their worksheet for that day. No further action is warranted by USDA.

VIII. Cooling Facility Requirements

Coolers in all official plants, including temporary plants, used for processed eggs must be capable of maintaining an ambient air temperature of 45° Fahrenheit or lower. Since this is a facility requirement, it is applicable to all processed egg coolers, not just coolers storing officially graded eggs.

A. Cooler Verification

When checking cooler temperatures, graders may use the thermometers provided and placed in the coolers by the applicant. These thermometers should be placed in areas where product is stored but not in front of doorways or refrigeration units. If multiple thermometers are available, the temperature is to be reported as an average. For resident and temporary plants, temperatures for each cooler are to be checked twice (approximately every 4 to 5 hours) during the production shift and recorded on the reverse of Form PY-75.

During periods of product loading or unloading, the cooler temperature may increase to 50° Fahrenheit provided the temperature is not above 45° Fahrenheit for more than 4 hours. Graders are to advise plant management each time cooler temperatures exceed these criteria. Coolers not in use during seasonal periods or coolers where it is apparent that there is no intention to store eggs are not to be checked or reported as non-complying.

When the cooler temperature exceeds 45˚Fahrenheit, the grader must notify plant management to take corrective action. If the ambient temperature is not being reduced effectively to the 45˚Fahrenheit level within 2 hours of notification, plant management must implement procedures to transfer the shell eggs to a compliant refrigerated storage area. Repeated cooler temperature non-compliances with no apparent corrective action by plant management are to be reported to the Federal-State supervisor.

B. Thermometer Certification

The accuracy of the plant's cooler thermometer needs to be verified by as follows:

1. Certified Test Thermometer –These certifications are good for one year. When the certification period expires or the thermometer becomes damaged, the Federal-State supervisor is to order a new certified test thermometer. The old thermometer can no longer be used and since it does not contain mercury can be discarded in any trash receptacle.

2. Digital Thermometer– The accuracy of each digital thermometer is to be verified by the Federal-State supervisor or assigned representative at least annually. This is to be accomplished by comparing the temperature readings of the digital

thermometer, coupled with the immersion probe**,** with a certified test thermometer. A certified digital thermometer can be used to verify the accuracy of another digital thermometer.

To verify accuracy, collect a test medium from tap water. While agitating the water, read both thermometers for comparison. If there is more than a 1ºF difference, the Federal-State supervisor is to request a new digital thermometer thru the regional office. If the temperature of the digital thermometer is within 1°F of the test thermometer, the digital thermometer is considered accurate. After each verification test, the results are to be documented on Form PY-227, Employee's Performance Record, or other forms of documentation approved by the Regional Director.

3. Grader's Pocket Thermometer – The accuracy of the grader's metal stem pocket thermometer (including any back-up thermometers) is to be verified by the Federal-State supervisor or assigned representative on a semi-annual basis. This is to be accomplished by collecting a test medium from tap water. With continuous agitation, place the digital thermometer and the pocket thermometer in the center of the water bath. After the temperature of both thermometers has stabilized, read and compare the temperatures to assure that they are within 2°Fahrenheit of each other.

   If there is more than a 2°Fahrenheit difference, the pocket thermometer must be adjusted or replaced. In either case, the thermometer must be re-tested for accuracy. After each verification test, the results are to be recorded on the Form PY-227 or other forms approved by the Regional Director.

During periods between the semi-annual verification when the grader suspects that the pocket thermometer is not accurate or they have been provided a new thermometer which has not been certified as accurate, they are to use the following method:

Prepare an ice water bath (mixture of ice and water). With continuous agitation, immerse the pocket thermometer in the center of the water bath. After the thermometer temperature has stabilized, the temperature reading should be between 31°Fahrenheit and 33°Fahrenheit. If the temperature is out of the accepted range, the thermometer cannot be used and must be adjusted or replaced.

After the test has been performed, the results are to be recorded on the Form PY-75. During the next supervisory visit, graders are to request supervisors to formally re-test the pocket thermometer as outlined in item 3. If the temperatures are within 1º Fahrenheit of each other, the pocket thermometer is considered accurate.

C. Refrigeration of Product

The Regulations Governing the Voluntary Grading of Shell Eggs 7 CFR Part 56.76 F.1 states that "Shell eggs that are to be officially identified as U.S. Grade AA, A, or B shall be placed under refrigeration at an ambient temperature no greater than 45° F (7.2°C) promptly after packaging". This statement means that all processed shell eggs, whether identified with the USDA grademark or not,

must be placed under refrigeration within 4 hours after packaging or at the end of the processing day, whichever comes first. For approved shifts longer than 8 hours, the timeframe may be extended proportionately. Graders can use the time listed on the USDA Sample Sticker as a general guide in determining compliance. Obvious noncompliance with this requirement is to be reported to management and documented on the Form PY-75. When continuous non-compliances are noted, the grader is to review these occurrences with the Federal-State supervisor during the next supervisory visit. The Federal- State supervisor will consult with the Regional Director to determine what future corrective action is to be taken.

To prevent the sweating of shell eggs, packaged product that has been placed in coolers may not be removed from refrigeration except for immediate processing/reprocessing, packaging, shipment, or for USDA use of cooler samples.

IX. Surveillance Responsibilities - Resident, Temporary, and Fee Graders

The Regulations, 7 CFR Part 57 require quarterly visits to all egg handlers (producer/packers, grading stations). In official shell egg plants, the Federal-State supervisor or designated USDA representative will conduct these quality inspections. The Federal-State supervisor may request assistance as follows:

A. Resident graders may assist the supervisor or their assistants in carrying out the quarterly shell egg surveillance inspections required by the EPIA. Copies of the quarterly surveillance reports, Form PY-156, prepared jointly by the supervisor and grader, are to be filed in folder "21" in the grader's official files. In instances where a violation requires submission of a copy of the Form PY-156 to the Regional Office, the supervisor is to make a machine copy for his file.

B. Graders may also assist the supervisor in the releasing of product retained during quarterly surveillance visits. When observing the reworking and releasing of retained product or when retained product is transferred from the point of retention and released to an egg products plant or other egg handler, graders are to follow the guidelines for handling retained product outlined in Sections 7 and 8 of this handbook.

C. All graders are responsible to assure that labeling of restricted eggs (checks, dirties, and spots) is correct and applied at point and time of segregation. The EPIA requires that eggs classed as "restricted eggs" (dirties, checks, leakers, loss, inedible) be labeled with required information as outlined below:

1. Shipping containers of restricted eggs must bear the packer's name, address, and zip code, or a corporate name and address and other egg packer identification codes approved by the National Office, and the type of restricted eggs in the container (e.g., dirties, checks, inedible, or loss); and

a. For Checks and Dirties: "Restricted Eggs-- For Processing Only in an Official USDA Egg Products Plant."

b. For Inedible and Loss Eggs in Shell Form: "Restricted Eggs-- Not to be used as Human Food."

2. The required wording on the label must be conspicuous and legible. The name, address, and zip code of the packer need not appear on the label if it appears elsewhere on the container. See Exhibit VIII for examples on the labeling of restricted eggs.

D. All graders are to assure that inedible eggs and egg products are handled according to accepted procedures, denatured when applicable, properly labeled, etc.

1 . Labeling - The EPIA requires that all inedible, unwholesome, or adulterated egg products be labeled with certain required information. The collection containers of inedible egg products at the point and time of segregation need only be labeled with the word, "Inedible" unless they are used as the final shipping container. In this case, the containers shall be legibly identified as, "Inedible Egg Product-- Not to be used as Human Food."

Note: The name, address, and zip code of the packer or distributor must appear on the label or container (See Exhibit VIII). Alternate procedures for labeling inedible collection containers may be authorized by the Federal-State supervisor.

2. Denaturing - Containers of liquid egg products need not be denatured or decharacterized at the point and time of segregation unless they are used as the final shipping container. Sufficient denaturant must be used to make it readily evident, either visually or by odor, that the eggs or egg product is unfit for human consumption.

Proper mixing of denaturant cannot be accomplished by adding the color powder to the top of the barrel of egg. To properly denature/de-characterize inedible egg in a barrel product should be added in liquid form, in stages, as the container is filled.

Inedible shell eggs must be denatured or de-characterized at the point and time of segregation. Inedible and loss eggs that are to be transported in the shell form from the point of segregation must be decharacterized or denatured by coloring the shells with a sufficient amount of Food, Drug, and Cosmetic (FD&C) dye to give a distinct change of appearance or by applying a substance that will penetrate the shell and de-characterize the egg meat.

a. Satisfactory Denaturants for Shell Eggs
   (1) FD&C black, blue, green, or red dyes
   *(2) Aromatic cedar, eucalyptus, pine oil, fish oil or wintergreen

b. Satisfactory Denaturants for Liquid Eggs Only
   *(1) Caramel, brown, black, blue, or green dyes

*(2) Meat and Fish by-products (non-deodorized)
*(3) Ground grain and milling by-products
*(4) Beet meat and pulp
*(5) Fish oil, aromatic, cedar, eucalyptus, pine oil, or wintergreen

c. Other Denaturants

* Requests to use denaturants, other than those listed, which will distinctively render the shell eggs or egg products because of appearance or odor, as unfit for human consumption, may be submitted to the National Office for comment and/or approval.

E. Generally, resident or temporary personnel will be primarily occupied with checking officially identified product to assure that it is in compliance with the marked grade.

Occasionally, management will request the grader to check non-identified product for quality control purposes. Additionally, resident, temporary, and fee graders are often requested to sample and grade stationary lots of eggs that have not previously been officially identified. Under any of these circumstances, if the grading shows the lot, or a portion of the lot, to exceed the restricted egg tolerances (based on a full size sample) for U.S. Grade B, the grader is required to place the product under retention until it is brought into compliance with the Act. Prior to conducting these types of gradings, the grader shall advise management of these responsibilities and the applicable tolerances that will be applied.

During the grading process, graders are to immediately notify plant management when U. S. Grade B restricted egg tolerances have been exceeded. Under these circumstances, management has the option of discontinuing the grading or continuing sampling up to an official sample size.

1. For stationary lots where a full representative sample has been examined, the entire lot is to be retained. When the grading is prematurely terminated by management, the product representing the samples examined is to be retained using the following criteria:

a. For unitized loads (pallets, racks, etc.), retain all product on the specific unit from which each sample originated. For example, if samples #1 and #2 exceed the tolerances and were selected from pallets one and two of a five pallet lot, pallets one and two are to be retained.

b. For product that has no distinct unitization, segregate the lot proportionately into 30 case sublots and retain only the sublots from which the samples originated. For example: If the original lot consists of 240/15-dozen cases stacked on the floor, the grader, for retention purposes, would consider the lot to be four, 30 case sublots.

If samples 1 and 2 exceeded EPIA tolerances and were selected from sublots one and two and the grading was terminated, these sublots would be retained. Additionally, when lots are less than 30 cases, the entire lot is to be retained.

Retention procedures and release of retained product is to be handled as outlined in this Section and Section 8 of this handbook. Time and expenses for releasing product at temporary and fee locations is to be handled and accountable under the surveillance program.

X. Shipping of Non-Denatured Inedible Egg Products

The overall responsibility for handling and monitoring the movement of this product to pet food plants, further processing plants, and warehouses is the responsibility of FSIS. Each producer of non-denatured inedible egg product is to be advised of their responsibilities in handling such product.

A. Responsibilities of Plant Management

1. Following approval, management in official USDA plants shall advise the grader or surveillance inspector when they wish to accumulate and ship non-denatured inedible shell eggs or egg products. Non-denatured inedible products may not be accumulated in non-USDA plants or in plants utilizing temporary resident shell egg grading service since USDA cannot continuously monitor and control inedible product located at these locations.

2. Edible and inedible products must be segregated in the official plant and in the shipping vehicle for product control and positive identification. Liquid product to be shipped in bulk must be held in specially designated tanks or vats.

3. When management has been granted permission to ship non-denatured product, each primary container and master or bulk container shall be legibly identified as follows:

   a. Egg products example-"Non-denatured Inedible Egg Products - **NOT TO BE USED FOR HUMAN CONSUMPTION**." Name and address of packer or distributor.

   b. Shell eggs example-"Non-denatured Restricted Eggs - **NOT TO BE USED AS HUMAN FOOD**." Name and address of packer or distributor.

B. Origin Inspector Responsibilities

1. The "balance on hand" figure shall be verified by actual count at least once each week, dated, and initialed by the inspector.

2. When non-denatured inedible egg products or shell eggs are to be shipped from one official plant to another, the inspector must personally seal the shipment and prepare Form PY-210S.

DAY OF THE YEAR CHART

DAY OF MONTH	JAN	FEB	MAR	APR	MAY	JUN	JUL	AUG	SEP	OCT	NOV	DEC
1	1	32	60	91	121	152	182	213	244	274	305	335
2	2	33	61	92	122	153	183	214	245	275	306	336
3	3	34	62	93	123	154	184	215	246	276	307	337
4	4	35	63	94	124	155	185	216	247	277	308	338
5	5	36	64	95	125	156	186	217	248	278	309	339
6	6	37	65	96	126	157	187	218	249	279	310	340
7	7	38	66	97	127	158	188	219	250	280	311	341
8	8	39	67	98	128	159	189	220	251	281	312	342
9	9	40	68	99	129	160	190	221	252	282	313	343
10	10	41	69	100	130	161	191	222	253	283	314	344
11	11	42	70	101	131	162	192	223	254	284	315	345
12	12	43	71	102	132	163	193	224	255	285	316	346
13	13	44	72	103	133	164	194	225	256	286	317	347
14	14	45	73	104	134	165	195	226	257	287	318	348
15	15	46	74	105	135	166	196	227	258	288	319	349
16	16	47	75	106	136	167	197	228	259	289	320	350
17	17	48	76	107	137	168	198	229	260	290	321	351
18	18	49	77	108	138	169	199	230	261	291	322	352
19	19	50	78	109	139	170	200	231	262	292	323	353
20	20	51	79	110	140	171	201	232	263	293	324	354
21	21	52	80	111	141	172	202	233	264	294	325	355
22	22	53	81	112	142	173	203	234	265	295	326	356
23	23	54	82	113	143	174	204	235	266	296	327	357
24	24	55	83	114	144	175	205	236	267	297	328	358
25	25	56	84	115	145	176	206	237	268	298	329	359
26	26	57	85	116	146	177	207	238	269	299	330	360
27	27	58	86	117	147	178	208	239	270	300	331	361
28	28	59	87	118	148	179	209	240	271	301	332	362
29	29		88	119	149	180	210	241	272	302	333	363
30	30		89	120	150	181	211	242	273	303	334	364
31	31		90		151		212	243		304		365

LEAP YEAR -- Advance all dates after February 29th by one day.
Use this chart to determine the consecutive day of the year.

Water Potability and Iron Certification Log

Exhibit II

Plant Name: _____ **Plant Number:**_____

Type of Water Source: ( ) Well ( ) Municipal

Date Sample Due	Date Sample Drawn	Date Sample Sent to Laboratory	Date Results Received	Satisfactory Results Yes/No	Need to Resample Yes/ No	Remarks

Notice of Guarantee
For
Approval of Compounds

To assure that only approved compounds are used for the purpose intended, this notice of guarantee is being provided certifying that the listed compound(s) complies with all applicable Federal Food laws and may be used in official resident or temporary shell egg plants.

1. Name and address of the manufacturer of the compound(s):

_____

_____

_____

2.

Name of Compound	Category Code*	Regulatory Authority Code**
1.		
2.		
3.		
4.		
5.		
6.		

* See reverse for most commonly used category codes.

******Regulatory Authority Codes (list as applicable):

(A) Federal Food, Drug, and Cosmetic Act (cite section of regulations)

(B) Federal Insecticide, Fungicide, and Rodenticide Act

(C) The requirements of 21 CFR 110.35 (b) Substances Used in Cleaning and Sanitizing; Current Good Manufacturing Practice in Manufacturing, Packing, or Handling Human Food

(D) Food Safety and Inspection Service Sanitation Performance Standards Compliance Guide

3. Material Safety Data Sheets (MSDSs) attached ( ) Yes ( ) No

Manufacturer's Certification: I certify that, if the above listed compound(s) are used according the instructions outlined on the label, comply with applicable Federal food regulations and the compound(s) will have no adverse effect on the eggs being processed. I understand that USDA retains the authority to refuse specific compounds that they determine unsafe or may cause product adulteration.

Signature: _____

Title and Date: _____

Category Code Letters

Exhibit III (Reverse)

Code Letters	Conditions For Use
A1, A2 A3, A4	**Cleaning Compounds** Compounds for use as general cleaning agents on all surfaces, or for use with steam or mechanical cleaning devices in all departments. Before using these compounds, food products and packaging materials must be removed from the room or carefully protected. After using these compounds, all surfaces must be thoroughly rinsed with potable water.
D1	**Antimicrobial Compounds** Before using these compounds, food products and packaging materials must be removed from the room or carefully protected. After using these compounds, surfaces must be thoroughly rinsed with potable water before operations are resumed. The compounds must always be used at dilutions and according to applicable directions provided on the EPA registered label.
D2	Before using these compounds, food products and packaging materials must be removed from the room or carefully protected. A potable water rinse is not required following the use of these compounds for sanitizing previously cleaned hard surfaces provided that the surfaces are adequately drained before contact with food.
E1, E2	**Employee Hand Care** The compounds must be dispensed from adequate dispensers located a sufficient distance from the processing lines to prevent accidental product contamination. The hands need not be washed prior to the use of the compounds. After the use of the compounds, the hands must be thoroughly rinsed with potable water.
E3	The compounds must be dispensed from adequate dispensers located a sufficient distance from the processing lines to prevent accidental product contamination. The hands must be washed and thoroughly rinsed prior to sanitizing with the compound. The compound may be injected into the wash and rinse water. The hands need not be rinsed with potable water following the use of the compound.
F1, F2 F3, F4	**Pesticides** The compounds must be used according to applicable instructions provided on the label.
F5	Before using these compounds, all edible products and packaging materials must be removed from the room to be fumigated. After fumigation, the treated equipment and space must be thoroughly aerated to remove all vapors before graders or employees reenter the area. Food contact surfaces must be rinsed with potable water before edible products are returned to the room.

Code Letters	Conditions For Use
G1, G2, G3	**Water Treatment Compounds** Compounds used in such treatment should not remain in the water in concentrations greater than required by good practice.
G7	Compounds for treating boilers, steam lines, and/or cooling systems where neither the treated water nor the steam produced may contact edible products.
H1	**Lubricants** These compounds may be used as a lubricant with incidental food contact. Such compounds may be used on food processing equipment as a protective anti-rust film, as a release agent on gaskets and as a lubricant for machine parts and equipment in locations in which there is potential exposure of the lubricated part to food. The amount used should be the minimum required to accomplish the desired technical effect on the equipment. If used as an anti-rust film, the compounds must be removed from the equipment surface by washing or wiping.
H2	These compounds may be used as a lubricant, release agent, or anti-rust film on equipment and machine parts or in closed systems in locations in which there is no possibility of the lubricant or lubricated part contacting edible products.
Q1	**Compounds For Use On Shell Eggs** Eggs that have been washed with these compounds shall be subjected to a thorough rinse of warm potable water containing as accepted sanitizer.
Q2	Eggs that have been destained with these compounds are to be rewashed and spray rinsed with warm potable water containing an acceptable sanitizer.
Q3	These quaternary ammonium chloride compounds shall be incorporated in a warm potable water spray rinse for use in sanitizing clean or freshly washed shell eggs.
Q4	These chlorine compounds shall be incorporated in a warm potable water spray rinse for use in sanitizing clean and fresh shell eggs.
Q5	These compounds may be used to control foam in egg washing machines. Eggs washed in water containing these compounds shall be immediately subjected to a thorough rinse of warm potable water containing an accepted sanitizer.
Q6	These iodine compounds shall be incorporated in a spray rinse of warm water for use in sanitizing clean or freshly washed shell eggs. For freshly washed eggs, a rinse with warm potable water is required prior to application of the compound. A subsequent rinse is not required.

Chemical Compound Log

Plant Name: _____ **Plant Number: _____**

City/State: _____ **Grader: _____**

Manufacturer	Product Name	Approval		Use in the Plant
		NSF *	Letter of Guarantee*	

***Attached** **Updated _____**

U.S. DEPARTMENT OF AGRICULTURE
AGRICULTURAL MARKETING SERVICE
POULTRY PROGRAMS, GRADING DIVISION

PRE-OPERATIVE SHELL EGG PLANT SANITATION REPORT

WEEK OF:

PLANT NAME/NUMBER:

NAME OF GRADER(S):

S = Satisfactory	U = Unsatisfactory		SUN	MON	TUE	WED	THU	FRI	SAT
I. Shell Egg Washing, Grading, and Packaging Operations and Equipment	CRITICAL	NON CRITICAL	S U	S U	S U	S U	S U	S U	S U
A. Loaders, conveyors, orienters (including any pre-rinse equipment) reasonably clean.		X							
B. Washers, heat exchangers, nozzles, brushes, compartments, and pasteurized tanks, if applicable, reasonably clean.		X							
C. Egg drying equipment including filters, if applicable, reasonably clean.		X							
D. Shell protecting equipment (if applicable) reasonably clean with all reservoir openings properly closed and oil/wax free of off-odors or obvious contamination. Sanitizing equipment reasonably clean.	X								
E. Mass scanning, scales, and egg carriage system reasonably clean.	X								
F. Packaging equipment and conveyors reasonably clean.	X								
G. Washing, grading, and packing equipment non-contact surface areas reasonably clean.		X							
H. Plastic flat washers and dryers reasonably clean.		X							
II. Processing Rooms									
A. Walls, ceilings, and floors reasonably clean.		X							
B. Packaging and packing materials reasonably clean and free of mold, mustiness, and off-odors. Racks, bossies, pallets, and baskets reasonably clean.	X								
C. Benches, shelves, packing tables, and conveyors reasonably clean.		X							
D. Fixtures over packing and packaging areas are reasonably clean.		X							
III. Cooler and Storage Areas									
A. Unprocessed egg coolers reasonably clean and free from odors. Walls, floor, and ceiling construction well maintained.	X								
B. Processed egg coolers clean and free from odors. Walls, floor, and ceiling construction well maintained.	X								
C. Packing and packaging storage areas reasonably clean and dry. Shielded cartons covered.		X							
D. Chemical compound / inedible containers and storage areas reasonably clean. Chemical containers covered.		X							
IV. Processing Building									
A. Processing facility in good repair. Tight fitting doors on all entrances.		X							
B. Outside shipping and receiving areas reasonably clean, well maintained (minimum of 18-inch perimeter maintained around premises), and properly drained. Unused equipment stored outside is reasonably distanced from the facility.		X							
C. Refuse removed and stored in designated area that is maintained in a reasonably clean manner.		X							
D. Restrooms reasonably clean with functioning exhaust fans and hot water.		X							
E. USDA grader's office and candling booth reasonably clean.		X							
F. Inspection of premises indicates rodent and pest control program is effective.		X							
GRADER INITIALS									
PLANT MANAGEMENT INITIALS									

REMARKS: (Please include accurate description of non-compliance)

DATE	ITEM #	DESCRIPTION OF NONCOMPLIANCE	CORRECTIVE ACTION TAKEN	DATE CORRECTED

U.S. DEPARTMENT OF AGRICULTURE
AGRICULTURAL MARKETING SERVICE
POULTRY PROGRAMS, GRADING DIVISION

PRE-OPERATIVE SHELL EGG PLANT SANITATION REPORT

WEEK OF: November 14-20, 2012

PLANT NAME/NUMBER: Egg County Egg Farm / P-1234

NAME OF GRADER(S):
Bob Wilson
Burt Dixon

S = Satisfactory	U = Unsatisfactory		SUN	MON	TUE	WED	THU	FRI	SAT
I. Shell Egg Washing, Grading, and Packaging Operations and Equipment	CRITICAL	NON CRITICAL	S U	S U	S U	S U	S U	S U	S U
A. Loaders, conveyors, orientors (including any pre-rinse equipment) reasonably clean.		X	S	S	S	S	S	S	S
B. Washers, heat exchangers, nozzles, brushes, compartments, and pasteurized tanks, if applicable, reasonably clean.		X	S	S	S	S	S	S	S
C. Egg drying equipment including filters, if applicable, reasonably clean.		X	S	S	S	S	U	S	S
D. Shell protecting equipment (if applicable) reasonably clean with all reservoir openings properly closed and oil/wax free of off-odors or obvious contamination. Sanitizing equipment reasonably clean.	X		S	S	S	S	S	S	S
E. Mass scanning, scales, and egg carriage system reasonably clean.	X		S	U	S	S	S	S	S
F. Packaging equipment and conveyors reasonably clean.	X		U	S	S	S	S	S	S
G. Washing, grading, and packing equipment non-contact surface areas reasonably clean.		X	S	S	S	S	U	S	S
H. Plastic flat washers and dryers reasonably clean.		X	S	S	S	S	S	S	S
II. Processing Rooms									
A. Walls, ceilings, and floors reasonably clean.		X	S	S	S	S	S	S	S
B. Packaging and packing materials reasonably clean and free of mold, mustiness, and off-odors. Racks, bossies, pallets, and baskets reasonably clean.	X		S	S	U	S	S	S	S
C. Benches, shelves, packing tables, and conveyors reasonably clean.		X	S	S	S	S	S	S	S
D. Fixtures over packing and packaging areas are reasonably clean.		X	S	S	S	S	S	S	S
III. Cooler and Storage Areas									
A. Unprocessed egg coolers reasonably clean and free from odors. Walls, floor, and ceiling construction well maintained.	X		S	S	S	S	S	S	S
B. Processed egg coolers clean and free from odors. Walls, floor, and ceiling construction well maintained.	X		S	U	S	S	S	S	S
C. Packing and packaging storage areas reasonably clean and dry. Shielded cartons covered.		X	S	S	S	S	S	S	S
D. Chemical compound / inedible containers and storage areas reasonably clean. Chemical containers covered.		X	S	S	S	S	S	S	S
IV. Processing Building									
A. Processing facility in good repair. Tight fitting doors on all entrances.		X	S	S	S	S	S	S	S
B. Outside shipping and receiving areas reasonably clean, well maintained (minimum of 18-inch perimeter maintained around premises), and properly drained. Unused equipment stored outside is reasonably distanced from the facility.		X	S	S	S	U	S	S	S
C. Refuse removed and stored in designated area that is maintained in a reasonably clean manner.		X	S	S	U	S	S	S	S
D. Restrooms reasonably clean with functioning exhaust fans and hot water.		X	S	U	S	S	S	S	S
E. USDA grader's office and candling booth reasonably clean.		X	S	S	S	S	S	S	S
F. Inspection of premises indicates rodent and pest control program is effective.		X	S	S	S	S	S	S	S
GRADER INITIALS			BW	BW	BW	BD	BD	BD	BD
PLANT MANAGEMENT INITIALS			TJ	TJ	ML	ML	ML	ML	ML

REMARKS: (Please include accurate description of non-compliance)

DATE	ITEM #	DESCRIPTION OF NONCOMPLIANCE	CORRECTIVE ACTION TAKEN	DATE CORRECTED
11/14	1F	Egg meat on packer # 7 clam shells. Corrected prior to start-up on 11/14.		
11/15	1E	Egg meat and shells on the pick-up bar. Corrected prior to start-up on 11/15.		
11/15	3B	Two cardboard boxes and some broken pallets near the Westside of the cooler floor.		
		Corrected prior to start-up on 11/15.		
11/15	4D	Men's restroom has toilet paper on the floor and the sink is dirty. Corrected at 0715 on 11/15.		
11/16	2B	Four bossies were dirty (shrink wrap and partially peeled off stickers). Corrected prior to start-up		
		On 11/16. Two baskets contained dried egg meat. Corrected prior to start-up on 11/16.		
11/16	4C	Garbage on the floor next to the trash compactor. Corrected at 0800 on 11/16.		
11/17	4B	Trash on the ground by the dry storage receiving dock. Corrected at 0945 on 11/17.		
11/18	1C	The egg drying filters are dirty. Needs to be reasonably cleaned or replaced by startup on 11/19.		
11/18	1G	Egg meat on the underside of the mass scanning area. Needs to be corrected prior to start-up on		
		11/19.		
11/19	*	The egg drying filters were replaced by the cleaning crew on 11/19. (11/18 – 1C has been corrected.)		
11/19	*	The egg meat on the underside of the mass scanning area was cleaned by the cleaning crew on 11/19. (11/18-1G has been corrected.)		

Documentation and Date of AMS Supervisor Review with Plant Management: (If Applicable)

U.S. GPO:1999 721-698/94090

Guidance for Completing the Form PY-74, Sanitation Report

Use only statements of fact when reporting sanitation deficiencies. Do not exaggerate words to document your findings. Below are some examples:

Incorrect: Bugs all over in the dry storage.
Correct: Dead bugs on the floor near the trash container: **Corrected**
Reason: Bugs all over in the dry storage could be misconstrued by some persons that the dry storage area has bugs crawling on the floor, ceiling, and walls in excessive proportions. Although, that is not your intention, it may read that way.

Incorrect: Women's restroom nasty
Correct: Women's restroom has toilet paper on the floor and the sink is dirty: **Corrected**
Reason: Nasty could mean many things…excrement on the wall, toilet overflowing, etc. - the sky is the limit. The word "nasty" means different things to different people and can be read as an exaggeration of the facts.

Incorrect: Water everywhere in the cooler
Correct: Water on the floor in front of loading dock is creating a safety hazard: **Corrected**
Reason: "Water everywhere in the cooler" may be misconstrued by some persons to mean there is two inches of water on the entire cooler floor or water is dripping off the ceiling. This is not a statement of fact.

Incorrect: Egg all over machine
Correct: Egg meat and shell on the pickup bar, shells in the washers, and egg meat on the candle light: **Corrected prior to start**
Reason: **"**Egg all over machine" is not a statement of fact unless the entire machine has egg <u>all</u> over it. This statement can be exaggerated to mean anything and is not factual.

Incorrect: Mold on ceiling of the cooler in front of fans.
Correct: Ceiling in front of north cooling unit is dirty. **Corrected**
Reason: Do you know for a fact that it is mold? Could it be dirt or mildew? Could it be refrigerant oil? If you know for a fact that it is mold, it would require immediate corrective action and you should notify your supervisor for further instruction. If you don't know for a fact what the material is, simply use a term such as "dirty".

Incorrect: Acid wash the washers tonight.
Correct: Washer #2 has scale buildup. To be corrected prior to start on 09/24/12: **Corrected**
Reason: We don't tell management how to clean. It is up to them to determine how to remove the scale buildup. We do not want to be held liable for damage caused to equipment because of our suggestion. What if there was material on the machine that is sensitive to acid, such as the rubber membrane on a check detector or electrical equipment, etc.?

Incorrect: Trash overflowing everywhere outside
Correct: Trash on the ground near the outside dumpster: **Corrected**
Reason: Upon reading "Trash overflowing everywhere outside", one might imagine something resembling a landfill. Stick to the facts.

Incorrect: Packer #14 full of egg
Correct: Egg meat on clamshells and guidebars of packer #14: **Corrected prior to start**
Reason: "Packer # 14 full of egg" could be misconstrued by some person(s) to mean there might be a gallon of liquid egg on top of packer #14. This is not a statement of fact.

<u>Every action that is written on the PY-74 must show corrective action. There are no exceptions.</u>

Do not use a checkmark or "ok" as a replacement for "corrected" when documenting deficiencies. Use the term "Corrected" or "Above items corrected prior to start". When using "To be corrected by 9/24/10" or similar verbiage, we must still follow up and show "Corrected".

All documentation must be legible for the plant and other graders to understand what is documented and what needs correction. Plant management should initial the front of your PY-74 on a daily basis. If they refuse to initial the form, we will still give our official contact (plant representative) at the facility a copy of the form.

SHELL EGG SURVEILLANCE LABELING

The following examples may be used as guidelines for developing labels.

Cases Containing Only Checked Eggs:

CHECKS

For Processing Only in an Official
USDA Egg Products Plant

Reisma Poultry Farm
Bryant, NY 13021

Cases Containing Only Dirty Eggs:

DIRTY EGGS

Ben Farms
Boppy Hill, PA 17070

Cases Containing Either Dirty Or Checked Eggs or a Combination Of the Two:

RESTRICTED EGGS

For Processing Only in an Official
USDA Egg Products Plant

Reisma Poultry Farm
Bryant, NY 13021

Check Eggs:

DIRTY AND CHECKED EGGS

For Processing Only in an Official USDA
Egg Products Plant

Laird Farms
Boppy Hill, PA 17070

Loss, Leakers, and Inedibles In Shell Form:

RESTRICTED EGGS
NOT TO BE USED AS HUMAN FOOD

Perigen Farms
Woodstock, VA 22050

Loss, Leakers, Inedibles, and Incubator Rejects in Crushed or Liquid Form:

INEDIBLE
EGG PRODUCT NOT TO BE USED
AS HUMAN FOOD

Perigen Farms
Woodstock, VA 22050

Hatchery Culls that are Washed, Unwashed Or Show Evidence of Daylight Segregating:

UNCLASSIFIED EGGS
TO BE REGRADED

Penny Farms
Huntsville, AL 68975

Product Containing Blood or Meat Spots, but No Other Types of Loss or Inedible Eggs:

SPOTS - FOR PROCESSING
ONLY IN AN OFFICIAL EGG
PRODUCTS PLANTS

Penny Farms
Huntsville, AL 68975

Nest-Run Eggs Which Have Been Washed,
Daylight Segregated to Remove Obvious Defects,
But Not Sized:

WASHED UNGRADED EGGS

Bucky Egg Company
Madison, NM 82032

Custom Packed Restricted Eggs Returned to the Producer:

Produced By:	Packed By:
Burt Dixon Farms Oak Grove, CA 95313	Stonebraker Poultry Mansfield, WV 29670
CHECKS AND DIRTIES	CHECKS AND DIRTIES

SECTION 6: BASICS OF GRADING

I. Placement of Container

When possible place the case, filler flat, or carton to be graded directly under the candling light so that sufficient light will shine on the eggs being examined. This permits proper observation of shell condition and packaging material.

II. Eggs to Grade

An official sample consists of candling 100-eggs from each sample case in the lot.

A. For 30-dozen cases:

Odd Numbered Sample: Examine odd numbered samples (1, 3, 5, 7, etc.) from the top 100 eggs. The odd numbered samples are to be checked on the USDA Sample Sticker (PY-12) side and initialed end of the case.

Even Numbered Sampled: Examine even numbered samples (2, 4, 6, 8, etc.) from the bottom 100 eggs. The even numbered samples are to be checked on the opposite end of the case that the USDA Sample Sticker and initials are placed.

B. For 15-dozen cases or baskets:

Odd Number Sample: Examine odd numbered samples (1, 3, 5, 7, etc.) from the top 100 eggs.

Even Number Sample: Examine even numbered samples (2, 4, 6, 8, etc.) from the bottom 100 eggs. For racks or bossies, examine the 100-eggs from the designated imaginary half-case position will be examined in the following rotation:

Sample #	7 High (Shelves 1 & 2)
	1 - Layer 1-2-3
	2 - Layer 4-5-6
	3 - Layer 1-2-7
	4 - Layer 3-4-5
	5 - Layer 1-6-7
	6 - Layer 2-3-4
	7 - Layer 5-6-7
	Repeat in same sequence for samples in excess of 7

Sample #	6 High (Top Shelf)
	1 - Layer 1-2-3
	2 - Layer 4-5-6
	3 - Layer 1-2-6
	4 - Layer 3-4-5
	5 - Layer 1-3-5
	6 - Layer 2-4-6
	Repeat in same sequence for samples in excess of 6

When less than a complete flat or carton is graded to complete the 100 egg sample, the grader is to initial the applicable flat or carton and grade the following eggs:

30-Egg Flat

X	X	X	X	X
X	X	X	X	X

18-Egg Carton

LID					
		X	X		
X	X	X	X	X	X
		X	X		

12-Egg Carton

LID					
		X	X		
		X	X		

8-Egg Carton

LID			
	X	X	
	X	X	

6-Egg Carton

LID		
X		X
X		X

36-Egg Carton

LID					
X	X	X	X	X	X
	X	X	X	X	
	X	X	X	X	
	X	X	X	X	
	X	X	X	X	
X	X	X	X	X	X

24-Egg Carton

LID					
		X	X		
		X	X		

III. Items to Observe Continuously

A. The newness, soundness, and cleanliness of each egg flat tray or carton as they are removed from the case at time of grading and weighing.

B. The presence and degree of abnormalities, stains, and dirties by examining individual eggs in direct light.

C. Color of the eggs; i.e., white, cream, brown, or shades thereof.

D. The number of eggs that are packed small end up (if it is a specification requirement).

E. Undesirable odors. If a definitive, undesirable odor is detected, retain the lot as "No Grade" and describe the odor on the worksheet, in the comment log.

Interior quality is determined by the firmness of the white as measured by the yolk movement. To maintain grade interpretation, some eggs are to be broken out occasionally to correlate the broken out appearance with the candled appearance. The grader can make any necessary adjustment to the candled grade interpretation. This method can also be used to correlate candled appearance of yolk defects with their broken out appearance.

When describing quality factors, use only the terminology shown in the regulations.

IV. Segregation of Eggs While Grading

As each individual egg is graded, place the eggs of each quality in separate egg flats, or if the lot of eggs is uniform, segregate the undergrades and place them in separate areas of one flat. In addition to segregating the eggs for quality, segregate the underweight eggs. After recording the number of underweight eggs, regrade them for quality and record the results.

V. How to Replace Graded Eggs in the Sample Case

Return the 100 eggs which were graded to the top layers in the end of the case which was graded. When grading loose packed eggs, the undergrades are to be returned to the sample, beginning with the third layer, second layer, etc. When grading eggs packed in consumer packages, return the undergrades to the individual containers in which they were packed. If requested by plant management, all, or certain undergrade eggs; i.e., checks, dirties, leakers, loss, may be removed from the samples and replaced with higher quality eggs after being tabulated on the worksheet. When plant management elects to replace undergrade eggs with higher quality eggs, the product is not eligible for an appeal grading.

When a completed sample is returned to a movable rack or "bossie", rather than to a case or basket, each primary unit in the sample (flat, carton, etc.) is to be identified; i.e., small letter "s", grader's initials, etc.

VI. Weighing

The assignment of a weight class to a lot of eggs is part of the service normally requested by the applicant. Either weighing or grading may be omitted at the request of the applicant. If so requested, make appropriate statement in the "Remarks" section of the certificate (refer to Section 10).

Determine the average net weight on all lots of eggs graded, based on 30-dozen eggs. Record the number of individual eggs which are below the minimum weight required for the weight class.

When weighing shipping containers of eggs and the scale reads between two graduation marks, the correct net weight is read to the lower graduation mark. When establishing tare weights for empty consumer containers, shipping containers, and other packing material, the correct tare weight is read to the higher graduation mark.

Prior to each grading, graders are to level, balance, and check the scales for accuracy with test weights sufficient in number and size to check the weight of product being weighed. The accuracy of test weights or scales must be periodically verified (at least yearly) by certified State or County weights and measures personnel or other qualified individuals licensed by the State or County to perform test certifications. All scales must zero at no load before testing with a test weight.

The following acceptance tolerance values apply only to digital type scales regardless of the increment of calibration. These tolerance values do not apply to dial-type scales which must be adjusted to reflect the actual weight of the test weight. Digital scales registering beyond the allotted tolerance value must be adjusted accordingly. Additionally, the tolerance value is to be determined

once for each scale and does not have to be recalculated unless the scale or test weights are replaced. When verifying scales for accuracy, graders are to use established tolerance values based on the formula listed below:

$$\frac{\text{TEST WEIGHT}}{\text{SCALE DIVISION}} = \text{TEST LOAD}$$

Once the test load is determined, the grader is to use the following chart to determine whether the scale meets maintenance tolerance values.

The scale must meet the below listed tolerances in order to be utilized for weighing procedures.

The tolerance is the maximum number of scale divisions allowed for a scale to be acceptable for official weighing without further adjustment.

TEST LOAD (Scale Divisions)	TOLERANCE (Scale Divisions)
0 – 500	1
501 – 2000	2
2001 – 4000	3
4001 - +	5

Once the tolerance (scale division) is determined; the information is to be stored in file folder 2 in the grader's official files of each resident and temporary plant as applicable; and posted near the scales or in the candling booth.

Example: A 2-ounce test weight used on a scale graduated in tenths of an ounce. Two ounces divided by .1 ounces = a test load of 20 scale divisions. A tolerance of ± 1 scale division or .10 ounce is allowed.

Example: A 50-pound test weight used on a scale graduated in .05 pound increments. Fifty pounds divided by .05 lbs = a test load of 1,000 scale divisions. A tolerance of ± 2 scale divisions or .10 pound is allowed.

A. The following procedures are to be used to determine the net weight of packed and packaged eggs:

1. The net weight of eggs packed in uniform (one-type construction) fiber cases may be determined by weighing at least two empty cases and the flats to obtain the average tare weight (case and packing material) per case. Gross weigh each sample case and obtain the net weight by subtracting the average case tare from the gross weight. Net weights are to be reported on worksheets to the lowest $^{1}/_{4}$-pound graduations, except when using the weight conversion chart for eggs packed in other than 30-dozen cases.

2. Cartons often vary in weight; therefore, prior to weighing product, graders are to establish a tare weight for each size container. The tare weight is determined by weighing 5 empty individual containers of each size. Using these weights, find the average packaging tare by adding the individual weights and dividing by the number of packages weighed. The package that is nearest without being lower than the average weight will represent the tare. Zero the scale with the representative container prior to weighing product.

   NOTE: These tare weights shall be re-established quarterly, at a minimum; or, when the manufacturer or the materials change.

Report all weights on the basis of 30-dozen units. When eggs are packed less than 30-dozen to a case, convert the net weight of the eggs to a 30-dozen case equivalent on the Form PY-210S. See Exhibit I for information on individual egg weights and Exhibit II for the minimum net weights for various egg containers.

VII. Assignment of Grades

Each lot of eggs is to be assigned a specific grade. If the lot shows extreme variations, no grade is to be assigned and the statement "No U.S. Grade Assigned" is used in place of the official grade.

When a lot of eggs have absorbed smoke, chemical, or other foreign odors which affect the appearance or flavor, the lot is to be classed as "No Grade." Retain the lot immediately and notify your supervisor in order to contact the applicable FDA official.

A. Examples of Correct Grade Terminology:

1. Consumer	U.S. Grade AA Large U.S. Grade A Medium U.S. Grade B Extra Large
2. Nest-Run	U.S. Nest-Run 85% AA Quality Class I

B. Assigning a Consumer Grade

A lot may be considered for a U.S. Consumer Grade:

1. When the lot does not exceed 0.50 percent leakers, dirties, or loss at origin. The loss is limited to meat or blood spots and may not exceed 0.30 percent.

2. When the lot does not exceed 1.00 percent leakers, dirties, or loss at destination. The loss is limited to meat or blood spots and may not exceed 0.30 percent.

For origin and destination gradings of Grades AA, A, and B, no lot shall be rejected or downgraded due to the quality of a single egg except for loss other than leakers, and blood or meat spots.

Note: A full-size sample is required for a lot to be eligible for a U.S. Consumer Grade designation.

Origin Gradings –

Grade AA: 87 % AA quality, no more than 5% checks (7% for Jumbos), no more than 1% B quality due to air cells, small blood spots or serious yolk defects.

Grade A: 87% A quality, no more than 5% checks (7% for Jumbos), no more than 1% B quality due to air cells, small blood spots or serious yolk defects.

Grade B: 90% B quality, no more than 10% checks

Destination Gradings –

Grade AA: 72% AA quality, 10% A quality, 7% checks (9% for Jumbo) no more than 1% B quality due to air cells, small blood spots or serious yolk defects.

