

## **MISC. TECHNICAL REQUIREMENTS FOR ASSEMBLED MREs AND CFM COMPLEMENTARY ITEMS:**

### **DESCRIPTION/SPECIFICATION**

**NSN: 8970-00-149-1094**

**Meal, Ready-to-Eat, Individual, menu numbers 1-12, (Case A); menu numbers 13-24 (Case B); 12 meals per shipping case; ACR-M-023A; TPK-2 item**

### **SECTION C:**

- a.** The procedures contained in the “Integrated Pest Management (IPM) Program Requirements for Operational Rations”, December 1998, and the “Contractor Sanitation Program - Operational Rations”, December 1998, are required and apply to all assembly and food component operations except as exempted in Section E of this document (see attached IPMP and sanitation programs). In addition, evidence of an insect or rodent infestation, foreign material, or contamination involving any component item, filled and sealed accessory packet, filled and sealed menu bag, or final assembly packed case will be cause for rejection of the involved lot.
- b.** Components shall be utilized in assembly operations on a first-in-first-out basis (or oldest manufacturer’s date of pack when receipted). Contractor shall be solely responsible for the proper care and storage of all components.
- c.** Maximum stacking height of assembled ration unit loads shall not be greater than four high.
- d.** Unless otherwise specified in individual item requirements, the thermoprocessing of (1) meat, poultry, and fish with sauce and gravy, (2) vegetables with sauce, (3) meat and poultry in loaf, slice, or solid form, and (4) fruit shall be in accordance with MIL-PRF-44073F, PACKAGING of Food in Flexible Packages.
- e.** The PACKAGING, labeling, packing, marking, and unitization of (1) meat, poultry, and fish with sauce and gravy, (2) vegetables with sauce, (3) meat and poultry in loaf, slice, or solid form, and (4) fruit shall be in accordance with Section D, TECHNICAL DATA FOR ENTREES, STARCHES AND SOUPS.
- f.** The provisions contained in Title 21, Chapter 1, Code of Federal Regulations, Part 110 “Current Good Manufacturing Practice In Manufacturing, PACKAGING Or Holding Human Food” are applicable.
- g.** All products shall comply with all applicable Federal and State mandatory requirements and regulations relating to the preparation, processing, thermoprocessing, PACKAGING, labeling, packing, storage, and distribution of those products and with all applicable provisions of the Federal Food, Drug, and Cosmetic Act and regulations promulgated thereunder. However, for all items thermostabilized by retorting, each filled and sealed pouch shall be in the retort process within two hours after sealing.
- h.** As required by 48 CFR 246.471-1 Subsistence; AR 40-657, Veterinary/Medical Food Inspection and Laboratory Service; DLAR 4155.3, Inspections of Subsistence Supplies and Services; DSCP Clause 52.246-9P31, ‘SANITARY CONDITIONS (JAN 1992) DSCP,’ contained in the solicitation for this product, and as clarified by the Armed Forces Food Risk Evaluation Committee, 31 JAN 1996; all Operational Ration food components will originate from sanitarily approved establishments . Acceptable sanitary approval is constituted by listing in the “Directory of Sanitarily Approved Food Establishments for Armed Forces Procurement,” published by the

U.S. Army Veterinary Command (VETCOM), or an establishment inspected and approved by the U.S. Department of Agriculture (USDA) or the U.S. Department of Commerce (USDC) and possessing a USDA/USDC establishment number. This requirement applies to all GFM and CFM Operational Ration food components and to all Operational Ration types. Requests for inspection and "Directory" listing by VETCOM will be routed through DSCP-HR for coordination and action. Situations involving sole sources of supply, proprietary supply sources, and commercial brand name items will be evaluated directly by the Chief, DSCP-HR, in coordination with the Chief, Approved Sources Division, VETCOM.

**i.** In addition to the requirements of any applicable COMMERCIAL ITEM DESCRIPTION (CID) or PERFORMANCE-BASED CONTRACT REQUIREMENT (PCR) for the components cited herein, all requirements, including the Performance Requirements, of the QUALITY ASSURANCE PROVISIONS AND PACKAGING REQUIREMENTS for the applicable CID or PCR are applicable.

**j.** In view of the fact that the ANSI/ASQC Z1.4-1993 Standard does not contain the definitions for critical, major, and minor defects, the following definitions become contractually binding through their inclusion here:

(1) Critical defect. A critical defect is a defect that judgment and experience indicate would result in hazardous or unsafe conditions for individuals using, maintaining, or depending on the item; or a defect that judgment and experience indicate is likely to prevent the performance of the major end item, i.e., the consumption of the ration.

(2) Major defect. A major defect is a defect, other than critical, that is likely to result in failure, or to reduce materially the usability of the unit of product for its intended purpose.

