

## 7- CANNED FRUIT - FILL OF CONTAINER - AUTHENTIC PACK

Collect samples only on a specific assignment or during inspections when it appears that the firm is not filling the containers to capacity.

1. INVESTIGATIONAL SAMPLES: Authentic Pack Preparation . Procedure for preparing authentic factory packs.
    - a. Remove 72 cans, 3 at a time, from packing line after fruit has been added and before syruring.
    - b. Mark 24 cans with the sub numbers A-1, A-2, A-3, etc.; 24 cans with sub numbers B-1, B-2, B-3; and 24 cans with sub numbers C-1, C-2, C-3, etc. See IOM 4.5.2.3.
    - c. Drain water from the "B" subs by inverting each can for 10 seconds, holding the fruit so it doesn't fall out.
    - d. Obtain gross weight of each can and record data for each series of sub on 3 separate FDA-485 - Field Weight Sheets.
    - e. Add additional fruit of the same kind and style to the "C" subs until the cans are filled to capacity. Do not tamp the contents or crush the fruit.
    - f. Record the number of fruit pieces added where the size of the fruit makes the procedure reasonable. Do not make time consuming counts of small pieces of fruit or berries.
    - g. Obtain the gross weight of the "C" subs after additional fruit is added and record on "C" series Field Weight Sheet.
  - h. Return all 72 cans to the filling line for syruring, exhausting, sealing, etc. in normal cannery operation.
  - i. Remove cans after cooking and cooling.
  - j. Identify cans with a single INV Sample number.
  - k. Attach FDA-485 - Field Weight Sheets to C/R.
2. OFFICIAL SAMPLES  
See Sample Schedule Chart 2 for sample size.
  3. SPECIAL REPORTING AND PRECAUTIONS
    - a. Report coding of cans and shipping cases.
    - b. Obtain label specimen(s) for the slack filled products.
    - c. Report shipments made before the inspection or since previous inspection in the same canning season.
    - d. Do not prepare Authentic Factory Samples when the cannery is packing for USDA fill-of-container certification unless:
      - i. USDA inspection is not continuous.
      - ii. USDA Certification is for quality only.
      - iii. USDA recommendations for weights are not being followed.
  4. SAMPLE SUBMISSION  
Submit samples to your district's designated workplan servicing laboratory