Product Information

Product Group: Further Prepared
Label Approval No: 2486713
Family: 06151, 06651

Allergens: Egg, Milk, Soy, Wheat
HACCP Plan: Fully Cooked, Not Shelf Stable
Intended Use: Child Nutrition
CN Number: 066410

Raw Material:

Freshness Statement:
Only USDA inspected and approved poultry may be used. Products will show no signs of off-odors or slickness.

Raw Material Code(s):
48215  CO2 Ground Breast 70# LT WIP 10% fat and down
49664, 49665, 49666  CO2 Ground Breast 70# BB WIP
31434  FZN Ground Breast 50# 20% fat and down
32498  FZN Ground Breast 50# 5% fat and down
32499, 32501  FZN Ground Breast 50# 10% fat and down
32525  FZN Ground Breast 50# 15% fat and down

Sampling Plan:
Instructions: Sample size is 70 lbs per 1750 lbs. per ANSI/ASQ Z-1.4, normal sampling. See Debone Off-Line Inspection SOP. Reject or rework any product not meeting requirements.

Product that is already ground is analyzed for fat and bone content during production of raw material. If frozen ground product is used, it will be flaked or reground prior to blending.

Grinding: N/A
Marination: N/A
Tumbling: N/A
Dicing: N/A

Blending:

<table>
<thead>
<tr>
<th>Ingredients</th>
<th>SKU</th>
<th>Percent</th>
<th>Axapta</th>
</tr>
</thead>
<tbody>
<tr>
<td>Ground White Chicken Meat</td>
<td>na</td>
<td>65.50</td>
<td>100.000</td>
</tr>
<tr>
<td>Water</td>
<td>na</td>
<td>23.18</td>
<td>35.389</td>
</tr>
<tr>
<td>Vegetable Protein Product (ProPlus 500F)</td>
<td>19030-00042</td>
<td>8.00</td>
<td>12.214</td>
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<tr>
<td>Dried Whole Egg</td>
<td>19030-00002</td>
<td>1.80</td>
<td>2.748</td>
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<tr>
<td>Salt</td>
<td>19020-00052</td>
<td>0.70</td>
<td>1.069</td>
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<tr>
<td>Sugar</td>
<td>19030-00034</td>
<td>0.35</td>
<td>0.534</td>
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<tr>
<td>Sodium Phosphates</td>
<td>19030-00048</td>
<td>0.25</td>
<td>0.382</td>
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<tr>
<td>White Pepper</td>
<td>19020-00041</td>
<td>0.15</td>
<td>0.229</td>
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<tr>
<td>Onion Powder</td>
<td>19020-00040</td>
<td>0.05</td>
<td>0.076</td>
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<tr>
<td>Garlic Powder</td>
<td>19020-00042</td>
<td>0.02</td>
<td>0.031</td>
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<tr>
<td>Total:</td>
<td></td>
<td>100.00</td>
<td>152.672</td>
</tr>
</tbody>
</table>

Blending Procedure:
1. Add ground white chicken meat to blender and blend for 1 minute at 6-8 rpm.
2. Add ProPlus 500F and blend to eliminate lumps.
3. Add water and blend for 1-2 minutes.
4. Add all remaining ingredients except for Dried Whole Egg and blend for 1-2 minutes.
5. Add Dried Whole Egg and blend to eliminate lumps.
6. Chill with CO₂.
7. Blend with ≥20” Hg vacuum for 3 minutes to eliminate excess CO₂.
8. Dump blended product into tared V-Mags (blended product temperature should remain 24-28°F).
9. All grinding and blending operations monitored per Meat Preparation QA Technician SOP.