Grade A: 82% A quality or better, 7% checks (9% for Jumbo) no more than 1% B quality due to air cells, small blood spots or serious yolk defects.

Grade B: 90% B quality or better, 10% checks.

C. Assigning a Nest-Run Class

Since loss is a factor which cannot be compensated for, the first step in assigning a nest-run grade is to compare the loss on the worksheet with the chart for nest-run grades.

Note: Unused tolerances of eggs with adhering dirt in excess of one-half inch may not be substituted for other tolerances.

When assigning a nest-run grade, it may be possible to substitute unused percentages of loss tolerance for the tolerance qualities of 6 percent checks, or 10 percent B quality as shown in Table 1

of AMS 56.231. If only 1 percent loss is found, the tolerances specified for either checks or B quality can be increased, if necessary, by 2 percent provided that a minimum of 85 percent A quality or better is maintained. Excess loss cannot be offset by unused percentages of other qualities. Next, compare the percentages of AA quality eggs with the required minimum of 20 percent. Additionally, no individual case may contain less than 10 percent AA quality eggs.

Once it has been determined that the lot meets the grade requirements, the appropriate weight class is to be assigned. Determine the lot average net weight and compare it to the weight classes shown in Table 1, AMS 56.232. For example: If the lot average net weight is 46.5 pounds, the correct weight class would be Class 2.

After the correct weight class has been determined, examine the net weight of each individual case in the sample to see that it does not vary more than 2 pounds (plus or minus) from the lot average. If the lot average net weight does not figure out to an even one-fourth pound, round off the lot average net weight to the nearest one-fourth pound for determining compliance with the 2 pounds (plus or minus) variation allowed. Do not round off the average net weight shown on the worksheet.

When eggs that were offered for nest-run grading fail to meet grade requirements, enter under "Official Grade and Size", the statement: "*No grade or size assigned.*" Under the "Remarks" section, enter the statement:

"*Product offered for nest-run grading failed to meet grade requirements for (list reasons the product did not make grade requirements).*"

When product that is offered for a nest-run grading fails to meet weight class requirements due to variation in weight, (exceeding plus or minus 2 pounds from the average net weight), enter under "Official Grade and Size" the words "*See Remarks.*" In the "Remarks" section, enter the statement:

"*No weight class assigned due to individual case(s) exceeding maximum variation permitted in each weight class.*"

In Weight Class 4, because of the small size of the eggs, there can be a quality problem due to a large percentage of the eggs packed small end up; therefore, special attention needs to be given to grading for yolk defects.

Example: A 380-case lot of "U.S. Nest-Run 35.08 percent.

AA quality, Class 2" eggs:

	1/	2/	3/	4/	5/	6/	7/
	Net Weight	AA	A	B's*	Checks	Loss	Dirty**
	45.50	44	31	10	9	1-LS	5
	47.75	15	70	5	10	---	-
	47.00	18	74	2	2	1-BW	3
	45.25	64	12	2	22	---	-
	46.25	51	32	2	5	2-MR/1-LS	7
	46.00	15	77	4	2	2-LS	-
	47.25	17	67	0	16	---	-
	45.50	24	65	3	6	2-LS	-
	47.25	70	14	10	4	1-LK	-
	46.75	20	70	3	2	---	5
	46.50	15	74	4	4	1-LK	2
	48.00	68	25	4	1	---	2
	48.00	35	58	4	-	1-LK	2
Total	607.00	456	669	53	83	13	26
Average	46.69	35.08	51.46	4.08	6.38	1.0	2.0

*B Quality for shell shape, pronounced ridges or thin spots, interior quality (including small blood or meat spots), or cage marks and blood stains.

**Dirties - only adhering dirt or foreign material one-half inch or larger in diameter is to be counted.

1/ Lot averages 46.69 and would therefore meet Class 2 weight classification. Weight rounded to the nearest one-fourth pound would be 46.75. No case can be less than 44.75 or more than 48.75.

2/ Minimum lot average must be 20 percent with no case less than 10 percent.

3/ No individual case may contain less than 75 percent A and AA quality eggs in any combination. Lot average must be a minimum of 85 percent A quality or better.

4/ Maximum of 10 percent permitted. Unused loss or check tolerance may be used for B tolerance.

5/ Checks exceed the 6-percent permitted tolerance. The 2-percent unused loss tolerance may be used for tolerance on checks or B qualities.

6/ Maximum of 3 percent permitted.

7/ Maximum of 5 percent permitted (unused tolerance for dirties may not be substituted).

Exhibit I

INDIVIDUAL EGG WEIGHT TABLE

SIZE	OUNCES PER DOZEN	OUNCES PER EGG				GRAMS PER EGG				
		Tenths	Hundreths	Thousandths	Ten Thousandths	Whole Number	Tenths	Hundreths	Thousandths	Ten Thousandths
PEE WEE										
SMALL	17	1.5	1.42	1.417	1.4167	41	40.2	40.17	40.162	40.1618
MEDIUM	20	1.7	1.67	1.667	1.6667	48	47.3	47.25	47.250	47.2492
LARGE	23	2.0	1.92	1.917	1.9167	55	54.4	54.34	54.337	54.3365
EXTRA LARGE	26	2.2	2.17	2.167	2.1667	62	61.5	61.43	61.424	61.4239
JUMBO	29	2.5	2.42	2.417	2.4167	69	68.6	68.52	68.512	68.5113

Minimum Net Weight for Various Egg Containers

Size	6 Egg Pack - Minimum Net. Weight					
	Ounces/Pack	Whole Grams	Tenths	Hundreths	Thousandths	Ten Thousandths
Pee Wee	7.5	213	212.7	212.63	212.622	212.6213
Small	9	256	255.2	255.15	255.146	255.1455
Medium	10.5	300	297.7	297.67	297.670	297.6698
Large	12	341	340.2	340.20	340.194	340.1940
Extra Large	13.5	383	382.8	382.72	382.719	382.7183
Jumbo	15	426	425.3	415.25	425.243	425.2425

Size	8 Egg Pack - Minimum Net. Weight					
	Ounces/Pack	Whole Grams	Tenths	Hundreths	Thousandths	Ten Thousandths
Pee Wee	10	284	283.5	283.50	283.495	283.4950
Small	12	341	340.2	340.20	340.194	340.1940
Medium	14	397	396.9	396.90	396.893	396.8930
Large	16	454	453.6	453.60	453.592	453.5920
Extra Large	18	511	510.3	510.30	510.291	510.2910
Jumbo	20	567	567.0	566.99	566.990	566.9900

Size	12 Egg Pack - Minimum Net. Weight					
	Ounces/Pack	Whole Grams	Tenths	Hundreths	Thousandths	Ten Thousandths
Pee Wee	15	426	425.3	425.25	425.243	425.2425
Small	18	511	510.3	510.30	510.291	510.2910
Medium	21	596	595.4	595.34	595.340	595.3395
Large	24	681	680.4	680.39	680.388	680.3880
Extra Large	27	766	765.5	765.44	765.437	765.4365
Jumbo	30	851	850.5	850.49	850.485	850.4850

Size	18 Egg Pack - Minimum Net. Weight					
	Ounces/Pack	Whole Grams	Tenths	Hundreths	Thousandths	Ten Thousandths
Pee Wee	22.5	638	637.9	637.87	637.864	637.8638
Small	27	766	765.5	765.44	765.437	765.4365
Medium	31.5	894	893.1	893.01	893.010	893.0093
Large	36	1021	1020.6	1020.59	1020.582	1020.5820
Extra Large	40.5	1149	1148.2	1148.16	1148.155	1148.1548
Jumbo	45	1276	1275.8	1275.73	1275.728	1275.7275

Size	20 Egg Pack - Minimum Net. Weight					
	Ounces/Pack	Whole Grams	Tenths	Hundreths	Thousandths	Ten Thousandths
Pee Wee	25	709	708.8	708.74	708.738	708.7375
Small	30	851	850.5	850.49	850.485	850.4850
Medium	35	993	992.3	992.24	992.233	992.2325
Large	40	1134	1134.0	1133.98	1133.980	1133.9800
Extra Large	45	1276	1275.8	1275.73	1275.728	1275.7275
Jumbo	50	1418	1417.5	1417.48	1417.475	1417.4750

Size	24 Egg Pack - Minimum Net. Weight					
	Ounces/Pack	Whole Grams	Tenths	Hundreths	Thousandths	Ten Thousandths
Pee Wee	30	851	850.5	850.49	850.485	850.4850
Small	36	1021	1020.6	1020.59	1020.582	1020.5820
Medium	42	1191	1190.7	1190.68	1190.679	1190.6790
Large	48	1361	1360.8	1360.78	1360.776	1360.7760
Extra Large	54	1531	1530.9	1530.88	1530.873	1530.8730
Jumbo	60	1701	1701.0	1700.97	1700.970	1700.9700

Size	30 Egg Pack - Minimum Net. Weight					
	Ounces/Pack	Whole Grams	Tenths	Hundreths	Thousandths	Ten Thousandths
Pee Wee	37.5	1064	1063.2	1063.11	1063.107	1063.1063
Small	45	1276	1275.8	1275.73	1275.728	1275.7275
Medium	52.5	1489	1488.4	1488.35	1488.349	1488.3488
Large	60	1701	1701.0	1700.97	1700.970	1700.9700
Extra Large	67.5	1914	1913.6	1913.60	1913.592	1913.5913
Jumbo	75	2127	2126.3	2126.22	2126.213	2126.2125

Size	36 Egg Pack - Minimum Net. Weight					
	Ounces/Pack	Whole Grams	Tenths	Hundreths	Thousandths	Ten Thousandths
Pee Wee	45	1276	1275.8	1275.73	1275.728	1275.7275
Small	54	1531	1530.9	1530.88	1530.873	1530.8730
Medium	63	1787	1786.1	1786.02	1786.019	1786.0185
Large	72	2042	2041.2	2041.17	2041.164	2041.1640
Extra Large	81	2297	2296.4	2296.31	2296.310	2296.3095
Jumbo	90	2552	2551.5	2551.46	2551.455	2551.4550

SECTION 7: STATIONARY LOT GRADING PROCEDURES

I. Lot Identification

Identify and count the cases in the lot prior to selecting the samples. Record the total number of cases on the memorandum. A lot may be identified by its physical location, with a grade or lot number stamp, or other methods that will maintain the identity of the lot.

II. Size of Sample

When eggs are graded on a representative sample basis, the number of samples selected shall be not less than the minimum number of cases shown below. When eggs are packed in other than 30-dozen cases, the lot shall be converted to an equivalent number of 30-dozen cases, rounded up to the next whole number, and sampled accordingly.

30-Dozen Cases in Lot	Cases in Sample
Less than 50 eggs	All eggs
50 - 359 eggs	50 eggs
1 case	1 case
2 - 10 Inclusive	2 cases
11 - 25 "	3 cases
26 - 50 "	4 cases
51 - 100 "	5 cases
101 - 200 "	8 cases
201 - 300 "	11 cases
301 - 400 "	13 cases
401 - 500 "	14 cases
501 - 600 "	16 cases
601 - 650 "	17 cases
651 - 700 "	18 cases
701 - 750 "	19 cases
751 - 800 "	20 cases
801 – 850 "	21 cases
851 - 900 "	22 cases
901 – 950 "	23 cases
951- 1,000 "	24 cases

For each additional 50 cases or fraction thereof in excess of 1000 cases, add 1 case

III. Reworking a Stationary Lot of Eggs

The quality of a lot is determined on the basis of the official representative sample selected from the lot offered by the applicant.

It is an applicant's privilege to rework a lot either by removing the eggs candled by identified candlers, performing - individual case inspection, re-candling for segregation, or by eliminating certain sublots. The USDA grader is to verify that plant management has modified or segregated the eggs prior to authorizing a re-examination.

When the applicant changes the character of a lot in this manner and requests another grading, a representative sample shall be selected and a grading made of the "new" lot. The reworking of product previously graded according to the online sampling plan is outlined in Section 8 of this Handbook.

IV. Consolidated Lot Grading – Institutional Gradings (Includes Military Consignments)

Product offered for consolidated lot gradings must be produced under continuous supervision as evidenced by identification with either the U.S. Grade AA, A, or B stamp or USDA lot number stamp applied to each case in the lot.

A. Military orders with different Defense Commissary Agency (DeCA) contract numbers may be consolidated into one lot.

B. Lots must be consolidated by the same grade and size.

C. When grading percentages are required on the certificate, show the consolidated lot percentages on each certificate issued as explained under Option 2 certification in Section 8.VII.B, of this Handbook.

D. Base the sample size selected on the total cases in the consolidated lot instead of the number of cases comprising each sublot delivery. In the "Number of Samples" entry on the certificate, place an asterisk and insert the following statement in the "Remarks" section: "Consolidated lot grading."

V. Official Identification of Cases

No appeal or regrading is permitted unless a lot is adequately identified and all cases are sealed.

A. How and What to Stamp

Cases of eggs officially identified are to be single stamped. Stamps are not to be applied over preprinted information.

Case tops shall be secured by taping, gluing, or strapping before cases are officially identified. Taped fiber cases are to have a legible stamp imprint placed partially on the case and partially on the tape on the end of the case. Fiber cases sealed with plastic tape may be stamped immediately adjacent to the tape rather than partially on the tape and partially on the case. Officially identified sample cases previously identified in this manner will not be eligible for reuse without obliterating the grade stamp.

B. Types of Stamps to Use

U.S. Grademark (Figures 1,2,3) - For use on eggs of current production that are candled under continuous USDA supervision at resident or temporary plants. This stamp should be applied at the time the eggs were packed. Incorporate the date of grading such as 04-12-2012, or April 12, 2012, in this stamp. Do not use the consecutive day of the year. Alternatively, the number of the certificate issued may be used in the stamp.

Figure-1

Figure-2

Figure-3

If a facility desires to have the cases officially identified with the grademark at a later date, the cases shall be identified with the USDA lot stamp (Figure 9) at the time of packing. The date in the consumer stamp must be the same as the official lot grading date, as shown in the lot stamp. If the product is fully sampled on a date other than that of original grading, that date or certificate number may be used in the stamp. Certificates may be issued as outlined in Section 8 of the Handbook, Options 1 or 2 certification.

U.S.D.A Sample Grade AA, A, B (Figures 4,5,6) - For use when the eggs were not graded under USDA supervision and the grade is determined on a sample graded basis. Use the issued certificate number in the stamp. All cases in the lot are to be stamped.

Figure-4

Figure-5

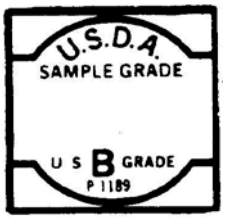


Figure-6

Graded For Export (Figure 7) - For use on product packed for export or for commercial export sales. Use the issued certificate number in the stamp.

Figure-7

Nest Run Grade (Figure 8) - For use on product meeting U.S. Nest-Run grade standards, approved nest-run specifications, or other types of nest-run certification. Use the issued certificate number in the stamp. The stamp includes washed, sized, or unsized nest-run eggs.

Figure-8

USDA Lot Stamp (Figure 9) - For use on product that has been processed under continuous USDA supervision, and will be identified with a consumer grademark (Figures 1, 2, 3) or the Graded For Export stamp (Figure 7) at a later date. The lot number used in the stamp is to be the consecutive day of the year the eggs are packed; i.e., 009 for January 9. Alternative lot numbering systems may be approved by the National Office or Federal State Supervisor.

If the eggs are not officially graded and identified with a consumer grademark as above, the lot stamp must be obliterated from all containers prior to leaving the official plant unless the eggs are shipped under USDA control.

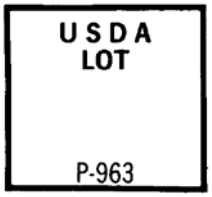


Figure 9

Contract Compliance (Figure 10) - When shell eggs are graded for contract compliance and commercial specifications, they may be identified with this stamp (Figure 10) or the applicable U.S. Consumer grademark. Either the date or the issued certificate number may be used in the stamp.

Figure 10

Produced from Grade AA or A (Figures 11 & 12) - for the identification of further processed shell eggs verified as originating from U.S. Consumer Grade AA or A.

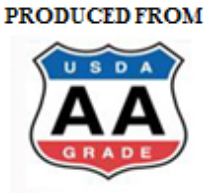


Figure 11

Figure 12

Certified Pasteurized (Figures 13 & 14) – Shell eggs verified as being treated in accordance with an FDA approved Salmonella 5 log reduction. Product originated from U.S. Consumer Grade AA or A.

Figure 13

Figure 14

C. Computer Generated Stamps

Upon review and approval by the National Office, packing materials may be officially identified with computer generated official stamp imprints. The use of computer stamp imprints will be limited to the U.S. Grademark. The Contract Compliance stamp may be used provided these labels are applied on the packing material only after all contract specification requirements have been verified. Computer stamp imprints may only be used where graders can closely monitor and verify proper use.

Use of any computer generated official stamp imprint requires approval by the National Office. Graders may not authorize the shipment of eggs in packing material bearing the stamp imprints until they are approved. To obtain approval, plant management must submit a copy of the label to the National Office with an example of how it will be applied on packaging material. Upon completion of the review and approval, the approving official will assign an approval number and will provide a copy of the label and related information regarding its approval to the appropriate Regional Director who will forward the

information to the applicable Federal-State supervisor and grader. It is the responsibility of plant management to provide a copy of the approved label to the grader. A copy of the approved label is to be filed in folder number “14” in the grader’s official files. Prior to each use, plant management must advise the grader of their intention to use the labels and the amount of product to be labeled.

Once approved, graders are to authorize and monitor the application of computer generated stamps by plant employees using the same guidelines applicable for the use of official stamps as outlined in AMS/PY Instruction 929-4, A-3, Accountability, in the General Index. The “List of Authorized Users of USDA Grading Stamps” log is to be completed and filed in folder number "6" in the grader's official files.

D. Eggs Not Processed Under USDA Supervision

When eggs of current production that were not processed under USDA supervision are presented to the USDA grader for official grading and identification, the eggs must be reprocessed (washed, rinsed, sanitized, graded, and sized) in accordance with the regulations to be eligible for official identification and a new production code.

E. Eggs Processed Under USDA Supervision

When eggs of current production that were previously processed and graded under USDA supervision are presented to the USDA grader for official repackaging, the eggs must be reprocessed (washed, rinsed, sanitized, graded, and sized) to be eligible for a new production code.

VI. Obliteration of Official Identification

The reuse of consumer containers, shipping containers, or labels bearing official identification or other information representing that the product was officially graded without having been so graded is not permitted unless all such official identification is obliterated. The satisfactory obliteration of the USDA grademark and other official stamps from consumer containers and shipping containers consists of blotting out the stamp outline and information contained therein. This may be accomplished by using a marking device, stencil brush, spray paint, or a pressure sensitive sticker that removes the imprint if the sticker is pulled off. All official narrative information must be completely obliterated so that it is not legible.

VII. Sealing Cases

The sealing of cases gives the case rigidity, reduces physical damage to the graded product, and also discourages substitution. Closure of shipping cases may be accomplished by applying gummed paper, plastic, or other suitable tape, gluing, or by utilizing methods that would secure the seams made by the closing of the top of the case. All tape shall be of sufficient width and length to preclude the top flaps from opening and shall extend down the sides and/or ends of the case to permit the official identification of the case, as applicable. Due to the design of certain cases, especially 15-dozen cases with interlocking flaps, it is permissible to seal the case by applying a strip of tape placed across the top of the case to secure the interlocking flaps. The use of staples for closing the tops of cases is not acceptable if the cases are officially identified.

Refer to Section 9, SPECIAL GRADINGS for guidance on situations where the firm selects the samples from lots that are to be graded.

VIII. Identifying Lots of Improperly Labeled Eggs

Cases marked with the letters AA, A, or B are not to be officially identified unless they are of the same or better quality of the consumer grade indicated by the letter as determined by an official grading. All previous official grademarks are to be removed before new official grademarks are applied to the cases. The same policy applies to grademarkings on consumer containers within the master container.

If an official identification is desired and each case in the lot has not been properly stamped or tagged with a storage lot number (identified), it will be necessary to detain the product if not corrected prior to leaving the premises.

IX. Marking Individual Eggs

The marking of individual eggs may be requested by processors as part of a specification requirement or for other marketing purposes. For example: Eggs shipped to locations other than the continental United States such as the State of Hawaii, the Commonwealth of Puerto Rico, Guam, and several other foreign countries, are required to be individually marked.

A. Stamping Eggs

Recognizing the difficulty in clearly stamping the rounded surface of an egg, a lot average tolerance of 10-percent for individual eggs with partial, illegible, or no marks in any combination is permitted with no individual case exceeding 20-percent. These tolerances may be applied as a moving average when performing online sampling or as a lot average while performing stationary lot gradings. Stamped eggs are not classified as stains or dirty. They are to be graded without regard to marking.

An official grade cannot be assigned to a mixed lot of eggs that contains individually marked and unmarked eggs. If requested, the lot may be graded for all factors except ink stains. Lot averages may be shown on the certificate. The section "Official Grade and Size" shall state "No U.S. Grade." The following statement shall also be placed in the "Remarks" section: "Lot contains marked and unmarked eggs. Eggs graded for all factors except ink stains." Individual eggs with ink blotches or smears from dating devices are to be classified as stains or dirty, depending on the intensity and/or area of the stain.

Inks used in marking individual eggs which will be officially graded are to be approved by the National Office prior to their use. The request for approval should be accompanied with a copy of the ink formula, the name of the product, and the name and address of the manufacturer. Refer to the Shell Egg Index, C-02, COMPOUNDS; List of Approved Inks for Stamping Shell Eggs.

B. Laser Etching (Marking Eggs)

The use of a laser etching system to mark information is subject to joint review by the Food and Drug Administration (food safety impact evaluation) and USDA (quality impact evaluation). Only approved

laser etching systems may be used to identify shell eggs to be officially graded and identified with a USDA grademark. The amount of the shell surface available for laser etching and the information etched on the shell is subject to review by the resident grader and the Federal-State supervisor. The information etched on the shell must not interfere with the graders ability to evaluate the quality attributes of the egg. When an individual egg is marked, whether an applied ink or laser etched, the information must be consistent with the information on the label. For example: Any marketing claims, production code, or packer identity. If this information is not consistent throughout the lot, the eggs are not eligible to be identified with a USDA grademark.

X. Cooler Samples

Examining cooler samples for quality serves as a valuable tool to verify candling accuracy, and packaged product handling practices at a facility. Each resident grader is to examine and record a minimum of three, 100-egg samples (when available) from the cooler each week to verify the accuracy of their grading. Cooled eggs can be graded more accurately for quality, identity of checks, and damage due to packing, sealing, etc. When possible, at least one cooler sample should be that of the grader's previously examined on-line samples.

Eggs should be selected proportionately from grades and sizes packed. For example: If the facility's cooler predominately consists of Extra Large and Large-sized product, those sizes should receive priority when selecting your cooler samples.

A. Cooler Sample Procedures:

1. Selection of an officially identified; previously examined sample. USDA graders are not to perform cooler samples that were previously graded by other USDA personnel. The USDA grader's officially identified sample must always take priority over a non-sampled, officially identified cooler sample.

2. Selection of an officially identified, previously non-examined sample (when a previously examined cooler sample is not available). The grader shall select officially identified product from various positions on the pallet.

AVOID SELECTING SAMPLES CONSISTENLY FROM THE TOP LAYERS OF A PALLET.

3. Sample and determine the quality factors from the selected cooler sample(s). Complete the Cooler Sample Worksheet (Exhibit I) accordingly.

4. When product fails to meet the requirements for the marked U.S. Grade standard (AA or A), plant management is to be notified of the cooler sample(s) results in order to determine any possible reasons for the apparent quality observed.

5. The cooler sample(s) is to be retained; however, the product represented by the sample(s) is not to be retained. Plant management may elect to rework the retained product.

6. Cooler samples exceeding the restricted egg tolerances for U.S. Grade B standards (at origin) for an individual case shall be retained. In addition, the individual pallet that the cooler sample(s) represents must also be retained. The product cannot be released until it is reworked and re-examined to ensure that it does not exceed the restricted egg tolerances for U.S. Grade B standards (at origin). On-line sampling takes priority over re-examination of retained product due to cooler samples.

7. File all completed Cooler Sample Worksheets in file folder 22 of the Shell Egg Graders Filing System as listed in Section 12 of this Handbook.

XI. Random Sample Selection – Stationary Lot Gradings

A separate "Sample Selection Worksheet" must be completed for each lot to be graded. Product may be offered for grading on a stationary lot basis rather than an online basis. A stationary lot is any identifiable group of product where the individual units are uniform in size, type, or style, and produced and/or processed under essentially the same conditions. Stationary lots may be presented for grading on different sized pallets, or on racks (bossies), or stacked in rows on the floor. Product may be packaged in various sized consumer containers, or may be loose in filler flats.

Product may be in full cases, half cases, baskets, etc. Prior to sampling any stationary lot of shell eggs, the grader must:

A. Determine how product is packed; i.e., in full-cases, half-cases, baskets, etc.

B. Determine the number of pallets, rows, racks, etc., and how product is stacked (e.g., thirty / 30-dozen cases per pallet, stacked 5-layers high with 6-cases per layer).

C. Verify the total number of containers, and convert to the 30-dozen equivalent (to determine number of samples needed).

D. Mentally, number each pallet, row, etc., in a logical sequence, according to how product is arranged in the cooler or elsewhere. If the lot contains a partial pallet, row, or rack always number it last.

   NOTE: In some situations it may be necessary to actually number each pallet, row, or rack to control the identity of the lot, particularly when product must be moved to select samples.

E. Determine the number of samples required as listed in [7 CFR 56.4(b)] part II of this section.

XII. Repackaging Eggs Shipped from another Official Plant

Some official plants pack consumer grade shell eggs in bulk and ship them to another official plant for packing under an official grademark label. To be eligible for this procedure, the eggs must be packed at the origin plant under continuous USDA supervision. The cases may be sealed and stamped with the

consumer grademark stamp.

If the applicant does not wish to seal and stamp the cases, the eggs may be packed in bulk cases without sealing and stamping when transported in a truck or trailer which is sealed by the origin plant grader. If this option is used, the USDA grader at the receiving plant must break the seal on the truck to maintain product identity. The grader at origin will prepare and send a narrative memorandum (not Form PY-211) to the grader at the second plant showing the quantity, size, and quality in the shipment and a statement that all eggs were individually graded under continuous USDA supervision. Both origin and destination graders are to retain a copy of the written memorandum in their files together with Form PY-211 and Form PY-75 or 75A.

When the above conditions are met, the eggs may, at the option of the applicant, be packed in officially identified containers bearing the original lot number, without being re-candled. Acceptance or rejection of the finished product will be on the basis of a full size sample being checked by the resident grader after the lot is repackaged or by other means when approved by the Federal-State supervisor.

As previously indicated, graders are expected to examine on-line product continuously when it is to be officially identified. If during the course of such continuous observation the grader finds the product to be out-of-grade, the following action is to be taken:

A. Notify the designated plant employee as soon as possible.

B. Identify and arrange for the segregation of product, which was not correctly graded or sized.

C. Personally observe the reworking or removal of the eggs which were not properly graded or packaged, the removal of all the eggs from the original containers in which packed, or the obliteration of all official identifying stamps.

In addition to this, graded product shipped from either an official plant or other processing locations, not packed under continuous USDA supervision, may be processed, repackaged, and eligible for official identification at the destination. For this to be acceptable, plant management must provide the grader with a certificate validating the date of lay and the product must be processed and packed at destination under continuous USDA supervision.

XIII. Consumer Grade-Labeled Product Which Was Not Officially Graded

Shell eggs which are consumer labeled with the official grademark normally have the label applied immediately after the product is sorted by the company employees. It is not always possible to complete the required official grading of product before the close of each shift or work day. Such product is then required to be held under controls until the resident grader has again reported for duty and the official grading is made. In spite of the controls which have been established by firms and the Poultry Grading Division, product has on occasion been released for distribution or sale before it is officially graded. This is a violation of the Agricultural Marketing Act (AMA). If this should occur, the resident grader will follow these procedures:

A. Protect the Consumer

To protect the consumer, the grader should immediately inform the highest plant management official available and insist that all product be returned to the plant for official grading.

B. Notice of Verbal Request

Confirm the verbal request to management in writing. The written notice given to the company should be acknowledged by obtaining the signature of the highest plant management official available.

C. Complete Inventory

A copy of the written request together with a complete inventory of the quantity of product involved, date, plant, actions taken by the company, etc., are to be faxed to the Federal-State office.

D. Request Letter from Firm

Request that plant management write a letter to the Federal-State supervisor. The letter should explain how the product happened to be shipped without official grading, and what specific steps the company intends to take to prevent a recurrence.

E. Notification of Resistance

If there is any resistance on the part of the applicant to recall the product, notify the Federal-State supervisor immediately by telephone. If the Federal-State supervisor is not available, contact the Regional Office. Such calls, if at all possible, are to be made from the plant so that applicable grading personnel may also speak with plant management.

F. Form PY-518-1

A Form, PY-518-1, "Alleged Violation and Detention Notice" is to be completed and distributed the day of the violation by the grader after guidance from the supervisor. See V-2, VIOLATIONS in the General Index.

XIV. Sampling and Grading Over-Wrap/Shrink-Wrap Product

Consumer cartons and filler-flats are frequently over-wrapped with polyethylene film and heated to create a unitized consumer package. Similar forms of packaging may include using lid type covers in combination with over-wrapping. The sampling and grading of these products are dependent on the packaging type, the sealing process, and assurance that the process does not result in an increase number of checks or leakers.

If the packaging, including over-wrapping, is a continuous process from when the eggs are processed, acceptance of the finished product will be based on on-line sampling procedures after the final packaging. If the eggs are packed in cartons or other protective packaging materials and then moved to another location for packaging within the plant, acceptance of the finished product will be based on on-line

sampling procedures before the over-wrap process. Additionally, and upon review and approval by the Federal-State supervisor, acceptance of eggs packed in filler-flats and moved to another packaging location within the plant may be sampled based on on-line sampling procedures before shrink-wrapping.

If over-wrapping is continuous as the eggs are processed or performed within the same facility, online sampling will be considered adequate. Over-wrapping performed at a location away from the origin packaging plant will require re-sampling and regrading of the product prior to overwrap or after destructive sampling as authorized by the Federal-State supervisor.

Regardless of the packaging process, approval to sample prior to final packaging is only allowed if the plant has demonstrated that the overall integrity of the product does not change during the process. To verify product integrity, the Federal-State supervisor is to establish a post-sampling plan whereas the grader selects and examines an occasional sample after final packaging and records the results on the Form PY-75. If the results of these samples indicate an increase in checks or leakers, sampling is to revert back to post final packaging and remain there until management has resolved the problem. All product sampled after over-wrapping is eligible to be placed back onto the processing line and repackaged.

XV. Previously Graded Product Received and Held in Official Plant

Officially identified shell eggs received and held in an official plant are subject to rechecking to determine their quality. When checking product received and held in an official plant, the grader is to follow the procedures outlined in R-13 RECORDS, Destination Inspections - Significantly Out-of-Grade Products, filed in the General Index.

XVI. Handling of Officially Identified Eggs Rejected By USDA at Locations Other Than Where Packed

A. Eggs Rejected for Quality and/or Size

The destination grader will place a U.S. retained tag (Form PY-36) on each lot rejected by USDA. The grader will record on the tags the number of cases in the lot by grades and sizes, and the reason for the rejection. No lot of eggs may be rejected for size unless the grader has balanced and tested each scale used during the grading. No rejected lots may be moved from the point where they are rejected until:

1. The official identification is obliterated, or

2. The eggs are removed from the consumer containers and the containers returned to an official plant or destroyed, or

3. Specific arrangements are made by the owner of the product or his designated representative to have the above work done at another plant which has USDA grading service.

B. Documentation of Rejection

Lots that are rejected for reasons other than significantly out-of-grade quality factors, such as weight factors, should be reported to the immediate supervisor.

C. Product Re-handled at Location Other than Point of Rejection

When product is to be re-handled at a plant other than where rejected, the owner of the product or his designated representative shall contact both plant management and the USDA grader at the point where the eggs are to be shipped. The information to be conveyed shall include the date and estimated time of arrival, the number of cases involved, etc.

When the grader who made the rejection is assured that grading service is available where the rework will be performed, the grader will advise management that the eggs may be shipped. The grader is to prepare a Retained Product Transfer/Release Memorandum (Refer to Section 8, Exhibit IV) to accompany the shipment to the final destination. The USDA grader is to place a phone call and send a facsimile to the destination grader / inspector confirming the details of the shipment.

Upon arrival, the retained tags attached to the cases are to be removed by the grader / inspector receiving the eggs. After verifying the count, the grader / inspector will mail a receipt copy of the narrative memorandum and the retained tags back to the grader who issued them. The receiving grader / inspector will place new retained tags on the lot until final disposition has been made. If the eggs, retained tags, and receipt memorandum are not received by the receiving grader on the agreed upon date for arrival, the grader shall contact the supervisor who will initiate action to determine the location of the eggs and other information.

Any discrepancy in the number of cases in the lot or failure of the eggs to arrive at the agreed upon location shall be telephoned immediately by the grader / inspector at the rework plant to the Federal-State supervisor. The supervisor will then investigate the reason why the eggs did not arrive. When the eggs arrive for reworking, the USDA grader / inspector will observe the reworking of product, the obliteration of applicable markings, and proper reuse or destruction of the containers.

D. Supervisory Follow-up of Unsatisfactory Product

The supervisor(s) of the origin and destination graders are to particularly observe the grader's gradeline, egg handling, and grading procedures on the first supervisory visit following a rejection. The supervisory visit should be scheduled as early as practicable.

XVII. Completion of Sample Selection Worksheet

Included in this section are Sample Selection Worksheets (see exhibits). These worksheets, which differ as to the size container and how containers are stacked, are designed to accommodate nearly all stationary lot grading situations. The worksheets are to be photocopied as needed for use in resident plant or fee grading locations. Many plants or fee grading locations will use only one worksheet since all product offered for grading will be packed and stacked the same way; e.g., 30 / 30-dozen cases per pallet. Select the applicable worksheet for the lot to be sampled and fill in the "Lot Information" data at the top. A

handheld calculator, capable of generating random numbers shall be used to identify which containers within the lot will be sampled.

XVIII. Selecting the Sample

The applicant must present a lot of eggs for grading so that the entire lot is readily accessible for sampling. When performing stationary lot gradings, follow the procedures outlined in item XI, of this section. All samples are to be personally selected by the grader, using a calculator which generates random numbers; however, warehouse or plant employees may aid in the physical drawing of the selected cases. If a problem using the calculator is encountered, graders should consult their Federal-State supervisor for guidance. At the time of selection, each sample is to be numbered and initialed to maintain sample integrity. Additionally, the grader is to number the pallet, rack, or bossy to enable the grader and management to accurately locate applicable product when a non-complying sample is found. Samples are to be taped and when applicable, stamped with official identification promptly after grading.

XIX. Identifying Designated Samples

A. Product on Pallets

Example #1

Fork Lift Openings = ^ ^ ^

```
/-------------------------------\        /-------------------------------\      /-----------------------------------\        /---------------------------------------\
| 25  <|----------------|> 30  |        | 55  <|----------------|> 60  |      | 85 <|----------------|>  90  |        | 115  <|--------------|> 120  |
| 19  < -------|-------- > 24  |        | 49  < -------|-------- > 54  |      | 79 < --------|------- >  84  |        | 109  <-------|--------> 114  |
| 13  <|----------------|> 18  |        | 43  <|----------------|> 48  |      | 73 <|----------------|>  78  |        | 103  <|--------------|> 108  |
|   7  < -------|---------> 12  |        | 37  < -------|---------> 42  |      |  67 <--------|-------->  72  |        |   97  <------ |--------> 102  |
|   1  < ----------------|> 6   |        | 31  < ----------------|> 36  |      |  61 <|----------------|>  66 |        |    91 <|--------------|>   96  |
\-------------------------------/        \-------------------------------/      \ -----------------------------------/        \ ---------------------------------------/
 ^  ^  ^              ^  ^  ^             ^  ^  ^                 ^  ^  ^          ^ ^ ^                 ^ ^ ^                 ^ ^ ^                 ^ ^ ^
```

Each container in the lot is mentally assigned a number, beginning with the bottom left corner of pallet number 1 (Example #1). There are 4 pallets of 30 containers (a total of 120 containers), stacked 5 layers high, with 6 containers, per layer. On pallet number 1, the bottom (first) layer is assigned numbers 1 through 6, the second layer would be 7 through 12, the third layer would be 13 through 18, the fourth layer would be 19 through 24, and the fifth (top) layer would be 25 through 30. Pallet number 2 would be numbered 31 through 60, using the same sequence. Pallet number 3 would be numbered 61 through 90, and pallet number 4 would be numbered 91 through 120.

The grid chart on each worksheet provides a method of identifying and locating the position of every container in the lot. On worksheets 1 through 10, the grid charts are divided into vertical columns and horizontal lines of numbers. The first vertical column of numbers on the left and the last vertical column of numbers on the right identify the pallet number. Vertical lines identify and separate the individual layers on a pallet, from layer 1 through 5 or 6, as applicable (left to right across the chart).

Reading horizontally across the chart, the "container position" is shown directly under "layer number." This identifies the position of each container on the applicable layer. The next horizontal line of numbers

under "container position" identifies the containers on pallet number 1. The next line identifies the containers on pallet number 2, etc. Circle the designated sample container numbers, as generated by the calculator, on the applicable worksheet grid chart. The chart can then be used to locate the indicated samples.

<u>NOTE</u>: On some worksheets, the grid charts only reflect even number containers. Therefore, when an odd number sample is selected, mark an "X" between the applicable even numbers on the chart (Example #2).

<u>Example # 2</u>

CONTAINER POSITION		2	4	6	8	10	12	2	4	6	8	10	12	2	4	6	8	10	12	2	4	6	8	10	12	CONTAINER POSITION	
P	1	2	4	6	8	10	12	14	16	18	20	22	24	26	28	30	32	34	36	38	40	42	44	46	48	1	P
A	2	50	52	54	56	58	60	62	64	66	68	70	72	74	76	78	80	82	84	86	88	90	92	94	96	2	A
L	3	98	100	102	104	106	108	110	112	114	116	118	120	122	124	126	128	130	132	134	136	138	140	142	144	3	L
L	4	146	148	150	152	154	156	158	160	162	164	166	168	170	172	174	176	178	180	182	184	186	188	190	192	4	L
E	5	194	196	198	200	202	204	206	208	210	212	214	216	218	220	222	224	226	228	230	232	234	236	238	240	5	E
T																											T
	6	242	244	246	248	250	252	254	256	258	260	262	264	266	268	270	272	274	276	278	280	282	284	286	288	6	
N	7	290	292	294	296	298	300	302	304	306	308	310	312	314	316	318	320	322	324	326	328	330	332	334	336	7	N
U	8	338	340	342	344	346	348	350	352	354	356	358	360	362	364	366	368	370	372	374	376	378	380	382	384	8	U
M	9	386	388	390	392	394	396	398	400	402	404	406	408	410	412	414	416	418	420	422	424	426	428	430	432	9	M
B	10	434	436	438	440	442	444	446	448	450	452	454	456	458	460	462	464	466	468	470	472	474	476	478	480	10	B
E																											E
R	11	482	484	486	488	490	492	494	496	498	500	502	504	506	508	510	512	514	516	518	520	522	524	526	528	11	R
	12	530	532	534	536	538	540	542	544	546	548	550	552	554	556	558	560	562	564	566	568	570	572	574	576	12	
	13	578	580	582	584	586	588	590	592	594	596	598	600	602	604	606	608	610	612	614	616	618	620	622	624	13	
	14	626	628	630	632	634	636	638	640	642	644	646	648	650	652	654	656	658	660	662	664	666	668	670	672	14	
	15	674	676	678	680	682	684	686	688	690	692	694	696	698	700	702	704	706	708	710	712	714	716	718	720	15	

For each circled number (or "X" between numbers) on the grid chart, first determine the pallet number by following across the applicable horizontal line to the far left or far right vertical column. Then follow up each vertical column which has a circled number to identify the layer number and the container position within the layer (Example #3).

- Container numbers 64, 25, 2, 39, and 98 are identified by the calculator as samples.
- Container #64 is located on pallet #3, layer #1, and position #4.
- Container #25 is located on pallet #1, layer #5, and position #1.
- Container #2 is located on pallet #1, layer #1, and position #2.
- Container #39 is located on pallet #2, layer #2, and position #3.
- Container #98 is located on pallet #4, layer #2, and position #2.

Example #3

CONTAINER POSITION		1	2	3	4	5	6	1	2	3	4	5	6	1	2	3	4	5	6	1	2	3	4	5	6	1	2	3	4	5	6	CONTAINER POSITION	
P	1	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	1	P
A	2	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50	51	52	53	54	55	56	57	58	59	60	2	A
L	3	61	62	63	64	65	66	67	68	69	70	71	72	73	74	75	76	77	78	79	80	81	82	83	84	85	86	87	88	89	90	3	L
L	4	91	92	93	94	95	96	97	98	99	100	101	102	103	104	105	106	107	108	109	110	111	112	113	114	115	116	117	118	119	120	4	L
E	5	121	122	123	124	125	126	127	128	129	130	131	132	133	134	135	136	137	138	139	140	141	142	143	144	145	146	147	148	149	150	5	E
T																																	T
	6	151	152	153	154	155	156	157	158	159	160	161	162	163	164	165	166	167	168	169	170	171	172	173	174	175	176	177	178	179	180	6	
N	7	181	182	183	184	185	186	187	188	189	190	191	192	193	194	195	196	197	198	199	200	201	202	203	204	205	206	207	208	209	210	7	N
U	8	211	212	213	214	215	216	217	218	219	220	221	222	223	224	225	226	227	228	229	230	231	232	233	234	235	236	237	238	239	240	8	U
M	9	241	242	243	244	245	246	247	248	249	250	251	252	253	254	255	256	257	258	259	260	261	262	263	264	265	266	267	268	269	270	9	M
B	10	271	272	273	274	275	276	277	278	279	280	281	282	283	284	285	286	287	288	289	290	291	292	293	294	295	296	297	298	299	300	10	B
E																																	E
R	11	301	302	303	304	305	306	307	308	309	310	311	312	313	314	315	316	317	318	319	320	321	322	323	324	325	326	327	328	329	330	11	R
	12	331	332	333	334	335	336	337	338	339	340	341	342	343	344	345	346	347	348	349	350	351	352	353	354	355	356	357	358	359	360	12	
	13	361	362	363	364	365	366	367	368	369	370	371	372	373	374	375	376	377	378	379	380	381	382	383	384	385	386	387	388	389	390	13	
	14	391	392	393	394	395	396	397	398	399	400	401	402	403	404	405	406	407	408	409	410	411	412	413	414	415	416	417	418	419	420	14	
	15	421	422	423	424	425	426	427	428	429	430	431	432	433	434	435	436	437	438	439	440	441	442	443	444	445	446	447	448	449	450	15	

The grader is to personally mark the applicable sample containers, as identified on the worksheet grid, by locating:

- The applicable pallet, as previously numbered (mentally or otherwise).

- The applicable layer on the designated pallet. In all instances, the bottom layer will be number 1; the second layer up from the bottom will be number 2, etc.

