

Corn - Proposed inspection method pack

Proposed order inspection plan | Corn | As of 2026-10-16

Proposed order inspection methods. Agree the SKU, sample state, sampling plan and acceptance criteria with GreenLand and the processor before use. Source standards retain their stated scope.

This is a proposed inspection plan, not a certificate, completed test or lot result. No sample size, AQL or numeric limit is created by this document.

Silk and husk material

Method status: proposed-contract-method. Proposed for agreement on an order; not a universal standard.

Definition

Loose corn silk, attached silk, husk leaf and broken cob core are four separate classes; kernel pericarp is not silk.

Sample state

As received frozen; sweet-corn kernels and cob ears are separate sample states; cooked aliquot only after safe-use approval.

Sampling approach

Take sealed cartons from beginning, middle and end of the lot; retain frozen until inspection. Do not pool cob and kernel styles. Set carton count, aliquot mass and acceptance number in the signed buyer plan; none is assumed here.

Inspection steps

Spread a frozen loose-kernel sample and inspect retained sieve material; inspect cob ears individually for attached silk and husk.

Calculation or reproducible observation

For each class: mass of class / net sample mass x100 (% w/w); for attached cob defects, affected ears / inspected ears x100 (% by count).

Proposed control response

Reset husking/silking and cob trimming; examine wash/sort rejects separately from kernels.

Evidence to retain

Record lot/pack/harvest identity, sample weight and count, method revision, equipment calibration where used, photographs of each class, raw tally, operator/date and any rework/retest. Retain Husker/silker or sheller setup, cob-trimmer setting, freezer discharge and cold-store event record.

Release or disposition

Hold affected lot for buyer-agreed class limits; reclean/regrade and resample before release; do not hide cob-core fragments in a silk total.

Buyer consequence

Loose plant matter can clog a depositor; attached silk changes cob presentation.

Source boundary

Operational calculation proposed for a buyer contract. Cited standard or guide informs definitions/scope only; no universal numeric tolerance or GreenLand capability is claimed.

Applicability and use boundary

For this proposed order method, we would confirm the SKU, sample condition, signed acceptance basis and factory control with the actual processor and buyer before use. This card is not an inspected-lot result or a statement of installed GreenLand capability.

Source references

P05: USDA AMS frozen corn on the cob, 2021 §52.931-944. Scope: URL:
https://www.ams.usda.gov/sites/default/files/media/Frozen_Corn_on_the_Cob_Standard.pdf

Damaged kernels

Method status: proposed-contract-method. Proposed for agreement on an order; not a universal standard.

Definition

Cracked kernel retains most flesh; broken kernel loses flesh; loose pericarp is a separate skin fragment.

Sample state

As received frozen; sweet-corn kernels and cob ears are separate sample states; cooked aliquot only after safe-use approval.

Sampling approach

Take sealed cartons from beginning, middle and end of the lot; retain frozen until inspection. Do not pool cob and kernel styles. Set carton count, aliquot mass and acceptance number in the signed buyer plan; none is assumed here.

Inspection steps

Spread still-frozen kernels in one layer, separate whole/cracked/broken/pericarp with reference photos; do not count deliberate cut kernels as damage.

Calculation or reproducible observation

mass of each defect class / net kernel sample mass x100 (% w/w), with removed pericarp weighed separately.

Proposed control response

Check sheller speed and screen size; compare pre- and post-freezer samples to locate breakage.

Evidence to retain

Record lot/pack/harvest identity, sample weight and count, method revision, equipment calibration where used, photographs of each class, raw tally, operator/date and any rework/retest. Retain Husker/silker or sheller setup, cob-trimmer setting, freezer discharge and cold-store event record.

Release or disposition

Quarantine if buyer's form-specific breakage limit is exceeded; adjust sheller/sorter, then regrade and repeat sample.

Buyer consequence

Fines alter pack fill, cooking yield and appearance in mixes.

Source boundary

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Maturity and prepared texture

Method status: proposed-contract-method. Proposed for agreement on an order; not a universal standard.

Definition

Kernel physiological maturity and pericarp toughness are distinct from food safety or microbial release.