**For more information, please refer to the document.**
Cooking:

**Fryer:**
- Line: 3
- Oil Temperature: 380°F
- Dwell Time: 30 seconds

**Fryer:**
- Line: 4
- Oil Temperature: 380°F
- Dwell Time: 46 seconds

**Oven:**
- Line: 3
- Oven Temperature: 350°F
- Dwell Time: 9.4 minutes
- Fans: 1100
- Steam: 30 & 10

**Oven:**
- Line 4
  - 1<sup>st</sup> Steam Chamber: 300 lbs.
  - 2<sup>nd</sup> Steam Chamber: 650 lbs.
  - Oven Temperature 1<sup>st</sup> Box: 445°F
  - Fans 1<sup>st</sup> Box: 80
  - Steam 1<sup>st</sup> Box: 10%
  - Hood 1<sup>st</sup> Box: 3.1
  - Oven Temperature 2<sup>nd</sup> Box: 460°F.
  - Fans 2<sup>nd</sup> Box: 80
  - Steam 2<sup>nd</sup> Box: 10%
  - Hood 2<sup>nd</sup> Box: 3.1
  - Total Dwell Time: 4.6 minutes

Fryer and oven settings are guidelines only, and adjustments made as needed. Product will be monitored at oven exit for internal temperature, piece weight, and template requirements per Oven Exit SOP.

**Freezer:**
- Dwell Time: 45-60 minutes
- Exit Internal Product Temperature: ≤10°F (twice per hour).

Procedure:
1. Product exiting freezer with internal temperatures >10°F placed on temperature hold and rejected or reworked.
2. Product exiting the freezer >20°F will be placed on QA hold and will also require that the spiral freezer be shut down until product temperature is in compliance.

**Metal Detection:**
1. All products will pass through a fully operable metal detector at the freezer exit.
2. Piece metal detector verified twice/hour using 1.5 mm ferrous sphere while product is running on freezer exit belt.
3. The bag and box metal detectors will be verified twice per hour using a 3.0 mm 316 Stainless Steel sphere. The verification sphere will be placed in, on, or under a bag and inside a box during verification.
4. All products failing metal detection check will be handled according to Metal Detection SOP.

**Packaging:**

**Primary Container:**
2. Supplier: Color Master
3. SKU: 06850-00007
4. Strength: 2 mil
5. Size: approximately 11” wide and 16 ½ in length
6. Style: Heat seal only
7. Tare: 0.30 oz.
8. Piece Count: N/A
9. Net Weight: 5 lbs

**Master Cases:**
1. Material: FP10-80
2. OD: 15 11/16 x 11 11/16 x 9 7/8”
3. Case cube: 1.05 ft³
4. Supplier: International Paper
5. SKU: 01140-00021
6. Tare weight (case): 1.35 lbs.
7. Tare weight (cases+bags): 1.45 lbs.
8. Number of bags per case: 4
10. Net weight: 20 lbs
11. Palletization: 10Ti/8Hi
12. Piece Count: 105 min
Downgrade Pack: SKU: 46651  
Bulk Pack: SKU: 00B06651

**Sampling Plan (QA Verification):** Refer to QA Packing Technician SOP. Collect microbiological, reference, and sensory evaluation samples once per hour.

Finished Product Evaluation:
1. Twice per hour randomly select 1 bag from packing line and determine weight of 50 randomly chosen pieces.
2. Average weight must be ≥3.05 oz.
3. Reject or rework affected product, adjust process, and document adjustments.

**Labeling:**
**Primary Container:** Print each bag with Plant number/ Production Date (mm/dd/yy format)/Shift Number/Lot Number.

**Master Case:**
Keep frozen.
Inkjet label with production code and lot number (lot number will be changed every 30 minutes of production).

**Case End Label:**
Applied to case end panel, center.
Printed with GK tracker requirements (reference GK tracker Program)

**Consumer Cooking Instructions:** N/A

**Preparation Procedure and Sensory Standards:** Once per hour a sensory evaluation will be done on all finished product(s) per Sensory Evaluation SOP with regard to appearance, flavor, color, odor, and texture.

**Analysis:**
**Microbiological Analysis:** Pull approximately 1 lb. per hour for microbiological analysis. Product will be analyzed by Gold Kist Inc. Laboratory per requirements of Microbiological limits for Fully Cooked Products SOP.

**Chemical Analysis:** N/A

**Finish Product Label Ingredients:**
Label approval form and label specimen