Example #4 - Pallet Layers (Fork Lift Openings = ^^^)

```
/------------\                 > /----------------\      > /----------------\
|  |  |  |   |                 > |  |  |  |  |   |      > |  1  |  |  |   |
| 8 | 7 | 6 |                 > |  |  |  |  |   |      > |-------| 6 | 5 |
|---|---|---|                   |1 |  6 |5 |4  |        |  |  |  |  |   |
| 9 |12 | 5 |                   |  |  |  |  |   |        |2 | 3 |-------|
|---|---|---|                   |-------|-------|        |  |  |  |  |   |
|10 |11 | 4 |                 > |  2    |   3   |      > |  |  |  |   4   |
|---|------|                   > \----------------/      > \----------------/
| 1 | 2 | 3 |
\------------/                        LAYER #1                  LAYER #2
^ ^ ^   ^ ^ ^
```

```
/------------\          /------------\
|  |  |     |          |     |  |  |
| 5 |------|            |     |------|
|   |  |   |            |  |  |  |   |
|---| 6 | 3 |            | 5 | 6 |---|
|   |  |   |            |  |  |  |   |
| 1 |------|            |------| 2 |
|  |  |  2 |            |  1  |  |  |
\------------/          \------------/
 ^ ^ ^   ^ ^ ^           ^ ^ ^   ^ ^
   ^ LAYER #1              LAYER #2
```

Locate the applicable container within the designated layer. When mentally numbering containers, always face (or count as if facing) toward the fork lift openings in the pallet. Begin on the left with number 1, and number counter-clockwise around the layer (Example #4). For chimney stacking, layer #2 will sit on layer #1 (or vice-versa) and this layering will alternate up to 6 or 7 layers high.
Example #5, page 17, shows a completed worksheet for 30-dozen cases on pallets. Example #6, page 18, shows a completed worksheet for 48 half-cases on pallets.

Example #5 (SAMPLE SELECTION WORKSHEET – 30 FULL CASES PER PALLET)

LOT INFORMATION
SELECTED

Grade & Size : AA Large

Type of pack : Loose

No./Size of Cases : 612/30 = 612/30-DOZ.

Samples Needed : Seventeen - 17

Audit Number :

SAMPLE CONTAINERS

1. 195	11. 101
2. 413	12. 588
3. 110	13. 176
4. 4	14. 49
5. 261	15. 546
6. 304	16. 394
7. 88	17. 513
8. 243	18.
9. 58	19.
10. 2	20.

INSTRUCTIONS: CIRCLE EACH SAMPLE IN THE CHART BELOW.

LAYER NUMBER		1						2						3						4						5						LAYER NUMBER	
CONT. POSITION		1	2	3	4	5	6	1	2	3	4	5	6	1	2	3	4	5	6	1	2	3	4	5	6	1	2	3	4	5	6	CONT. POSITION	
P	1	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	1	P
A	2	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50	51	52	53	54	55	56	57	58	59	60	2	A
L	3	61	62	63	64	65	66	67	68	69	70	71	72	73	74	75	76	77	78	79	80	81	82	83	84	85	86	87	88	89	90	3	L
L	4	91	92	93	94	95	96	97	98	99	100	101	102	103	104	105	106	107	108	109	110	111	112	113	114	115	116	117	118	119	120	4	L
E	5	121	122	123	124	125	126	127	128	129	130	131	132	133	134	135	136	137	138	139	140	141	142	143	144	145	146	147	148	149	150	5	E
T																																	T
	6	151	152	153	154	155	156	157	158	159	160	161	162	163	164	165	166	167	168	169	170	171	172	173	174	175	176	177	178	179	180	6	
N	7	181	182	183	184	185	186	187	188	189	190	191	192	193	194	195	196	197	198	199	200	201	202	203	204	205	206	207	208	209	210	7	N
U	8	211	212	213	214	215	216	217	218	219	220	221	222	223	224	225	226	227	228	229	230	231	232	233	234	235	236	237	238	239	240	8	U
M	9	241	242	243	244	245	246	247	248	249	250	251	252	253	254	255	256	257	258	259	260	261	262	263	264	265	266	267	268	269	270	9	M
B	10	271	272	273	274	275	276	277	278	279	280	281	282	283	284	285	286	287	288	289	290	291	292	293	294	295	296	297	298	299	300	10	B
E																																	E
R	11	301	302	303	304	305	306	307	308	309	310	311	312	313	314	315	316	317	318	319	320	321	322	323	324	325	326	327	328	329	330	11	R
	12	331	332	333	334	335	336	337	338	339	340	341	342	343	344	345	346	347	348	349	350	351	352	353	354	355	356	357	358	359	360	12	
	13	361	362	363	364	365	366	367	368	369	370	371	372	373	374	375	376	377	378	379	380	381	382	383	384	385	386	387	388	389	390	13	
	14	391	392	393	394	395	396	397	398	399	400	401	402	403	404	405	406	407	408	409	410	411	412	413	414	415	416	417	418	419	420	14	
	15	421	422	423	424	425	426	427	428	429	430	431	432	433	434	435	436	437	438	439	440	441	442	443	444	445	446	447	448	449	450	15	
	16	451	452	453	454	455	456	457	458	459	460	461	462	463	464	465	466	467	468	469	470	471	472	473	474	475	476	477	478	479	480	16	
	17	481	482	483	484	485	486	487	488	489	490	491	492	493	494	495	496	497	498	499	500	501	502	503	504	505	506	507	508	509	510	17	
	18	511	512	513	514	515	516	517	518	519	520	521	522	523	524	525	526	527	528	529	530	531	532	533	534	535	536	537	538	539	540	18	
	19	541	542	543	544	545	546	547	548	549	550	551	552	553	554	555	556	557	558	559	560	561	562	563	564	565	566	567	568	569	570	19	
	20	571	572	573	574	575	576	577	578	579	580	581	582	583	584	585	586	587	588	589	590	591	592	593	594	595	596	597	598	599	600	20	
	21	601	602	603	604	605	606	607	608	609	610	611	612	613	614	615	616	617	618	619	620	621	622	623	624	625	626	627	628	629	630	21	
	22	631	632	633	634	635	636	637	638	639	640	641	642	643	644	645	646	647	648	649	650	651	652	653	654	655	656	657	658	659	660	22	
	23	661	662	663	664	665	666	667	668	669	670	671	672	673	674	675	676	677	678	679	680	681	682	683	684	685	686	687	688	689	690	23	
	24	691	692	693	694	695	696	697	698	699	700	701	702	703	704	705	706	707	708	709	710	711	712	713	714	715	716	717	718	719	720	24	
	25	721	722	723	724	725	726	727	728	729	730	731	732	733	734	735	736	737	738	739	740	741	742	743	744	745	746	747	748	749	750	25	
	26	751	752	753	754	755	756	757	758	759	760	761	762	763	764	765	766	767	768	769	770	771	772	773	774	775	776	777	778	779	780	26	
	27	781	782	783	784	785	786	787	788	789	790	791	792	793	794	795	796	797	798	799	800	801	802	803	804	805	806	807	808	809	810	27	
	28	811	812	813	814	815	816	817	818	819	820	821	822	823	824	825	826	827	828	829	830	831	832	833	834	835	836	837	838	839	840	28	
	29	841	842	843	844	845	846	847	848	849	850	851	852	853	854	855	856	857	858	859	860	861	862	863	864	865	866	867	868	869	870	29	
	30	871	872	873	874	875	876	877	878	879	880	881	882	883	884	885	886	887	888	889	890	891	892	893	894	895	896	897	898	899	900	30	

REMARKS:

GRADER'S SIGNATURE_____DATE_____

Example #6 (SAMPLE SELECTION WORKSHEET – 48 HALF CASES PER PALLET)

LOT INFORMATION

Grade & Size : A Medium

Type of pack : 1 dz ctns (w/d brand)

No./Size of Cases : 736/15 = 368/30-DOZ.

Samples Needed : 13

Audit Number :

SAMPLE CONTAINERS SELECTED

1. 728	11. 736
2. 321	12. 161
3. 524	13. 230
4. 260	14.
5. 525	15.
6. 79	16.
7. 167	17.
8. 294	18.
9. 261	19.
10. 391	20.

INSTRUCTIONS: CIRCLE EACH SAMPLE IN THE CHART BELOW.

LAYER NUMBER	1						2						3						4						LAYER NUMBER
CONT. POS.	2	4	6	8	10	12	2	4	6	8	10	12	2	4	6	8	10	12	2	4	6	8	10	12	CONT. POS.
PALLET NUMBER 1	2	4	6	8	10	12	14	16	18	20	22	24	26	28	30	32	34	36	38	40	42	44	46	48	1
2	50	52	54	56	58	60	62	64	66	68	70	72	74	76	78	80	82	84	86	88	90	92	94	96	2
3	98	100	102	104	106	108	110	112	114	116	118	120	122	124	126	128	130	132	134	136	138	140	142	144	3
4	146	148	150	152	154	156	158	160	162	164	166	168	170	172	174	176	178	180	182	184	186	188	190	192	4
5	194	196	198	200	202	204	206	208	210	212	214	216	218	220	222	224	226	228	230	232	234	236	238	240	5
6	242	244	246	248	250	252	254	256	258	260	262	264	266	268	270	272	274	276	278	280	282	284	286	288	6
7	290	292	294	296	298	300	302	304	306	308	310	312	314	316	318	320	322	324	326	328	330	332	334	336	7
8	338	340	342	344	346	348	350	352	354	356	358	360	362	364	366	368	370	372	374	376	378	380	382	384	8
9	386	388	390	392	394	396	398	400	402	404	406	408	410	412	414	416	418	420	422	424	426	428	430	432	9
10	434	436	438	440	442	444	446	448	450	452	454	456	458	460	462	464	466	468	470	472	474	476	478	480	10
11	482	484	486	488	490	492	494	496	498	500	502	504	506	508	510	512	514	516	518	520	522	524	526	528	11
12	530	532	534	536	538	540	542	544	546	548	550	552	554	556	558	560	562	564	566	568	570	572	574	576	12
13	578	580	582	584	586	588	590	592	594	596	598	600	602	604	606	608	610	612	614	616	618	620	622	624	13
14	626	628	630	632	634	636	638	640	642	644	646	648	650	652	654	656	658	660	662	664	666	668	670	672	14
15	674	676	678	680	682	684	686	688	690	692	694	696	698	700	702	704	706	708	710	712	714	716	718	720	15
16	722	724	726	728	730	732	734	736	738	740	742	744	746	748	750	752	754	756	758	760	762	764	766	768	16
17	770	772	774	776	778	780	782	784	786	788	790	792	794	796	798	800	802	804	806	808	810	812	814	816	17
18	818	820	822	824	826	828	830	832	834	836	838	840	842	844	846	848	850	852	854	856	858	860	862	864	18
19	866	868	870	872	874	876	878	880	882	884	886	888	890	892	894	896	898	900	902	904	906	908	910	912	19
20	914	916	918	920	922	924	926	928	930	932	934	936	938	940	942	944	946	948	950	952	954	956	958	960	20
21	962	964	966	968	970	972	974	976	978	980	982	984	986	988	990	992	994	996	998	1000	1002	1004	1006	1008	21
22	1010	1012	1014	1016	1018	1020	1022	1024	1026	1028	1030	1032	1034	1036	1038	1040	1042	1044	1046	1048	1050	1052	1054	1056	22
23	1058	1060	1062	1064	1066	1068	1070	1072	1074	1076	1078	1080	1082	1084	1086	1088	1090	1092	1094	1096	1098	1100	1102	1104	23
24	1106	1108	1110	1112	1114	1116	1118	1120	1122	1124	1126	1128	1130	1132	1134	1136	1138	1140	1142	1144	1146	1148	1150	1152	24
25	1154	1156	1158	1160	1162	1164	1166	1168	1170	1172	1174	1176	1178	1180	1182	1184	1186	1188	1190	1192	1194	1196	1198	1200	25
26	1202	1204	1206	1208	1210	1212	1214	1216	1218	1220	1222	1224	1226	1228	1230	1232	1234	1236	1238	1240	1242	1244	1246	1248	26
27	1250	1252	1254	1256	1258	1260	1262	1264	1266	1268	1270	1272	1274	1276	1278	1280	1282	1284	1286	1288	1290	1292	1294	1296	27
28	1298	1300	1302	1304	1306	1308	1310	1312	1314	1316	1318	1320	1322	1324	1326	1328	1330	1332	1334	1336	1338	1340	1342	1344	28
29	1346	1348	1350	1352	1354	1356	1358	1360	1362	1364	1366	1368	1370	1372	1374	1376	1378	1380	1382	1384	1386	1388	1390	1392	29
30	1394	1396	1398	1400	1402	1404	1406	1408	1410	1412	1414	1416	1418	1420	1422	1424	1426	1428	1430	1432	1434	1436	1438	1440	30

REMARKS:

GRADER'S SIGNATURE_____DATE_____

B. Product on Racks ("Bossies")

Example # 7

18	17	16
13	14	15
12	11	10
7	8	9
6	5	4
1	2	3

RACK #1

36	35	34
31	32	33
30	29	28
25	26	27
24	23	22
19	20	21

RACK #2

54	53	52
49	50	51
48	47	46
43	44	45
42	41	40
37	38	39

RACK #3

72	71	70
67	68	69
66	65	64
61	62	63
60	59	58
55	56	57

RACK #4

90	89	88
85	86	87
84	83	82
79	80	81
78	77	76
73	74	75

RACK#5

108	107	106
103	104	105
102	101	100
97	98	99
96	95	94
91	92	93

RACK #6

126	125	124
121	122	123
120	119	118
115	116	117
114	113	112
109	110	111

RACK #7

144	143	142
139	140	141
138	137	136
133	134	135
132	131	130
127	128	129

RACK #8

162	161	160
157	158	159
156	155	154
151	152	153
150	149	148
145	146	147

RACK #9

180	179	178
175	176	177
174	173	172
169	170	171
168	167	166
163	164	165

RACK #10

198	197	196
193	194	195
192	191	190
187	188	189
186	185	184
181	182	183

RACK #11

216	215	214
211	212	213
210	209	208
205	206	207
204	203	202
199	200	201

RACK #12

234	233	232
229	230	231
228	227	226
223	224	225
222	221	220
217	218	219

RACK #13

252	251	250
247	248	249
246	245	244
241	242	243
240	239	238
235	236	237

RACK #14

270	269	268
265	266	267
264	263	262
259	260	261
258	257	256
253	254	255

RACK #15

288	287	286
283	284	285
282	281	280
277	278	279
276	275	274
271	272	273

RACK #16

Worksheet #11 is designed for product which is stacked on movable racks or bossies. The total amount of product in the lot must be converted into equivalent 30-dozen cases to determine the number of samples. The lot must also be broken down into "imaginary half cases" on the worksheet to determine which cartons or flats will be sampled. Each imaginary half case may contain from 15 to 21-dozen, depending on how high product is stacked on the shelves (see Example #7).

3,600/1-dozen cartons (equivalent to 120/30-dozen cases) are stacked on 10 racks, with 3 shelves each. The bottom 2 shelves are stacked 7 high, 2 deep, 9 across, which equals 126-dozen on each shelf. The top shelf is stacked 6 high, 2 deep, 9 across, which equals 108-dozen.

Each shelf is to be mentally divided into six imaginary half cases. In this example, the imaginary half cases on the bottom shelves will contain 21-dozen (three/7-carton stacks), while the half cases on the top shelf will contain 18-dozen (three/6-carton stacks). When facing the front of the rack, begin on the left front of the bottom shelf with #1, and proceed counter-clockwise across the front side and then to the backside, mentally numbering 6 half cases.

By following the same procedures, mentally number half cases 7 through 12 on the second shelf, and 13 through 18 on the top shelf. Repeating this procedure for racks 2 through 10 will result in a total of 180 half-cases being identified. The "180" is the "total number of containers" which would be entered into the calculator. Eight numbers are then generated, which will be the samples. Circle these numbers on the worksheet, to locate the appropriate rack number and shelf number.

Worksheet #15 is designed for sampling partial pallets or racks, as applicable. There are eight grids for pallets, with "full" cases. Half cases may also be accommodated by diagonally dividing each box. There are also 8 grids for racks, with space for up to 18 "imaginary" half-cases on each rack. Using one grid for each partial pallet or rack, number the boxes, beginning on the bottom left, to correspond to the number of containers on the pallet or rack (Example #9).

C. Sampling Partial Pallets or "Racks"

Example #9 – Sample Selection Worksheet #15

LOT INFORMATION

Grade & Size : A Extra Large

Type of pack : 1 dz ctns

No./Size of Cases : 4 Part = 87/30-DOZ.

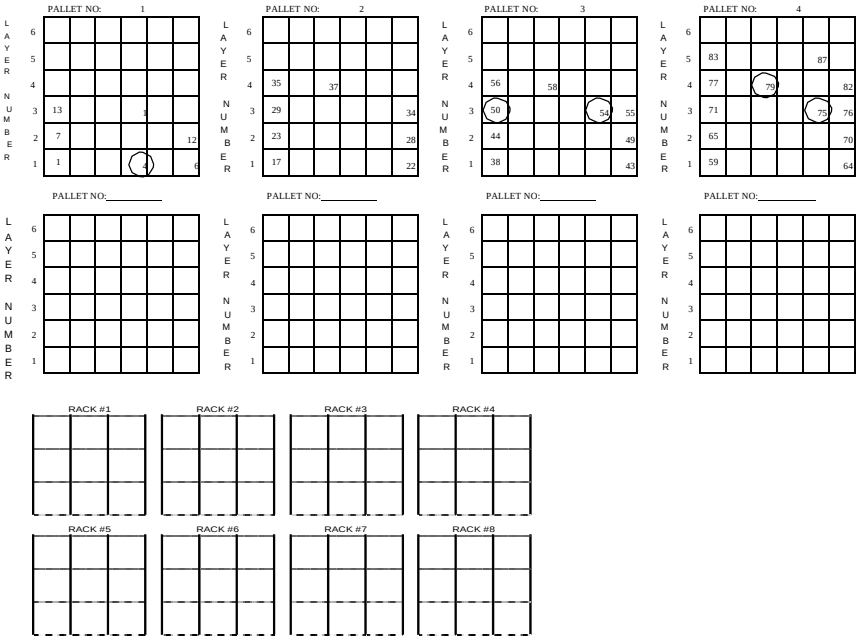
Samples Needed : 5

Audit Number :

SAMPLE CONTAINERS SELECTED

1. 79	11.
2. 54	12.
3. 50	13.
4. 75	14.
5. 4	15.
6.	16.
7.	17.
8.	18.
9.	19.
10.	20.

INSTRUCTIONS: CIRCLE EACH SAMPLE IN THE CHART BELOW.



REMARKS:

GRADER'S SIGNATURE_____DATE_____

D. Combining Different Types (Sizes) of Packing or Shipping Containers

On occasion, product of the same grade and size packed in different size containers and/or types of packaging material may be presented for grading as one stationary lot. For example: 100/30-dozen cases of A Large cartoned eggs and 200/15-dozen cases of A Large loose eggs are offered as one lot. In this situation, one "grand" lot equaling 200/30-dozen cases is the sampling unit. The lot may be sampled on this basis; however, it may be necessary to use separate worksheets to record the different sized containers and types of packing material and to designate the samples.

Completed Sample Selection Worksheets are to be attached to the applicable Form PY-211, Poultry Products Grading Memorandum.

COOLER SAMPLE WORKSHEET

Plant Name:											**Plant Number:**
Grader:											**Week of:**
	Date Sampled	Dated Packed	Sample Number	Brand Name	Grade / Size	AA	A	B	Dirts	Checks	Loss
Original											
Regrade											
Original											
Regrade											
Original											
Regrade											
Original											
Regrade											
Original											
Regrade											

Plant Name:											**Plant Number:**
Grader:											**Week of:**
	Date Sampled	Dated Packed	Sample Number	Brand Name	Grade / Size	AA	A	B	Dirts	Checks	Loss
Original											
Regrade											
Original											
Regrade											
Original											
Regrade											
Original											
Regrade											
Original											
Regrade											
Comments:											

Worksheet #1

SAMPLE SELECTION WORKSHEET
15 FULL CASES PER "DOLLY"

LOT INFORMATION

Grade & Size :_____

Type of pack :_____

No./Size of Cases :_____=____/30-DOZ.

Samples Needed :_____

Audit Number :_____

SAMPLE CONTAINERS SELECTED

1._____ 11._____
2._____ 12._____
3._____ 13._____
4._____ 14._____
5._____ 15._____
6._____ 16._____
7._____ 17._____
8._____ 18._____
9._____ 19._____
10._____ 20._____

INSTRUCTIONS: CIRCLE EACH SAMPLE IN THE CHART BELOW.

LAYER NUMBER		1			2			3			4			5			LAYER NUMBER	
CONTAINER POSITION		1	2	3	1	2	3	1	2	3	1	2	3	1	2	3	CONTAINER POSITION	
D	1	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	1	D
O	2	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	2	O
L	3	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	3	L
L	4	46	47	48	49	50	51	52	53	54	55	56	57	58	59	60	4	L
Y	5	61	62	63	64	65	66	67	68	69	70	71	72	73	74	75	5	Y
N	6	76	77	78	79	80	81	82	83	84	85	86	87	88	89	90	6	N
U	7	91	92	93	94	95	96	97	98	99	100	101	102	103	104	105	7	U
M	8	106	107	108	109	110	111	112	113	114	115	116	117	118	119	120	8	M
B	9	121	122	123	124	125	126	127	128	129	130	131	132	133	134	135	9	B
E	10	136	137	138	139	140	141	142	143	144	145	146	147	148	149	150	10	E
R																		R
	11	151	152	153	154	155	156	157	158	159	160	161	162	163	164	165	11	
	12	166	167	168	169	170	171	172	173	174	175	176	177	178	179	180	12	
	13	181	182	183	184	185	186	187	188	189	190	191	192	193	194	195	13	
	14	196	197	198	199	200	201	202	203	204	205	206	207	208	209	210	14	
	15	211	212	213	214	215	216	217	218	219	220	221	222	223	224	225	15	
	16	226	227	228	229	230	231	232	233	234	235	236	237	238	239	240	16	
	17	241	242	243	244	245	246	247	248	249	250	251	252	253	254	255	17	
	18	256	257	258	259	260	261	262	263	264	265	266	267	268	269	270	18	
	19	271	272	273	274	275	276	277	278	279	280	281	282	283	284	285	19	
	20	286	287	288	289	290	291	292	293	294	295	296	297	298	299	300	20	
	21	301	302	303	304	305	306	307	308	309	310	311	312	313	314	315	21	
	22	316	317	318	319	320	321	322	323	324	325	326	327	328	329	330	22	
	23	331	332	333	334	335	336	337	338	339	340	341	342	343	344	345	23	
	24	346	347	348	349	350	351	352	353	354	355	356	357	358	359	360	24	
	25	361	362	363	364	365	366	367	368	369	370	371	372	373	374	375	25	
	26	376	377	378	379	380	381	382	383	384	385	386	387	388	389	390	26	
	27	391	392	393	394	395	396	397	398	399	400	401	402	403	404	405	27	
	28	406	407	408	409	410	411	412	413	414	415	416	417	418	419	420	28	
	29	421	422	423	424	425	426	427	428	429	430	431	432	433	434	435	29	
	30	436	437	438	439	440	441	442	443	444	445	446	447	448	449	450	30	
	31	451	452	453	454	455	456	457	458	459	460	461	462	463	464	465	31	
	32	466	467	468	469	470	471	472	473	474	475	476	477	478	479	480	32	
	33	481	482	483	484	485	486	487	488	489	490	491	492	493	494	495	33	
	34	496	497	498	499	500	501	502	503	504	505	506	507	508	509	510	34	
	35	511	512	513	514	515	516	517	518	519	520	521	522	523	524	525	35	
	36	526	527	528	529	530	531	532	533	534	535	536	537	538	539	540	36	
	37	541	542	543	544	545	546	547	548	549	550	551	552	553	554	555	37	
	38	556	557	558	559	560	561	562	563	564	565	566	567	568	569	570	38	
	39	571	572	573	574	575	576	577	578	579	580	581	582	583	584	585	39	
	40	586	587	588	589	590	591	592	593	594	595	596	597	598	599	600	40	
	41	601	602	603	604	605	606	607	608	609	610	611	612	613	614	615	41	
	42	616	617	618	619	620	621	622	623	624	625	626	627	628	629	630	42	
	43	631	632	633	634	635	636	637	638	639	640	641	642	643	644	645	43	
	44	646	647	648	649	650	651	652	653	654	655	656	657	658	659	660	44	
	45	661	662	663	664	665	666	667	668	669	670	671	672	673	674	675	45	
	46	676	677	678	679	680	681	682	683	684	685	686	687	688	689	690	46	
	47	691	692	693	694	695	696	697	698	699	700	701	702	703	704	705	47	
	48	706	707	708	709	710	711	712	713	714	715	716	717	718	719	720	48	
	49	721	722	723	724	725	726	727	728	729	730	731	732	733	734	735	49	
	50	736	737	738	739	740	741	742	743	744	745	746	747	748	749	750	50	

REMARKS:

GRADER'S SIGNATURE_____DATE_____

Worksheet #2

SAMPLE SELECTION WORKSHEET
24 FULL CASES PER PALLET

LOT INFORMATION

Grade & Size :_____

Type of pack :_____

No./Size of Cases :_____=____/30-DOZ.

Samples Needed :_____

Audit Number :_____

SAMPLE CONTAINERS SELECTED

1._____ 11._____
2._____ 12._____
3._____ 13._____
4._____ 14._____
5._____ 15._____
6._____ 16._____
7._____ 17._____
8._____ 18._____
9._____ 19._____
10._____ 20._____

INSTRUCTIONS: CIRCLE EACH SAMPLE IN THE CHART BELOW.

LAYER #		1						2						3						4						LAYER #	
CONT. POS.		1	2	3	4	5	6	1	2	3	4	5	6	1	2	3	4	5	6	1	2	3	4	5	6	CONT. POS.	
P	1	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	1	P
A	2	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	46	47	48	2	A
L	3	49	50	51	52	53	54	55	56	57	58	59	60	61	62	63	64	65	66	67	68	69	70	71	72	3	L
L	4	73	74	75	76	77	78	79	80	81	82	83	84	85	86	87	88	89	90	91	92	93	94	95	96	4	L
E	5	97	98	99	100	101	102	103	104	105	106	107	108	109	110	111	112	113	114	115	116	117	118	119	120	5	E
T																											T
	6	121	122	123	124	125	126	127	128	129	130	131	132	133	134	135	136	137	138	139	140	141	142	143	144	6	
N	7	145	146	147	148	149	150	151	152	153	154	155	156	157	158	159	160	161	162	163	164	165	166	167	168	7	N
U	8	169	170	171	172	173	174	175	176	177	178	179	180	181	182	183	184	185	186	187	188	189	190	191	192	8	U
M	9	193	194	195	196	197	198	199	200	201	202	203	204	205	206	207	208	209	210	211	212	213	214	215	216	9	M
B	10	217	218	219	220	221	222	223	224	225	226	227	228	229	230	231	232	233	234	235	236	237	238	239	240	10	B
E																											E
R	11	241	242	243	244	245	246	247	248	249	250	251	252	253	254	255	256	257	258	259	260	261	262	263	264	11	R
	12	265	266	267	268	269	270	271	272	273	274	275	276	277	278	279	280	281	282	283	284	285	286	287	288	12	
	13	289	290	291	292	293	294	295	296	297	298	299	300	301	302	303	304	305	306	307	308	309	310	311	312	13	
	14	313	314	315	316	317	318	319	320	321	322	323	324	325	326	327	328	329	330	331	332	333	334	335	336	14	
	15	337	338	339	340	341	342	343	344	345	346	347	348	349	350	351	352	353	354	355	356	357	358	359	360	15	
	16	361	362	363	364	365	366	367	368	369	370	371	372	373	374	375	376	377	378	379	380	381	382	383	384	16	
	17	385	386	387	388	389	390	391	392	393	394	395	396	397	398	399	400	401	402	403	404	405	406	407	408	17	
	18	409	410	411	412	413	414	415	416	417	418	419	420	421	422	423	424	425	426	427	428	429	430	431	432	18	
	19	433	434	435	436	437	438	439	440	441	442	443	444	445	446	447	448	449	450	451	452	453	454	455	456	19	
	20	457	458	459	460	461	462	463	464	465	466	467	468	469	470	471	472	473	474	475	476	477	478	479	480	20	
	21	481	482	483	484	485	486	487	488	489	490	491	492	493	494	495	496	497	498	499	500	501	502	503	504	21	
	22	505	506	507	508	509	510	511	512	513	514	515	516	517	518	519	520	521	522	523	524	525	526	527	528	22	
	23	529	530	531	532	533	534	535	536	537	538	539	540	541	542	543	544	545	546	547	548	549	550	551	552	23	
	24	553	554	555	556	557	558	559	560	561	562	563	564	565	566	567	568	569	570	571	572	573	574	575	576	24	
	25	577	578	579	580	581	582	583	584	585	586	587	588	589	590	591	592	593	594	595	596	597	598	599	600	25	
	26	601	602	603	604	605	606	607	608	609	610	611	612	613	614	615	616	617	618	619	620	621	622	623	624	26	
	27	625	626	627	628	629	630	631	632	633	634	635	636	637	638	639	640	641	642	643	644	645	646	647	648	27	
	28	649	650	651	652	653	654	655	656	657	658	659	660	661	662	663	664	665	666	667	668	669	670	671	672	28	
	29	673	674	675	676	677	678	679	680	681	682	683	684	685	686	687	688	689	690	691	692	693	694	695	696	29	
	30	697	698	699	700	701	702	703	704	705	706	707	708	709	710	711	712	713	714	715	716	717	718	719	720	30	

REMARKS:

GRADER'S SIGNATURE_____DATE_____

Worksheet #3

SAMPLE SELECTION WORKSHEET
30 FULL CASES PER PALLET

LOT INFORMATION

Grade & Size :_____

Type of pack :_____

No./Size of Cases :_____=____/30-DOZ.

Samples Needed :_____

Audit Number :_____

SAMPLE CONTAINERS SELECTED

1._____ 11._____
2._____ 12._____
3._____ 13._____
4._____ 14._____
5._____ 15._____
6._____ 16._____
7._____ 17._____
8._____ 18._____
9._____ 19._____
10._____ 20._____

INSTRUCTIONS: CIRCLE EACH SAMPLE IN THE CHART BELOW.

LAYER #		1						2						3						4						5						LAYER #	
CONT. POS.		1	2	3	4	5	6	1	2	3	4	5	6	1	2	3	4	5	6	1	2	3	4	5	6	1	2	3	4	5	6	CONT. POS.	
P	1	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	1	P
A	2	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50	51	52	53	54	55	56	57	58	59	60	2	A
L	3	61	62	63	64	65	66	67	68	69	70	71	72	73	74	75	76	77	78	79	80	81	82	83	84	85	86	87	88	89	90	3	L
L	4	91	92	93	94	95	96	97	98	99	100	101	102	103	104	105	106	107	108	109	110	111	112	113	114	115	116	117	118	119	120	4	L
E	5	121	122	123	124	125	126	127	128	129	130	131	132	133	134	135	136	137	138	139	140	141	142	143	144	145	146	147	148	149	150	5	E
T																																	T
	6	151	152	153	154	155	156	157	158	159	160	161	162	163	164	165	166	167	168	169	170	171	172	173	174	175	176	177	178	179	180	6	
N	7	181	182	183	184	185	186	187	188	189	190	191	192	193	194	195	196	197	198	199	200	201	202	203	204	205	206	207	208	209	210	7	N
U	8	211	212	213	214	215	216	217	218	219	220	221	222	223	224	225	226	227	228	229	230	231	232	233	234	235	236	237	238	239	240	8	U
M	9	241	242	243	244	245	246	247	248	249	250	251	252	253	254	255	256	257	258	259	260	261	262	263	264	265	266	267	268	269	270	9	M
B	10	271	272	273	274	275	276	277	278	279	280	281	282	283	284	285	286	287	288	289	290	291	292	293	294	295	296	297	298	299	300	10	B
E																																	E
R	11	301	302	303	304	305	306	307	308	309	310	311	312	313	314	315	316	317	318	319	320	321	322	323	324	325	326	327	328	329	330	11	R
	12	331	332	333	334	335	336	337	338	339	340	341	342	343	344	345	346	347	348	349	350	351	352	353	354	355	356	357	358	359	360	12	
	13	361	362	363	364	365	366	367	368	369	370	371	372	373	374	375	376	377	378	379	380	381	382	383	384	385	386	387	388	389	390	13	
	14	391	392	393	394	395	396	397	398	399	400	401	402	403	404	405	406	407	408	409	410	411	412	413	414	415	416	417	418	419	420	14	
	15	421	422	423	424	425	426	427	428	429	430	431	432	433	434	435	436	437	438	439	440	441	442	443	444	445	446	447	448	449	450	15	
	16	451	452	453	454	455	456	457	458	459	460	461	462	463	464	465	466	467	468	469	470	471	472	473	474	475	476	477	478	479	480	16	
	17	481	482	483	484	485	486	487	488	489	490	491	492	493	494	495	496	497	498	499	500	501	502	503	504	505	506	507	508	509	510	17	
	18	511	512	513	514	515	516	517	518	519	520	521	522	523	524	525	526	527	528	529	530	531	532	533	534	535	536	537	538	539	540	18	
	19	541	542	543	544	545	546	547	548	549	550	551	552	553	554	555	556	557	558	559	560	561	562	563	564	565	566	567	568	569	570	19	
	20	571	572	573	574	575	576	577	578	579	580	581	582	583	584	585	586	587	588	589	590	591	592	593	594	595	596	597	598	599	600	20	
	21	601	602	603	604	605	606	607	608	609	610	611	612	613	614	615	616	617	618	619	620	621	622	623	624	625	626	627	628	629	630	21	
	22	631	632	633	634	635	636	637	638	639	640	641	642	643	644	645	646	647	648	649	650	651	652	653	654	655	656	657	658	659	660	22	
	23	661	662	663	664	665	666	667	668	669	670	671	672	673	674	675	676	677	678	679	680	681	682	683	684	685	686	687	688	689	690	23	
	24	691	692	693	694	695	696	697	698	699	700	701	702	703	704	705	706	707	708	709	710	711	712	713	714	715	716	717	718	719	720	24	
	25	721	722	723	724	725	726	727	728	729	730	731	732	733	734	735	736	737	738	739	740	741	742	743	744	745	746	747	748	749	750	25	
	26	751	752	753	754	755	756	757	758	759	760	761	762	763	764	765	766	767	768	769	770	771	772	773	774	775	776	777	778	779	780	26	
	27	781	782	783	784	785	786	787	788	789	790	791	792	793	794	795	796	797	798	799	800	801	802	803	804	805	806	807	808	809	810	27	
	28	811	812	813	814	815	816	817	818	819	820	821	822	823	824	825	826	827	828	829	830	831	832	833	834	835	836	837	838	839	840	28	
	29	841	842	843	844	845	846	847	848	849	850	851	852	853	854	855	856	857	858	859	860	861	862	863	864	865	866	867	868	869	870	29	
	30	871	872	873	874	875	876	877	878	879	880	881	882	883	884	885	886	887	888	889	890	891	892	893	894	895	896	897	898	899	900	30	

REMARKS:

GRADER'S SIGNATURE_____DATE_____

Worksheet #4

SAMPLE SELECTION WORKSHEET
36 FULL CASES PER PALLET

LOT INFORMATION

Grade & Size :_____

Type of pack :_____

No./Size of Cases :_____=____/30-DOZ.

Samples Needed :_____

Audit Number :_____

SAMPLE CONTAINERS SELECTED

1._____ 11._____
2._____ 12._____
3._____ 13._____
4._____ 14._____
5._____ 15._____
6._____ 16._____
7._____ 17._____
8._____ 18._____
9._____ 19._____
10._____ 20._____

INSTRUCTIONS: CIRCLE EACH SAMPLE IN THE CHART BELOW.

LAYER NO.	1						2						3						4						5						6						LAYER NO.
CONT. POS.	1	2	3	4	5	6	1	2	3	4	5	6	1	2	3	4	5	6	1	2	3	4	5	6	1	2	3	4	5	6	1	2	3	4	5	6	CONT. POS.
P 1	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	1 P
A 2	37	38	39	40	41	42	43	44	45	46	47	48	49	50	51	52	53	54	55	56	57	58	59	60	61	62	63	64	65	66	67	68	69	70	71	72	2 A
L 3	73	74	75	76	77	78	79	80	81	82	83	84	85	86	87	88	89	90	91	92	93	94	95	96	97	98	99	100	101	102	103	104	105	106	107	108	3 L
L 4	109	110	111	112	113	114	115	116	117	118	119	120	121	122	123	124	125	126	127	128	129	130	131	132	133	134	135	136	137	138	139	140	141	142	143	144	4 L
E 5	145	146	147	148	149	150	151	152	153	154	155	156	157	158	159	160	161	162	163	164	165	166	167	168	169	170	171	172	173	174	175	176	177	178	179	180	5 E
T																																					T
6	181	182	183	184	185	186	187	188	189	190	191	192	193	194	195	196	197	198	199	200	201	202	203	204	205	206	207	208	209	210	211	212	213	214	215	216	6
N 7	217	218	219	220	221	222	223	224	225	226	227	228	229	230	231	232	233	234	235	236	237	238	239	240	241	242	243	244	245	246	247	248	249	250	251	252	7 N
U 8	253	254	255	256	257	258	259	260	261	262	263	264	265	266	267	268	269	270	271	272	273	274	275	276	277	278	279	280	281	282	283	284	285	286	287	288	8 U
M 9	289	290	291	292	293	294	295	296	297	298	299	300	301	302	303	304	305	306	307	308	309	310	311	312	313	314	315	316	317	318	319	320	321	322	323	324	9 M
B 10	325	326	327	328	329	330	331	332	333	334	335	336	337	338	339	340	341	342	343	344	345	346	347	348	349	350	351	352	353	354	355	356	357	358	359	360	10 B
E																																					E
R 11	361	362	363	364	365	366	367	368	369	370	371	372	373	374	375	376	377	378	379	380	381	382	383	384	385	386	387	388	389	390	391	392	393	394	395	396	11 R
12	397	398	399	400	401	402	403	404	405	406	407	408	409	410	411	412	413	414	415	416	417	418	419	420	421	422	423	424	425	426	427	428	429	430	431	432	12
13	433	434	435	436	437	438	439	440	441	442	443	444	445	446	447	448	449	450	451	452	453	454	455	456	457	458	459	460	461	462	463	464	465	466	467	468	13
14	469	470	471	472	473	474	475	476	477	478	479	480	481	482	483	484	485	486	487	488	489	490	491	492	493	494	495	496	497	498	499	500	501	502	503	504	14
15	505	506	507	508	509	510	511	512	513	514	515	516	517	518	519	520	521	522	523	524	525	526	527	528	529	530	531	532	533	534	535	536	537	538	539	540	15
16	541	542	543	544	545	546	547	548	549	550	551	552	553	554	555	556	557	558	559	560	561	562	563	564	565	566	567	568	569	570	571	572	573	574	575	576	16
17	577	578	579	580	581	582	583	584	585	586	587	588	589	590	591	592	593	594	595	596	597	598	599	600	601	602	603	604	605	606	607	608	609	610	611	612	17
18	613	614	615	616	617	618	619	620	621	622	623	624	625	626	627	628	629	630	631	632	633	634	635	636	637	638	639	640	641	642	643	644	645	646	647	648	18
19	649	650	651	652	653	654	655	656	657	658	659	660	661	662	663	664	665	666	667	668	669	670	671	672	673	674	675	676	677	678	679	680	681	682	683	684	19
20	685	686	687	688	689	690	691	692	693	694	695	696	697	698	699	700	701	702	703	704	705	706	707	708	709	710	711	712	713	714	715	716	717	718	719	720	20
21	721	722	723	724	725	726	727	728	729	730	731	732	733	734	735	736	737	738	739	740	741	742	743	744	745	746	747	748	749	750	751	752	753	754	755	756	21
22	757	758	759	760	761	762	763	764	765	766	767	768	769	770	771	772	773	774	775	776	777	778	779	780	781	782	783	784	785	786	787	788	789	790	791	792	22
23	793	794	795	796	797	798	799	800	801	802	803	804	805	806	807	808	809	810	811	812	813	814	815	816	817	818	819	820	821	822	823	824	825	826	827	828	23
24	829	830	831	832	833	834	835	836	837	838	839	840	841	842	843	844	845	846	847	848	849	850	851	852	853	854	855	856	857	858	859	860	861	862	863	864	24
25	865	866	867	868	869	870	871	872	873	874	875	876	877	878	879	880	881	882	883	884	885	886	887	888	889	890	891	892	893	894	895	896	897	898	899	900	25
26	901	902	903	904	905	906	907	908	909	910	911	912	913	914	915	916	917	918	919	920	921	922	923	924	925	926	927	928	929	930	931	932	933	934	935	936	26
27	937	938	939	940	941	942	943	944	945	946	947	948	949	950	951	952	953	954	955	956	957	958	959	960	961	962	963	964	965	966	967	968	969	970	971	972	27
28	973	974	975	976	977	978	979	980	981	982	983	984	985	986	987	988	989	990	991	992	993	994	995	996	997	998	999	1000	1001	1002	1003	1004	1005	1006	1007	1008	28
29	1009	1010	1011	1012	1013	1014	1015	1016	1017	1018	1019	1020	1021	1022	1023	1024	1025	1026	1027	1028	1029	1030	1031	1032	1033	1034	1035	1036	1037	1038	1039	1040	1041	1042	1043	1044	29
30	1045	1046	1047	1048	1049	1050	1051	1052	1053	1054	1055	1056	1057	1058	1059	1060	1061	1062	1063	1064	1065	1066	1067	1068	1069	1070	1071	1072	1073	1074	1075	1076	1077	1078	1079	1080	30

REMARKS:

GRADER'S SIGNATURE_____DATE_____

Worksheet #5

SAMPLE SELECTION WORKSHEET
42 FULL CASES PER PALLET

LOT INFORMATION

Grade & Size :_____

Type of pack :_____

No./Size of Cases :_____=____/30-DOZ.

Samples Needed :_____

Audit Number :_____

SAMPLE CONTAINERS SELECTED

1._____ 11._____
2._____ 12._____
3._____ 13._____
4._____ 14._____
5._____ 15._____
6._____ 16._____
7._____ 17._____
8._____ 18._____
9._____ 19._____
10._____ 20._____

INSTRUCTIONS: CIRCLE EACH SAMPLE IN THE CHART BELOW.