Sample state

As received frozen; sweet-corn kernels and cob ears are separate sample states; cooked aliquot only after safe-use approval.

Sampling approach

Take sealed cartons from beginning, middle and end of the lot; retain frozen until inspection. Do not pool cob and kernel styles. Set carton count, aliquot mass and acceptance number in the signed buyer plan; none is assumed here.

Inspection steps

Sample matched cobs/kernels from one cultivar and harvest lot; compare frozen state and a buyer-approved cooked preparation only after safe-use approval.

Calculation or reproducible observation

Record calibrated °Brix of expressed thawed juice at stated temperature, plus blinded cooked chew panel score using fixed cooking time, portion and anchors; neither number alone is a universal grade.

Proposed control response

Change harvest window/cultivar segregation and blanch profile only after comparing paired raw/cooked lots.

Evidence to retain

Record lot/pack/harvest identity, sample weight and count, method revision, equipment calibration where used, photographs of each class, raw tally, operator/date and any rework/retest. Retain Husker/silker or sheller setup, cob-trimmer setting, freezer discharge and cold-store event record.

Release or disposition

Release by signed use-specific texture/flavor reference and safety plan; never approve by Brix alone.

Buyer consequence

Too-tough skin or starchy flavor can fail a ready-meal texture target despite sweetness.

Source boundary

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Cob length and cut ends

Method status: proposed-contract-method. Proposed for agreement on an order; not a universal standard.

Definition

Cob length, ragged end, missing tip and residual stalk are separate features of cob style; not a loose-kernel criterion.

Sample state

As received frozen; sweet-corn kernels and cob ears are separate sample states; cooked aliquot only after safe-use approval.

Sampling approach

Take sealed cartons from beginning, middle and end of the lot; retain frozen until inspection. Do not pool cob and kernel styles. Set carton count, aliquot mass and acceptance number in the signed buyer plan; none is assumed here.

Inspection steps

Measure each frozen ear end-to-end and inspect both cut faces and stalk base without thawing.

Calculation or reproducible observation

Length = tip-to-base mm on ruler; report median/range and ears outside contracted interval / total ears x100; residual stalk ears / total ears x100.

Proposed control response

Set cob saw and end trim, remove stalk base, sort by finished cob length.

Evidence to retain

Record lot/pack/harvest identity, sample weight and count, method revision, equipment calibration where used, photographs of each class, raw tally, operator/date and any rework/retest. Retain Husker/silker or sheller setup, cob-trimmer setting, freezer discharge and cold-store event record.

Release or disposition

Hold and re-cut/regrade any out-of-contract cob style; identify product as cob, never apply cob standard to kernels.

Buyer consequence

Uneven cob length prevents consistent tray fit and portion costing.

Source boundary

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Clumps

Method status: proposed-contract-method. Proposed for agreement on an order; not a universal standard.

Definition

A cluster that separates under gentle inversion differs from welded kernels and juice-derived clear ice.

Sample state

As received frozen; sweet-corn kernels and cob ears are separate sample states; cooked aliquot only after safe-use approval.

Sampling approach

Take sealed cartons from beginning, middle and end of the lot; retain frozen until inspection. Do not pool cob and kernel styles. Set carton count, aliquot mass and acceptance number in the signed buyer plan; none is assumed here.

Inspection steps

Tip the unopened bag twice, then spread sample frozen; photograph recoverable clusters, hard agglomerates and free ice separately.

Calculation or reproducible observation

Hard-agglomerate mass / net sample mass x100; free ice mass / net sample mass x100; state inversion protocol and ice separation temperature.

Proposed control response

Review post-freeze drying, bagging temperature and storage/door events; inspect seals for thaw-refreeze evidence.

Evidence to retain

Record lot/pack/harvest identity, sample weight and count, method revision, equipment calibration where used, photographs of each class, raw tally, operator/date and any rework/retest. Retain Husker/silker or sheller setup, cob-trimmer setting, freezer discharge and cold-store event record.

Release or disposition

Hold if buyer's free-flow or ice criterion fails; investigate temperature history before any rework/release.

Buyer consequence

Bridging blocks weighers and may signal cold-chain damage.

Source boundary

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