LAYER NUMBER		1			2			3			4			5			6			7			LAYER NUMBER	
CONT. POS.		2	4	6	2	4	6	2	4	6	2	4	6	2	4	6	2	4	6	2	4	6	CONT. POS.	
P	1	2	4	6	8	10	12	14	16	18	20	22	24	26	28	30	32	34	36	38	40	42	1	P
A	2	44	46	48	50	52	54	56	58	60	62	64	66	68	70	72	74	76	78	80	82	84	2	A
L	3	86	88	90	92	94	96	98	100	102	104	106	108	110	112	114	116	118	120	122	124	126	3	L
L	4	128	130	132	134	136	138	140	142	144	146	148	150	152	154	156	158	160	162	164	166	168	4	L
E	5	170	172	174	176	178	180	182	184	186	188	190	192	194	196	198	200	202	204	206	208	210	5	E
T																								T
	6	212	214	216	218	220	222	224	226	228	230	232	234	236	238	240	242	244	246	248	250	252	6	
N	7	254	256	258	260	262	264	266	268	270	272	274	276	278	280	282	284	286	288	290	292	294	7	N
U	8	296	298	300	302	304	306	308	310	312	314	316	318	320	322	324	326	328	330	332	334	336	8	U
M	9	338	340	342	344	346	348	350	352	354	356	358	360	362	364	366	368	370	372	374	376	378	9	M
B	10	380	382	384	386	388	390	392	394	396	398	400	402	404	406	408	410	412	414	416	418	420	10	B
E																								E
R	11	422	424	426	428	430	432	434	436	438	440	442	444	446	448	450	452	454	456	458	460	462	11	R
	12	464	466	468	470	472	474	476	478	480	482	484	486	488	490	492	494	496	498	500	502	504	12	
	13	506	508	510	512	514	516	518	520	522	524	526	528	530	532	534	536	538	540	542	544	546	13	
	14	548	550	552	554	556	558	560	562	564	566	568	570	572	574	576	578	580	582	584	586	588	14	
	15	590	592	594	596	598	600	602	604	606	608	610	612	614	616	618	620	622	624	626	628	630	15	
	16	632	634	636	638	640	642	644	646	648	650	652	654	656	658	660	662	664	666	668	670	672	16	
	17	674	676	678	680	682	684	686	688	690	692	694	696	698	700	702	704	706	708	710	712	714	17	
	18	716	718	720	722	724	726	728	730	732	734	736	738	740	742	744	746	748	750	752	754	756	18	
	19	758	760	762	764	766	768	770	772	774	776	778	780	782	784	786	788	790	792	794	796	798	19	
	20	800	802	804	806	808	810	812	814	816	818	820	822	824	826	828	830	832	834	836	838	840	20	
	21	842	844	846	848	850	852	854	856	858	860	862	864	866	868	870	872	874	876	878	880	882	21	
	22	884	886	888	890	892	894	896	898	900	902	904	906	908	910	912	914	916	918	920	922	924	22	
	23	926	928	930	932	934	936	938	940	942	944	946	948	950	952	954	956	958	960	962	964	966	23	
	24	968	970	972	974	976	978	980	982	984	986	988	990	992	994	996	998	1000	1002	1004	1006	1008	24	
	25	1010	1012	1014	1016	1018	1020	1022	1024	1026	1028	1030	1032	1034	1036	1038	1040	1042	1044	1046	1048	1050	25	
	26	1052	1054	1056	1058	1060	1062	1064	1066	1068	1070	1072	1074	1076	1078	1080	1082	1084	1086	1088	1090	1092	26	
	27	1094	1096	1098	1100	1102	1104	1106	1108	1110	1112	1114	1116	1118	1120	1122	1124	1126	1128	1130	1132	1134	27	
	28	1136	1138	1140	1142	1144	1146	1148	1150	1152	1154	1156	1158	1160	1162	1164	1166	1168	1170	1172	1174	1176	28	
	29	1178	1180	1182	1184	1186	1188	1190	1192	1194	1196	1198	1200	1202	1204	1206	1208	1210	1212	1214	1216	1218	29	
	30	1220	1222	1224	1226	1228	1230	1232	1234	1236	1238	1240	1242	1244	1246	1248	1250	1252	1254	1256	1258	1260	30	

REMARKS:

GRADER'S SIGNATURE_____DATE_____

Worksheet #6

SAMPLE SELECTION WORKSHEET
36 HALF CASES PER PALLET

LOT INFORMATION

Grade & Size :_____

Type of pack :_____

No./Size of Cases :_____=____/30-DOZ.

Samples Needed :_____

Audit Number :_____

SAMPLE CONTAINERS SELECTED

1._____ 11._____
2._____ 12._____
3._____ 13._____
4._____ 14._____
5._____ 15._____
6._____ 16._____
7._____ 17._____
8._____ 18._____
9._____ 19._____
10._____ 20._____

INSTRUCTIONS: CIRCLE EACH SAMPLE IN THE CHART BELOW.

LAYER NUMBER		1						2						3						LAYER NUMBER	
CONTAINER POSITION		2	4	6	8	10	12	2	4	6	8	10	12	2	4	6	8	10	12	CONTAINER POSITION	
P	1	2	4	6	8	10	12	14	16	18	20	22	24	26	28	30	32	34	36	1	P
A	2	38	40	42	44	46	48	50	52	54	56	58	60	62	64	66	68	70	72	2	A
L	3	74	76	78	80	82	84	86	88	90	92	94	96	98	100	102	104	106	108	3	L
L	4	110	112	114	116	118	120	122	124	126	128	130	132	134	136	138	140	142	144	4	L
E	5	146	148	150	152	154	156	158	160	162	164	166	168	170	172	174	176	178	180	5	E
T																					T
	6	182	184	186	188	190	192	194	196	198	200	202	204	206	208	210	212	214	216	6	
N	7	218	220	222	224	226	228	230	232	234	236	238	240	242	244	246	248	250	252	7	N
U	8	254	256	258	260	262	264	266	268	270	272	274	276	278	280	282	284	286	288	8	U
M	9	290	292	294	296	298	300	302	304	306	308	310	312	314	316	318	320	322	324	9	M
B	10	326	328	330	332	334	336	338	340	342	344	346	348	350	352	354	356	358	360	10	B
E																					E
R	11	362	364	366	368	370	372	374	376	378	380	382	384	386	388	390	392	394	396	11	R
	12	398	400	402	404	406	408	410	412	414	416	418	420	422	424	426	428	430	432	12	
	13	434	436	438	440	442	444	446	448	450	452	454	456	458	460	462	464	466	468	13	
	14	470	472	474	476	478	480	482	484	486	488	490	492	494	496	498	500	502	504	14	
	15	506	508	510	512	514	516	518	520	522	524	526	528	530	532	534	536	538	540	15	
	16	542	544	546	548	550	552	554	556	558	560	562	564	566	568	570	572	574	576	16	
	17	578	580	582	584	586	588	590	592	594	596	598	600	602	604	606	608	610	612	17	
	18	614	616	618	620	622	624	626	628	630	632	634	636	638	640	642	644	646	648	18	
	19	650	652	654	656	658	660	662	664	666	668	670	672	674	676	678	680	682	684	19	
	20	686	688	690	692	694	696	698	700	702	704	706	708	710	712	714	716	718	720	20	
	21	722	724	726	728	730	732	734	736	738	740	742	744	746	748	750	752	754	756	21	
	22	758	760	762	764	766	768	770	772	774	776	778	780	782	784	786	788	790	792	22	
	23	794	796	798	800	802	804	806	808	810	812	814	816	818	820	822	824	826	828	23	
	24	830	832	834	836	838	840	842	844	846	848	850	852	854	856	858	860	862	864	24	
	25	866	868	870	872	874	876	878	880	882	884	886	888	890	892	894	896	898	900	25	
	26	902	904	906	908	910	912	914	916	918	920	922	924	926	928	930	932	934	936	26	
	27	938	940	942	944	946	948	950	952	954	956	958	960	962	964	966	968	970	972	27	
	28	974	976	978	980	982	984	986	988	990	992	994	996	998	1000	1002	1004	1006	1008	28	
	29	1010	1012	1014	1016	1018	1020	1022	1024	1026	1028	1030	1032	1034	1036	1038	1040	1042	1044	29	
	30	1046	1048	1050	1052	1054	1056	1058	1060	1062	1064	1066	1068	1070	1072	1074	1076	1078	1080	30	

REMARKS:

GRADER'S SIGNATURE_____DATE_____

Worksheet #7

SAMPLE SELECTION WORKSHEET
48 HALF CASES PER PALLET

LOT INFORMATION

Grade & Size :_____

Type of pack :_____

No./Size of Cases :_____=____/30-DOZ.

Samples Needed :_____

Audit Number :_____

SAMPLE CONTAINERS SELECTED

1._____ 11._____
2._____ 12._____
3._____ 13._____
4._____ 14._____
5._____ 15._____
6._____ 16._____
7._____ 17._____
8._____ 18._____
9._____ 19._____
10._____ 20._____

INSTRUCTIONS: CIRCLE EACH SAMPLE IN THE CHART BELOW.

LAYER NUMBER		1						2						3						4						LAYER NUMBER	
CONT. POS.		2	4	6	8	10	12	2	4	6	8	10	12	2	4	6	8	10	12	2	4	6	8	10	12	CONT. POS.	
P	1	2	4	6	8	10	12	14	16	18	20	22	24	26	28	30	32	34	36	38	40	42	44	46	48	1	P
A	2	50	52	54	56	58	60	62	64	66	68	70	72	74	76	78	80	82	84	86	88	90	92	94	96	2	A
L	3	98	100	102	104	106	108	110	112	114	116	118	120	122	124	126	128	130	132	134	136	138	140	142	144	3	L
L	4	146	148	150	152	154	156	158	160	162	164	166	168	170	172	174	176	178	180	182	184	186	188	190	192	4	L
E	5	194	196	198	200	202	204	206	208	210	212	214	216	218	220	222	224	226	228	230	232	234	236	238	240	5	E
T																											T
	6	242	244	246	248	250	252	254	256	258	260	262	264	266	268	270	272	274	276	278	280	282	284	286	288	6	
N	7	290	292	294	296	298	300	302	304	306	308	310	312	314	316	318	320	322	324	326	328	330	332	334	336	7	N
U	8	338	340	342	344	346	348	350	352	354	356	358	360	362	364	366	368	370	372	374	376	378	380	382	384	8	U
M	9	386	388	390	392	394	396	398	400	402	404	406	408	410	412	414	416	418	420	422	424	426	428	430	432	9	M
B	10	434	436	438	440	442	444	446	448	450	452	454	456	458	460	462	464	466	468	470	472	474	476	478	480	10	B
E																											E
R	11	482	484	486	488	490	492	494	496	498	500	502	504	506	508	510	512	514	516	518	520	522	524	526	528	11	R
	12	530	532	534	536	538	540	542	544	546	548	550	552	554	556	558	560	562	564	566	568	570	572	574	576	12	
	13	578	580	582	584	586	588	590	592	594	596	598	600	602	604	606	608	610	612	614	616	618	620	622	624	13	
	14	626	628	630	632	634	636	638	640	642	644	646	648	650	652	654	656	658	660	662	664	666	668	670	672	14	
	15	674	676	678	680	682	684	686	688	690	692	694	696	698	700	702	704	706	708	710	712	714	716	718	720	15	
	16	722	724	726	728	730	732	734	736	738	740	742	744	746	748	750	752	754	756	758	760	762	764	766	768	16	
	17	770	772	774	776	778	780	782	784	786	788	790	792	794	796	798	800	802	804	806	808	810	812	814	816	17	
	18	818	820	822	824	826	828	830	832	834	836	838	840	842	844	846	848	850	852	854	856	858	860	862	864	18	
	19	866	868	870	872	874	876	878	880	882	884	886	888	890	892	894	896	898	900	902	904	906	908	910	912	19	
	20	914	916	918	920	922	924	926	928	930	932	934	936	938	940	942	944	946	948	950	952	954	956	958	960	20	
	21	962	964	966	968	970	972	974	976	978	980	982	984	986	988	990	992	994	996	998	1000	1002	1004	1006	1008	21	
	22	1010	1012	1014	1016	1018	1020	1022	1024	1026	1028	1030	1032	1034	1036	1038	1040	1042	1044	1046	1048	1050	1052	1054	1056	22	
	23	1058	1060	1062	1064	1066	1068	1070	1072	1074	1076	1078	1080	1082	1084	1086	1088	1090	1092	1094	1096	1098	1100	1102	1104	23	
	24	1106	1108	1110	1112	1114	1116	1118	1120	1122	1124	1126	1128	1130	1132	1134	1136	1138	1140	1142	1144	1146	1148	1150	1152	24	
	25	1154	1156	1158	1160	1162	1164	1166	1168	1170	1172	1174	1176	1178	1180	1182	1184	1186	1188	1190	1192	1194	1196	1198	1200	25	
	26	1202	1204	1206	1208	1210	1212	1214	1216	1218	1220	1222	1224	1226	1228	1230	1232	1234	1236	1238	1240	1242	1244	1246	1248	26	
	27	1250	1252	1254	1256	1258	1260	1262	1264	1266	1268	1270	1272	1274	1276	1278	1280	1282	1284	1286	1288	1290	1292	1294	1296	27	
	28	1298	1300	1302	1304	1306	1308	1310	1312	1314	1316	1318	1320	1322	1324	1326	1328	1330	1332	1334	1336	1338	1340	1342	1344	28	
	29	1346	1348	1350	1352	1354	1356	1358	1360	1362	1364	1366	1368	1370	1372	1374	1376	1378	1380	1382	1384	1386	1388	1390	1392	29	
	30	1394	1396	1398	1400	1402	1404	1406	1408	1410	1412	1414	1416	1418	1420	1422	1424	1426	1428	1430	1432	1434	1436	1438	1440	30	

REMARKS:

GRADER'S SIGNATURE_____DATE_____

Worksheet #8

SAMPLE SELECTION WORKSHEET
50 HALF CASES PER PALLET

LOT INFORMATION

Grade & Size :_____

Type of pack :_____

No./Size of Cases :_____=____/30-DOZ.

Samples Needed :_____

Audit Number :_____

SAMPLE CONTAINERS SELECTED

1._____ 11._____
2._____ 12._____
3._____ 13._____
4._____ 14._____
5._____ 15._____
6._____ 16._____
7._____ 17._____
8._____ 18._____
9._____ 19._____
10._____ 20._____

INSTRUCTIONS: CIRCLE EACH SAMPLE IN THE CHART BELOW.

LAYER NO.		1						2						3						4						5	LAYER NO.	
CONT. POS.		2	4	6	8	10	12	2	4	6	8	10	12	2	4	6	8	10	12	2	4	6	8	10	12	2	CONT. POS.	
P	1	2	4	6	8	10	12	14	16	18	20	22	24	26	28	30	32	34	36	38	40	42	44	46	48	50	1	P
A	2	52	54	56	58	60	62	64	66	68	70	72	74	76	78	80	82	84	86	88	90	92	94	96	98	100	2	A
L	3	102	104	106	108	110	112	114	116	118	120	122	124	126	128	130	132	134	136	138	140	142	144	146	148	150	3	L
L	4	152	154	156	158	160	162	164	166	168	170	172	174	176	178	180	182	184	186	188	190	192	194	196	198	200	4	L
E	5	202	204	206	208	210	212	214	216	218	220	222	224	226	228	230	232	234	236	238	240	242	244	246	248	250	5	E
T																												T
	6	252	254	256	258	260	262	264	266	268	270	272	274	276	278	280	282	284	286	288	290	292	294	296	298	300	6	
N	7	302	304	306	308	310	312	314	316	318	320	322	324	326	328	330	332	334	336	338	340	342	344	346	348	350	7	N
U	8	352	354	356	358	360	362	364	366	368	370	372	374	376	378	380	382	384	386	388	390	392	394	396	398	400	8	U
M	9	402	404	406	408	410	412	414	416	418	420	422	424	426	428	430	432	434	436	438	440	442	444	446	448	450	9	M
B	10	452	454	456	458	460	462	464	466	468	470	472	474	476	478	480	482	484	486	488	490	492	494	496	498	500	10	B
E																												E
R	11	502	504	506	508	510	512	514	516	518	520	522	524	526	528	530	532	534	536	538	540	542	544	546	548	550	11	R
	12	552	554	556	558	560	562	564	566	568	570	572	574	576	578	580	582	584	586	588	590	592	594	596	598	600	12	
	13	602	604	606	608	610	612	614	616	618	620	622	624	626	628	630	632	634	636	638	640	642	644	646	648	650	13	
	14	652	654	656	658	660	662	664	666	668	670	672	674	676	678	680	682	684	686	688	690	692	694	696	698	700	14	
	15	702	704	706	708	710	712	714	716	718	720	722	724	726	728	730	732	734	736	738	740	742	744	746	748	750	15	
	16	752	754	756	758	760	762	764	766	768	770	772	774	776	778	780	782	784	786	788	790	792	794	796	798	800	16	
	17	802	804	806	808	810	812	814	816	818	820	822	824	826	828	830	832	834	836	838	840	842	844	846	848	850	17	
	18	852	854	856	858	860	862	864	866	868	870	872	874	876	878	880	882	884	886	888	890	892	894	896	898	900	18	
	19	902	904	906	908	910	912	914	916	918	920	922	924	926	928	930	932	934	936	938	940	942	944	946	948	950	19	
	20	952	954	956	958	960	962	964	966	968	970	972	974	976	978	980	982	984	986	988	990	992	994	996	998	1000	20	
	21	1002	1004	1006	1008	1010	1012	1014	1016	1018	1020	1022	1024	1026	1028	1030	1032	1034	1036	1038	1040	1042	1044	1046	1048	1050	21	
	22	1052	1054	1056	1058	1060	1062	1064	1066	1068	1070	1072	1074	1076	1078	1080	1082	1084	1086	1088	1090	1092	1094	1096	1098	1100	22	
	23	1102	1104	1106	1108	1110	1112	1114	1116	1118	1120	1122	1124	1126	1128	1130	1132	1134	1136	1138	1140	1142	1144	1146	1148	1150	23	
	24	1152	1154	1156	1158	1160	1162	1164	1166	1168	1170	1172	1174	1176	1178	1180	1182	1184	1186	1188	1190	1192	1194	1196	1198	1200	24	
	25	1202	1204	1206	1208	1210	1212	1214	1216	1218	1220	1222	1224	1226	1228	1230	1232	1234	1236	1238	1240	1242	1244	1246	1248	1250	25	
	26	1252	1254	1256	1258	1260	1262	1264	1266	1268	1270	1272	1274	1276	1278	1280	1282	1284	1286	1288	1290	1292	1294	1296	1298	1300	26	
	27	1302	1304	1306	1308	1310	1312	1314	1316	1318	1320	1322	1324	1326	1328	1330	1332	1334	1336	1338	1340	1342	1344	1346	1348	1350	27	
	28	1352	1354	1356	1358	1360	1362	1364	1366	1368	1370	1372	1374	1376	1378	1380	1382	1384	1386	1388	1390	1392	1394	1396	1398	1400	28	
	29	1402	1404	1406	1408	1410	1412	1414	1416	1418	1420	1422	1424	1426	1428	1430	1432	1434	1436	1438	1440	1442	1444	1446	1448	1450	29	
	30	1452	1454	1456	1458	1460	1462	1464	1466	1468	1470	1472	1474	1476	1478	1480	1482	1484	1486	1488	1490	1492	1494	1496	1498	1500	30	

REMARKS:

GRADER'S SIGNATURE_____DATE_____

Worksheet #9

SAMPLE SELECTION WORKSHEET
60 HALF CASES PER PALLET

LOT INFORMATION

Grade & Size :_____

Type of pack :_____

No./Size of Cases :_____=____/30-DOZ.

Samples Needed :_____

Audit Number :_____

SAMPLE CONTAINERS SELECTED

1._____ 11._____
2._____ 12._____
3._____ 13._____
4._____ 14._____
5._____ 15._____
6._____ 16._____
7._____ 17._____
8._____ 18._____
9._____ 19._____
10._____ 20._____

INSTRUCTIONS: CIRCLE EACH SAMPLE IN THE CHART BELOW.

LAYER NO.	1						2						3						4						5						LAYER NO.
CONT. POS.	2	4	6	8	10	12	2	4	6	8	10	12	2	4	6	8	10	12	2	4	6	8	10	12	2	4	6	8	10	12	CONT. POS.
PALLET NUMBER 1	2	4	6	8	10	12	14	16	18	20	22	24	26	28	30	32	34	36	38	40	42	44	46	48	50	52	54	56	58	60	1
2	62	64	66	68	70	72	74	76	78	80	82	84	86	88	90	92	94	96	98	100	102	104	106	108	110	112	114	116	118	120	2
3	122	124	126	128	130	132	134	136	138	140	142	144	146	148	150	152	154	156	158	160	162	164	166	168	170	172	174	176	178	180	3
4	182	184	186	188	190	192	194	196	198	200	202	204	206	208	210	212	214	216	218	220	222	224	226	228	230	232	234	236	238	240	4
5	242	244	246	248	250	252	254	256	258	260	262	264	266	268	270	272	274	276	278	280	282	284	286	288	290	292	294	296	298	300	5
6	302	304	306	308	310	312	314	316	318	320	322	324	326	328	330	332	334	336	338	340	342	344	346	348	350	352	354	356	358	360	6
7	362	364	366	368	370	372	374	376	378	380	382	384	386	388	390	392	394	396	398	400	402	404	406	408	410	412	414	416	418	420	7
8	422	424	426	428	430	432	434	436	438	440	442	444	446	448	450	452	454	456	458	460	462	464	466	468	470	472	474	476	478	480	8
9	482	484	486	488	490	492	494	496	498	500	502	504	506	508	510	512	514	516	518	520	522	524	526	528	530	532	534	536	538	540	9
10	542	544	546	548	550	552	554	556	558	560	562	564	566	568	570	572	574	576	578	580	582	584	586	588	590	592	594	596	598	600	10
11	602	604	606	608	610	612	614	616	618	620	622	624	626	628	630	632	634	636	638	640	642	644	646	648	650	652	654	656	658	660	11
12	662	664	666	668	670	672	674	676	678	680	682	684	686	688	690	692	694	696	698	700	702	704	706	708	710	712	714	716	718	720	12
13	722	724	726	728	730	732	734	736	738	740	742	744	746	748	750	752	754	756	758	760	762	764	766	768	770	772	774	776	778	780	13
14	782	784	786	788	790	792	794	796	798	800	802	804	806	808	810	812	814	816	818	820	822	824	826	828	830	832	834	836	838	840	14
15	842	844	846	848	850	852	854	856	858	860	862	864	866	868	870	872	874	876	878	880	882	884	886	888	890	892	894	896	898	900	15
16	902	904	906	908	910	912	914	916	918	920	922	924	926	928	930	932	934	936	938	940	942	944	946	948	950	952	954	956	958	960	16
17	962	964	966	968	970	972	974	976	978	980	982	984	986	988	990	992	994	996	998	1000	1002	1004	1006	1008	1010	1012	1014	1016	1018	1020	17
18	1022	1024	1026	1028	1030	1032	1034	1036	1038	1040	1042	1044	1046	1048	1050	1052	1054	1056	1058	1060	1062	1064	1066	1068	1070	1072	1074	1076	1078	1080	18
19	1082	1084	1086	1088	1090	1092	1094	1096	1098	1100	1102	1104	1106	1108	1110	1112	1114	1116	1118	1120	1122	1124	1126	1128	1130	1132	1134	1136	1138	1140	19
20	1142	1144	1146	1148	1150	1152	1154	1156	1158	1160	1162	1164	1166	1168	1170	1172	1174	1176	1178	1180	1182	1184	1186	1188	1190	1192	1194	1196	1198	1200	20
21	1202	1204	1206	1208	1210	1212	1214	1216	1218	1220	1222	1224	1226	1228	1230	1232	1234	1236	1238	1240	1242	1244	1246	1248	1250	1252	1254	1256	1258	1260	21
22	1262	1264	1266	1268	1270	1272	1274	1276	1278	1280	1282	1284	1286	1288	1290	1292	1294	1296	1298	1300	1302	1304	1306	1308	1310	1312	1314	1316	1318	1320	22
23	1322	1324	1326	1328	1330	1332	1334	1336	1338	1340	1342	1344	1346	1348	1350	1352	1354	1356	1358	1360	1362	1364	1366	1368	1370	1372	1374	1376	1378	1380	23
24	1382	1384	1386	1388	1390	1392	1394	1396	1398	1400	1402	1404	1406	1408	1410	1412	1414	1416	1418	1420	1422	1424	1426	1428	1430	1432	1434	1436	1438	1440	24
25	1442	1444	1446	1448	1450	1452	1454	1456	1458	1460	1462	1464	1466	1468	1470	1472	1474	1476	1478	1480	1482	1484	1486	1488	1490	1492	1494	1496	1498	1500	25

REMARKS:

GRADER'S SIGNATURE_____DATE_____

Worksheet #10

SAMPLE SELECTION WORKSHEET
72 HALF CASES PER PALLET

LOT INFORMATION

Grade & Size :_____

Type of pack :_____

No./Size of Cases :_____=____/30-DOZ.

Samples Needed :_____

Audit Number :_____

SAMPLE CONTAINERS SELECTED

1._____ 11._____
2._____ 12._____
3._____ 13._____
4._____ 14._____
5._____ 15._____
6._____ 16._____
7._____ 17._____
8._____ 18._____
9._____ 19._____
10._____ 20._____

INSTRUCTIONS: CIRCLE EACH SAMPLE IN THE CHART BELOW.

LAYER NO.		1						2						3						4						5						6					
CONT. POS.		2	4	6	8	10	12	2	4	6	8	10	12	2	4	6	8	10	12	2	4	6	8	10	12	2	4	6	8	10	12	2	4	6	8	10	12
P	1	2	4	6	8	10	12	14	16	18	20	22	24	26	28	30	32	34	36	38	40	42	44	46	48	50	52	54	56	58	60	62	64	66	68	70	72
A	2	74	76	78	80	82	84	86	88	90	92	94	96	98	100	102	104	106	108	110	112	114	116	118	120	122	124	126	128	130	132	134	136	138	140	142	144
L	3	146	148	150	152	154	156	158	160	162	164	166	168	170	172	174	176	178	180	182	184	186	188	190	192	194	196	198	200	202	204	206	208	210	212	214	216
L	4	218	220	222	224	226	228	230	232	234	236	238	240	242	244	246	248	250	252	254	256	258	260	262	264	266	268	270	272	274	276	278	280	282	284	286	288
E	5	290	292	294	296	298	300	302	304	306	308	310	312	314	316	318	320	322	324	326	328	330	332	334	336	338	340	342	344	346	348	350	352	354	356	358	360
T																																					
	6	362	364	366	368	370	372	374	376	378	380	382	384	386	388	390	392	394	396	398	400	402	404	406	408	410	412	414	416	418	420	422	424	426	428	430	432
N	7	434	436	438	440	442	444	446	448	450	452	454	456	458	460	462	464	466	468	470	472	474	476	478	480	482	484	486	488	490	492	494	496	498	500	502	504
U	8	506	508	510	512	514	516	518	520	522	524	526	528	530	532	534	536	538	540	542	544	546	548	550	552	554	556	558	560	562	564	566	568	570	572	574	576
M	9	578	580	582	584	586	588	590	592	594	596	598	600	602	604	606	608	610	612	614	616	618	620	622	624	626	628	630	632	634	636	638	640	642	644	646	648
B	10	650	652	654	656	658	660	662	664	666	668	670	672	674	676	678	680	682	684	686	688	690	692	694	696	698	700	702	704	706	708	710	712	714	716	718	720
E																																					
R	11	722	724	726	728	730	732	734	736	738	740	742	744	746	748	750	752	754	756	758	760	762	764	766	768	770	772	774	776	778	780	782	784	786	788	790	792
	12	794	796	798	800	802	804	806	808	810	812	814	816	818	820	822	824	826	828	830	832	834	836	838	840	842	844	846	848	850	852	854	856	858	860	862	864
	13	866	868	870	872	874	876	878	880	882	884	886	888	890	892	894	896	898	900	902	904	906	908	910	912	914	916	918	920	922	924	926	928	930	932	934	936
	14	938	940	942	944	946	948	950	952	954	956	958	960	962	964	966	968	970	972	974	976	978	980	982	984	986	988	990	992	994	996	998	1000	1002	1004	1006	1008
	15	1010	1012	1014	1016	1018	1020	1022	1024	1026	1028	1030	1032	1034	1036	1038	1040	1042	1044	1046	1048	1050	1052	1054	1056	1058	1060	1062	1064	1066	1068	1070	1072	1074	1076	1078	1080
	16	1082	1084	1086	1088	1090	1092	1094	1096	1098	1100	1102	1104	1106	1108	1110	1112	1114	1116	1118	1120	1122	1124	1126	1128	1130	1132	1134	1136	1138	1140	1142	1144	1146	1148	1150	1152
	17	1154	1156	1158	1160	1162	1164	1166	1168	1170	1172	1174	1176	1178	1180	1182	1184	1186	1188	1190	1192	1194	1196	1198	1200	1202	1204	1206	1208	1210	1212	1214	1216	1218	1220	1222	1224
	18	1226	1228	1230	1232	1234	1236	1238	1240	1242	1244	1246	1248	1250	1252	1254	1256	1258	1260	1262	1264	1266	1268	1270	1272	1274	1276	1278	1280	1282	1284	1286	1288	1290	1292	1294	1296
	19	1298	1300	1302	1304	1306	1308	1310	1312	1314	1316	1318	1320	1322	1324	1326	1328	1330	1332	1334	1336	1338	1340	1342	1344	1346	1348	1350	1352	1354	1356	1358	1360	1362	1364	1366	1368
	20	1370	1372	1374	1376	1378	1380	1382	1384	1386	1388	1390	1392	1394	1396	1398	1400	1402	1404	1406	1408	1410	1412	1414	1416	1418	1420	1422	1424	1426	1428	1430	1432	1434	1436	1438	1440
	21	1442	1444	1446	1448	1450	1452	1454	1456	1458	1460	1462	1464	1466	1468	1470	1472	1474	1476	1478	1480	1482	1484	1486	1488	1490	1492	1494	1496	1498	1500	1502	1504	1506	1508	1510	1512
	22	1514	1516	1518	1520	1522	1524	1526	1528	1530	1532	1534	1536	1538	1540	1542	1544	1546	1548	1550	1552	1554	1556	1558	1560	1562	1564	1566	1568	1570	1572	1574	1576	1578	1580	1582	1584
	23	1586	1588	1590	1592	1594	1596	1598	1600	1602	1604	1606	1608	1610	1612	1614	1616	1618	1620	1622	1624	1626	1628	1630	1632	1634	1636	1638	1640	1642	1644	1646	1648	1650	1652	1654	1656
	24	1658	1660	1662	1664	1666	1668	1670	1672	1674	1676	1678	1680	1682	1684	1686	1688	1690	1692	1694	1696	1698	1700	1702	1704	1706	1708	1710	1712	1714	1716	1718	1720	1722	1724	1726	1728
	25	1730	1732	1734	1736	1738	1740	1742	1744	1746	1748	1750	1752	1754	1756	1758	1760	1762	1764	1766	1768	1770	1772	1774	1776	1778	1780	1782	1784	1786	1788	1790	1792	1794	1796	1798	1800

REMARKS:

GRADER'S SIGNATURE_____DATE_____

Worksheet #11

SAMPLE SELECTION WORKSHEET
PRODUCT ON “BOSSIES” OR RACKS

LOT INFORMATION

Grade & Size :_____

Type of pack :_____

No./Size of Cases :_____=____/30-DOZ.

Samples Needed :_____(From half-cases)

Audit Number :_____

SAMPLE CONTAINERS SELECTED

1._____	11._____
2._____	12._____
3._____	13._____
4._____	14._____
5._____	15._____
6._____	16._____
7._____	17._____
8._____	18._____
9._____	19._____
10._____	20._____

INSTRUCTIONS: CIRCLE EACH SAMPLE IN THE CHART BELOW.

18	17	16
13	14	15
12	11	10
7	8	9
6	5	4
1	2	3

RACK #1

36	35	34
31	32	33
30	29	28
25	26	27
24	23	22
19	20	21

RACK #2

54	53	52
49	50	51
48	47	46
43	44	45
42	41	40
37	38	39

RACK #3

72	71	70
67	68	69
66	65	64
61	62	63
60	59	58
55	56	57

RACK #4

90	89	88
85	86	87
84	83	82
79	80	81
78	77	76
73	74	75

RACK#5

108	107	106
103	104	105
102	101	100
97	98	99
96	95	94
91	92	93

RACK #6

126	125	124
121	122	123
120	119	118
115	116	117
114	113	112
109	110	111

RACK #7

144	143	142
139	140	141
138	137	136
133	134	135
132	131	130
127	128	129

RACK #8

162	161	160
157	158	159
156	155	154
151	152	153
150	149	148
145	146	147

RACK #9

180	179	178
175	176	177
174	173	172
169	170	171
168	167	166
163	164	165

RACK #10

198	197	196
193	194	195
192	191	190
187	188	189
186	185	184
181	182	183

RACK #11

216	215	214
211	212	213
210	209	208
205	206	207
204	203	202
199	200	201

RACK #12

234	233	232
229	230	231
228	227	226
223	224	225
222	221	220
217	218	219

RACK #13

252	251	250
247	248	249
246	245	244
241	242	243
240	239	238
235	236	237

RACK #14

270	269	268
265	266	267
264	263	262
259	260	261
258	257	256
253	254	255

RACK #15

288	287	286
283	284	285
282	281	280
277	278	279
276	275	274
271	272	273

RACK #16

306	305	304
301	302	303
300	299	298
295	296	297
294	293	292
289	290	291

RACK #17

324	323	322
319	320	321
318	317	316
313	314	315
312	311	310
307	308	309

RACK #18

342	341	340
337	338	339
336	335	334
331	332	333
330	329	328
325	326	327

RACK #19

360	359	358
355	356	357
354	353	352
349	350	351
348	347	346
343	344	345

RACK #20

378	377	376
373	374	375
372	371	370
367	368	369
366	365	364
361	362	363

RACK #21

396	395	394
391	392	393
390	389	388
385	386	387
384	383	382
379	380	381

RACK #22

414	413	412
409	410	411
408	407	406
403	404	405
402	401	400
397	398	399

RACK #23

432	431	430
427	428	429
426	425	424
421	422	423
420	419	418
415	416	417

RACK #24

450	449	448
445	446	447
444	443	442
439	440	441
438	437	436
433	434	435

RACK #25

468	467	466
463	464	465
462	461	460
457	458	459
456	455	454
451	452	453

RACK #26

486	485	484
481	482	483
480	479	478
475	476	477
474	473	472
469	470	471

RACK #27

504	503	502
499	500	501
498	497	496
493	494	495
492	491	490
487	488	489

RACK #28

522	521	520
517	518	519
516	515	514
511	512	513
510	509	508
505	506	507

RACK #29

540	539	538
535	536	537
534	533	532
529	530	531
528	527	526
523	524	525

RACK #30

558	557	556
553	554	555
552	551	550
547	548	549
546	545	544
541	542	543

RACK #31

576	575	574
571	572	573
570	569	568
565	566	567
564	563	562
559	560	561

RACK #32

594	593	592
589	590	591
588	587	586
583	584	585
582	581	580
577	578	579

RACK #33

612	611	610
607	608	609
606	605	604
601	602	603
600	599	598
595	596	597

RACK #34

630	629	628
625	626	627
624	623	622
619	620	621
618	617	616
613	614	615

RACK #35

648	647	646
643	644	645
642	641	640
637	638	639
636	635	634
631	632	633

RACK #36

666	665	664
661	662	663
660	659	658
655	656	657
654	653	652
649	650	651

RACK #37

684	683	682
679	680	681
678	677	676
673	674	675
672	671	670
667	668	669

RACK #38

702	701	700
697	698	699
696	695	694
691	692	693
690	689	688
685	686	687

RACK #39

720	719	718
715	716	717
714	713	712
709	710	711
708	707	706
703	704	705

RACK #40

REMARKS:

GRADER’S SIGNATURE_____DATE_____

Worksheet #12

SAMPLE SELECTION WORKSHEET
16 HALF CASES PER PACK

LOT INFORMATION

Grade & Size :_____

Type of pack :_____

No./Size of Cases :_____=____/30-DOZ.

Samples Needed :_____(From half-cases)

Audit Number :_____

SAMPLE CONTAINERS SELECTED

1._____	11._____
2._____	12._____
3._____	13._____
4._____	14._____
5._____	15._____
6._____	16._____
7._____	17._____
8._____	18._____
9._____	19._____
10._____	20._____

INSTRUCTIONS: CIRCLE EACH SAMPLE IN THE CHART BELOW.

16	15	14	13	32	31	30	29	48	47	46	45	64	63	62	61	80	79	78	77
9	10	11	12	25	26	27	28	41	42	43	44	57	58	59	60	73	74	75	76
8	7	6	5	24	23	22	21	40	39	38	37	56	55	54	53	72	71	70	69
1	2	3	4	17	18	19	20	33	34	35	36	49	50	51	52	65	66	67	68
RACK #1				RACK #2				RACK #3				RACK #4				RACK#5			
96	95	94	93	112	111	110	109	128	127	126	125	144	143	142	141	160	159	158	157
89	90	91	92	105	106	107	108	121	122	123	124	137	138	139	140	153	154	155	156
88	87	86	85	104	103	102	101	120	119	118	117	136	135	134	133	152	151	150	149
81	82	83	84	97	98	99	100	113	114	115	116	129	130	131	132	145	146	147	148
RACK #6				RACK #7				RACK #8				RACK #9				RACK #10			
176	175	174	173	192	191	190	189	208	207	206	205	224	223	222	221	240	239	238	237
169	170	171	172	185	186	187	188	201	202	203	204	217	218	219	220	233	234	235	236
168	167	166	165	184	183	182	181	200	199	198	197	216	215	214	213	232	231	230	229
161	162	163	164	177	178	179	180	193	194	195	196	209	210	211	212	225	226	227	228
RACK #11				RACK #12				RACK #13				RACK #14				RACK #15			
256	255	254	253	272	271	270	269	288	287	286	285	304	303	302	301	320	319	318	317
249	250	251	252	265	266	267	268	281	282	283	284	297	298	299	300	313	314	315	316
248	247	246	245	264	263	262	261	280	279	278	277	296	295	294	293	312	311	310	309
241	242	243	244	257	258	259	260	273	274	275	276	289	290	291	292	305	306	307	308
RACK #16				RACK #17				RACK#18				RACK #19				RACK #20			
336	335	334	333	352	351	350	349	368	367	366	365	384	383	382	381	400	399	398	397
329	330	331	332	345	346	347	348	361	362	363	364	377	378	379	380	393	394	395	396
328	327	326	325	344	343	342	341	360	359	358	357	376	375	374	373	392	391	390	389
321	322	323	324	337	338	339	340	353	354	355	356	369	370	371	372	385	386	387	388
RACK #21				RACK #22				RACK #23				RACK #24				RACK #25			
416	415	414	413	432	431	430	429	448	447	446	445	464	463	462	461	480	479	478	477
409	410	411	412	425	426	427	428	441	442	443	444	457	458	459	460	473	474	475	476
408	407	406	405	424	423	422	421	440	439	438	437	456	455	454	453	472	471	470	469
401	402	403	404	417	418	419	420	433	434	435	436	449	450	451	452	465	466	467	468
RACK #26				RACK #27				RACK #28				RACK #29				RACK #30			
496	495	494	493	512	511	510	509	528	527	526	525	544	543	542	541	560	559	558	557
489	490	491	492	505	506	507	508	521	522	523	524	537	538	539	540	553	554	555	556
488	487	486	485	504	503	502	501	520	519	518	517	536	535	534	533	552	551	550	549
481	482	483	484	497	498	499	500	513	514	515	516	529	530	531	532	545	546	547	548
RACK #31				RACK #32				RACK #33				RACK #34				RACK #35			
576	575	574	573	592	591	590	589	608	607	606	605	624	623	622	621	640	639	638	637
569	570	571	572	585	586	587	588	601	602	603	604	617	618	619	620	633	634	635	636
568	567	566	565	584	583	582	581	600	599	598	597	616	615	614	613	632	631	630	629
561	562	563	564	577	578	579	580	593	594	595	596	609	610	611	612	625	626	627	628
RACK #36				RACK #37				RACK #38				RACK #39				RACK #40			

REMARKS:

GRADER'S SIGNATURE_____DATE_____

Worksheet #13

SAMPLE SELECTION WORKSHEET
24 HALF CASES PER PACK

LOT INFORMATION

Grade & Size :_____

Type of pack :_____

No./Size of Cases :_____=____/30-DOZ.

Samples Needed :_____(From half-cases)

Audit Number :_____

SAMPLE CONTAINERS SELECTED

1._____ 11._____
2._____ 12._____
3._____ 13._____
4._____ 14._____
5._____ 15._____
6._____ 16._____
7._____ 17._____
8._____ 18._____
9._____ 19._____
10._____ 20._____

INSTRUCTIONS: CIRCLE EACH SAMPLE IN THE CHART BELOW.

24	23	22	21	48	47	46	45	72	71	70	69	96	95	94	93	120	119	118	117
17	18	19	20	41	42	43	44	65	66	67	68	89	90	91	92	113	114	115	116
16	15	14	13	40	39	38	37	64	63	62	61	88	87	86	85	112	111	110	109
9	10	11	12	33	34	35	36	57	58	59	60	81	82	83	84	105	106	107	108
8	7	6	5	32	31	30	29	56	55	54	53	80	79	78	77	104	103	102	101
1	2	3	4	25	26	27	28	49	50	51	52	73	74	75	76	97	98	99	100
RACK #1				RACK #2				RACK #3				RACK #4				RACK#5			
144	143	142	141	168	167	166	165	192	191	190	189	216	215	214	213	240	239	238	237
137	138	139	140	161	162	163	164	185	186	187	188	209	210	211	212	233	234	235	236
136	135	134	133	160	159	158	157	184	183	182	181	208	207	206	205	232	231	230	229
129	130	131	132	153	154	155	156	177	178	179	180	201	202	203	204	225	226	227	228
128	127	126	125	152	151	150	149	176	175	174	173	200	199	198	197	224	223	222	221
121	122	123	124	145	146	147	148	169	170	171	172	193	194	195	196	217	218	219	220
RACK #6				RACK #7				RACK #8				RACK #9				RACK #10			
264	263	262	261	288	287	286	285	312	311	310	309	336	335	334	333	360	359	358	357
257	258	259	260	281	282	283	284	305	306	307	308	329	330	331	332	353	354	355	356
256	255	254	253	280	279	278	277	304	303	302	301	328	327	326	325	352	351	350	349
249	250	251	252	273	274	275	276	297	298	299	300	321	322	323	324	345	346	347	348
248	247	246	245	272	271	270	269	296	295	294	293	320	319	318	317	344	343	342	341
241	242	243	244	265	266	267	268	289	290	291	292	313	314	315	316	337	338	339	340
RACK #11				RACK #12				RACK #13				RACK #14				RACK #15			
384	383	382	381	408	407	406	405	432	431	430	429	456	455	454	453	480	479	478	477
377	378	379	380	401	402	403	404	425	426	427	428	449	450	451	452	473	474	475	476
376	375	374	373	400	399	398	397	424	423	422	421	448	447	446	445	472	471	470	469
369	370	371	372	393	394	395	396	417	418	419	420	441	442	443	444	465	466	467	468
368	367	366	365	392	391	390	389	416	415	414	413	440	439	438	437	464	463	462	461
361	362	363	364	385	386	387	388	409	410	411	412	433	434	435	436	457	458	459	460
RACK #16				RACK #17				RACK#18				RACK #19				RACK #20			
504	503	502	501	528	527	526	525	552	551	550	549	576	575	574	573	600	599	598	597
497	498	499	500	521	522	523	524	545	546	547	548	569	570	571	572	593	594	595	596
496	495	494	493	520	519	518	517	544	543	542	541	568	567	566	565	592	591	590	589
489	490	491	492	513	514	515	516	537	538	539	540	561	562	563	564	585	586	587	588
488	487	486	485	512	511	510	509	536	535	534	533	560	559	558	557	584	583	582	581
481	482	483	484	505	506	507	508	529	530	531	532	553	554	555	556	577	578	579	580
RACK #21				RACK #22				RACK #23				RACK #24				RACK #25			
624	623	622	621	648	647	646	645	672	671	670	669	696	695	694	693	720	719	718	717
617	618	619	620	641	642	643	644	665	666	667	668	689	690	691	692	713	714	715	716
616	615	614	613	640	639	638	637	664	663	662	661	688	687	686	685	712	711	710	709
609	610	611	612	633	634	635	636	657	658	659	660	681	682	683	684	705	706	707	708
608	607	606	605	632	631	630	629	656	655	654	653	680	679	678	677	704	703	702	701
601	602	603	604	625	626	627	628	649	650	651	652	673	674	675	676	697	698	699	700
RACK #26				RACK #27				RACK #28				RACK #29				RACK #30			

REMARKS:

GRADER'S SIGNATURE_____DATE_____

Worksheet #14

SAMPLE SELECTION WORKSHEET
32 HALF CASES PER PACK

LOT INFORMATION

Grade & Size :_____

Type of pack :_____

No./Size of Cases :_____=____/30-DOZ.

Samples Needed :_____(From half-cases)

Audit Number :_____

SAMPLE CONTAINERS SELECTED

1._____	11._____
2._____	12._____
3._____	13._____
4._____	14._____
5._____	15._____
6._____	16._____
7._____	17._____
8._____	18._____
9._____	19._____
10._____	20._____

INSTRUCTIONS: CIRCLE EACH SAMPLE IN THE CHART BELOW.

32	31	30	29
25	26	27	28
24	23	22	21
17	18	19	20
16	15	14	13
9	10	11	12
8	7	6	5
1	2	3	4

RACK #1

64	63	62	61
57	58	59	60
56	55	54	53
49	50	51	52
48	47	46	45
41	42	43	44
40	39	38	37
33	34	35	36

RACK #2

96	95	94	93
89	90	91	92
88	87	86	85
81	82	83	84
80	79	78	77
73	74	75	76
72	71	70	69
65	66	67	68

RACK #3

128	127	126	125
121	122	123	124
120	119	118	117
113	114	115	116
112	111	110	109
105	106	107	108
104	103	102	101
97	98	99	100

RACK #4

160	159	158	157
153	154	155	156
152	151	150	149
145	146	147	148
144	143	142	141
137	138	139	140
136	135	134	133
129	130	131	132

RACK#5

192	191	190	189
185	186	187	188
184	183	182	181
177	178	179	180
176	175	174	173
169	170	171	172
168	167	166	165
161	162	163	164

RACK #6

224	223	222	221
217	218	219	220
216	215	214	213
209	210	211	212
208	207	206	205
201	202	203	204
200	199	198	197
193	194	195	196

RACK #7

256	255	254	253
249	250	251	252
248	247	246	245
241	242	243	244
240	239	238	237
233	234	235	236
232	231	230	229
225	226	227	228

RACK #8

288	287	286	285
281	282	283	284
280	279	278	277
273	274	275	276
272	271	270	269
265	266	267	268
264	263	262	261
257	258	259	260

RACK #9

320	319	318	317
313	314	315	316
312	311	310	309
305	306	307	308
304	303	302	301
297	298	299	300
296	295	294	293
289	290	291	292

RACK #10

352	351	350	349
345	346	347	348
344	343	342	341
337	338	339	340
336	335	334	333
329	330	331	332
328	327	326	325
321	322	323	324

RACK #11

384	383	382	381
377	378	379	380
376	375	374	373
369	370	371	372
368	367	366	365
361	362	363	364
360	359	358	357
353	354	355	356

RACK #12

416	415	414	413
409	410	411	412
408	407	406	405
401	402	403	404
400	399	398	397
393	394	395	396
392	391	390	389
385	386	387	388

RACK #13

448	447	446	445
441	442	443	444
440	439	438	437
433	434	435	436
432	431	430	429
425	426	427	428
424	423	422	421
417	418	419	420

RACK #14

480	479	478	477
473	474	475	476
472	471	470	469
465	466	467	468
464	463	462	461
457	458	459	460
456	455	454	453
449	450	451	452

RACK #15

512	511	510	509
505	506	507	508
504	503	502	501
497	498	499	500
496	495	494	493
489	490	491	492
488	487	486	485
481	482	483	484

RACK #16

544	543	542	541
537	538	539	540
536	535	534	533
529	530	531	532
528	527	526	525
521	522	523	524
520	519	518	517
513	514	515	516

RACK #17

576	575	574	573
569	570	571	572
568	567	566	565
561	562	563	564
560	559	558	557
553	554	555	556
552	551	550	549
545	546	547	548

RACK#18

608	607	606	605
601	602	603	604
600	599	598	597
593	594	595	596
592	591	590	589
585	586	587	588
584	583	582	581
577	578	579	580

RACK #19

640	639	638	637
633	634	635	636
632	631	630	629
625	626	627	628
624	623	622	621
617	618	619	620
616	615	614	613
609	610	611	612

RACK #20

672	671	670	669
665	666	667	668
664	663	662	661
657	658	659	660
656	655	654	653
649	650	651	652
648	647	646	645
641	642	643	644

RACK #21

704	703	702	701
697	698	699	700
696	695	694	693
689	690	691	692
688	687	686	685
681	682	683	684
680	679	678	677
673	674	675	676

RACK #22

736	735	734	733
729	730	731	732
728	727	726	725
721	722	723	724
720	719	718	717
713	714	715	716
712	711	710	709
705	706	707	708

RACK #23

768	767	766	765
761	762	763	764
760	759	758	757
753	754	755	756
752	751	750	749
745	746	747	748
744	743	742	741
737	738	739	740

RACK #24

800	799	798	797
793	794	795	796
792	791	790	789
785	786	787	788
784	783	782	781
777	778	779	780
776	775	774	773
769	770	771	772

RACK #25

REMARKS:

GRADER'S SIGNATURE_____DATE_____

Worksheet #15

SAMPLE SELECTION WORKSHEET
PARTIAL PALLETS OR RACKS

LOT INFORMATION

Grade & Size :_____

Type of pack :_____

No./Size of Cases :_____=____/30-DOZ.

Samples Needed :_____

Audit Number :_____

SAMPLE CONTAINERS SELECTED

1._____	11._____
2._____	12._____
3._____	13._____
4._____	14._____
5._____	15._____
6._____	16._____
7._____	17._____
8._____	18._____
9._____	19._____
10._____	20._____

INSTRUCTIONS: CIRCLE EACH SAMPLE IN THE CHART BELOW.

PALLET NO:_____

LAYER NUMBER						
6						
5						
4						
3						
2						
1						

PALLET NO:_____

LAYER NUMBER						
6						
5						
4						
3						
2						
1						

PALLET NO:_____

LAYER NUMBER						
6						
5						
4						
3						
2						
1						

PALLET NO:_____

LAYER NUMBER						
6						
5						
4						
3						
2						
1						

PALLET NO:_____

LAYER NUMBER						
6						
5						
4						
3						
2						
1						

PALLET NO:_____

LAYER NUMBER						
6						
5						
4						
3						
2						
1						

PALLET NO:_____

LAYER NUMBER						
6						
5						
4						
3						
2						
1						

PALLET NO:_____

LAYER NUMBER						
6						
5						
4						
3						
2						
1						

RACK #1

RACK #2

RACK #3

RACK #4

RACK #5

RACK #6

RACK #7

RACK #8

REMARKS:

GRADER'S SIGNATURE_____DATE_____

Worksheet #16

SAMPLE SELECTION WORKSHEET
54-9 DOZ. BASKETS PER PALLET

LOT INFORMATION

Grade & Size :_____

Type of pack :_____

No./Size of Cases :_____=____/30-DOZ.

Samples Needed :_____

Audit Number :_____

SAMPLE CONTAINERS SELECTED

1._____ 11._____
2._____ 12._____
3._____ 13._____
4._____ 14._____
5._____ 15._____
6._____ 16._____
7._____ 17._____
8._____ 18._____
9._____ 19._____
10._____ 20._____

INSTRUCTIONS: CIRCLE EACH SAMPLE IN THE CHART BELOW.

LAYER NO.	1					2					3					4					5					6				
CONT. POS.	1	3	5	7	9	1	3	5	7	9	1	3	5	7	9	1	3	5	7	9	1	3	5	7	9	1	3	5	7	9
PALLET NUMBER 1	1	3	5	7	9	10	12	14	16	18	19	21	23	25	27	28	30	32	34	36	37	39	41	43	45	46	48	50	52	54
2	55	57	59	61	63	64	66	68	70	72	73	75	77	79	81	82	84	86	88	90	91	93	95	97	99	100	102	104	106	108
3	109	111	113	115	117	118	120	122	124	126	127	129	131	133	135	136	138	140	142	144	145	147	149	151	153	154	156	158	160	162
4	163	165	167	169	171	172	174	176	178	180	181	183	185	187	189	190	192	194	196	198	199	201	203	205	207	208	210	212	214	216
5	217	219	221	223	225	226	228	230	232	234	235	237	239	241	243	244	246	248	250	252	253	255	257	259	261	262	264	266	268	270
6	271	273	275	277	279	280	282	284	286	288	289	291	293	295	297	298	300	302	304	306	307	309	311	313	315	316	318	320	322	324
7	325	327	329	331	333	334	336	338	340	342	343	345	347	349	351	352	354	356	358	360	361	363	365	367	369	370	372	374	376	378
8	379	381	383	385	387	388	390	392	394	396	397	399	401	403	405	406	408	410	412	414	415	417	419	421	423	424	426	428	430	432
9	433	435	437	439	441	442	444	446	448	450	451	453	455	457	459	460	462	464	466	468	469	471	473	475	477	478	480	482	484	486
10	487	489	491	493	495	496	498	500	502	504	505	507	509	511	513	514	516	518	520	522	523	525	527	529	531	532	534	536	538	540
11	541	543	545	547	549	550	552	554	556	558	559	561	563	565	567	568	570	572	574	576	577	579	581	583	585	586	588	590	592	594
12	595	597	599	601	603	604	606	608	610	612	613	615	617	619	621	622	624	626	628	630	631	633	635	637	639	640	642	644	646	648
13	649	651	653	655	657	658	660	662	664	666	667	669	671	673	675	676	678	680	682	684	685	687	689	691	693	694	696	698	700	702
14	703	705	707	709	711	712	714	716	718	720	721	723	725	727	729	730	732	734	736	738	739	741	743	745	747	748	750	752	754	756
15	757	759	761	763	765	766	768	770	772	774	775	777	779	781	783	784	786	788	790	792	793	795	797	799	801	802	804	806	808	810
16	811	813	815	817	819	820	822	824	826	828	829	831	833	835	837	838	840	842	844	846	847	849	851	853	855	856	858	860	862	864
17	865	867	869	871	873	874	876	878	880	882	883	885	887	889	891	892	894	896	898	900	901	903	905	907	909	910	912	914	916	918
18	919	921	923	925	927	928	930	932	934	936	937	939	941	943	945	946	948	950	952	954	955	957	959	961	963	964	966	968	970	972
19	973	975	977	979	981	982	984	986	988	990	991	993	995	997	999	1000	1002	1004	1006	1008	1009	1011	1013	1015	1017	1018	1020	1022	1024	1026
20	1027	1029	1031	1033	1035	1036	1038	1040	1042	1044	1045	1047	1049	1051	1053	1054	1056	1058	1060	1062	1063	1065	1067	1069	1071	1072	1074	1076	1078	1080
21	1081	1083	1085	1087	1089	1090	1092	1094	1096	1098	1099	1101	1103	1105	1107	1108	1110	1112	1114	1116	1117	1119	1121	1123	1125	1126	1128	1130	1132	1134
22	1135	1137	1139	1141	1143	1144	1146	1148	1150	1152	1153	1155	1157	1159	1161	1162	1164	1166	1168	1170	1171	1173	1175	1177	1179	1180	1182	1184	1186	1188
23	1189	1191	1193	1195	1197	1198	1200	1202	1204	1206	1207	1209	1211	1213	1215	1216	1218	1220	1222	1224	1225	1227	1229	1231	1233	1234	1236	1238	1240	1242
24	1243	1245	1247	1249	1251	1252	1254	1256	1258	1260	1261	1263	1265	1267	1269	1270	1272	1274	1276	1278	1279	1281	1283	1285	1287	1288	1290	1292	1294	1296
25	1297	1299	1301	1303	1305	1306	1308	1310	1312	1314	1315	1317	1319	1321	1323	1324	1326	1328	1330	1332	1333	1335	1337	1339	1341	1342	1344	1346	1348	1350
26	1351	1353	1355	1357	1359	1360	1362	1364	1366	1368	1369	1371	1373	1375	1377	1378	1380	1382	1384	1386	1387	1389	1391	1393	1395	1396	1398	1400	1402	1404
27	1405	1407	1409	1411	1413	1414	1416	1418	1420	1422	1423	1425	1427	1429	1431	1432	1434	1436	1438	1440	1441	1443	1445	1447	1449	1450	1452	1454	1456	1458
28	1459	1461	1463	1465	1467	1468	1470	1472	1474	1476	1477	1479	1481	1483	1485	1486	1488	1490	1492	1494	1495	1497	1499	1501	1503	1504	1506	1508	1510	1512
29	1513	1515	1517	1519	1521	1522	1524	1526	1528	1530	1531	1533	1535	1537	1539	1540	1542	1544	1546	1548	1549	1551	1553	1555	1557	1558	1560	1562	1564	1566
30	1567	1569	1571	1573	1575	1576	1578	1580	1582	1584	1585	1587	1589	1591	1593	1594	1596	1598	1600	1602	1603	1605	1607	1609	1611	1612	1614	1616	1618	1620

REMARKS:

GRADER'S SIGNATURE_____DATE_____

Worksheet #17

SAMPLE SELECTION WORKSHEET
72-9 DOZ. BASKETS PER PALLET

LOT INFORMATION

Grade & Size :_____

Type of pack :_____

No./Size of Cases :_____=____/30-DOZ.

Samples Needed :_____

Audit Number :_____

SAMPLE CONTAINERS SELECTED

1._____ 11._____
2._____ 12._____
3._____ 13._____
4._____ 14._____
5._____ 15._____
6._____ 16._____
7._____ 17._____
8._____ 18._____
9._____ 19._____
10._____ 20._____

INSTRUCTIONS: CIRCLE EACH SAMPLE IN THE CHART BELOW.

LAYER NO.	1						2						3						4						5						6					
CONT. POS.	2	4	6	8	10	12	2	4	6	8	10	12	2	4	6	8	10	12	2	4	6	8	10	12	2	4	6	8	10	12	2	4	6	8	10	12
P 1	2	4	6	8	10	12	14	16	18	20	22	24	26	28	30	32	34	36	38	40	42	44	46	48	50	52	54	56	58	60	62	64	66	68	70	72
A 2	74	76	78	80	82	84	86	88	90	92	94	96	98	100	102	104	106	108	110	112	114	116	118	120	122	124	126	128	130	132	134	136	138	140	142	144
L 3	146	148	150	152	154	156	158	160	162	164	166	168	170	172	174	176	178	180	182	184	186	188	190	192	194	196	198	200	202	204	206	208	210	212	214	216
L 4	218	220	222	224	226	228	230	232	234	236	238	240	242	244	246	248	250	252	254	256	258	260	262	264	266	268	270	272	274	276	278	280	282	284	286	288
E 5	290	292	294	296	298	300	302	304	306	308	310	312	314	316	318	320	322	324	326	328	330	332	334	336	338	340	342	344	346	348	350	352	354	356	358	360
T																																				
6	362	364	366	368	370	372	374	376	378	380	382	384	386	388	390	392	394	396	398	400	402	404	406	408	410	412	414	416	418	420	422	424	426	428	430	432
N 7	434	436	438	440	442	444	446	448	450	452	454	456	458	460	462	464	466	468	470	472	474	476	478	480	482	484	486	488	490	492	494	496	498	500	502	504
U 8	506	508	510	512	514	516	518	520	522	524	526	528	530	532	534	536	538	540	542	544	546	548	550	552	554	556	558	560	562	564	566	568	570	572	574	576
M 9	578	580	582	584	586	588	590	592	594	596	598	600	602	604	606	608	610	612	614	616	618	620	622	624	626	628	630	632	634	636	638	640	642	644	646	648
B 10	650	652	654	656	658	660	662	664	666	668	670	672	674	676	678	680	682	684	686	688	690	692	694	696	698	700	702	704	706	708	710	712	714	716	718	720
E																																				
R 11	722	724	726	728	730	732	734	736	738	740	742	744	746	748	750	752	754	756	758	760	762	764	766	768	770	772	774	776	778	780	782	784	786	788	790	792
12	794	796	798	800	802	804	806	808	810	812	814	816	818	820	822	824	826	828	830	832	834	836	838	840	842	844	846	848	850	852	854	856	858	860	862	864
13	866	868	870	872	874	876	878	880	882	884	886	888	890	892	894	896	898	900	902	904	906	908	910	912	914	916	918	920	922	924	926	928	930	932	934	936
14	938	940	942	944	946	948	950	952	954	956	958	960	962	964	966	968	970	972	974	976	978	980	982	984	986	988	990	992	994	996	998	1000	1002	1004	1006	1008
15	1010	1012	1014	1016	1018	1020	1022	1024	1026	1028	1030	1032	1034	1036	1038	1040	1042	1044	1046	1048	1050	1052	1054	1056	1058	1060	1062	1064	1066	1068	1070	1072	1074	1076	1078	1080
16	1082	1084	1086	1088	1090	1092	1094	1096	1098	1100	1102	1104	1106	1108	1110	1112	1114	1116	1118	1120	1122	1124	1126	1128	1130	1132	1134	1136	1138	1140	1142	1144	1146	1148	1150	1152
17	1154	1156	1158	1160	1162	1164	1166	1168	1170	1172	1174	1176	1178	1180	1182	1184	1186	1188	1190	1192	1194	1196	1198	1200	1202	1204	1206	1208	1210	1212	1214	1216	1218	1220	1222	1224
18	1226	1228	1230	1232	1234	1236	1238	1240	1242	1244	1246	1248	1250	1252	1254	1256	1258	1260	1262	1264	1266	1268	1270	1272	1274	1276	1278	1280	1282	1284	1286	1288	1290	1292	1294	1296
19	1298	1300	1302	1304	1306	1308	1310	1312	1314	1316	1318	1320	1322	1324	1326	1328	1330	1332	1334	1336	1338	1340	1342	1344	1346	1348	1350	1352	1354	1356	1358	1360	1362	1364	1366	1368
20	1370	1372	1374	1376	1378	1380	1382	1384	1386	1388	1390	1392	1394	1396	1398	1400	1402	1404	1406	1408	1410	1412	1414	1416	1418	1420	1422	1424	1426	1428	1430	1432	1434	1436	1438	1440
21	1442	1444	1446	1448	1450	1452	1454	1456	1458	1460	1462	1464	1466	1468	1470	1472	1474	1476	1478	1480	1482	1484	1486	1488	1490	1492	1494	1496	1498	1500	1502	1504	1506	1508	1510	1512
22	1514	1516	1518	1520	1522	1524	1526	1528	1530	1532	1534	1536	1538	1540	1542	1544	1546	1548	1550	1552	1554	1556	1558	1560	1562	1564	1566	1568	1570	1572	1574	1576	1578	1580	1582	1584
23	1586	1588	1590	1592	1594	1596	1598	1600	1602	1604	1606	1608	1610	1612	1614	1616	1618	1620	1622	1624	1626	1628	1630	1632	1634	1636	1638	1640	1642	1644	1646	1648	1650	1652	1654	1656
24	1658	1660	1662	1664	1666	1668	1670	1672	1674	1676	1678	1680	1682	1684	1686	1688	1690	1692	1694	1696	1698	1700	1702	1704	1706	1708	1710	1712	1714	1716	1718	1720	1722	1724	1726	1728
25	1730	1732	1734	1736	1738	1740	1742	1744	1746	1748	1750	1752	1754	1756	1758	1760	1762	1764	1766	1768	1770	1772	1774	1776	1778	1780	1782	1784	1786	1788	1790	1792	1794	1796	1798	1800

REMARKS:

GRADER'S SIGNATURE_____DATE_____

Worksheet #18

OPTIONAL SAMPLE
SELECTION WORKSHEET

LOT INFORMATION

Grade & Size :_____

Type of pack :_____

No./Size of Cases :_____=____/30-DOZ

Samples Needed :_____

Audit Number :_____

INSTRUCTIONS: CIRCLE EACH SAMPLE IN THE CHART BELOW.

SAMPLE NUMBER	PALLET NUMBER	LAYER NUMBER	CONTAINER POSITION	SAMPLE NUMBER	PALLET NUMBER	LAYER NUMBER	CONTAINER POSITION
1				11			
2				12			
3				13			
4				14			
5				15			
6				16			
7				17			
8				18			
9				19			
10				20			

REMARKS:

GRADER'S SIGNATURE_____DATE_____

Worksheet #19

SAMPLE SELECTION WORKSHEET
45-9 DOZ. BASKETS PER PALLET

LOT INFORMATION

Grade & Size :_____

Type of pack :_____

No./Size of Cases :_____=____/30-DOZ.

Samples Needed :_____

Audit Number :_____

SAMPLE CONTAINERS SELECTED

1._____ 11._____
2._____ 12._____
3._____ 13._____
4._____ 14._____
5._____ 15._____
6._____ 16._____
7._____ 17._____
8._____ 18._____
9._____ 19._____
10._____ 20._____

INSTRUCTIONS: CIRCLE EACH SAMPLE IN THE CHART BELOW.

LAYER NO.		1					2					3					4					5					LAYER NO.	
CONT. POS.		1	3	5	7	9	1	3	5	7	9	1	3	5	7	9	1	3	5	7	9	1	3	5	7	9	CONT. POS.	
P	1	1	3	5	7	9	10	12	14	16	18	19	21	23	25	27	28	30	32	34	36	37	39	41	43	45	1	P
A	2	46	48	50	52	54	55	57	59	61	63	64	66	68	70	72	73	75	77	79	81	82	84	86	88	90	2	A
L	3	91	93	95	97	99	100	102	104	106	108	109	111	113	115	117	118	120	122	124	126	127	129	131	133	135	3	L
L	4	136	138	140	142	144	145	147	149	151	153	154	156	158	160	162	163	165	167	169	171	172	174	176	178	180	4	L
E	5	181	183	185	187	189	190	192	194	196	198	199	201	203	205	207	208	210	212	214	216	217	219	221	223	225	5	E
T																												T
	6	226	228	230	232	234	235	237	239	241	243	244	246	248	250	252	253	255	257	259	261	262	264	266	268	270	6	
N	7	271	273	275	277	279	280	282	284	286	288	289	291	293	295	297	298	300	302	304	306	307	309	311	313	315	7	N
U	8	316	318	320	322	324	325	327	329	331	333	334	336	338	340	342	343	345	347	349	351	352	354	356	358	360	8	U
M	9	361	363	365	367	369	370	372	374	376	378	379	381	383	385	387	388	390	392	394	396	397	399	401	403	405	9	M
B	10	406	408	410	412	414	415	417	419	421	423	424	426	428	430	432	433	435	437	439	441	442	444	446	448	450	10	B
E																												E
R	11	451	453	455	457	459	460	462	464	466	468	469	471	473	475	477	478	480	482	484	486	487	489	491	493	495	11	R
	12	496	498	500	502	504	505	507	509	511	513	514	516	518	520	522	523	525	527	529	531	532	534	536	538	540	12	
	13	541	543	545	547	549	550	552	554	556	558	559	561	563	565	567	568	570	572	574	576	577	579	581	583	585	13	
	14	586	588	590	592	594	595	597	599	601	603	604	606	608	610	612	613	615	617	619	621	622	624	626	628	630	14	
	15	631	633	635	637	639	640	642	644	646	648	649	651	653	655	657	658	660	662	664	666	667	669	671	673	675	15	
	16	676	678	680	682	684	685	687	689	691	693	694	696	698	700	702	703	705	707	709	711	712	714	716	718	720	16	
	17	721	723	725	727	729	730	732	734	736	738	739	741	743	745	747	748	750	752	754	756	757	759	761	763	765	17	
	18	766	768	770	772	774	775	777	779	781	783	784	786	788	790	792	793	795	797	799	801	802	804	806	808	810	18	
	19	811	813	815	817	819	820	822	824	826	828	829	831	833	835	837	838	840	842	844	846	847	849	851	853	855	19	
	20	856	858	860	862	864	865	867	869	871	873	874	876	878	880	882	883	885	887	889	891	892	894	896	898	900	20	
	21	901	903	905	907	909	910	912	914	916	918	919	921	923	925	927	928	930	932	934	936	937	939	941	943	945	21	
	22	946	948	950	952	954	955	957	959	961	963	964	966	968	970	972	973	975	977	979	981	982	984	986	988	990	22	
	23	991	993	995	997	999	1000	1002	1004	1006	1008	1009	1011	1013	1015	1017	1018	1020	1022	1024	1026	1027	1029	1031	1033	1035	23	
	24	1036	1038	1040	1042	1044	1045	1047	1049	1051	1053	1054	1056	1058	1060	1062	1063	1065	1067	1069	1071	1072	1074	1076	1078	1080	24	
	25	1081	1083	1085	1087	1089	1090	1092	1094	1096	1098	1099	1101	1103	1105	1107	1108	1110	1112	1114	1116	1117	1119	1121	1123	1125	25	
	26	1126	1128	1130	1132	1134	1135	1137	1139	1141	1143	1144	1146	1148	1150	1152	1153	1155	1157	1159	1161	1162	1164	1166	1168	1170	26	
	27	1171	1173	1175	1177	1179	1180	1182	1184	1186	1188	1189	1191	1193	1195	1197	1198	1200	1202	1204	1206	1207	1209	1211	1213	1215	27	
	28	1216	1218	1220	1222	1224	1225	1227	1229	1231	1233	1234	1236	1238	1240	1242	1243	1245	1247	1249	1251	1252	1254	1256	1258	1260	28	
	29	1261	1263	1265	1267	1269	1270	1272	1274	1276	1278	1279	1281	1283	1285	1287	1288	1290	1292	1294	1296	1297	1299	1301	1303	1305	29	
	30	1306	1308	1310	1312	1314	1315	1317	1319	1321	1323	1324	1326	1328	1330	1332	1333	1335	1337	1339	1341	1342	1344	1346	1348	1350	30	

REMARKS:

GRADER'S SIGNATURE_____DATE_____

SECTION 8: ON-LINE SAMPLING OF SHELL EGGS

I. General

The effectiveness of on-line sampling of shell eggs in each plant is directly related to the plant's efforts, in cooperation with the grader, to maintain a sound quality control program. Essential to a successful program are clearly defined procedures with regard to line identity, product control, sampling frequency, recording and evaluating sampling results, retention action, and issuing certificates, all of which will be addressed separately in this section. The evaluation of shell egg quality by "on-line" sampling provides certain options not available when product is sampled on a stationary lot basis.

For a stationary lot grading, average product quality is determined by samples selected from a completed lot. There is no provision for improving the average quality of the lot since it was completed before the samples were taken. Consequently, if the samples show that individual case or average tolerance requirements are exceeded for any factor, the entire lot is unacceptable.

On-line sampling, however, provides for product quality evaluation at regular intervals during production, with a primary goal of maintaining quality within reasonable, specified limits. If marginal quality product is encountered, as evidenced by a sample which shows that tolerance requirements for any factor are approaching the non-compliance level, the plant has the opportunity to make adjustments. Should such adjustments prove ineffective and the tolerance is exceeded on a subsequent sample, the amount of product affected (retained) is limited to that which was produced since the last acceptable sample.

II. Line Identity

The basic principle of on-line sampling involves the separation of production into various "lines" for sampling purposes. A "line" is defined as product being packed to meet the same grade and size requirements. For example: All U.S. Grade A Large eggs being packed onto one or more packing lines may be sampled as one line without regard to brand, type of packaging material, etc. Each sample taken from the U.S. Grade A Large line throughout the shift represents a segment of the ongoing production from that line. This segment of production, in effect, becomes a separate "lot," and is accepted or retained based on the cumulative quality history of the line, as determined by the results of the particular sample.

A. A "primary" line is one which is anticipated to pack 100 or more 30-dozen cases of the same grade and size during the shift.

B. A "secondary" line is one which is anticipated to pack less than 100 / 30-dozen cases of the same grade and size during the shift.

C. Each size must be sampled as a separate line.

D. U.S. Grade A product cannot be combined with U.S. Grade AA product for sampling purposes, except when the plant agrees that all product must meet U.S. Grade AA requirements.

E. Product being packed for an approved specification with more restrictive tolerances must be sampled as a separate line.

F. Normally, product from each machine will be sampled separately by size category. However, a plant may request to combine production of the same size from more than one machine into a single line for sampling purposes. For example: The same brand of U.S. Grade A Large being packed on two or more machines can be sampled as a single line.

If production of the same size from two or more machines is combined, samples will normally be selected on an alternating basis between machines. However, the USDA grader has the option of varying the sampling sequence, depending on product quality and volume on each machine. In any case, each sample represents the accumulated production from all machines since the last sample.

G. If the USDA grader's workload permits, a plant may request to designate individual brands, different types of packaging materials, or even individual packing "heads" or stations, as separate lines for sampling purposes.

H. Under some situations it may be possible to merge 2 separate lines of the same grade and size into a single line. Two "in control" lines could be merged into the line having the lowest quality and the first sample after the merge would be from that line. If either line is "out of control" or in a retain status, it is not permissible to merge into a single line without first bringing the line(s) back into control.

III. Product Control

A. Designated Plant Employee

The plant shall designate one or more employees to work with the USDA grader while officially identified product is being packed. These employees shall be readily available at all times to:

1. Receive notification from the USDA grader when a non-compliance sample is encountered on any line, or when a line is approaching maximum tolerance levels.

2. Assist the USDA grader in locating and segregating product to be retained when a noncompliance sample is encountered.

3. Notify the USDA grader when new lines are started any time during the shift.

B. Sampling Intervals

When officially identified product is being packed, samples are to be examined from each line at regular intervals during the shift. A "sampling interval" is defined as:

1. The elapsed time between samples.

2. The amount of product packed between samples.

C. Measurement

When calculating elapsed time or the amount of product packed, measurement is from the point where the completed sample is returned to the line. Beginning with the first sample, and on each subsequent sample, all product packed up to the point where the completed sample is returned to the line may be released for shipment.

NOTE: Graders shall not “stockpile” samples in their candling booth. Only one sample shall be taken off of the conveyor/line for an official sample at any given time.

When a non-compliant sample is found, notify the designated plant employee as soon as possible. Do not return the sample to the line until after the plant employee has been notified. When returned, the sample becomes the "marker" and all product from that point back to the last acceptable sample is to be retained.

D. Identification System for Samples

The plant must have an approved identification system for each line which will permit segregation of product represented by unsatisfactory samples.

1. To assist in accomplishing this requirement, USDA will provide self-adhesive labels (Form PY-12) for identifying official samples. These will also serve as "markers" to identify sampling intervals.

    a. USDA label markers will be affixed to each sample container, showing the date, sample number, and grader's initials. If desired, the time the sample is returned to the line may also be shown. When stacked, the sample container must be placed in proper sequence, with the USDA label marker plainly visible on the outside of the pallet, dolly, row, etc. Some pallets, dollies, racks, bossies, etc., filled between official samples will not have any containers identified with a USDA label marker. These pallets, etc., must be marked or segregated in some manner so they can be identified as part of the applicable sampling interval, should retention be necessary.

    b. When a completed 100-egg sample is returned to a movable rack or "bossie," rather than to a case or basket, each primary unit in the sample (flat, carton, etc.) is to be identified in some way; i.e., small letters with the USDA grader's initials, etc. The entire sample unit (100 eggs) is to be identified with a USDA label marker clearly visible on the outside of the rack.

    c. Some plants may, on occasion, pack more than one brand on the same grading machine with the different brands stacked on separate pallets. When the eggs on a grading machine are being sampled as a single day’s production of an identified weight class (size) rather than each brand being sampled as a separate lot, the eggs packaged are recognized as a single lot. For control purposes, the grader must identify the next container of each brand when an examined sample is returned to the packaging line. For example: "Ace" brand and "Best" brand U.S. Grade A Large are being packed on the same grading machine with the USDA grader alternating samples between the two

brands. Since each sample represents a day's production of the large eggs packaged on the grading machine, the brand not sampled must also be marked each time an examined sample is returned to the packaging line.

Accordingly, a USDA label marker must be applied to the container last filled on the line of Ace brand when a Best brand sample is completed, and vice versa. The applicable sampling interval is to be shown on the label marker applied to the non-sample container. Mark a large "X" on the label marker to indicate the container was not sampled. Similarly, if more than two brands are being sampled as a single line, all brands must be identified with a USDA label marker to mark the intervals, each time a sample is returned to the line.

2. In lieu of using USDA label markers, the plant may request to use another equivalent system for identifying official samples and sampling intervals. Any system used must provide for positive control and be approved by the Federal-State supervisor. A description of the plant's current system is to be kept in the "Information for Relief Grader" file folder 2.

3. Label markers are used primarily to control or identify sample intervals in the plant and may be removed at time of shipment. Any container used as an official sample must have the sample number and grader's initials affixed elsewhere to the case, basket, bossie, etc.

E. Overlapping

Overlapping occurs when product from different sampling intervals is mixed on the same pallet. Unless a plant elects to start a new pallet, row, etc., for each sampling interval, overlapping of intervals is unavoidable. When a non-compliant sample is found, all pallets, rows, dollies, etc. (as applicable) which contain any product represented by the noncompliance sample, must be retained. When acceptable product is mixed on the same pallet with non-acceptable product, the plant may request to segregate the acceptable product (for release), provided plant employees always follow an established, uniform system of stacking product. Otherwise, the entire pallet must be retained in order to assure all noncompliant product is accounted for. The plant's stacking system(s) must be diagramed by the USDA grader, and a copy kept in the "Information for Relief Grader" file folder 2. The USDA grader must also verify from time to time that the established stacking system is being followed.

F. Stacking Product

Stacking occurs when product from two or more machines is placed on the same pallet. <u>For example</u>: Ace brand A Large eggs are being packed on two machines and stacked onto the same pallet.

1. Containers not identified by machine - A non-compliant sample on any machine requires retention of the accumulated production from all machines since the last acceptable sample. This applies regardless of whether all machines are sampled as a single line, or each machine is sampled separately.

2. Containers are identified by machine - A non-compliant sample on any machine requires retention of the accumulated production from all machines since the last acceptable sample.

a. If each machine is sampled as a separate line, the plant may elect to segregate and hold product from the "out of control" machine(s) for full-sampling. Product from the "in control" machine(s) may be released for shipment.

b. If machines are combined and sampled as a single line, there is no provision for segregating acceptable product for immediate release. However, the plant may elect to segregate product by machine into separate sublots for a full representative sampling.

IV. Sampling Frequency

Sampling frequency is based primarily on the volume being packed on each line. However, product quality must also be considered. Generally, poor or marginal quality product will be sampled more frequently.

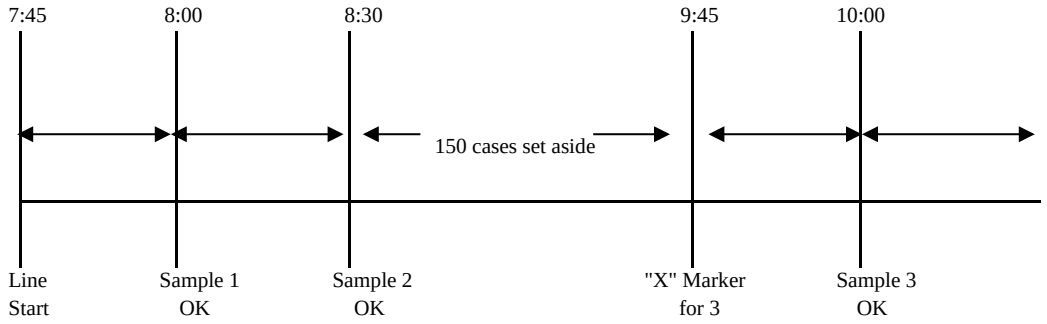
A. Determination Primarily by Volume

To meet minimum sampling requirements on primary lines, the USDA grader must average one sample for each 100 / 30-dozen cases produced on each line. Time permitting, graders should sample at a more frequent rate in order to promptly address fluctuations in quality, and to reduce the quantity of retained product. If plant management requests an increased frequency of sampling and time is not available, the grader's Federal-State supervisor will provide additional staffing.

For an "in control" line, any one sample can represent up to 125 / 30-dozen cases, provided the average sampling interval for that line is 100 cases or less at the completion of the shift. If more than 125 cases will have accumulated during any sampling interval, all product packed on that line since the last acceptable sample must be held for later evaluation as a separate stationary lot (not to be combined with retained product). To identify the cut-off point for the product being set aside, and to mark the beginning of the next sampling interval, place a USDA label marker on the container last filled on the line. Since this container is not a sample, place a large "X" through the marker and show the number of the next sample to be taken, which will represent product produced from the marker forward. That next sample should be selected as soon as possible in order to determine the current status of the line (Example #1).

The product to be set aside for later full sampling must be conspicuously identified in some manner, such as with USDA hold tape, to preclude it from being shipped. Show under "Comment Log" on the reverse of Form PY-75 the total number of cases set aside and the time frame involved. For example: 0830-0945: 150 / 30-dozen cases, Ace brand U.S. Grade A Large cartons not sampled - set aside for full sampling.

Example #1 – U.S. Grade A Large - (Line production - approximately 125 cases per hour)



In high volume plants, the grader may need to informally project an estimated volume for each primary line at the beginning of the shift. These estimates can be used to calculate the number of samples needed to meet the minimum requirement of 1 sample for each 100 cases produced. Recent ordering patterns by the plant's regular accounts, along with current information from the plant, should aid in estimating daily volume. Approximate spacing of samples (minutes between samples or cases produced between samples) can be projected using these estimates.

To avoid becoming predictable or setting a pattern, the spacing of samples throughout the day should be varied slightly; i.e., samples should be taken at different time intervals and occasionally taken "back-to-back" on the same line.

On slow volume (secondary) lines where a total of less than 100 / 30-dozen cases is expected to be packed during the shift, examine at least one sample for every 2 hours of production time. Alternatively, if production is not continuous, examine enough samples to equal the number required for a stationary lot.

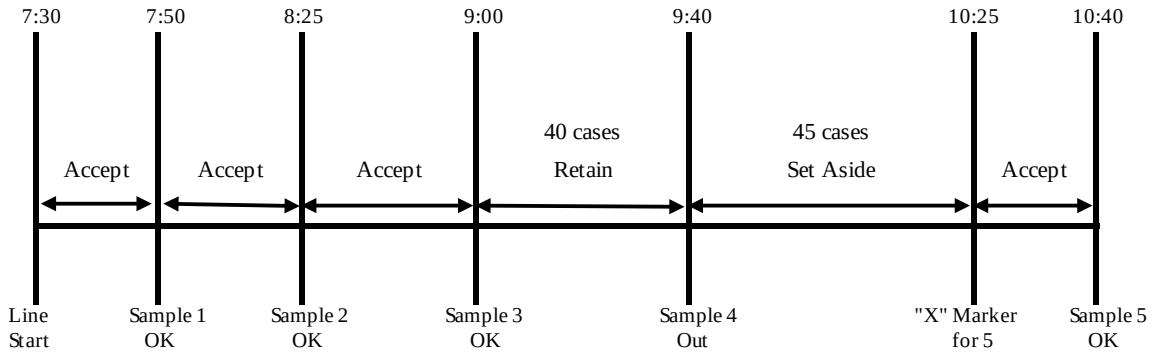
There may be occasions when a limited volume of product is produced in a short period of time. For example, the only U.S. Grade A Small packed on the shift is a special order for 40 cases, which is produced in 30 minutes. If the USDA grader takes one sample during production, and this sample meets the tightened start-up tolerances, product may be accepted based on the one sample. If the grader is not able to examine a sample during production, a full representative sample must be examined from the finished lot.

B. Sampling Following a Retention

When retention is necessary on any line, immediately notify the designated plant employee of the reason(s) for the retention and document on a Form PY-75 or 75A. **DO NOT RETURN THE NON-COMPLIANT SAMPLE TO THE LINE UNTIL THIS IS ACCOMPLISHED**. If the plant continues to pack officially identified product, select and examine another sample from that line as soon as possible (complete the sample within approximately 25 minutes) to determine if corrections have been made. If a sample cannot be taken and completed within approximately 25 minutes, all product packed since the last acceptable sample must be held for later evaluation as a separate stationary lot. If management advises the grader that corrections cannot be made immediately or elects not to correct the non-compliance within the prescribed time and waives the 25 minutes for sampling, then all officially identified product must be held until the line is back in control.

Graders are to follow the procedures outlined in IV.A, (pages 5 and 6) of this section for identifying the cutoff point, controlling the product set aside, and selecting the next online sample (Example #2).

Example #2 – U.S. Grade A Large (Line Production - Approximately 60 cases per hour)



C. Sampling Frequency Adjustments

During the shift, production from any line may vary from hour to hour. Accordingly, when necessary, adjust the sampling frequency to maintain the minimum ratio of 1 sample for each 100 cases produced.

Quality on a particular line may decline without requiring retention. For example: Accumulated checks may move above the average tolerance line, indicating a potential problem. In this situation, if time permits, select another sample as soon as possible to determine the status of the line.

When sampling poor quality product, recurring retentions on the same line or back to back retentions on two or three different lines may make it impossible for the USDA grader to keep up with minimum sampling requirements on all lines. In such situations, give priority to lines with the highest volume in an effort to minimize the amount of product which could be retained or set aside.

D. Assuring That Minimum Sampling Requirements Are Met

The USDA grader is to calculate average sampling intervals for each line as soon as practical after each shift is completed. This requires that production figures for the previous day's shift be available to the grader no later than the following workday. Instructions for calculating average sampling intervals are shown in V.F.1, of this section.

V. Recording and Evaluation of Sampling Results

A. Forms

The Shell Egg Online Candling Record (Forms PY-75 and 75A) will be used for recording sampling results (Exhibits I and II, respectively).

1. Use Form PY-75 to record samples of product being packed to meet U.S. Grade AA or U.S. Grade A requirements.

2. Use Form PY-75A to record samples of product being packed for an approved specification. Checks may not exceed 4 percent average tolerance, with a maximum of 8 percent as the individual case tolerance.

3. The front of both forms is divided, with space to record nine samples on the left half and eight on the right.

4. Normally, only two lines (sizes) will be recorded on one form. For example: U.S. Grade A Large on the left half and U.S. Grade A Medium on the right half.

   a. If the grader anticipates that more than 8 or 9 samples will be examined from the same line during the shift, one form may be utilized by beginning on the left and continuing across the right half to record up to 17 samples.

   b. For secondary lines from which only a few samples are anticipated, sampling results from more than one line may be entered on either the left or right half of Form PY-75 or 75A. Space for at least three samples should be reserved for each size (Example #3).

Example #3 - Recording Secondary Lines

DATE	CODE	GRADER	PLANT	NO.	MACHINE(S)
08/29/16	242	Burt Dixon	ABC Egg Co.	1234	2

	U.S. GRADE & SIZE									U.S. GRADE & SIZE							
	AA SMALL				AA EXTRA LARGE					A SMALL				A JUMBO			
Brand	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
Exp.																	

B. Tolerances

1. To assist the grader in quickly verifying compliance in sections II, III, and IV after each sample is completed, the average tolerance (shaded line) and individual case tolerance (top space) are "built-in" on Forms PY-75 and 75A. In these three sections, the "one egg over" allowance has been incorporated, which means that the top space becomes an action level indicator. Product is acceptable (one egg over) when the top space is filled, but not acceptable when the top space is exceeded.

2. Sections I and V do not have a built-in action level indicator since non-compliances for grade and weight factors are generally quite infrequent. However, the grader must verify that average and individual case tolerance requirements are met in these sections after each sample is completed.

a. Section I - Grade

The moving average for U.S. Grade AA or A, as applicable, must be 87 or better with no individual case below 77.

The moving average for B* cannot exceed 1 percent and no case can exceed 3 percent. The first sample may not exceed two B* eggs including the one egg over allowance.

b. Section V - Individual Underweight Eggs

The moving average for individual underweight eggs cannot exceed 3.3 percent, with no case exceeding 5 percent. The first sample may not exceed three individual underweight eggs. The one egg over allowance does not apply to underweight eggs.

c. Section VI - Container Weight

There is no tolerance for individual containers which weigh less than the minimum net weight for the size involved.

3. At the beginning of each shift, or when a new line is started during the same shift, individual case tolerances are tightened on both Form PY-75 and 75A for the first sample (second and third samples for some factors) in sections II, III, and IV (Example #4).

By providing product which meets the tightened "startup" tolerances, the plant may immediately ship all product represented by the first sample when it is completed. Product represented by each subsequent satisfactory sample will also be released for immediate shipment, provided individual case tolerances are not exceeded in any section.

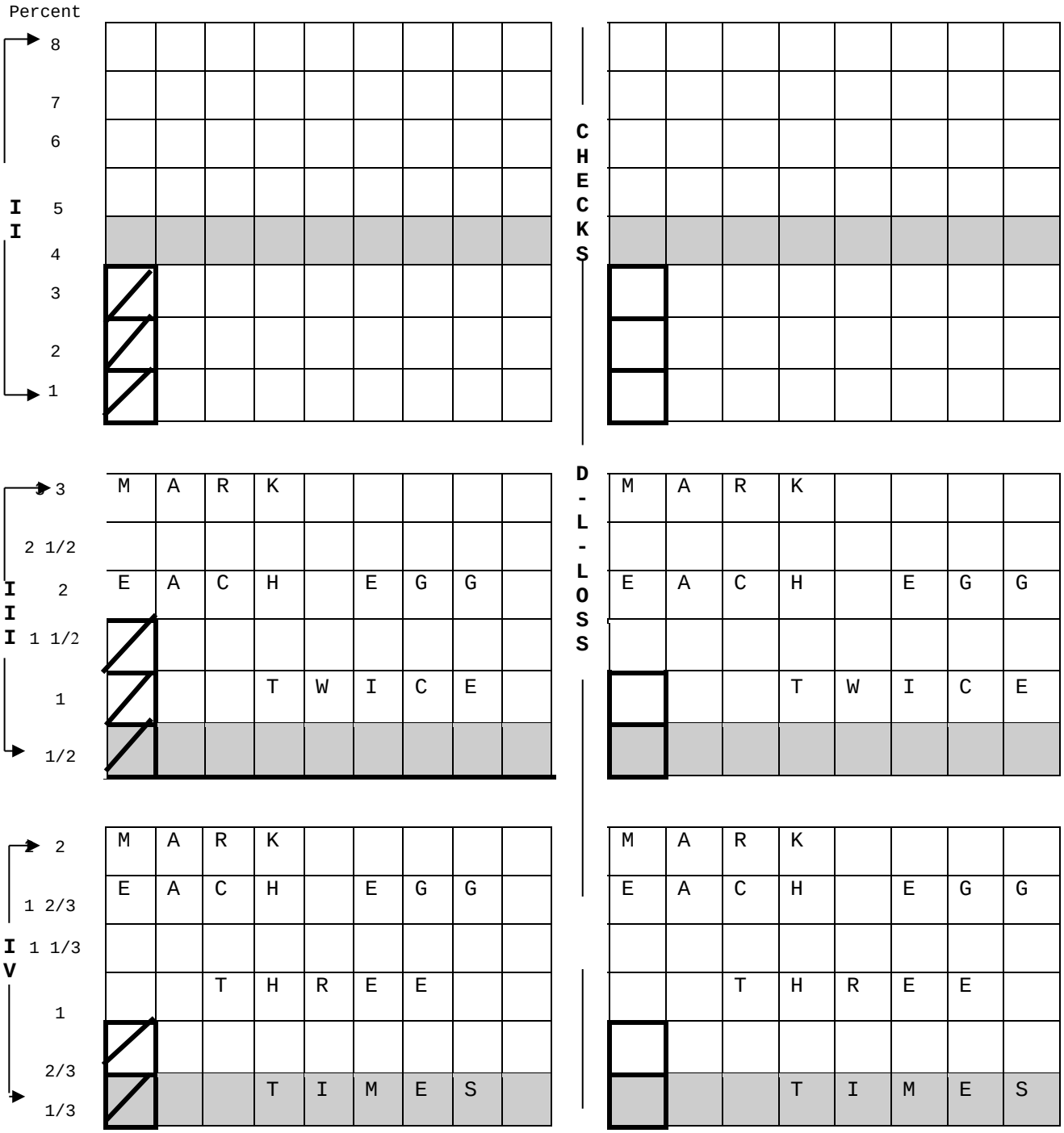
When production or sampling on a previously started line stops and then later resumes on the same shift, it may continue as the same line, without reverting back to a first sample "startup" situation. Any retention of product would be back to the place where the line resumed.

4. The first sample tightened tolerances are to be marked off in sections II, III, and IV with diagonal lines through the spaces outlined with bold lines (Examples 4, 5, and 6).

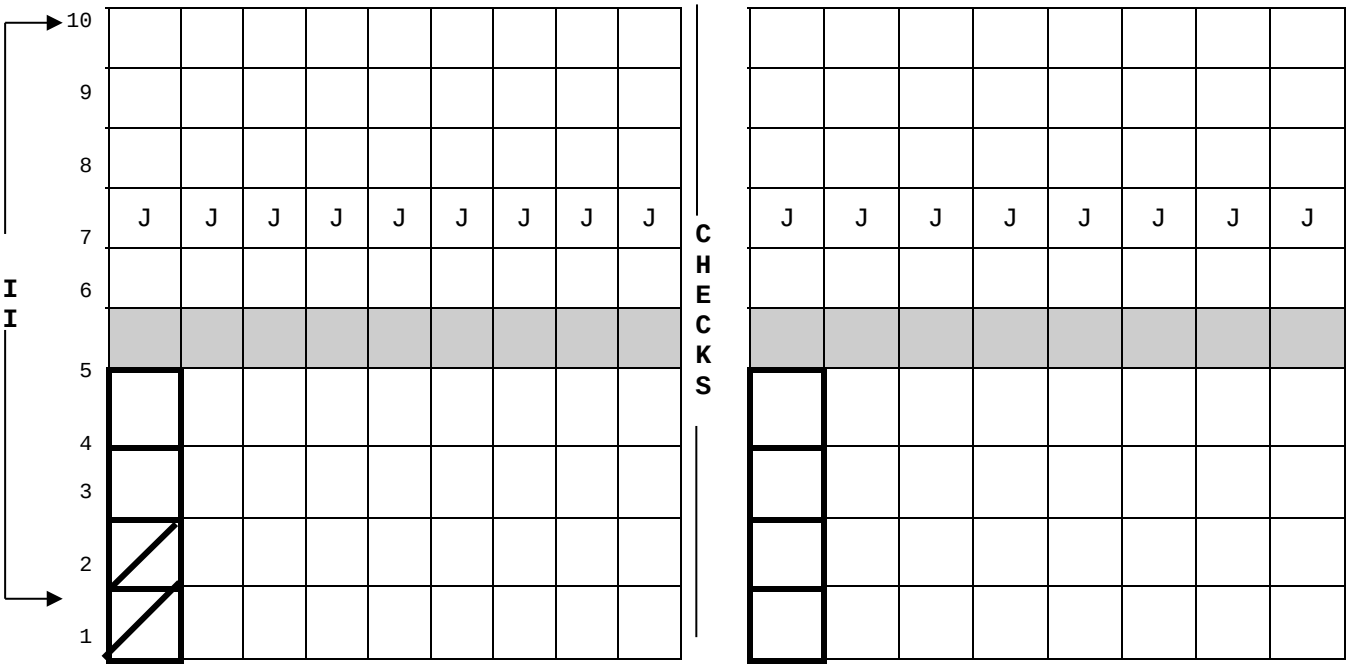
Example #4 - Form PY-75 (all sizes except Jumbo)

Sample										GRADE									Sample
AA																			AA
A																			A
I																			I
B																			B
E																			E
Percent																			
10																			10
9																			9
8																			8
	J	J	J	J	J	J	J	J	J	CHECKS	J	J	J	J	J	J	J	J	
7																			7
I 6																			6
I 5																			5
4																			4
3																			3
2																			2
1																			1
3	M	A	R	K						D-L-LOSS	M	A	R	K					3
2 1/2																			2 1/2
I 2	E	A	C	H		E	G	G			E	A	C	H		E	G	G	2
I 1 1/2																			1 1/2
1				T	W	I	C	E					T	W	I	C	E		1
1/2																			1/2
2	M	A	R	K							M	A	R	K					2
1 2/3	E	A	C	H		E	G	G			E	A	C	H		E	G	G	1 2/3
I V 1 1/3										LS									1 1/3
1			T	H	R	E	E						T	H	R	E	E		1
2/3																			2/3
1/3				T	I	M	E	S						T	I	M	E	S	1/3

Example #5 - Form PY-75A (all sizes except Jumbo)



Example #6 - Jumbo Only (Form PY-75)



For Jumbo, (Form PY-75), the only difference is in section II (checks), where two spaces instead of four are marked off on the first sample. The tolerances in sections III and IV are marked off the same as shown in examples 4 and 5.

NOTE: If the first sample is unsatisfactory (retained), the startup tolerances are applicable to the second sample, and the appropriate spaces are to be blocked off in sections II, III, and IV.

C. Carryover

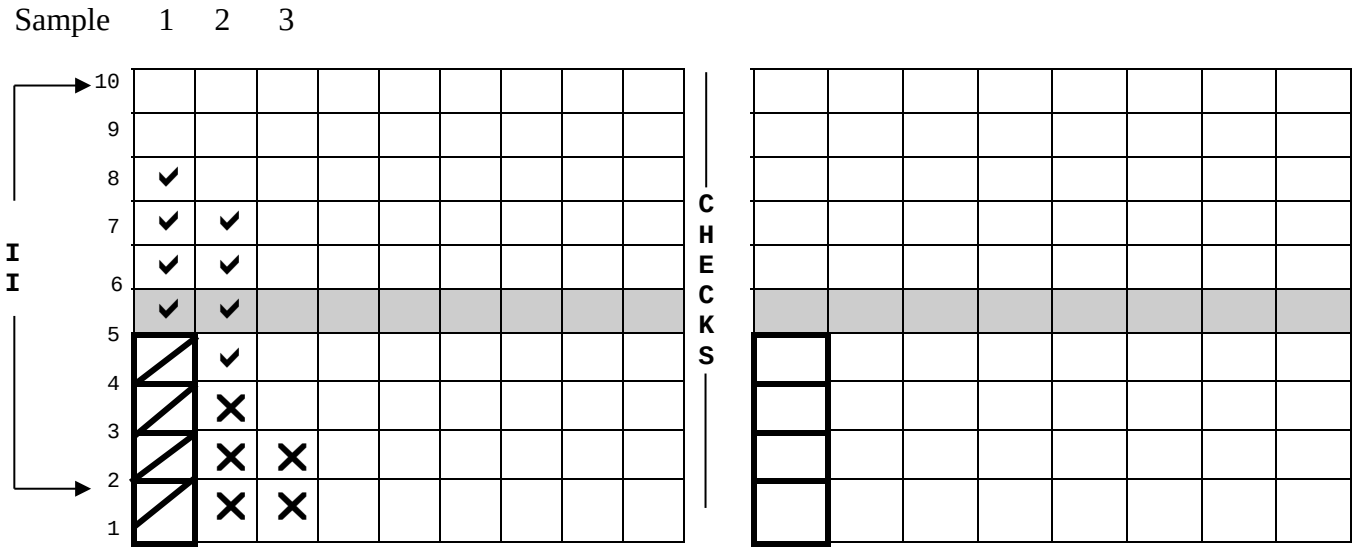
When the results for any sample approach the individual tolerance (top space) in sections II, III, or IV, the designated plant employee is to be advised that improvement is needed to avoid a possible retention on the next sample. To emphasize the need for improvement, the results of the previous sample are used to determine the maximum allowable tolerance on the next sample.

This system, called "carryover," is designed to prevent acceptance of product represented by several consecutive samples which exceed average tolerance requirements.

When the average tolerance in sections II, III, or IV is exceeded on any sample, the number of spaces by which the line is exceeded in each section must be "carried over" to the next sample. In effect, this means that better quality product must be provided (at least meeting the average tolerance requirement) to avoid a retention situation. If corrective action is not initiated, or is not successful, and the next sample exceeds the individual case tolerance (with actual sample results added to the carryover), retention would be necessary.

Example #7 Form PY-75 - Section II

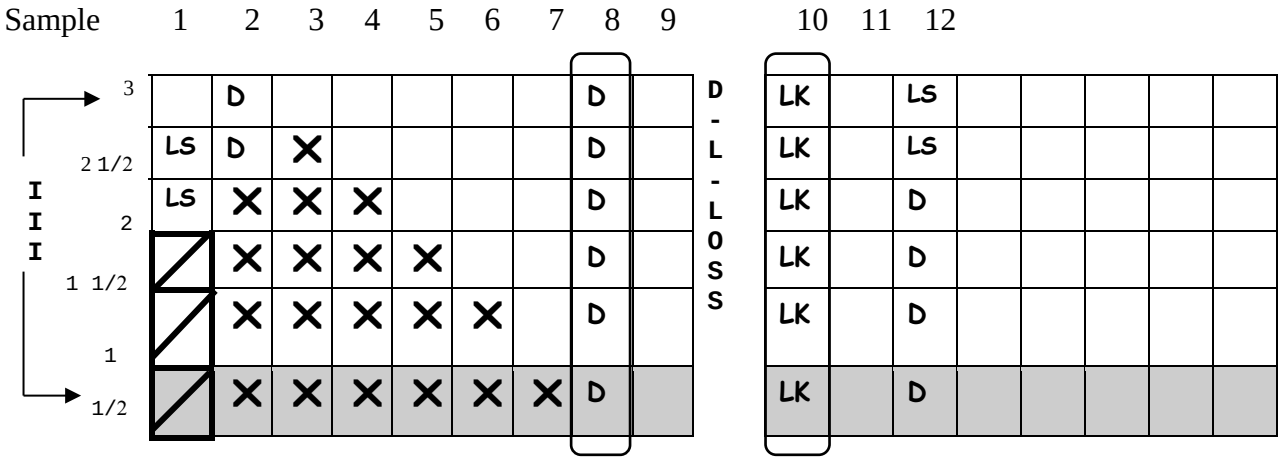
(Carryover shown for samples 2 and 3)



In the first sample, four checks which fill eight spaces (including the four lined out spaces) were found. This is three spaces above the average tolerance line (5 percent). Therefore, the carryover of 3 is shown with an "X" in the bottom three spaces on the second sample.

Four checks were found in the second sample which fills seven spaces (including the three lined out spaces). This is two spaces above the average tolerance, so the bottom two spaces on the third sample are marked with an "X" to show the carryover.

Example #8, Form PY-75 - Section III



In the first sample, which fills five spaces (including the three lined out spaces), one LS was found. This is four spaces above the tolerance line (.50 percent), resulting in a carryover of 4 to the second sample.

In the second sample, a dirty egg was found (recorded in spaces 5 and 6). Five spaces are now filled above the average tolerance line, requiring a carryover of 5 to the third sample.

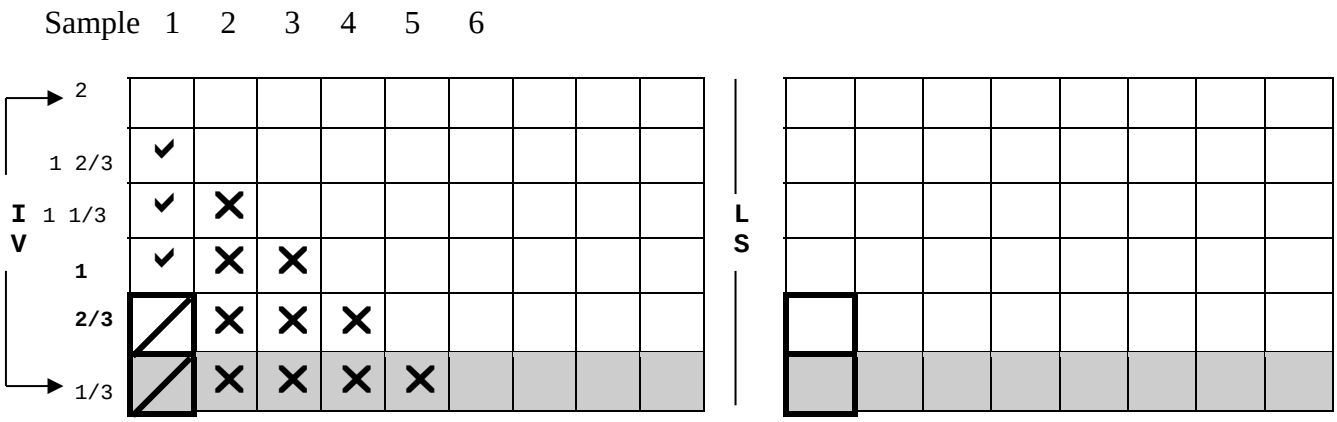
NOTE: In Example #8 one dirty, leaker, or large spot loss egg in sample 3 would cause retention (individual case tolerance would be exceeded).

In sample 8, three dirty eggs were found causing retention because the individual case tolerance of two dirty eggs was exceeded.

In sample 10, three leaker eggs were found causing retention because the individual case tolerance of two leaker eggs was exceeded.

In sample 12, which is acceptable, two dirty eggs and one LS egg were found. Since there is no carryover, a total of three undergrade eggs are permitted in this section provided there are not more than two dirty eggs or two leaker eggs in the sample.

Example #9, Form PY-75 - Section IV

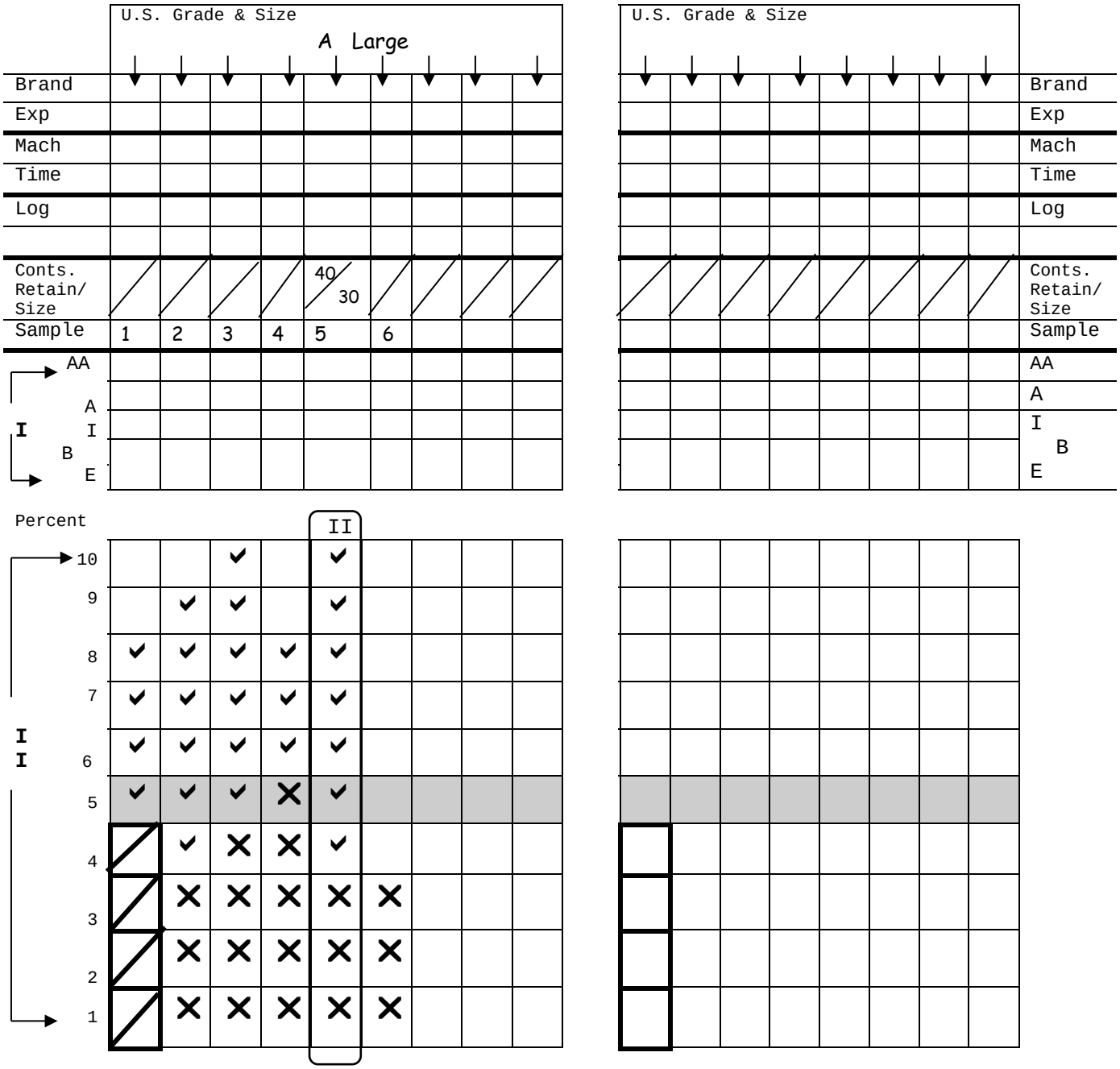


The LS recorded in section III on the first sample (Example #8) must also be recorded three times in section IV. This fills five spaces (including the two lined out spaces), which is four spaces above the tolerance line (.33 percent). Therefore, a carryover of 4 is required for the second sample.

NOTE: In Example #9, one "LS" in the second sample would cause retention (individual case tolerance of 2 eggs would be exceeded).

If no LS eggs are found in samples 2 through 5, the carryover is reduced by 1 on successive samples until, on sample 6, there is no carryover.

Example #10, Form PY-75 - Carryover When Retention Is Involved



The nine checks found in sample number 5 would cause retention.

IN A RETENTION SITUATION, THE SAMPLE WHICH CAUSED THE RETENTION IS DISREGARDED, AND THE CARRYOVER IS FROM THE LAST ACCEPTABLE SAMPLE BEFORE THE RETENTION.

In this example, the carryover is from sample 4, (three spaces blocked off on sample 6).

D. Example #11 Completing Forms - Recording Results

PAGE 1 OF 2 GRADER'S DUTY HOURS 0800 TO 1630

DATE 1	CODE 1	GRADER 1	PLANT 1	NO. 1	MACHINE(S)1
08/29/16	242	Burt Dixon	ABC Egg Co.	1234	1 & 2

3	U.S. GRADE & SIZE 2 AA Medium										U.S. GRADE & SIZE								
Brand	4	WD																	Brand
Exp	5	9/27																	Exp
Mach	6	2																	Mach
Time	7	0900																	Time
Log Ref #	8	0845 1130																	Log Ref #
	9	4																	
Cont. Retain Size	10	70 / 15																	Cont Retain Size
Sample	11	1																	Sample

For Example #11 note the following guidelines for the completion of Form PY-75:

1/ Show at the top of each form the date, code date, grader's name and duty hours, plant name and number, and machine number(s).

2/ Enter the U.S. Grade and Size being sampled on the appropriate half of the form.

3/ Each vertical column under "U.S. Grade and Size," beginning with "Brand" at the top and continuing through section VI (CWT, container weight) at the bottom of the form, is for recording results of each 100-egg sample.

4/ Show the brand name abbreviation, or show "Loose." (A record of the various brands of consumer containers packed in the plant, with an appropriate abbreviation for each, is to be maintained by the grader in the "Information for Relief Grader" file folder 2).

5/ Show the "EXP" (expiration) date, if applicable.

6/ Show the machine number (if more than one machine is being sampled).

7/ Show the time the sample was returned to the line. Samples should always be completed as soon as possible after selecting from the line.

8/ Show the start/stop time for the line, breaks in production, etc. This space may also be used to denote a “Ref #” for special or unusual situations which are to be

explained under "Comment Log" on the reverse of the form. The "Ref #" will be the applicable sample number.

9/ Show the acceptance or rejection of plant number, lot number and expiration date legibility. A checkmark should be used to indicate an acceptable sample, while an "X" is used to indicate that the sample was rejected.

10/ Show the number and size of containers retained; e.g., 70/15, when a noncompliance sample is found.

11/ Show the sample number. Record the sample number in sequence without regard for retentions.

a. Section I - "Grade" (Example #12)

In Section I, "Grade," record B interior eggs in the top half of the divided "B" space, and B exterior eggs in the bottom half (use slash marks). Record B* eggs individually in the top half, using "S" for small blood spots, "A" for over $^{3}/_{8}$-inch air cells, and "Y" for serious yolk defects. B* eggs may not exceed 1 percent (average) at time of shipment. No individual case may have more than three B* eggs.

When sampling U.S. Grade AA product, use the "A" space to record (with slash marks) individual U.S. Grade A quality eggs found in the sample.

When sampling U.S. Grade A product which has a minimum AA requirement, such as for an approved specification, record individual AA eggs from each sample on a separate note pad using slash marks, or any other method approved by the supervisor. After the sample is completed, record the total number of AA eggs in the "AA" space.

b. Section II - "Checks"

On each sample, begin recording results in the first open space in section II, III, and IV (Example #12). First sample results: 3 checks, 1 LS, 1 BI, 3 A, 3 underweight eggs. Note the carryovers shown for sample 2.

The shaded area across the 5 percent space on Form PY-75, and the 4 percent space on Form PY-75A, is the average tolerance level for all sizes except Jumbo. When sampling Jumbo eggs on Form PY-75, disregard the shaded area and use the 7 percent line as the average tolerance ("J" shown across seventh space). Record each check found in a sample with a check mark (✓), beginning in the first open space at the bottom of the section.

Example #12

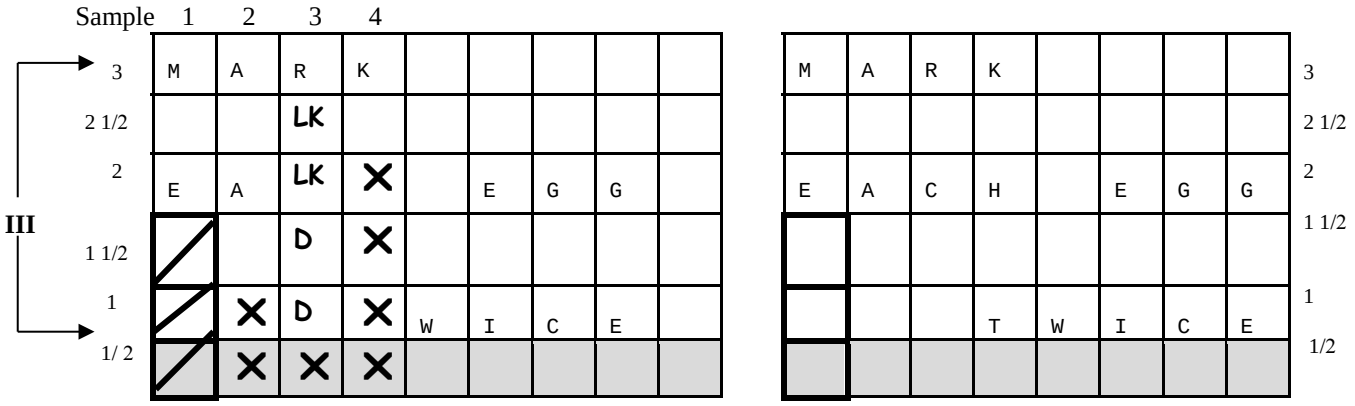
Sample	1									!								Sample
AA	92									GRADE								AA
I A	III																	A
I	I																	I
B E																		B E
Percent																		
10																		10
9																		9
8																		8
7	✔	J	J	J	J	J	J	J	J	CHECKS	J	J	J	J	J	J	J	7
6	✔																	6
II 5	✔																	5
4																		4
3																		3
2		✕																2
1		✕																1
3	M	A	R	K						D, LK, LOSS	M	A	R	K				3
2 1/2	LS																	2 1/2
2	LS	✕	C	H		E	G	G			E	A	C	H				2
III 1 1/2		✕													E	G	G	1 1/2
1		✕		T	W	I	C	E				T	W	I	C	E		1
1/2		✕																1/2
2	M	A	R	K							M	A	R	K				2
1 2/3	✔	A	C	H		E	G	G			E	A	C	H				1 2/3
IV 1 1/3	✔	✕								LS					E	G	G	1 1/3
1	✔	✕	T	H	R	E	E					T	H	R	E	E		1
2/3		✕																2/3
1/3		✕		T	I	M	E	S				T	I	M	E	S		1/3
V	III									U								

If a sample exceeds the individual case tolerance, record above the top space using a slash mark for each egg.

c. Section III - "D/LK/Loss" (Dirty/Leaker/Loss)

The average tolerance level is shown in the shaded space across the bottom (.50 percent) on both Form PY-75 and 75A. Each space represents .50 percent, rather than 1 percent, so each egg found must be recorded twice, beginning in the first open space at the bottom of the section (Example #13).

Example #13 - One Dirty and One Leaker Egg in Sample 3



Record all dirty eggs with the letter "D." Alternatively, to further identify the type of dirty egg, use the following abbreviations; "DA" for dirty adhering, "DF" for dirty fecal, "DS" for dirty stain, and "DY" for dirty yolk. Record leaker eggs with an "LK", and other types of loss with the appropriate abbreviation.

If the individual case tolerance is exceeded on any sample, record any additional eggs above the top space, using the appropriate symbol. No individual case shall exceed two dirty eggs or two leaker eggs.

Any large meat or blood spots over a $^{1}/_{8}$-inch diameter (LS) recorded in Section III will also be recorded in Section IV.

LOSS EGGS OTHER THAN “LS” OR “LK” ARE NOT PERMITTED.

IF FOUND IN AN OFFICIAL SAMPLE; IMMEDIATE RETENTION IS REQUIRED ON PRODUCT REPRESENTED BY THE PARTICULAR SAMPLE.

In this example, the carryover to sample number 4 is 4.

d. Section IV - "LS" (Large Spot)

The average tolerance level is shown in the shaded space across the bottom (.33 percent) on both, Form PY-75 and 75A. Each space represents .33 percent, rather than 1 percent, so each LS egg found must be recorded three times (use check marks), beginning in the first open space at the bottom of the section (see Example #14).

Example #14

Sample	1	2	3	4	5	6	7										
					11 ~~1111~~	~~1111~~ ~~1111~~											
IV 2		A	✓	K	✓	✓				M	A	R	K					2
1 2/3	E	A	✓	✗	✓	✓	G	G		E	A	C	H		E	G	G	1 2/3
1 1/3		✓	✓	✗	✗	✗	✗											1 1/3
1		✓	✗	✗	✗	✗	✗					T	H	R	E	E		1
2/3		✓	✗	✗	✗	✗	✗											2/3
1/3		✗	✗	✗	✗	✗	✗	S					T	I	M	E	S	1/3

Sample 2: 1 LS; Sample 3: 1 LS; Sample 5: 3 LS; Sample 6: 4 LS. In this example, the carryover to sample 7 is 4.

When an LS egg causes the individual case tolerance to be exceeded on any sample, continue with check marks above the top space to record that egg. Record any additional LS eggs found in the sample with a single slash mark for each egg above or to the right of the check marks (see samples 5 and 6, Example #14).

e. Section V - "Individual Underweight Eggs"

Record individual underweight eggs found in each sample, using slash marks. The individual case tolerance is 5 percent underweight eggs, and the average tolerance is 3.3 percent. These tolerances apply to eggs which are in the next lower weight class only. There is no tolerance for individual eggs which weigh more than 3 ounces below the marked weight for the size being packed. For example: If large eggs are being packed, no individual egg may weigh less than the minimum dozen-weight for medium, which is 21 ounces. If found, show actual weight of the noncompliance egg(s) in Section V and circle to show a retention.

f. Section VI - "Container Weight"

Weigh a minimum of two containers (one dozen cartons or other consumer sized containers) from each sample. Record in Section VI the actual net weight of each container. If either of the containers are within .25 ounce of the stated weight of the consumer container involved, at least two more containers are to be weighed and recorded (above or below the two spaces in Section VI).

THERE IS NO TOLERANCE FOR INDIVIDUAL CONTAINERS WHICH WEIGH LESS THAN THE MINIMUM NET WEIGHT FOR THE SIZE INVOLVED.

g. Small Ends Up

Small ends up may be recorded, if desired, between Sections IV and V, using slash marks.

h. Internal Egg Temperatures

For each shift, record on the reverse of Form PY-75 a minimum of two internal egg temperatures taken before the eggs enter the washer. This is to assure that the wash water temperature is at least 20˚ Fahrenheit warmer than the temperature of the eggs.

E. Totaling Results

1. For U.S. Grade AA Product: When finished with each sample, determine the number of AA quality eggs by totaling the number of eggs recorded in sections I through III, and subtracting from 100. Record the resultant number in the "AA" space (top of Section I) for the applicable sample.

2. For U.S. Grade A Product: When finished with each sample, determine the number of A quality eggs by totaling the number of eggs recorded in Sections I through III (including AA's if applicable), and subtracting from 100. Record the resultant number in the "A" space (Section I) for the applicable sample.

3. For U.S. Grade B Product: A minimal number of plants pack U.S. Grade B Product. In U.S. Grade B product, the lot average for checks is 10 percent with an individual case tolerance of 20 percent. In the first sample, mark off 9 spaces allowing for 11 checks incorporating the one egg over rule. Each space in section II of the Form PY-75 could also be divided in half so that two eggs could be recorded in each space. The carryover would be calculated using the number of eggs recorded above the 5 percent line. The startup tolerance for dirties, leakers, and loss in U.S. Grade B is identical to U.S. Grade A.

F. Completing the Reverse of Form PY-75

1. Calculation of Average Sampling Intervals

Example #15

GRADE SIZE	MACHINE(S)
AA MEDIUM ←	2 ↑
BRAND(S) STATION	P S
LUCKY LADY →	↓

CASES PACKED	# SAMPLES	ONE SAMPLE PER
421 °	10 ±	(42) CASES ″

GRADE SIZE	MACHINE(S)
A EXTRA LARGE ←	2 ↑
BRAND(S) STATION	P S
BETTER BUY →	↓

CASES PACKED	# SAMPLES	ONE SAMPLE PER
305 °	8 ±	(38) CASES ″

Complete the reverse upper portion of Form PY-75 by recording the information from each line marked on the front of Form PY-75 or 75A and showing:

← The applicable grade and size.

↑ The machine(s) on which packed.

→ The brand(s) involved, and if applicable, the packing station or other information to identify the line.

↓ Circle P or S to indicate Primary or Secondary line.

° The total cases (converted to 30 dozen) packed on this line for the shift involved, including product retained based on unsatisfactory samples. Do not include product which has not been sampled (set aside for stationary lot sampling).

± The total number of samples examined from this line including unsatisfactory samples.

″ Divide the cases packed by the number of samples to determine the average interval. Round to the nearest whole number and show in the bracketed space. This figure must be 100 cases or less for each primary line.

If, on any line, the average interval exceeds the minimum requirement of 1 sample for each 100 cases produced, the grader must increase the number of samples taken on that line the next day (assuming the volume produced on that line is approximately the same), to assure that the 1 sample per 100 case average interval is met. Product will not be held for additional sampling.

When the average sampling interval exceeds 1 sample for each 100 cases produced, on any line on more than two occasions during any week, the USDA grader must notify the Federal-State supervisor.

If necessary, the supervisor will arrange for additional staffing on a temporary basis, and will review the need for increased staffing on a permanent basis.

2. Cooler Temperatures - Humidity; Wash Water Temperatures, Sanitizer Strength.

Example #16

COOLER	# 1		#	
TEMP ←	45 °F	43	°F	
HUMIDITY	76 %	72	%	
TIME	8:15	3:00		

MACHINE	# 1		# 2		#	
EGG TEMP ↑	78 °F	80	75 °F	79	°F	
WASH WATER →	105 °F	107	109 °F	110	°F	
SANITIZER ↓	120 PPM	140	135 PPM	140	PPM	
TIME	8:30	2:45	8:35	2:50		

As applicable, show for each shift on the reverse of Form PY-75:

← Cooler temperature and humidity - record twice per shift, showing time readings were made.

↑ Internal egg temperatures, taken before eggs enter washer. Record twice per shift for each washer. Times should coincide with wash water temperature readings.

→ Wash water temperatures - record twice per shift for each washer, and indicate time readings were made.

↓ Strength of sanitizer in final rinse water - record twice per shift for each unit, and indicate time tested.

3. Comment Log

Example #17

REF #	TIME	(BREAK TIMES, SAFETY HAZARDS, SANITATION, ETC.)
← 2	9:15	BROKEN EGGS ON FLOOR, UNDER #2 MACHINE - CORRECTED 9:30.
---------	10:05	GRADER'S POCKET THERMOMETER TESTED AND CERTIFIED AS ACCURATE.
↑ 5	1:05	FIRE EXIT BLOCKED WITH EMPTY CASES - CORRECTED 1:15.
→ 7	2:15	#2 MACHINE BROKE DOWN - REPAIRED 3:00.
---------	4:15	INSUFFICIENT DENATURANT IN INEDIBLE BARRELS - MORE ADDED 4:30.

↓ Are restricted eggs properly labeled and denatured as applicable? ☐ YES ☐ NO

As applicable for each shift, record on the reverse of Form PY-75:

← Equipment or facility sanitation deficiencies observed during processing.

↑ Observed or potential safety hazards.

→ Any references regarding breaks in production, or other online sampling problems (from Ref# - front of form).

↓ Indicate whether labeling and denaturing of restricted eggs is satisfactory (checkbox).

VI. Retention Action

A. Cumulative Sampling Results

After each sample is completed, product packed to that point is either accepted or retained, based on that sample's cumulative results.

Sample #18

Containers Ret./Size		60						48	28										Contain. Ret./Size
		15						30	30										
Sample	1	2	3	4	5	6	7	8	9	10	11								Sample
I — AA																			AA
A																			A
I																			I
B — E																			B — E

GRADE

Percent

	1	2	3	4	5	6	7	8	9	10	11								Percent
II 10	✔	✔				✔		✔	✔										10
9	✔	✔	✔			✔	✔	✔	✔	✔									9
8	✔	✔	✔	✔		✔	✔	✔	✔	✔									8
7	✔	✔	✔	✔		✔	✔	✔	✔	✔									7
6	✔	✔	✔	✔	✔	✔	✔	✔	✔	✔									6
5	✔	×	×	✔	✔	✔	×	✔	✔	✔									5
4		×	×	×	✔	✔	×	×	×	×	×								4
3		×	×	×	×	✔	×	×	×	×	×								3
2		×	×	×	×	✔	×	×	×	×	×								2
1		×	×	×	×	×	×	×	×	×	×								1

CHECKS

	1	2	3	4	5	6	7	8	9	10	11								
III 3		LS	LS				LS		LS										3
2 1/2	D	LS	LS	×		LS	LS	×	×	×									22
2	D	×	×	×	×	LS	×	×	×	×	×								2
1 1/2		×	×	×	×	×	×	×	×	×	×								12
1		×	×	×	×	×	×	×	×	×	×								1
1/2		×	×	×	×	×	×	×	×	×	×								2

D, LK, LOSS

	1	2	3	4	5	6	7	8	9	10	11								
IV 2							✔		✔										2
1 2/3							✔	×	×	×									1β
1 1/3		✔	✔			✔	✔	×	×	×	×								1α
1		✔	✔	×		✔	×	×	×	×	×								1
2/3		✔	✔	×	×	✔	×	×	×	×	×								β
1/3		×	×	×	×	×	×	×	×	×	×								α

LS

Explanation of Example #18

Sample #1: 6 checks, 1 dirty - acceptable.

Sample #2: 5 checks, 1 LS -not acceptable, top space filled in 2 sections (II and III).

Sample #3: (Carryover is from sample #1) 4 checks, 1 LS - acceptable.

Sample #4: 4 checks - acceptable.

Sample #5 3 checks - acceptable.

Sample #6 9 checks, 1 LS - acceptable.

Sample #7 4 checks, 1 LS - acceptable (Top space filled in section III and IV by same egg).

Sample #8 7 checks - not acceptable, individual case tolerance exceeded in section II.

Sample #9: (Carryover is from sample 7) 6 checks, 1 LS - not acceptable, individual case tolerance exceeded in sections III and IV (caused by same egg).

Sample #10: (Carryover is from sample 7) 5 checks - acceptable.

Sample #11: (Carryover shown from sample 10.)

The one egg over allowance has been incorporated as part of the individual case tolerance in sections II, III, and IV. When the top space has been exceeded in any of these sections, retention is required. Retention is also required when the top space is filled in two sections, except when caused by the same egg, (LS), in sections III and IV, (see Example #18, sample 7).

If the top space has not been filled in sections II, III, or IV, the one egg over allowance has not been used and may be applied, if needed, to the moving averages for AA, A, B, or B*, as applicable, in section I. Retention is required if the moving average or individual case tolerance for any quality (AA, A, B, or B*) is not in compliance.

In section V, individual underweight eggs, retention is required if the moving average exceeds 3.3 percent or the individual case tolerance exceeds 5 percent. Retention, when required, will always be from the point where the non-compliance sample is returned to the line, back to where the last acceptable sample was returned to the line.

When retention action is required, circle the non-compliance in the applicable section(s). Use of a "highlight" marking pen to line out the entire sample from top to bottom will help assure that the carryover for each section is correctly shown from the previous acceptable sample and that moving averages are correctly computed for Sections I and V.

All quality and weight data of any non-compliance sample is eliminated from the cumulative totals.

NOTE: Some plants may have a policy which is stricter than the USDA tolerance regarding the maximum number of checks in an individual sample. For example: The USDA individual case tolerance for checks is 10 percent, but a plant may wish to retain product when an individual sample exceeds 7 percent checks.

If the plant provides the USDA grader with a letter specifically stating their policy on individual case tolerances (sizes, brands, etc.), and requests that USDA follow the more restrictive tolerances, the grader will officially retain any product which exceeds the plant's tolerances. Appropriate carryovers would be shown accordingly on the online sampling form. If the plant chooses not to formalize their policy by providing the grader with a letter, USDA tolerances will apply regardless of what retention action the plant may take.

If a plant is packing a line of U.S. consumer grade product and the number of checks or other non-compliance factors is approaching retention levels, the plant may voluntarily ask that product from the last sample interval be set aside for sampling as a stationary lot. This is permissible, and appropriate carryovers would be shown accordingly on the Form PY-75 or 75A.

Show the number and size of containers retained in the space marked "containers retained/size" immediately above "Sample." Additionally, document each retention on the Form PY-516 "Product Retention Log" (Exhibit III). Continue to consecutively number subsequent samples without regard to retention action. (Example: If sample 2 is out of compliance, the next sample would be 3.)

Reminder: When the first sample is out of compliance, the tightened tolerances are applicable to the second sample, and the appropriate spaces are to be blocked off accordingly.

B. Use of Rejected or Retained Tag – Form PY-36

1. Tags Applied For Product Identification and Control

Each grader is required to have a supply of tags. They are to be used only when necessary and never indiscriminately to resolve small problems within the plant. It is mandatory to retain product with an official tag that does not meet the grade assigned or mislabeled product before the grader leaves the plant at the end of the shift. There are many large plants that operate more than one shift and pack several brands and grades of product. It is extremely difficult for management, the shipping supervisor, or the loading crew to know the location of a rejected lot of packaged product or for the processing supervisor to know the exact pieces of unsatisfactory equipment involved without some form of identification. Proper use of "Rejected" or "Retained" portion of the tags can be advantageous to plant management as well as the grading service. Each grader is to advise the designated company contact each time these tags are used so as to prevent any misunderstanding between management and grading personnel.

2. How Tags Are to Be Used

The "U.S. Retained" block is to be marked and the tag placed on product which has been found to be unacceptable for shipping. Keep it attached to the product until it is regraded, the official identification is removed, or the product is otherwise made acceptable.

The "U.S. Rejected" block is to be marked when equipment is found to be in poor repair or in an unsanitary condition. The tag is to remain attached until the equipment is made acceptable. Never place this tag onto an electrical control switch to prevent the use of equipment. Damage to equipment has been experienced by the accidental starting of such equipment.

3. Use of Tags

a. Graded product that does not meet the marked grade or weight class.

b. Incorrectly labeled graded product.

c. Equipment which have not been properly cleaned.

d. Incorrectly labeled or denatured inedible.

e. Incorrectly labeled restricted eggs.

f. Any packaging material bearing unauthorized grade labeling.

4. Completing information required on a Tag

The date and appropriate remarks such as "Hold for regrading" or "Hold for recleaning and further inspection" are to be written on the upper and lower portions of the tag each time one is used. Attach the upper portion of the tag to the product or equipment and retain the lower portion in the grader's file until the corrections have been made. Then both portions of the tag are to be destroyed. Tags used to move product under retention between shell egg facilities are to be returned to the grader issuing them after the product has been satisfactorily handled.

5. USDA Hold Tape

Each grader is required to have a supply of "Product under USDA Hold" tape. It is to be used in conjunction with retained tags to identify and control retained product. After product is released from retention, make sure that all tags and hold tape are removed from the lot.

6. Product Retention Log (Form PY-516)

To assure proper control and disposition of retained lots, graders are required to document product retentions on Form PY-516, Product Retention Log. The log includes the date, grade and size, number and size of containers retained, reason for retention, applicable brand/code date, retain tag number (if used), and final product disposition and date. The USDA grader who retains the product must initial the log. Additionally, the grader who makes the final disposition must initial the log. The Form, PY-516 must be retained in the grader's file for 1 year after the close of the fiscal year in which it was completed.

7. Disappearance of Retained Tags or Product

In the event that a retained tag is lost or removed without authorization, it must first be determined if all retained product is accounted for. If any amount of product is missing, contact the Federal-State supervisor for further guidance. If all product is accounted for, gather all pertinent information about

the product and the incident (i.e., amount of product, location of product, retention procedures, how/why tag was lost, etc.,) and contact the Federal-State supervisor for further guidance. Additionally, a new retained tag is to be affixed to the product to replace those that were lost.

The unauthorized shipment of any retained product or the disappearance of any product under hold is a violation of the Agricultural Marketing Act (AMA) and must be reported immediately, by phone, to your supervisor.

C. Handling Retained Product

Product that is retained must be reworked and re-graded or otherwise handled to assure that it is brought into compliance. The rework, re-regrading, and release of retained product shall be accomplished by one of the following methods:

1. Reworked, Re-graded, and Released –During on-line sampling, product that is retained due to a combination of individual sample results and the running lot average (shaded line), must be completely re-worked prior to re-grading. For example, if a carryover mark (X) is recorded in the shaded line, or above, in sections II, III, or IV, this indicates the lot average is ***at or above*** the running lot average prior to taking a sample. In this case, if the sample results cause the top space to be exceeded, or the top space is reached in two sections, the product is not eligible for re-grading until the sub-lot is reworked. Note the following exceptions:

   a. Since non-compliances in sections I and V are generally infrequent, product retained on the basis of grade and weight factors may be re-graded without reworking the lot.

   b. Product that is retained due to sample results exceeding the top space in sections II, III, or IV, where the carryover for the sample is ***below*** the shaded line, may be regraded without reworking the lot. This indicates a spike in poor quality rather than a recurring problem over several samples.

   c. If the first sample exceeds the top space, the product may be re-graded without re-working the lot. This exception is applicable until the first sample passes.

   NOTE: If product fails a re-grade for any reason, the entire lot must be re-worked prior to subsequent re-grading requests.

   Re-grading of retained product shall be on a lot or sublot basis with a full representative sample graded prior to release. If management desires to keep the lot intact and have it regraded as such, the lot may be reworked by removing all eggs that were not properly graded or by re-processing the entire lot as an intact unit. Reworking must include all packages within the lot if the entire lot is offered for re-grading. However, if the grader determines that the cause of the retention can be isolated to a portion of the lot, (i.e. damage due to a specific

packing head) then only that portion of the lot must undergo reworking prior to re-grading the entire lot. Additionally, retained eggs may be blended with eggs currently being processed and sampled online accordingly.

2. Removed Eggs From Original Packaging Material and Labeled as "Restricted Eggs" - The eggs can only be labeled as restricted if they meet restricted egg tolerances for loss and re-grading is limited to verifying these tolerances. Loose packed product may be relabeled as “restricted eggs” and released provided official identification on the original packaging material is obliterated.

3. Transport to another Location for Reworking- In most instances, the movement will be to another packer or an egg products plant. The following steps are to be taken when transporting retained product: Retained product sent to official egg breaking plants will be considered released once loaded and sealed.

   a. Determine the name and address of the handler where the product will be shipped. Verify that plant management has contacted the applicable destination Federal-State supervisor or FSIS representative to arrange for the supervision of reworking, relabeling, processing or other final disposition of the product. For expediency, the grader should offer to make this call (at management's expense).

   b. Prepare a Retained Product Transfer/Release Memorandum (Exhibit IV) to accompany the shipment to the destination location. To facilitate the return of the transfer/release memorandum and retained tags, the origin plant's mailing address is to be placed on the memorandum.

      Additionally, the memorandum is to include the packer’s name, number of cases involved, the retain tag numbers, and date of retention. The original copy of the memorandum is to accompany the retained product. One copy is to be placed in the grader's file (file folder 4b).

   c. Once the product has been reworked and the tags removed, the destination grader or inspector will return the completed transfer/release memorandum as well as the upper portion(s) of the Form, PY-36 retained tag(s) advising that the product was received, and indicating its disposition.

D. Sampling Retained Product

1. When the plant requests a full representative sampling of product retained on the basis of an online sample(s), the USDA grader will select the required number of samples using stationary lot sampling procedures. If, during the course of the re-grading process, and prior to completion of the required number of samples for a full representative sample, the sample results exceed the lot average or an individual case tolerance for the stated grade, the re-grading may be discontinued and the product will remain under retention. Product that fails a re-grade must be completely re-worked again before another re-grading is permitted. For each lot, show information regarding product identity, how the lot is stacked, location where samples are to be taken, etc., on

a sample selection worksheet. Grading data is to be recorded on the Form PY-211, Poultry Products Grading Memorandum. The retention period for Form PY-211's which are used to record samples of retained product only (no certificate issued) will be the same as the retention period for Form PY-75 & 75A; i.e., 1 year after the close of the fiscal year.

2. STATIONARY LOT GRADINGS CANNOT TAKE PRIORITY OVER ONLINE SAMPLING. Depending on the USDA grader's workload, requests for stationary lot grading of retained online product may involve overtime and/or additional staffing. If overtime is incurred on a regular basis due to re-grading of retained product causing excessive overtime hours, the grader is to contact the Federal-State supervisor to determine whether additional staffing is warranted.

4. Sizes May Not Be Combined Under Any Circumstances.

   a. Different grades may not be combined, unless the plant agrees that all product must meet the requirements of the highest grade.

   b. All product of the same grade and size retained for the same factor may be combined into one stationary lot for sampling. For example: During the same shift, 4 separate samples of U.S. Grade A Large exceed the check tolerance, resulting in retentions of 50, 40, 45, and 55 / 30-dozen cases. The plant may combine the 4 sublots into one lot of 190 cases for a full representative sample by the USDA grader.

4. Product retained for two or more noncompliance factors in the same sample (for example, checks and dirties) generally cannot be combined with other product for sampling. However, at the plant's option, product retained for different factors may be combined into one stationary lot for sampling. For purposes of combining online sampled, retained product into a stationary lot for regrading, dirties, leakers, and loss are considered to be one factor with a combined tolerance of 0.5 percent. B quality and B* are separate factors because each has specific tolerances completely different from the other.

5. Any prior sample containers which exceed individual case tolerances (not counting carryover) must be removed before initial representative sampling or any subsequent re-sampling is permitted. These samples must be held under retention and released only when action as described under items 8.a, b, c, or d, which are listed below, have been accomplished. Other samples may be left in the lot. However, if the stationary lot sample selection plan identifies a previously examined sample, use the next container. Do not examine any sample more than one time.

6. Each lot of retained product will be examined for and must meet requirements for all factors, not just the factor(s) for which the retention occurred. For example: A lot retained for excess checks could be found acceptable for checks, but out-of-compliance for another factor when fully sampled.

a. Exception - Product which is retained solely on the basis of a failure to meet minimum net weight requirements for individual containers, incorrect carton dates, or shell stamping, but meet all other requirements, may be fully sampled for individual container net weights, carton dates, or shell stamping requirements only.

For example, 50 / 30-dozen cases of U.S. Grade A Large packed in one-dozen cartons are retained for one carton which weighs 23 $^{1}/_{2}$ ounces. If the plant requests full-sampling, four samples are to be selected, using stationary lot sampling procedures. Nine-dozen cartons are to be weighed from each of the four sample cases. If each of the 36 / 1-dozen cartons weighs 24-ounces or more, the lot would be acceptable. Product would not be graded for quality or for weight of individual eggs.

Product retained for failing to meet individual underweight egg requirements (lot average or individual case), must be fully sampled for all quality factors including weight.

7. If the initial representative sample shows the product to be out-of-compliance, the plant may request that the lot be resampled. Prior to resampling, the plant may elect to take no action, change the character of the lot by partially reworking the lot, removing some containers, etc. The number of containers in the new lot may be less than the original lot size.

8. If The Lot Fails, The Plant Has The Following Options:

a. Rework the entire lot under the supervision of the USDA grader by removing the eggs from the original containers, reprocessing over mass scanning equipment, and resampling according to the online sampling plan, or as a stationary lot, as applicable; or rework the entire lot under the supervision of the USDA grader by visually examining each egg in the lot by hand candling or other means so that the lot is essentially reworked. The reworked product is to be fully sampled as a stationary lot.

b. Remove the eggs from the original containers, or otherwise rework the product without supervision, but save the containers, restricted eggs, etc., so the USDA grader can verify that this has been accomplished. The exact verification procedures are to be approved by the Federal-State supervisor. The resultant reworked product is to be fully sampled and graded by the USDA grader as a stationary lot.

c. If the plant feels that there are extenuating circumstances or justifiable reasons for allowing another stationary lot examination, it may be granted with the concurrence of the Federal-State supervisor.

d. The USDA grader verifies that the U.S. grademark or other official stamp is completely obliterated from all containers and/or cases.

9. All retained product must remain under the USDA grader's control (U.S. retained tag) until one of the above conditions are met.

Note: Any product exceeding the restricted egg tolerances for U.S. Grade B, as determined by a full-sample, may not be released until brought into compliance.

VII. Certificate Issuance for On-line Sampled Shell Eggs (Form PY-210S)

A. Option 1 - Certification with No Quality Percentages or Net Weight

An official Poultry Products Grading Certificate (Form PY-210S), without quality percentages or net weight information, may be issued up to 21 days after the product was packed and graded including the date of pack on any shell eggs which have met online sampling requirements. Show the following statement in the remarks section of the Form PY-210S certificate:

"Product represented on this certificate meets the requirements for the stated grade and size as determined by online sampling on (date product was packed)."

All grading data and net weight information are to be recorded on the Form PY-75 or 75A. The completed Form PY-75 or 75A are to be filed together for the required retention period of 1 year after the close of the fiscal year.

B. Option 2 - Certification with Quality Percentages and/or Net Weight

When a Form PY-210S certificate with quality percentages and net weight is requested, a full size representative sample [based on 56.4(b) of the regulations] must be examined from the product to be certified. When plant management knows in advance that such certification is needed, the USDA grader is to be advised, so that the required number of samples may be examined from the lot to be certified during processing. All grading data and net weight information are to be recorded on the Form PY-75 or 75A. The completed Form PY-75 or 75A are to be filed together for the required retention period of 1 year after the close of the fiscal year.

1. Procedures When Sufficient Online Samples Are Examined During Processing

a. Certification of All Product Produced During a Specific Period

Up to 5 consecutive days' production of the same grade and size may be combined and averaged as one lot on a certificate. A certificate may be issued on product up to 21 days after the product was packed and graded including the date of pack. Enter the following statement in the remarks section of the Form PY-210S certificate:

"The results shown on this certificate are an average of samples graded during processing on (show dates)."

b. Certification of a Portion of Production

The average quality percentages and net weight of all samples graded may be shown on a Form PY-210S certificate covering any portion of production from a line. In this situation, the results of all online samples

from a particular line would be averaged to determine quality percentages and net weight. Enter the following statement in the remarks section of the Form PY-210S certificate issued to cover any portion of production from the applicable line:

"The product represented on this certificate was part of a lot of eggs graded during processing on (show date). The quality percentages and net weight shown are an average of all samples graded from the entire lot."

2. Procedures When Insufficient On-line Samples Are Examined During Processing

If the USDA grader is unable to examine sufficient samples from the line during processing, the additional samples needed (to equal the minimum number required to certify percentages) may be selected from the cooler, provided that: the product is identified with an official U.S. grade stamp, U.S. lot number stamp, or other official identification; not more than 21 days have passed since the product was packed; all the product to be certified is in the plant and available for additional samples to be taken.

The additional samples will be identified using a calculator, according to stationary lot sampling procedures. The results of the grading are to be averaged with online sample results on a Form PY-211. Alternatively, if it is anticipated that additional samples may be needed to later certify quality percentages, the USDA grader may randomly select and set aside such additional samples from the line, during processing, as may be needed. These "potential" samples must be sealed, marked with the grader's initials, and officially identified. The potential samples should be placed together in a readily accessible location in the cooler. The additional samples, if needed, will be averaged with the online samples examined during processing. The Form PY-211 will be attached to the Form PY-75 or 75A and disposed of 1 year after the close of fiscal year.

a. Certification of All Product Produced During a Specific Period

If the entire lot(s) is certified, enter the following statement in the remarks section of the Form PY-210S certificate:

"The results shown on this certificate are an average of samples graded during processing on (show date/dates) and (show number). Additional samples were graded on (show date)."

b. Certification of a Portion of Production

(1) If the entire lot is available, and a portion of the production lot is certified, enter the following statement in the remarks section of the Form PY-210S certificate:

"The product represented on this certificate was part of a lot of eggs graded during processing on (show date). (Number)

additional samples were graded on (show date). The quality percentages and net weight shown are an average of all samples graded from the entire lot."

(2) If the entire production lot is not available for sampling, but the portion of the lot to be certified is available and can be positively identified with individual samples selected and graded during processing, enter the following statement in the remarks section of the Form PY-210S certificate.

"The results shown on this certificate are an average of samples graded during processing on (show date/dates) and (show number). Additional samples were graded on (show date)."

NOTE: In the event that additional cooler samples show the product to be out-of-compliance, the grader may not issue a certificate listing the individual quality percentages or net weight. A certificate may be issued showing that the product met the requirements for the stated grade and size as determined by online sampling. If the results of the cooler samples reveal that the product exceeds the restricted egg tolerances, the product must be retained.

VIII. Official Identification of On-line Product

If a U.S. grade stamp is used to identify shipping containers, each day's production must bear the actual date of grading (processing), or the certificate number.

Product identified with a USDA lot stamp which is eligible for official identification, must be restamped with the applicable consumer grade stamp bearing the date that coincides with the date shown in the lot stamp. Alternatively, the product may be fully sampled as a stationary lot, and stamped with the U.S. grade stamp showing the actual date of grading or the certificate number. When the certificate number is used, a Form PY-210S certificate must be prepared and provided to plant management.

U.S. DEPARTMENT OF AGRICULTURE
AGRICULTURAL MARKETING SERVICE

SHELL EGG ONLINE CANDLING RECORD (10% CHECKS)

Exhibit I

PAGE OF

DATE	CODE	GRADER

GRADER'S DUTY HOURS TO

PLANT	NO.	MACHINE(S)

U.S. GRADE & SIZE:

Brand																			Brand
Exp																			Exp
Mach																			Mach
Time																			Time
Log (Ref #)																			Log (Ref #)
Containers Retained/Size																			Containers Retained/Size
Sample																			Sample
I — AA																			AA
I — A																			A
I — Bi																			Bi
I — Be																			Be
Percent 10																			10
9																			9
8																			8
III — 7	J	J	J	J	J	J	J	J	J	J	J	J	J	J	J	J	J	J	7
6																			6
5																			5
4																			4
3																			3
2																			2
1																			1
III — 3	M	A	R	K						M	A	R	K						3
2 1/2																			2 1/2
2	E	A	C	H		E	G	G		E	A	C	H		E	G	G		2
1 1/2																			1 1/2
1				T	W	I	C	E					T	W	I	C	E		1
1/2																			1/2
IV — 2	M	A	R	K						M	A	R	K						2
1 2/3	E	A	C	H		E	G	G		E	A	C	H		E	G	G		1 2/3
1 1/3																			1 1/3
1			T	H	R	E	E					T	H	R	E	E			1
2/3																			2/3
1/3				T	I	M	E	S					T	I	M	E	S		1/3
V																			
VI																			

GRADE CHECKS DOLLOSS LS U CWT

PY-75 (12-96) *(Use previous edition dated 02-94.)*

U.S. GRADE & SIZE:

Brand									
Exp									
Mach									
Time									
Log (Ref #)									
Containers Retained/Size									
Sample									
I — AA									
I — A									
I — i									
I — B									
I — e									
Percent 10									
9									
8									
7	J	J	J	J	J	J	J	J	J
6									
5									
4									
3									
2									
1									
III — 3	M	A	R	K					
2 1/2									
2	E	A	C	H		E	G	G	
11/2									
1				T	W	I	C	E	
1/2									
IV — 2	M	A	R	K					
1 2/3	E	A	C	H		E	G	G	
1 1/3									
1			T	H	R	E	E		
2/3									
1/3				T	I	M	E	S	
V									
VI									

Are restricted eggs properly labeled and denatured as applicable? ☐ YES ☐ NO

GRADE CHECKS

DATE

GRADE/SIZE	MACHINE(S)
BRAND(S)/STATION	P S
CASES PACKED / NO. SAMPLES	ONE SAMPLE PER ( ) CASES
GRADE/SIZE	MACHINE(S)
BRAND(S)/STATION	P S
CASES PACKED / NO. SAMPLES	ONE SAMPLE PER ( ) CASES

MACHINE	#	#	#
EGG TEMP	°F	°F	°F
WASH WATER	°F	°F	°F
SANITIZER	PPM	PPM	PPM
TIME			
COOLER	#	#	#
TEMP	°F	°F	°F
HUMIDITY	%	%	%
TIME			

COMMENT LOG

REF. NUMBER	TIME	(BREAK TIMES, SAFETY HAZARDS, SANITATION, ETC.)

D-LOSS LS U CWT

*U.S.GPO:1997-515-834/83731

U.S. DEPARTMENT OF AGRICULTURE
AGRICULTURAL MARKETING SERVICE

SHELL EGG ONLINE CANDLING RECORD (8% CHECKS)

PAGE OF

DATE	CODE	GRADER	GRADER'S DUTY HOURS		TO
			PLANT	NO.	MACHINE(S)

U.S. GRADE & SIZE:

Brand																					Brand
Exp																					Exp
Mach																					Mach
Time																					Time
Log (Ref #)																					Log (Ref #)
Containers Retained/Size																					Containers Retained/Size
Sample																					Sample
I — AA																					AA
I — A																					A
I — Ai																					Ai
I — Be																					Be
Percent																					Percent
III — 8																					8
III — 7																					7
III — 6																					6
III — 5																					5
III — 4																					4
III — 3																					3
III — 2																					2
III — 1																					1
III — 3	M	A	R	K						M	A	R	K								3
III — 2 1/2																					2 1/2
III — 2	E	A	C	H		E	G	G		E	A	C	H		E	G	G				2
III — 1 1/2																					1 1/2
III — 1				T	W	I	C	E					T	W	I	C	E				1
III — 1/2																					1/2
IV — 2	M	A	R	K						M	A	R	K								2
IV — 1 2/3	E	A	C	H		E	G	G		E	A	C	H		E	G	G				1 2/3
IV — 1 1/3																					1 1/3
IV — 1			T	H	R	E	E					T	H	R	E	E					1
IV — 2/3																					2/3
IV — 1/3				T	I	M	E	S					T	I	M	E	S				1/3
V																					
VI																					

GRADE CHECKS D'LOSS LS U CWT

PY-75-A (12-96) *(Use previous edition dated 02-94.)*

U.S. GRADE & SIZE:

Brand									
Exp									
Mach									
Time									
Log (Ref #)									
Containers Retained/Size									
Sample									
I — AA									
I — A									
I — i									
I — B									
I — e									
Percent									
II — 8									
II — 7									
II — 6									
II — 5									
II — 4									
II — 3									
II — 2									
II — 1									
III — 3	M	A	R	K					
III — 2 1/2									
III — 2	E	A	C	H		E	G	G	
III — 11/2									
III — 1				T	W	I	C	E	
III — 1/2									
IV — 2	M	A	R	K					
IV — 1 2/3	E	A	C	H		E	G	G	
IV — 1 1/3									
IV — 1			T	H	R	E	E		
IV — 2/3									
IV — 1/3				T	I	M	E	S	
V									
VI									
VI									

Are restricted eggs properly labeled and denatured as applicable? ☐ YES ☐ NO

GRADE CHECKS D'LOSS LS UCWT

DATE

GRADE/SIZE		MACHINE(S)
BRAND(S)/STATION		P S
CASES PACKED	NO. SAMPLES	ONE SAMPLE PER ( ) CASES
GRADE/SIZE		MACHINE(S)
BRAND(S)/STATION		P S
CASES PACKED	NO. SAMPLES	ONE SAMPLE PER ( ) CASES

MACHINE	#	#	#
EGG TEMP	°F	°F	°F
WASH WATER	°F	°F	°F
SANITIZER	PPM	PPM	PPM
TIME			
COOLER	#	#	#
TEMP	°F	°F	°F
HUMIDITY	%	%	%
TIME			

COMMENT LOG

REF. NUMBER	TIME	(BREAK TIMES, SAFETY HAZARDS, SANITATION, ETC.)

U.S. DEPARTMENT OF AGRICULTURE
AGRICULTURAL MARKETING SERVICE
POULTRY DIVISION

Exhibit III

PRODUCT RETENTION LOG

Fiscal Year_____

DATE	PRODUCT TYPE	LOT NO.	TYPE & SIZE OF CONTAINER	NUMER OF CONTAINERS	REASON FOR RETENTION	TAG NO.	RETAINED BY (INITIALS)	PRODUCTS DISPOSITION	RELEASED BY (INITIALS)

PY-516 (10-96)

U.S. Government Printing Office: 1996 -- 514-832/83691

Exhibit IV

RETAINED PRODUCT TRANSFER / RELEASE MEMORANDUM

DATE:

TO: _____ (Grader / Inspector at Destination Location)

FROM: _____ Origin Grader / Inspector (Print Name)

SUBJECT: Retained Eggs

Company Name & Address of Retention Location:

_____
_____
_____
_____

Registration Number (if applicable)

Company Name & Address of Destination Location:

_____
_____
_____
_____

Date	Total 30-Dozen	Brand	Carton / Loose	Grade	Size	Tag Number

Product was: Broken, Retagged, Relabeled, Regraded, Re-inspected & Released on _____ (circle as applicable). Type of violation: ( ) EPIA ( ) AMA

Date	Total 30-Dozen	Brand	Carton / Loose	Grade	Size	Tag Number

Product was: Broken, Retagged, Relabeled, Regraded, Re-inspected & Released on _____ (circle as applicable). Type of violation: ( ) EPIA ( ) AMA

REMARKS

Name, Address, and Signature of Destination Grader / Inspector

_____
_____
_____

Return this memo and retained tags to: (Completed by Origin Grader / Inspector)

_____
_____
_____

SECTION 9: SPECIAL GRADINGS

I. Partial Gradings

Partial gradings may be made in specific situations when:

- The grader is unable to select a representative sample due to the way the cases are stacked.
- The applicant requests a smaller sample than that required by the regulations.
- The applicant selects the samples rather than the grader.
- The applicant requests the grader to stop a grading before completion of the samples because the quality is lower than required.
- When a firm requests that the grader examine sample cases of eggs selected by the firm from a lot of shell eggs received from another plant, the Form PY-210S is to include a statement as follows:

"The results shown on this certificate represent the quality of (number) cases of eggs identified as (grade and size) presented by plant management on (date). According to the applicant, these cases were selected from a lot of (total number) cases of (grade and size) shell eggs received from (firm name) on (date)."

Note: When a partial grading is performed, only the samples examined are to be stamped. The certificate will show "Total Cases" and the number of "Cases Examined" as being identical.

II. Institutional Gradings - Contract Acceptance

When performing institutional gradings, the grader must have a copy of the purchase order or instructions from the procuring agency prior to performing the grading. Certification will be for all requirements stated in the purchase order.

III. Specification Gradings

An applicant for shell egg specification certification service must submit two copies of Form PY-33, "Application for Specification Approval" (Exhibit I) and two copies of the specification to the Shell Egg Section. The information may be sent to the National Office directly or through the Federal- State supervisor in the State where the applicant is headquartered. The following procedures apply only to shell eggs graded according to specifications listed in section S-02 of the Supervisors/Resident Graders Shell Egg Index.

A. Specification Review and Approval Process

Upon receipt of Form PY-33 and the submitted commercial specification into the National Office, the approving official will review the information for approval or advise the applicant of the reason(s) for disapproval. If the specification is approved, a letter enclosing a copy of the approved application and specification will be returned to the applicant with a request to provide copies of the specification to each supplier and applicable USDA grader. Each page of the approved specification will have an approval stamp bearing the date of approval and the signature of the approving official. Additionally, each page will be sequentially numbered such as page 1 of 5, page 2 of 5, etc.

The original copy of the application and specification will be retained in the National Office. A copy of the letter, application, and specification will be sent to the responsible Federal-State supervisor associated with the applicant's location and the applicable regional office. Copies of the specification will also be sent to other Regional Offices and Federal-State supervisors for information purposes. The National Office will periodically update the list of approved specifications or list any changes on transmittal notices. All approved specifications must be treated as confidential at all times. Only authorized USDA representatives are to review and have access to the specifications.

B. Certification of Specification Requirements

Plant management is responsible for advising graders when they are preparing to pack shell eggs in accordance with an approved specification. However, each grader must be familiar with the approved specification list and, to the extent practically possible, be aware when products with approved specifications are being packed at the duty location. When a plant packs product requiring compliance with an approved specification, the grader shall obtain a copy of the specification from plant management and assure that all provisions of the specification are met. If plant management is unable or refuses to provide a copy of the required specification, or states that the approved specification does not apply to product packed in the plant, the grader shall contact the applicable Federal-State supervisor, request a copy of the specification, and review the requirements and responsibilities outlined in the specification. If necessary the supervisor shall contact plant management to clarify certification requirements and resolve the issue.

If the facility elects to continue production without resolving the issue(s), the USDA grader shall not interfere with the production. The supervisor will contact the authorized person whose name appears on Form PY-33 for clarification. During the interim period, there will be no certification of specification requirements. Should the product bear a U.S. grademark, applicable grade requirements must be met or retention is required on that basis.

If a plant is attempting to legitimately pack product in compliance with an approved specification and fails, product not meeting the provisions of the specification is to be placed under USDA retention as outlined in Sections 7 and 8 of this handbook. If the product otherwise meets applicable USDA grade requirements and the plant desires to ship the product, the plant management is to call the person authorized to waive specification requirements as stated on the approved specification. If a waiver is granted, the waiver must be provided to the grader directly, either verbally or in writing. The grader is to document the appropriate information on the applicable worksheet and certificate (if issued) and release the product. If provisions of the specification are waived frequently, or over an extended period of time, the grader is to notify the Federal-State supervisor who, through the Regional Director,

will notify the National Office. The National Office will review the matter with the specification applicant and urge that they consider modifying the specification or terminating its approval.

As applicable, product meeting specification requirements will be identified in accordance with procedures outlined in the approved specification. When the specification requires the issuance of a grading certificate, the following statement is to be placed in the remarks section of the certificate:

"Product covered by this certificate meets specification requirements for _____."

Additionally, list any special certification statements as outlined in the approved specification. When appropriate, the following additional statement would be shown:

"...except for (requirement(s) waived by (name of authorized representative) on (date)."

Within three months of all new specification approvals, the Federal-State supervisor responsible for supervising the State where the applicant is located shall contact the applicant to review responsibilities, answer questions, and resolve any issues that may have developed. Subsequent follow-up visits shall be conducted on an annual or more frequent basis as determined by the Regional Director.

IV. Military or Other Special Gradings

Supplementary instructions for grading shell eggs for delivery to the military, state are covered under specific instructions in the Supervisors/Resident Graders Shell Egg Index.

V. Condition Inspection of Shell Eggs (sensory evaluation)

Graders are not to conduct these types of inspections unless they receive guidance from a Federal-State supervisor. For all types of condition inspections, the top portion of the certificate is filled out in the usual manner.

A. Certification Covering Truck Damage

The following information is required on a "condition" certificate issued to cover accidental truck damage:

1. The number of cases from which egg contents are leaking, or which show visible damage. Give full case and material description.

2. In cases showing visible damage, follow the proper layer rotation and report the percentage of leakers and dented checks for each sample case.

3. When observed by the grader, a properly qualified statement reporting any shifting of the load, and the type bracing used.

B. Certification Covering Frozen Egg Damage

The following information is required on a certificate issued to cover frozen egg damage:

1. The opening temperature of the truck, both at floor and top level.

2. The case temperature of eggs.

3. The number of frozen eggs, and if freezing has caused breakage.

C. Certification Covering Off-Odor or Otherwise Contaminated Eggs

Normally, shell eggs that are allegedly contaminated with odors caused by chemicals, smoke, or other potentially harmful substances come under the jurisdiction of the Food and Drug Administration (FDA). If FDA elects not to investigate the matter, the Poultry Grading Division may be requested to examine the product and determine appropriate disposition of the shell eggs. In these instances the following action is to be taken unless otherwise directed by the supervisor:

1. Select a partial sample of shell eggs from various places in the lot and take to an odor-free area where an organoleptic examination can be made. Remove the eggs from the packaging materials and attempt to determine if only the packaging materials are affected by the odor. Smell the egg shells, candle the eggs, and break out a few eggs to determine if the odor has permeated the egg shells and into the egg meat.

2. If the eggs have been subjected to fire and smoke damage, determine if any of the packaging materials are wet and if the eggs are contaminated with smoke or soot. Additionally, graders are to assure requirements outlined in Section 3 are followed.

In all cases when completing a "Condition" Certificate, the "Remarks" section should be utilized to record any additional comments which will aid in describing the condition of the eggs and packaging material. No official grading is required unless specifically requested. A copy of all condition certificates are to be sent to the National Office.

VI. U.S. Grade A or AA Interior Quality for Egg Products

Since there are no grade standards for egg products, no designation of grade or quality is permitted. However, Food Safety and Inspection Service (FSIS), will allow egg product labels to bear statements of fact such as “Produced from Shell Eggs of U.S. Grade A (or AA) Interior Quality.” Therefore, an interested party may request that a lot of shell eggs, used to produce egg products, be officially certified for interior quality when certain conditions are met. Each lot of shell eggs must be officially graded by a USDA grader and meet the following requirements:

A. The lot shall meet applicable origin or destination requirements for interior quality and checks for U.S. Grade A or AA, as applicable.

B. Exterior grade factors, except for checks, do not apply.

C. Up to 2 percent bloody whites, large blood or meat spots, or leakers, in any combination, are permitted. No other loss or inedible eggs are permitted.

D. Dirts are permitted.

USDA graders may certify the quality of these shell eggs based on either online or stationary lot grading. The grade results are to place on the Form PY-75 or Form PY-211, as applicable. Additionally, the grader is to prepare the Form PY-210S grading certificate showing no U.S. grade assigned under "Official Grade and Size" and the following statement under "Remarks:"

"Product covered by this certificate does (or does not) meet the criteria for U.S. Grade A (AA) interior quality shell eggs for the production of egg products identified with the quality statement."

VII. Kosher Certification of Shell Eggs

Shell eggs intended for kosher certification must meet an established blood spot tolerance before certification can be made. Shell eggs identified and/or certified as meeting kosher requirements are required to contain no more than one blood spot, of any size, for each lot. No other types of blood loss are allowed. Graders may certify that shell eggs meet kosher certification requirements based on the results of either online sampling or stationary lot grading.

For online sampling, when the first blood spot is found, the portion of the online production represented by that sample must be held for stationary lot grading. This product may be used for other non-kosher accounts or, if the plant wants that portion of the lot to be eligible for kosher certification, the USDA grader will take a full sample of the lot using stationary lot sampling procedures. If no additional blood spots are found during this stationary lot grading, the lot is eligible for kosher certification. However, if another blood spot is found, the product must then be retained, reworked, regraded, and re-examined.

Since any retained product that has been reworked is considered a new lot, the lot can be certified as meeting kosher requirements provided no more than one blood spot is found during the re-examination. Alternatively, retained product may be released for non-kosher accounts provided it does not exceed the normal tolerance for blood spots. In this instance, the eggs are to be removed from packaging material bearing the kosher symbol (see kosher symbols listed below).

When the grader determines that a lot is eligible for kosher certification based on online sampling, the following statement may be included on the Form PY-210S grading certificate:

"Product represented on this certificate meets the requirements for the stated grade, size, and kosher certification for blood spots as determined by online sampling on (date the product was packed)."

Product may also be eligible for kosher certification based on stationary lot grading. In this case, sampling results must indicate that no more than one blood spot was found in the official samples examined. Product failing to meet this tolerance must be reworked and regraded. However, if the plant wants to use the product for other non-kosher accounts, retained product may be released provided the product does not exceed the normal tolerance for blood spots. In this instance, the eggs are to be removed from packaging material bearing the kosher symbol.

When the grader determines the lot is eligible for kosher certification based on stationary lot grading, the following statement may be included on a Form PY-210S:

"Product represented on this certificate meets kosher certification requirements for blood spots as determined by candling a representative sample of shell eggs selected from a stationary lot."

VIII. Certification of Shell Eggs as Fit for Human Consumption

Any interested party may request that a lot of shell eggs be described as "Fit for Human Consumption," on the certificate. When requested, the product must be officially graded by examining a representative sample, either online sampling or stationary lot, and found to contain no more restricted eggs than permitted in the standards for U.S. Consumer Grade B shell eggs.

IX. Certification of Organic Shell Eggs

Any interested party may request certification and official identification of organic eggs for domestic and export sales at resident, temporary, and fee grading locations. This instruction provides specific guidance to the USDA grader on the processing, certification, and identification of organic shell eggs packed in containers bearing the USDA grademark. Guidance is also provided for certification of eggs when containers do not bear the grademark.

The term "Organic" may only be used on containers of shell eggs, for domestic sales, that have been produced and handled in accordance with the requirements of the USDA, National Organic Program (NOP), 7 CFR Part 205.

When processed shell eggs are to be identified with applicable USDA organic standards, a final rinse of potable water is required when chlorinated substances are used as a processing agent (cleaning and sanitizing compounds). The active chlorine content of the potable water rinse, subsequent to the sanitizing cycle cannot exceed 4 p/m. Plant management is responsible for monitoring the active chlorine content of the potable water rinse and maintaining records to demonstrate conformance. Eggs not processed in accordance with the NOP Standards are not eligible for identification with NOP emblem.

Shell eggs for export sales must be labeled "For Export Only" when the foreign country of destination does not recognize the NOP Standard as equivalent to that country's regulatory requirements or the eggs are identified as organic to a standard other than the USDA National Organic Standard.

A. Examination of Accreditation and Certification Documents

Under the USDA, National Organic Program (NOP), a state, private or foreign organization, or private person may be accredited as a "certifying agent." Before shell eggs can be labeled “organic,” an accredited certifying agent must approve the production and processing operations according to the national standards. Verification of a certifier’s accreditation can be retrieved from the web site at http://www.ams.usda.gov/nop/CertifyingAgents/Accredited.html. Alternatively, verification can be confirmed by reviewing the formal letter of accreditation or the Decision of Accreditation, as provided by plant management. These documents shall include the following information:

1. The area(s) for which accreditation is given (production and processing operations)

2. Current letter of accreditation

3. Terms and conditions of the accreditation

Accreditation is authorized for a period of 5 years. Certification of producers and packers by an accredited certifying agent is valid for 1 year.

B. Responsibility

In official plants, before shell eggs can be labeled “organic,” plant management must provide the USDA grader a current copy of the producer’s and/or packer’s organic certificate, issued by the accredited certifying agent. Documents provided by the certifying agent must list the approved layer flock(s) for the production of eggs eligible for organic labeling and list the shell egg grading operation approved as meeting the organic handling requirements.

At fee locations, before shell eggs can be labeled “organic,” the applicant must provide the USDA grader with the appropriate documents identifying the certifying agent for each producer and packer of shell eggs presented for grading. Additionally, the applicant must also demonstrate the origin of such eggs (invoices, bill of lading, etc.). The USDA grader is to attach supporting documents to their copy of the Form PY-210S certificate issued.

C. Product Labeling Requirements

In addition to the labeling requirements outlined in Section L-1, LABELING in the Supervisors/Resident Graders Shell Egg Index, the following information applies to labeling product as “organic:”

1. Labeling materials bearing the official grademark must be submitted to the National Office for approval prior to use. The term “organic” may appear on any panel of consumer packaging material and shipping containers in the format and color as specified in 7 CFR, Part 205.

2. The full name or registered trade name of the certifying agent (name which may be expressed as an acronym if registered as a trade name or mark) must be placed on the label or packaging material near the name and address of the packer or

distributor. No other printed material or information may be placed between the certifying agent's name and the name of the packer or distributor. As an option, the certifying agent's name, trade name, or registered acronym, the statement "Certified organic by (insert certifying agent's name)," or similar phrase, may be used.

3. It is optional for certified operations to display the USDA organic emblem, as shown below, on their packing and packaging material. Shell egg exports identified as organic to a standard other than the National Organic Standard are not eligible for identification with the USDA organic emblem.

D. Verification and Control

Shell eggs from each approved organic production location must be labeled and otherwise handled to maintain their identity through processing and packaging. Firms must develop and implement a monitoring program to assure that only "organic" eggs are officially certified and appropriately identified with an approved USDA label. Graders must verify through a document review that the shell eggs identified as "organic" originate from a flock(s) listed on the producer's organic certificate issued by the accrediting agent. Management must present documentation and processing records that correlate the identity of the product with the certified flock. This would include product markings such as a flock number(s), producer name and address, or specific production code number(s) that can be directly associated with shipping invoices to indicate compliance.

E. Official Certification

Upon verification of documentation, the USDA grader may officially certify the quality, quantity, and condition of organically produced shell eggs, for domestic and export sales, based on the results of either online sampling or stationary lot grading. Additionally, organically produced eggs can be officially certified on a sample graded basis. When requested, the grader may issue a Form PY-210S certificate reflecting these results. For each certificate issued covering shell eggs produced in accordance with the USDA National Organic Standards, place the following statement in the "Remarks" section:

"Product meets the requirements for identifying shell eggs as organic in accordance with the USDA, National Organic Standards."

X. United Egg Producers (UEP) Certified

To improve the welfare of egg-laying flocks, the United Egg Producers (UEP) has developed animal husbandry guidelines for egg laying flocks. Official plants recognized by the UEP as certified under this program will be eligible to use the following "United Egg Producers Certified" emblem. The

emblem represents certification that a company's production facility is participating in the UEP Animal Husbandry Program for Egg-Laying Flocks.

Labeling materials bearing the official grademark and the "United Egg Producers Certified" emblem must be submitted to the National Office for approval prior to use. The emblem may appear on any panel of the consumer packaging material and shipping containers. For previously approved labels, the original approval number will be reassigned to the new label format.

Once approved, use of container labels is contingent on the registration of a company's production facility in UEP's Animal Husbandry Program for Egg-Laying Flocks. Verification can be confirmed through the certificate issued by UEP to each company for registration of the identified production facility(s). This document must be provided to the USDA grader prior to packing eggs in containers identified with the emblem. Continued use of the approved labeling material will be determined based on the company's compliance with the provisions of the program.

XI. Recognized Organizations Certifying Animal Husbandry Practices for Egg-Laying Flocks

When a company elects to use a recognized organization's animal care certification based upon verification of compliance as meeting or exceeding industry standards by an independent certifying agent, the certificate or letter issued must be issued within the past 12 months. Plant management must provide a current letter of certification from the certifying agent identifying the certified layer flocks. Plant management must provide, upon request from a USDA representative, a copy of the organization's standards for egg-laying flocks and the emblem representing the organization (Exhibit IV). A written copy of plant managements plan for maintaining the identity of the eggs from the certified source flock(s) from the time of production through storage, transport, processing and packaging must be presented to the USDA grader.

XII. Cage-Free or Free-Range Egg Production Verification Procedures

To assure that a source flock(s) identity is consistent with the animal care marketing claim on the label bearing a USDA grademark, the Federal-State supervisor or designee will visit each egg production site to verify the animal husbandry practices for the identified layer flock and/or other related marketing claims. The verification shall be conducted as outlined below:

A. Upon request from a producer, verification service for cage free or free range animal husbandry practices shall be provided on a fee basis including associated expenses.

B. The Federal-State supervisor or designee will conduct an onsite visit to visually examine the animal husbandry practices employed for each identified flock at the egg production site. A minimum of two verification visits per year is required which is consistent with AMS verification procedures. All company established biosecurity procedures shall be followed when visiting an egg production site.

When an egg producer has a layer flock(s) certified by an independent third-party certifying agent as meeting recognized industry standards for cage free or free range animal husbandry practices, the annual letter of certification for an identified layer flock(s) can be substituted for one of the two verification visits required per year by the Livestock, Poultry and Seed Program (LPS). **Note**: Flocks in layer houses designed to provide continuous access to acceptable outdoor areas to roam may be identified with the marketing claim "free range layers."

C. The Federal-State supervisor is responsible for reviewing the applicable observations and information documented for the identified layer flock(s) during the verification visit. Exhibits II and III are provided to assist with the recording of observations and information relative to each layer flock or egg production site identified by the producer. The Cage Free Layer House Verification Report can be used to document that verification is acceptable, record the general size and identity of the layer flock(s), continuous access to an acceptable outdoor area to roam, and whether the layer house design provides perches, scratch or dust bathing areas, etc. that may be requested as additional marketing claims.

D. If the egg producer/packer provides a copy of an approved label used to distribute the eggs from the identified cage free layer flock(s) that includes additional marketing claims, such as vegetarian diet, no animal by-products, etc., these statements may also be verified during the visit.

E. The verification procedure will also require determination of an acceptable written plan to maintain the segregation and identity of the eggs for a certified source flock(s) from the time of production through storage, transport, processing and packaging. If acceptable, this written plan must be provided to the resident USDA grader assigned to the identified egg packing plant. The resident grader will file a copy of the written plan in File Folder 2 for reference information accessible by an assigned relief grader.

F. Upon determining that the identified flock(s) meets the policy definition for a cage free layer flock, the fee certificate can be completed. The quality section of the Shell Egg Grading Certificate, Form PY-210S, shall be crossed out. The remarks section will include the statement "The flock(s) identified as (name, address, and any applicable flock identity) meet USDA, LPS policy requirements for recognition as a cage free egg-laying operation." Follow established procedures for distribution of an issued fee certificate.

G. When the egg-laying facility does not meet USDA, LPS policy describing a cage-free and/or free-range, egg-laying operation, the remarks section of the certificate will include the following statement:

"Based upon the onsite visit conducted, the layer flocks identified as (name, address, and any applicable flock identity) do not meet the USDA, Livestock, Poultry and Seed Program's policy for (cage free / free range) egg-laying flocks."

XIII. Appeal Gradings

An appeal grading may be requested by any interested party who is not satisfied with the determination of the class, quality, quantity, or condition of any product as evidenced by the USDA grademark and accompanying label, or as stated on a grading certificate (7 CFR 56.60). To qualify for an appeal grading, shell eggs shall not have been moved from the point of the original grading that is being appealed [7 CFR 56.65(c)].

A. Who Shall Perform the Appeal Grading:

1. The appeal is to be filed with the grader's immediate supervisor.

2. The appeal grading shall be made by the grader's immediate Federal-State supervisor or by a licensed grader assigned by the immediate Federal-State supervisor.

3. The grader who performed the original grading shall not be assigned to perform the appeal grading.

B. Procedures for Appeal Gradings: (7 CFR 56.65)

1. When the original samples are available, the sample shall consist of the original samples plus an equal number of additional samples.

2. When the grade is sustained, the appeal certificate is not to show the percentage breakdown of qualities. The certificate will show "Original U.S. Grade Sustained." When the grade is not sustained, the appeal certificate should show the percentage of qualities. The U.S. grade is not to be shown. The certificate will show, "Original U.S. Grade Not Sustained" (7 CFR 56.66).

3. The appeal certificate always supersedes the original certificate.

4. When a grading is appealed and a new certificate is issued, show under remarks:

   "This is an appeal grading and this certificate supersedes Certificate Number ____, dated _____."

   A copy of all appeal certificates is to be sent to the National Office. Whenever the detailed grade results of the appeal and the original grade findings are not shown on the front of the appeal certificate include this data on the back of the National Office copy.

   The original and all copies of the superseded resident certificate shall be recalled and filed in the same manner as "Void" certificates.

The original and all copies of the superseded certificate shall be recalled. All returned superseded certificates shall be marked “Void” and filed by the grader in the same manner as "Void" certificates.

XIV. Export Certification

Foreign governments, not unlike this country, will develop regulations stating public and animal health certification requirements. Additionally, some foreign governments will specify labeling requirements for prepackaged food for direct sale to the consumer. Recognizing that the requirement may differ for each country, the USDA grader must refer to Section-E, Exports, in the Supervisors/Resident Graders Shell Egg Index. When export certification requirements are not provided, plant management may request a quality certification as “Fit for Human Consumption”, and the “Disease Free Statements – Other Countries.” Although these certificates represent government documents, USDA cannot guarantee the import of the shell eggs to the foreign country.

The Disease Free Statements (animal health statements for egg–laying flocks) are authorized by the Animal Plant Health Inspection Service (APHIS), USDA. The grader has no authority to modify these animal health statements.

Occasionally, plant management may request the use of a date or statement relative to the duration or quality of eggs certified for export. Since the USDA cannot control conditions of handling, storage, or transport of exported eggs, declaration of an “expiration or use by date” beyond the period for domestic product may only be authorized when the certificate includes a qualifying statement. For example: When plant management requests a 90-day “Use by” date on the lot of eggs certified for export and the foreign country has no labeling restrictions prohibiting such a declaration, the certificate issued (Form PY-210S) will include the following statement in the remarks section:

“The expiration date (or use by date) declared on the label is the responsibility of the applicant.”

Container labels identified with an “Expiration (EXP)” date (or “Use by” date) exceeding the maximum period authorized for the U.S. market are not eligible for distribution and retail sale in domestic commerce without removing the declaration or repackaging the product.

Plant management is responsible for providing shipping records to the USDA grader demonstrating product not labeled in accordance with applicable FDA and USDA labeling regulations and policy (i.e. expiration dates beyond 30 days, labeled in accordance with foreign government requirements – Canada retail product, certified for export) is exported to assure it does not enter domestic commerce.

REPRODUCE LOCALLY. *Include form number and edition date on all reproductions.* **OMB APPROVED - NO. 0581-0127**

U.S. DEPARTMENT OF AGRICULTURE
AGRICULTURAL MARKETING SERVICE
POULTRY PROGRAMS

APPLICATION FOR SPECIFICATION APPROVAL

Response is required in order to obtain specification approval applicable to grading service specification (CFR 56.4 and 70.10).

According to the Paperwork Reduction Act of 1995, an agency may not conduct or sponsor, and a person is not required to respond to a collection of information unless it displays a valid OMB control number. The valid OMB control number for this information collection is 0581-0127. The time required to complete this information collection is estimated to average 2 hours per response, including the time for reviewing instructions, searching existing data sources, gathering and maintaining the data needed, and completing and reviewing the collection of information. The United States Department of Agriculture (USDA) prohibits discrimination in all its programs and activities on the basis of race, color, national origin, gender, religion, age, disability, political beliefs, sexual orientation, and martial or family status. (Not all prohibited bases apply to all programs.) Persons with disabilities who require alternative means for communication of program information (Braille, large print, audiotape, etc.) should contact the USDA's TARGET Center at (202)720-2600 (voice and TDD). To file a complaint, write USDA, Director, Office of Civil Rights, Room 326-W, Whitten Building., 1400 Independence Avenue, SW, Washington, DC 20250-9410 or call (202) 720-5964 (voice or TDD). USDA is an equal opportunity provider and employer.

I hereby apply for Acceptance Service certification of the product(s) checked below. It is understood that:

- The applicant will provide an approved copy of the specifications to plant management and the U.S. Department of Agriculture (USDA) representative at each plant packing to these specifications.
- Any graded or inspected product subject to these specifications which does not meet the terms of the specifications will be placed under USDA retention. Retained product will be released only when reworked to meet specification requirements, or when verbal or written authority is granted by the applicant to waive specific requirements.
- The applicant will provide waivers to specific requirements directly to plant management and the USDA representative at the packing location.
- When applicable, the applicant is to verify that all products procured under the Acceptance Service certification program are properly identified and accompanied by the required certification documents when received at destination.
- Any product bearing any USDA identification shall at all times comply with USDA requirements and regulations.

PRODUCT	APPLICABLE REGULATIONS
☐ SHELL EGG	Regulations Governing the Voluntary Grading of Shell Eggs (7 CFR 56) United States Standards, Grades, and Weight Classes for Shell Eggs (AMS 56)
☐ POULTRY	Regulations Governing the Voluntary Grading of Poultry Products and Rabbit (7 CFR 70) United States Classes, Standards, and Grades for Poultry (AMS 70.200 et. seq.)

TITLES OF PERSONS AUTHORIZED TO GRANT SPECIFICATION WAIVERS	TELEPHONE NUMBERS *(Include Area Code)*

NAME OF APPLICANT*	ADDRESS OF APPLICANT *(Street and No., city, State, and ZIP Code)*
E-MAIL ADDRESS:	
DATE OF APPLICATION	SIGNATURE OF APPLICANT

FOR USE BY AGRICULTURAL MARKETING SERVICE

DATE APPLICATION APPROVED	DATE SPECIFICATIONS APPROVED
TITLE	SIGNATURE OF USDA OFFICIAL

*No member of or delegate to Congress, or Resident Commissioner, shall be admitted to any benefit that may arise from this service unless derived through service rendered a corporation for its general benefit.

Semi-Annual Cage-Free Layer Flock Verification

Calendar Year: 2013

Name of Producer: THE EGG FARM	**Name of Facility:** THE EGG FARM - COMPLEX A
Address of Producer: 123 EGG STREET EGG, SHELL 00123	**Address of Facility:** 678 EGG STREET EGG, SHELL 00123

Please check the independent third party certifying agent(s) that have industry recognized animal care standards for cage-free / free-range egg laying flocks for the listed producer/facility.

	National Organic Program (NOP), USDA		United Egg Producers Certified (UEP)
X	Certified Humane – Raised & Handled		American Humane Certified

Please complete the applicable independent third party certifying agent(s) information:

House Number	Cage-Free				Free-Range				Layers Per House (Approximately)
1	YES	✓	NO		YES		NO		10,000
2	YES	✓	NO		YES		NO		
3	YES	✓	NO		YES		NO		
4	YES	✓	NO		YES		NO		
5	YES	✓	NO		YES		NO		
6	YES	✓	NO		YES		NO		
7	YES	✓	NO		YES		NO		
8	YES	✓	NO		YES		NO		
9	YES	✓	NO		YES		NO		
10	YES	✓	NO		YES		NO		
11	YES	✓	NO		YES		NO		
12	YES	✓	NO		YES		NO		
	YES		NO		YES		NO		
	YES		NO		YES		NO		
	YES		NO		YES		NO		

Does the facility have a written Standard Operating Procedure (SOP) for the segregation and identification of the Cage-Free / Free-Range eggs?	YES	X	NO	

Remarks:

- ELIGIBLE FOR CAGE-FREE MARKETING CLAIMS.
- CERTIFICATE # 1234567 ISSUED ON 10/04/2012.

Semi-Annual Cage-Free Layer Flock Verification

Calendar Year: 2013

Name of Producer: THE EGG FARM	**Name of Facility:** THE EGG FARM - Complex B
Address of Producer: 123 EGG STREET EGG, SHELL 00123	**Address of Facility:** 1025 EGG STREET EGG, SHELL 00123

Please check the independent third party certifying agent(s) that have industry recognized animal care standards for cage-free / free-range egg laying flocks for the listed producer/facility.

	National Organic Program (NOP), USDA		United Egg Producers Certified (UEP)
X	Certified Humane – Raised & Handled		American Humane Certified

Please complete the applicable independent third party certifying agent(s) information:

House Number	Cage-Free		Free-Range		Layers Per House (Approximately)
1	YES	NO	YES ✓	NO	8,000
2	YES	NO	YES ✓	NO	10,000
3	YES	NO	YES ✓	NO	6,500
4	YES	NO	YES ✓	NO	8,000
5	YES	NO	YES ✓	NO	8,000
6	YES	NO	YES ✓	NO	10,000
	YES	NO	YES	NO	
	YES	NO	YES	NO	
	YES	NO	YES	NO	
	YES	NO	YES	NO	
	YES	NO	YES	NO	
	YES	NO	YES	NO	
	YES	NO	YES	NO	
	YES	NO	YES	NO	
	YES	NO	YES	NO	

Does the facility have a written Standard Operating Procedure (SOP) for the segregation and identification of the Cage-Free / Free-Range eggs?	YES	X	NO	

Remarks:

- CONTINUOUS ACCESS TO THE OUTDOORS IS PROVIDED AND ACCEPTABLE.
- ELIGIBLE FOR FREE-RANGE AND CAGE-FREE MARKETING CLAIMS.
- CERTIFICATE # 7654321 ISSUED ON 10/05/2012.

Semi-Annual Cage-Free Layer Flock Verification

Calendar Year: _____

Name of Producer:	**Name of Facility:**
Address of Producer:	**Address of Facility:**

Please check the independent third party certifying agent(s) that have industry recognized animal care standards for cage-free / free-range egg laying flocks for the listed producer/facility.

	National Organic Program (NOP), USDA		**United Egg Producers Certified (UEP)**
	Certified Humane – Raised & Handled		**American Humane Certified**

Please complete the applicable independent third party certifying agent(s) information:

House Number	Cage-Free				Free-Range				Layers Per House (Approximately)
	YES		NO		YES		NO		
	YES		NO		YES		NO		
	YES		NO		YES		NO		
	YES		NO		YES		NO		
	YES		NO		YES		NO		
	YES		NO		YES		NO		
	YES		NO		YES		NO		
	YES		NO		YES		NO		
	YES		NO		YES		NO		
	YES		NO		YES		NO		
	YES		NO		YES		NO		
	YES		NO		YES		NO		
	YES		NO		YES		NO		
	YES		NO		YES		NO		
	YES		NO		YES		NO		

Does the facility have a written Standard Operating Procedure (SOP) for the segregation and identification of the Cage-Free / Free-Range eggs?	**YES**		**NO**	

Remarks:

Recognized Certification Standards for Cage-Free Layer Flocks

National Organic Program (NOP), USDA

Certified Humane – Raised & Handled

Humane Farm Animal Care Standards

American Humane Certified

American Humane Association

United Egg Producers Certified

United Egg Producers Guidelines for U.S. Cage Free Egg-Laying Flocks

Although the above information references cage free layer flock animal husbandry practices, the terminology “free range” may be used when continuous access to acceptable outdoor areas is provided.

SECTION 10: CERTIFICATE AND MEMORANDUM PREPARATION

I. Preparation and Distribution of Worksheets

A. Guidelines Regarding Use

Form PY-211, Poultry Products Grading Memorandum, Sample Selection Worksheets, and Forms PY-75 and 75A, Shell Egg Online Candling Record, are used as the official worksheets to support certificates issued. Industry may examine the above mentioned forms during the graders scheduled tour of duty; however, they cannot make, nor possess copies of the worksheets.

THESE WORKSHEETS ARE NOT TO BE DISTRIBUTED TO INDUSTRY.

Approved company forms may be used instead of official worksheets when an official certificate is not requested and it will be useful to the firm. Company forms are to be approved prior to their use by a supervisor who should confirm the approval in writing to the grader. They may not be signed or initialed by the grader.

B. Entries Required

The detail required on the worksheet includes all information which will be placed on the certificate, except as noted below. In addition, include such comments as to loading, holding, and any other potentially useful information concerning the general character of the eggs. When such information is not for inclusion on the certificate, circle it to indicate that is not to be typed on the certificate. Worksheets are to be signed in blue ink by all graders making the official grading.

When Form PY-210S grading certificates are prepared by the grader at the time the grading is performed, either typewritten preferably or in longhand, it is not necessary to complete a memorandum. Memorandums must be prepared when information such as individual case data, net weight, percentages or information not normally included on the grading certificate is needed. In these cases the certificate number, date of grading, and grader's signature shall be shown on the memorandum. The only time it is necessary to fill out the memorandum completely is when someone other than the grader will prepare the grading certificate. When more than one grader is assigned to grade a lot of eggs, each grader is to record and initial his/her entry on the worksheets for the specific samples graded.

C. Egg Oiling

Do not show "shell protected" on a certificate unless it is a specification requirement or is requested by the applicant or receiver. In order for a grader to certify that eggs have been shell protected, the packing plant shall have equipment capable of applying oil to approximately the entire shell surface of the egg as observed by the grader.

D. Temperature

Record the temperature of the refrigerated holding room or refrigerated area where the eggs were held. Knowing the temperature of the eggs at the time of grading is important to enable a grader to grade properly.

E. Egg Color

State the color as white or brown and the number of cases of each, when applicant can furnish such information. State the color as mixed when the actual number of cases for each is identified. Definitions for determining the color are as follows:

1. White - When all eggs in the lot have a distinct white color.

2. Brown - When all eggs in the lot have a definite shade of brown which may vary from light brown (buff) to dark brown.

3. Mixed – A lot of eggs consisting of more than one color is to be declared as mixed colors.

A tolerance of 10 percent eggs with a cream shade in a lot, described as white or brown is permitted on an individual case basis.

F. Defects

Describe the character of loss and certain other B* qualities by using the below listed symbols. Limit the terms used to the ones listed in the regulations and below. It is not mandatory to report the actual type of dirty eggs on official reports, but use the symbols to further identify the exact reason, as necessary.

Air Cell . . . . . ….AC (Over $^{3}/_{8}$ in.)	Dirty Stain . . . . . …...DS	Mixed Rot . . . . . …...MR
Black Rot . . . BLRT	Dirty Yolk. . . . . …..DY	Moldy . . . . . …..MLDY
Bloody White. . . BW*	Frozen. . . . . …….FZ	Serious Yolk Defect. .SYD
Cooked Egg. . . . CE	Green White . . . . . .GW	Small Blood Spot . . . . …SS (less than $^{1}/_{8}$ in.)
Dirty Adhering. . DA	Large Blood Spot. . ..LS	Sour Rot. . . . . …….. .SR
Dirty Fecal . . . . …DF	Large Meat Spot . . ..LS	Stuck Yolk. . . . . …….SY
	Leaker. . . . . …….LK	

*Eggs with blood spots which show a slight diffusion into the albumen around the localized spot are not to be classified as bloody white.

G. Shortages

When "shortages" are found in any sample, report the number of eggs short on the memorandum and certificate, but do not include such shortage when computing the grade. Select and grade a minimum

of 100 eggs. To determine the weight of such a case, replace the shortage with other eggs from within the lot.

H. Labeling

When applicable, record under "Remarks" pertinent labeling information such as:

1. Lot numbers (USDA, storage, or company). Storage or company lot numbers are only recorded when each case is identified.

2. Brand name as displayed on carton or case.

3. Name and address of packer or distributor.

4. Any other marks identifying the contents of the case.

I. Underweight Eggs

Record individual underweight eggs found in each sample, using slash marks. In consumer weight classes, the individual case tolerance is 5 percent underweight eggs and the lot average tolerance is 3.3 percent eggs in the next lower weight class.

J. Case Temperature

If, an applicant requests internal case temperatures while performing a stationary lot grading, record the temperature range of each case examined. Place this information in the Remarks section. Obtain temperatures by placing a thermometer between the second and the third filler flat tier. Shell egg carton container temperatures are obtained by placing the metal stem thermometer horizontally in the carton. The thermometer should remain in place until the temperature stabilizes for recording.

Leave the thermometer with the top fillers in place while grading the opposite end. Read the thermometer immediately upon removing it from the case and record the temperature in the designated column. For eggs known to be under refrigeration long enough to equalize the temperature of the lot, show the following statement under "Remarks" on certificates issued:

"Product held under ___° F temperature. Individual egg temperatures not checked."

When eggs have not been held long enough for temperatures to have equalized throughout the lot, each sample must be checked and the temperature range shown on the certificate. For line sampled product, a sufficient number of case temperatures are to be recorded throughout the day so as to determine the product temperature.

K. B and B* Quality

List small (not more than one-eighth inch in diameter) meat spots in the "B" column without additional comment. In the B* column, record eggs with air cells over three-eighths inch, eggs with small blood

spots aggregating not more than one-eighth inch in diameter, and eggs with serious yolk defects. Identify these eggs using the appropriate symbol on the memorandum or worksheet, but do not include this information on the grading certificate.

L. Dirties and Checks

A "dirty" egg is graded only to determine whether it is a loss or check. A dirty is classified higher than a check because a dirty egg can be upgraded by cleaning, while the quality of a checked egg can only deteriorate and is susceptible to bacterial adulteration.

M. Leakers

Leakers are to be reported as loss eggs. Within the tolerance permitted, an allowance is made at destination to permit 1.00 percent leakers, dirties, or loss (due to meat or blood spots) in any combination in Consumer Grades AA, A, and B, except that loss may not exceed 0.30 percent.

N. Damaged Containers

A container of eggs selected as a sample which shows evidence of obvious damage is to be removed from the lot for reworking and is not to be used as one of the official samples.

O. Recording Results

Record the grade factors of each sample. The total of the quality factor columns when added across shall always equal 100 eggs. Shortages and underweight eggs are never included in the 100-egg quality totals. After the entire lot is graded, total each column vertically. Determine the "average percent" of each grade factor by dividing the total of each column by the number of cases sampled in the lot or by using the percentage table provided each grader.

The total of the combined averages shall be 100 percent. If the percentage totals 99.99, add 0.01 to the column representing the highest percentage or vice versa if the percentage totals 100.01.

P. Conversion of Small Units

When requested, a conversion of small units to 30-dozen equivalents will be recorded in the “remarks” section. DO NOT ROUND.

Actual conversions must appear on the certificate. Example: 51/15-dozen cases = 25.5/30-dozen cases. The grader may convert from the smaller cases to the 30-dozen units with this formula:

Number of 12-dozen units times	.4
Number of 15-dozen units times	.5
Number of 16-dozen units times	.533
Number of 18-dozen units times	.6
Number of 24-dozen units times	.8

Number of 25-dozen units times .833
Number of 40-dozen units times 1.33

II. DISTRIBUTION

A. Fee or temporary plant graders are to file certificates and worksheets according to the supervisor's instructions.

B. Resident graders are to file certificates with worksheets attached for all certificates issued in the resident plant. Retain these files according to current record disposition schedules.

III. PREPARATION OF CERTIFICATES

A. Preparation of Form PY-210S, Shell Egg Grading Certificate

Prepare certificates from the data recorded on the worksheets. It is preferred that only the front of the certificate be used. Refer to Section 8 of this handbook for examples on how to complete the Form PY-210S.

B. General Information Concerning Certificates

1. Certificates are to be used in numerical sequence.

2. Certificates are to be used in numerical sequence.

3. Complete all applicable sections of the certificate. Do not use abbreviations, except as designated in this section. The lot number shall be documented as the consecutive day of the year (Julian Date) representing the date of packaging.

4. All originals are to be signed in ink. However, certificates issued covering shell eggs for export must be typed, the grader's name must be typed on the signature line, and the certificate must be signed in blue ink.

   Note: When certificates are printed using computers or word-processors, it is permissible to print only the original certificate and make subsequent copies from the original. In this situation, all carbon copies are to be removed from the certificate carbon set prior to printing and shall be destroyed.

   After printing the original certificate, the original shall be copied by plant management prior to grader signature. Each machine copy is to carry an original signature of the grader. A copy of the signed certificate is to be filed by the grader, as instructed. Permission to use computer or word-processors for printing certificates must be obtained from the Federal-State supervisor, prior to use.

5. Fee or temporary plant graders are to issue certificates covering all product offered for grading by the applicant, since a fee charge is required by the regulations.

6. Resident graders are to issue certificates only upon request of the applicant or their supervisor.

7. Resident graders shall use certificates in numerical order from the same numbered pad when issuing resident and fee certificates.

8. The resident grader's accountability record, Form PY-185 for "Resident" certificates is maintained at the plant.

9. The supervisor will determine how the accountability record is kept for other graders.

10. When minor errors are made on a certificate prior to the release of said certificate, correct the errors and initial the correction in ink. Errors often challenge the validity of a certificate. Numerous errors may void the certificate.

C. "Void" Certificates

When numerous errors are made in preparing a certificate, write "VOID" diagonally on the original and destroy all copies. The original is to be filed at the office where the accountability record is maintained. Voided certificates shall be indicated on the Form PY-185, by writing, "VOID" or "VOIDED" in the corresponding certificate number section.

D. Certificate Amendments

When an error is discovered after a certificate has been issued, it may be necessary to complete an amendment to correct the original certificate. Amendments may be issued:

1. To correct minor errors such as the name of applicant, etc.

2. When a major error has been made and all copies of the distributed certificate cannot be recovered, providing all interested parties can be supplied with copies of the amendment.

Please Note: Amendments are prepared on official Livestock, Poultry and Seed Program, AMS, USDA letterhead only (**refer to Exhibit I**). The grader issuing the amendment dates and signs the document in blue ink.

Graders other than the grader issuing the original certificate may issue amendments covering errors in entries that are as stated by the applicant. Amendments for factors certified by USDA may be made by a second grader only if the grader can personally verify the amended information through observation of product or examination of grading records. Utilize the same distribution as was issued for the original certificate, which was amended.

E. Superseded Certificates

Superseding certificates should only be used when an amendment is not acceptable. Occasionally, original certificates are distributed that require extensive modifications to correct a previously issued certificate. Under these circumstances, every effort should be made to retrieve the original certificate. If the original certificate cannot be retrieved, a new certificate can be issued to supersede the original certificate. When issuing a superseded certificate, the original certificate number and date must be referenced in the remarks section (**refer to Exhibit II**). Any licensed grader may issue a superseded certificate if it can be supported by examination of official grading records. Utilize the same distribution as the original certificate.

IV. Certificate Distribution

A. Distribute original and one copy to the applicant or designated representative. Additional copies may be furnished to the applicant when requested.

B. Distribute the additional copies as directed by the Federal-State supervisor.

C. Preparation and distribution of fee certificates, see, "Billing and Collection Document Preparation."

Exhibit I

USDA Agricultural Marketing Service

Livestock,
Poultry
and Seed Program

1400 Independence Avenue, SW.
Room 3938-S, STOP 058
Washington, DC 20250-0249

November 29, 2012

United States Department of Agriculture
Agricultural Marketing Service
Livestock, Poultry and Seed Program
Poultry Grading Division
1400 Independence Avenue SW
Washington DC 20250-0258

This amendment is to be attached to Certificate No. SEA-1234567, dated November 27, 2012.

TO WHOM IT MAY CONCERN:

Shell Egg Grading Certificate SEA-1234567, dated November 27, 2012, applicant Joanne Nelson Egg Farms, Phoenix, Arizona, covering shell eggs graded at Joanne Nelson Egg Farms, Phoenix, Arizona is amended as follows:

Original Certificate:

Official Grade and Size – U.S. Grade A Large

Amended to:

Official Grade and Size – U.S. Grade AA Large

John Hancock

/s/ John Hancock, Grader

Exhibit II

(See reverse side of form for OMB and EEO Statement)

FORM OMB APPROVED - NO. 0581-0127

U.S. DEPARTMENT OF AGRICULTURE
AGRICULTURAL MARKETING SERVICE
POULTRY PROGRAMS

SHELL EGG GRADING CERTIFICATE

This certificate is receivable in all courts of the United States as prima facie evidence of the truth of the statements therein contained. This certificate does not excuse failure to comply with any of the regulatory laws enforced by the United States Department of Agriculture.

CERTIFICATE NO. **SEA- 1234567**

PLACE EXAMINED **City, State**

PLANT NUMBER **P-XXXX**

TO: APPLICANT (Name and address, including ZIP)	NAME AND ADDRESS OF SHIPPER OR SELLER 1/	NAME AND ADDRESS OF RECEIVER OR BUYER 1/
Applicant Name **Street Address** **City, State, Zip Code**	**Commercial Distributor's Name** **Street Address** **City, State, Zip Code**	**Receiver/Buyer Name** **Street Address** **City, State, Zip Code**

LOT NO.	NO. OF CONTAINERS PER LOT 1/	NO. OF CONTAINERS EXAMINED	NET WT. 2/	PERCENTAGES								U.S. OFFICIAL GRADE AND SIZE
				AA	A	B	B*	Dirties	Checks	Loss	Under Wt. 3/	
111	**390**	**All**										**U.S. Grade A, Extra Large**
112	**390**	**All**										**U.S. Grade A, Large**

LOT NO.	DESCRIPTION							
	EGGS	TYPE OF PACKING	TYPE OF PACKAGING	CASE QUALITY RANGE	CHARACTER OF LOSS	WHERE HELD AND TEMPERATURE	CASES STAMPED WITH	
111	**Fresh White**	**New 30-Dozen Tops Taped**	**New Fiber Filler Flats**			**Cooler 45 F**	**USDA Grade A Stamp**	☒ Sample ☒ All
112	**Fresh White**	**New 30-Dozen Tops Taped**	**New Fiber Filler Flats**			**Cooler 45 F**	**USDA Grade A Stamp**	☒ Sample ☒ All
								☐ Sample ☐ All
								☐ Sample ☐ All

ADDITIONAL CERTIFICATION

Product represented by this certificate meets specification requirements for:

Volume Food Buyer's Commercial Specification dated XX-XX-XXXX.

Check each applicable box:

☒ Product represented on this certificate meets the requirements for the stated grade and size as determined by online sampling on **April 21 and 22, 2013**.

☐ Disease Free Certification Statements attached.

REMARKS

This certificate supersedes USDA certificate number SEA-1234566, dated XX-XX-XXXX.

CERTIFICATION STATEMENT

In compliance with the Regulations of the Secretary of Agriculture Governing the Grading of Shell Eggs issued pursuant to the Agricultural Marketing Act of 1946, as amended, and any other Act of Congress conferring like authority, it is certified that the product(s) listed hereon were examined and that the class, quality, quantity, and/ or condition of the product(s) at the time and on the date shown, were as stated above.

Typed or Printed Name and Signature (Blue Ink)

OFFICIAL GRADER *(Signature)*

Date of Issued Superseded Certificate

DATE

1/ As stated by applicant or contractor.
2/ Weights based on 30-dozen equivalent.
3/ Eggs reported as undersized are also reported under other headings according to their quality.

PY-210S (01-08) (Previous edition dated 12-03 may be used.)

SECTION 11: SHELL EGG VOLUME REPORT (FORM LPS – 240 S)

I. Purpose

This Instruction provides guidance for the preparation of Form LPS-240S "Shell Egg Grading Volume Report". Form LPS- 240S, has been developed as a means of obtaining accurate information concerning the volume of shell eggs graded or certified by Livestock, Poultry, & Seed personnel. It is also used as the basis for determining the administrative service charge for resident plants in accordance with the voluntary grading regulations.

II. Responsibility

A. Each grader-in-charge (GIC), or other designated grading personnel, stationed at a resident plant location is responsible for preparing Form LPS-240S by the last workday of the billing period (billing periods end on the last Saturday of the month). Reports are to be completed for resident plants even though no product may have been graded or certified during the reporting period. Volumes are to be reported in 30-dozen cases.

   In temporary plants and fee or other processing locations, the frequency (daily, weekly, or billing period) for reporting the volume information on the Form LPS-240S is determined by the Federal-State supervisor.

B. Volume information shall be obtained from plant management. Graders are responsible for review of the totals to ensure that the information provided is a fair reflection of the activities for the operation. If questions concerning the validity or appropriateness of the information exist, graders are to notify their supervisor who will review the volume reporting criteria with plant management to resolve the issue**.**

III. Completion of Report

Graders shall complete the following items on Form LPS- 240S (Exhibit I).

A. General Information Section

1. <u>Name and Address of Work Location</u> - Enter the complete name, address, and zip code of the plant where grading service is provided. This is the physical address of the work location and not a headquarters or billing address.

2(a). <u>Plant No</u>. - For resident and temporary plants, enter the official plant number assigned to the work location.

2(b). <u>Fee Request No</u>. - For fee plants only, enter the fee request number.

3. <u>Reporting Period</u> - Check the appropriate box to identify whether the volume totals reported are a daily, weekly, or billing period summary.

4. From - Enter the starting date of the period being reported, including the year.

5. To - Enter the ending date of the period being reported, including the year.

B. Administrative Volume Section (to be completed at resident plants only)

6. Total Received - Enter the number of 30-dozen cases received and which enter the plant. Do not include cases of cartoned or bulk product received from other plants for reshipment unless this product is processed in some manner at the location for which the volume report is prepared.

Note: If there are multiple pages completed for the LPS-240S, the Administrative Volume Section should be entered on Page 1 only.

C. Acceptance Service Section

All products that are graded / certified are to be reported in the acceptance service section.

7. Size - Leave box 7 blank. It is no longer necessary to report sizes for each entry.

8. Grade - Report the grade or classification for each volume using the following list. Consumer grades (AA, A, B) shall be combined and reported as one entry for all sizes.

- AA/A/B
- Nest Run (i.e., Canada Grade C, US Nest-Run)
- Pasteurized
- Washed Ungraded

NOTE: Report the volume of pasteurized eggs that are identified with the "Produced From" grademark or "certified as pasteurized" symbol, as fully graded-officially identified (FG-0I).

9. Acceptance Service - Report each type of acceptance service performed using the following list:

C	Commercial (Approved Specification)
XS	Export – Approved Export Specification (Refer to Section E, Exports for listing of country specifications)
XN	Export – Non-Contract (All countries that do not have an approved Export Specification listed in Section E, Exports)
D	Department of Defense
E	Egg Clearinghouse, Inc.
N	None
G	Other Government Agencies

For officially grade identified product that is not part of any acceptance service, graders shall assign an "Acceptance Service" of “None”.

10. Export Country or Group Code - When entering the acceptance service for export grading, whether an approved specification or non-contract, record the applicable code as listed in Exhibit II. If the destination country has an approved export specification listed in Section E of the Shell Egg Index, use the corresponding Export **Country** Code. If the destination country does not have an approved export specification, record the volume using the appropriate Export **Group** Code.

    For example, eggs exported to Hong Kong are certified using the specification found in the Export section (E-07) of the Shell Egg Index. The Acceptance Service (box 9) would be recorded as XS, the Export Code (box 10) as HK, and Graded (box 11) as FG-DF.

    Eggs exported to Australia may be certified using the general export instructions since this country does not have a negotiated export agreement with the U.S. The Acceptance Service (box 9) would be recorded as XN, the Export Code (box 10) as OC and Graded (box 11) as FG-DF.

    NOTE: All exported product is considered fully graded and issued either a country specific Disease Free Statement or one that is non-specific (Other Countries). Record both types of exports as FG-DF in box 11. Canada shipments and countries that require APHIS to issue animal health certificates (Taiwan) are also considered fully graded and disease free (FG-DF).

    Shipments destined for territories of the United States (Guam, Puerto Rico, US Virgin Islands, American Samoa, Northern Mariana Islands (Saipan)) and military commissary sales are considered domestic products and should not be reported as exports.

11. Graded - For each volume reported, record the applicable certification code as listed below:

FG-OI	Fully Graded/Officially Identified
FG-OIO	Fully Graded/Officially Identified/Organic
FG-OIC	Fully Graded/Officially Identified/Cage Free/Free Range (Non-Organic)
FG-NGE	Fully Graded/Officially Identified/Non-GMO/GE
FG-OIP	Fully Graded/Officially Identified/Federal Purchase Program
FG-DF	Fully Graded/Disease Free (All exports, **including Canada**)
LG-NI	Limited Graded/Not Identified (Non-identified)
NG	Not Graded

Definitions of certification codes:

Fully Graded (FG) – This is used when product is sampled online or when a full sample is examined to make a US Grade determination. This includes fully grading product for quality control purposes and non-identified product that is fully graded. Enter the total number of 30-dozen cases that are fully graded (online or full size sample).

Limited Grading (LG) - This includes the partial grading of product for quality control purposes. (30-dozen cases)

> **Example**: While performing quality control work, the grader examines 3 cases from a lot of 200 / 30-dozen cases produced. The grader will enter a total of 200 / 30-dozen cases as a limited grading.
>
> Alternately, when a sample is examined online, the grader will multiply the total number of samples examined by 75 to determine the volume of 30-dozen cases recognized as limited graded for the day's production. (Not to exceed the total number of cases produced.).
>
> **Example**: A grader applying online sampling criteria examines 4 cases of extra-large eggs for a day's production of 500/30-dozen cases. The total amount of extra-large eggs entered as limited graded in this instance is 300/30-dozen cases (4 samples x 75 = 300/30-dozen cases).
>
> A grader applying online sampling criteria examines 7 cases of extra-large eggs for a day's production of 500/30-dozen cases. The total amount of extra-large eggs entered as limited graded in this instance is 500/30-dozen cases (7 samples x 75 = 525/30-dozen cases, which exceeds the total number of cases produced, that is, 500/30-dozen cases).

Officially Identified (0I) - used when product is graded and/or certified and identified with the grademark (shield) or certification stamps imprinted on cartons, labels, cases or with following stamps:

- U.S. Grademark, AA, A
- USDA Contract Compliance
- USDA Certified Pasteurized
- USDA Produced From AA or A
- USDA Nest Run Grade

Not Identified (NI) - used when fully or limited graded product is not officially identified.

Not Graded (NG) - used when certifying product for factors other than grade

(i.e., breaking stock).

12. Consumer Labeled - Enter "YES" or "NO" to identify if the product is packed in any package or packaging which is identified with the U.S. Grademark (shield) as AA, A, or B.

13. 30-Doz. Cases Accepted - Record the total number of 30-dozen cases of eggs accepted. When partial cases are encountered, round-up to the nearest whole case.

14. 30-Doz. Cases Retained - Record the total number 30-dozen cases of eggs retained regardless of the final disposition of the product. For partial cases of eggs, round-up to the nearest whole case.

    Eggs identified as “Fit for Human Consumption” must be fully graded and meet U.S. Grade Standards. Disease Free Statements authorized by APHIS, USDA, may only be issued to cover fully graded eggs certified for export.

D. Certification Statements Section

Request an official representative of the company to sign the report.

E. Distribution

A. One copy to the Business Operations Branch (BOB) by the last day of the billing period. It is preferable to scan and email the form, however, faxing is acceptable.

   BOB contact information: QAD.BusinessOps@ams.usda.gov
   (888) 857-8941 (fax)

B. One copy to the Federal-State office.

C. Original copy retained in the grader's file at the plant location (if resident plant).

D. One copy provided to plant management.

U.S. DEPARTMENT OF AGRICULTURE
AGRICULTURAL MARKETING SERVICE
POUTLRY PROGRAMS

SHELL EGG GRADING VOLUME REPORT

1. NAME AND ADDRESS OF WORK LOCATION *(Include Zip Code)*:

2 (a). Plant No.

2 (b). Fee Request No.

OMB APPROVED - NO. 0581-0128

Page _____ of _____

3. REPORTING PERIOD

☐ Daily ☐ Weekly ☐ Billing Period

4. From

5. To

Exhibit 1

ADMINISTRATIVE VOLUME

6. TOTAL RECEIVED

ACCEPTANCE SERVICE VOLUME

LPS-240S forthcoming - Currently in Draft

7. SIZE	8. GRADE	9. ACCEPTANCE SERVICE	10. EXPORT COUNTRY CODE	11. GRADED	12. CONSUMER LABELED	13. 30 DOZ. CASES ACCEPTED	14. 30 DOZ. CASES RETAINED

CERTIFICATION STATEMENTS

I certify that the volumes stated above are the volumes of products processed and received.

Signature of Plant Manager

I certify that the volumes of products processed and received, as stated above, are correct to the best of my knowledge and the product officially identified as marked.

Signature of Grader

The following statements are made in accordance with the Privacy Act of 1974 (5 USC 552a). The authority for requesting the information to be supplied on this form and by supplements to this form is the Agricultural Marketing Act of 1946, as amended (7 U.S.C. 162-1627) to provide voluntary grading programs. Response is required to obtain volume of shell eggs (7CFR56.52(a)(4)) to determine the administrative volume charge per billing period.

According to the Paperwork Reduction Act of 1995, an agency may not conduct or sponsor, and a person is not required to respond to a collection of information unless it displays a valid OMB control number. The valid OMB control number for this information collection is 0581-0128. The time required to complete this information collection is estimated to average 45 minutes per response, including the time for reviewing instructions, searching existing data sources, gathering and maintaining the data needed, and completing and reviewing the collection of information.

The U.S. Department of Agriculture (USDA) prohibits discrimination in all its programs and activities on the basis of race, color, national origin, gender, religion, age, disability, sexual orientation, marital or family status, political beliefs, parental status, or protected genetic information. (Not all prohibited bases apply to all programs.) Persons with disabilities who require alternative means for communication of program information (Braille, large print, audiotape, etc.) should contact USDA's TARGET Center at 202-720-2600 (voice and TDD). To file a complaint of discrimination, write USDA, Director, Office of Civil Rights, Room 326-W, Whitten Building, 14th and Independence Ave, SW, Washington, DC 20250-9410 or call 202-720-5964 (voice and TDD). USDA is an equal opportunity provider and employer.

GPO U.S. GOVERNMENT PRINTING OFFICE : 2005 --- 717 - 486

COUNTRY CODES
(WITH APPROVED EXPORT SPECIFICATION)

MX	Mexico
HK	Hong Kong
JP	Japan
GC	Gulf Cooperative Council (GCC)
UA	United Arab Emirates (UAE)
IS	Israel
EL	El Salvador
SK	South Korea
AF	Afghanistan
CR	Costa Rica
CH	Chile
DB	Dubai
CD	Chad
DR	Dominican Republic
CU	Cuba
MC	Macao
CN	Canada
SG	Singapore
TW	Taiwan
TL	Thailand
TH	Tahiti-French Polynesia
BB	Barbados
GU	Guatemala
JM	Jamaica
GA	Ghana
KO	Kosovo
CO	Colombia
CB	Cambodia
AG	Angola
PA	Panama
EU	(all member states)

GROUP CODES
(All other areas)

AF AFRICA
Republic of South Africa
Cameroon

AS ASIA
China (PRC)

EE EASTERN EUROPE
Hungary
Poland
Romania

SA SOUTH AMERICA
Argentina
Brazil
Venezuela

OC OCEANIA
Australia
Micronesia, Federate

FS FORMER SOVIET UNION
Russia
Ukraine

ME MIDDLE EAST
Turkey

WE OTHER WESTERN EUROPE
Czech Republic
Switzerland

CA CENTRAL AMERICA
Caribbean Islands

SECTION 12: FILING SYSTEM, FORMS, AND EQUIPMENT

I. Shell Egg Graders Filing System

The responsibility for a current filing and maintenance system for instructions, supplies, memorandums, reports, certificates, etc., is an essential part of a grader's duties. Adequate file cabinets shall be available at each plant and files are to be kept locked when not in use. File folders are to be stored vertically beginning with file No. 1 in the front of the cabinet and working toward the back for additional folders. All filing systems should be set up on a uniform basis following the general guide plan shown below.

1a Current set of report forms requiring daily completion (i.e. Form PY-101, etc.).

1b Completed Form PY-101 and Form PY-240, etc. (attached together by billing periods).

2 Information for relief graders regarding arrangements for service, noise level record, log of approved chemical compounds used in the plant, identification system for online samples, tare weights of packaging material, any approved alternate procedures, GIC designation, etc.

2a Signed copy of designated company official letter and Form PY-100, Work Schedule Request-Voluntary Grading Service.

2b Other pertinent information which may be helpful: Motels, Restaurants, etc.

3a Current billing period certificates, Form PY-210S and memorandum, Form PY-211's.

3b File copies of issued certificates, memorandums, and worksheets (by billing periods).

4a Completed Form PY-75 and 75-A's, Daily Candling Record.

4b Form PY-516, Product Retention Log; Retained Product Transfer/Release Memorandum.

4c Completed Form PY-74, Pre-Operative Shell Egg Plant Sanitation Report.

5 Completed Form PY-227, Employee's Performance Record.

6 Form PY-238, Grading Stamp Control Record and the list of users of USDA grading stamps.

7 Current pad of unused numbered certificates with current Form PY-185, Consignment, Receipt, and Disposition.

8 General correspondence to and from State, Regional, and National Office.

9 Miscellaneous material (not indexed) such as "Information Only".

10 Personnel records (Orientation Training Checklist).

11 Injury reporting information (Form CA-1).

12 AD-616 Travel Vouchers and AD-617, Travel Voucher Continuation Sheets.

13 Military purchase program, institutional purchase information, approved commercial specifications, and materials of this type.

14 Form PY-221, Label Notice, and approved labeling material.

15 Poultry Grading Division transmittal notices.

16 Completed Form PY-185, Consignment, Receipt, and Disposition Record.

17 Official stationery.

18 Stamped envelopes.

19 Water and iron content analysis reports and water certification log.

20 State Egg Laws (i.e. specific labeling requirements).

21 Grader's copy of Form PY-156, Surveillance Inspection Report. Retain for 1 year after close of fiscal year.

22 Completed Cooler Sample worksheets.

Additional folders may follow in numerical order, as necessary. However, when adding new folders, careful adherence to the current filing system is mandatory.

II. Additional Equipment, Unused Forms, and Instruction Storage

Official grade identification stamps, unused numbered certificates, and unused officially accountable forms must be kept in a locked drawer or file which is accessible only to authorized personnel.

Index manuals must be maintained on a current basis and may be kept in a specific file or on the grader's desk.

When some file folders are not applicable, they may be omitted.

Each Grader-in-Charge (GIC) is to be supplied with a government-owned lock for securing the files. The use of the keys to these locks must be restricted to authorized personnel, only. Duplicate keys must be obtained from your supervisor.

Supervisors are required to check grader's files and record their observations on Form PY-227, Grader's Performance Record.

III. Disposition Schedule for Grading Program Records

The disposition schedule is filed as R-1 RECORDS in the General Index.