(3) Minor defect. A minor defect is a defect that is not likely to reduce materially the usability of the unit of product for its intended purpose, or is a departure from established standards having little bearing on the effective use or operation of the unit.

**k.** However for all items thermostabilized by retorting, each filled and sealed pouch shall be in the retort process within two hours after sealing."

**l.** Additionally, the following applies to perishable raw and cooked beef, chicken, pork, turkey, and other meats used in the production of end items intended for operational rations. All perishable meats shipped from the supplier to the processing plant shall be accompanied by either a USDA Grading Certificate (if required) or a COC indicating compliance to specified requirements, initial chilling or freezing date of the product as applicable. The ingredient supplier shall certify compliance with processing and PACKAGING requirements for formed or breaded meats. Under no circumstances shall any meat or meat product be CIDER than 180 days at time of use:

1. Chilled meats: Meats received in the chilled state shall have not been previously frozen and shall have been held at an internal temperature of 28~ to 40~ Fahrenheit for a period not to exceed 4 days following initial chilling and prior to preparation and further processing. Upon arrival at the processing plant, if chilled product is not used within 72 hours, it shall be frozen and stored at a temperature not to exceed 0 degrees Fahrenheit. Frozen product must be used within 180 days after initial freezing.

2. Frozen meats: Frozen meats received at the processing plant may be accepted provided the product internal temperature has never exceeded 20 degrees Fahrenheit. Upon arrival at the processing plant, if not used immediately, the product shall be stored at a temperature not to exceed 0 degrees Fahrenheit, and product must be used within 180 days after initial freezing.

**DATE OF PACK**

- a. For the assembled ration: Acceptance will be limited to assembled rations containing components, including the flameless ration heater, which have been processed and packed subsequent to date of award, except as otherwise specified below.
- b. For thermostabilized entrees/starches, cakes, and for components not otherwise listed below: Acceptance will be limited to product processed and packed subsequent to date of award.
- c. For thermostabilized and hot filled fruits and other seasonal crop components (i.e., peanuts, raisins): Acceptance will be limited to product processed and packed subsequent to date of award and from the latest season’s crop.
- d. For crackers: Acceptance will be limited to product manufactured and packed subsequent to date of award. For ration assembly, the crackers shall not be more than 90 days CID at time of unit PACKAGING.

**MISC. PACKAGING LABELING, PACKING MARKING, AND UNITIZATION REQUIREMENTS FOR ASSEMBLED MREs AND COMPLIMENTARY CFM COMPONENTS:**

**SECTION D:**

**A. ASSEMBLED RATIONS:**

In accordance with D-1 B.(1) and (2) of ACR-M-023.

**PACKAGING:**

Accessory packets: In accordance with para D-1, A.(1), A(1)a., A(1)b. and Table II of ACR-M-023.

Meal bags: In accordance with para 3.1.1, para 3.1.3, Table I, para 3.3, and Table III of MIL-M-44074.

**LABELING:**

Accessory packets: In accordance with D-2 A. of ACR-M-023.

Meal bags: In accordance with D-2 B. and Figure 1 of ACR-M-023.

**PACKING:** Meal bags shall be packed into shipping cases in accordance with D-3 A. of ACR-M 023.

**MARKING:**

**ASSEMBLED RATION SHIPPING CONTAINERS 1/2/:**

In accordance with DSCP 3556 and D-5 of ACR-M-023 and as follows:

8970-00-149-1094

MEAL, READY-TO-EAT, INDIVIDUAL

12 MEALS A/A

CASE A (MENUS 1-12) or CASE B (MENUS 13-24) (As applicable)

WT. \_\_\_\_\_ CU. \_\_\_\_\_

CONTRACT NO. \_\_\_\_\_ LOT NO. \_\_\_\_\_

NAME AND ADDRESS OF ASSEMBLY CONTRACTOR

DATE PACKED \_\_\_\_\_

INSPECTION/TEST DATE \_\_\_\_\_

U. S. GOVERNMENT PROPERTY - COMMERCIAL RESALE IS UNLAWFUL

1/The shipping containers shall contain all of the required markings. The ration assembler shall be responsible for applying the markings required. The shelf life for the assembled ration is 36 months, and shall be used in computing the Inspection/Test date.

2/ For line items scheduled for delivery to cCID storage, the following additional special markings shall be printed on pressure sensitive labels. One label shall be applied to each case sleeve on the end opposite the contractual markings and one label shall be applied adjacent to the unit load markings and shall read as follows:

DPSC OWNED STOCKS (ACCT. NO. SCO300)

NOTICE

THIS PRODUCT HAS BEEN HELD UNDER CONTROLLED TEMPERATURE AND HUMIDITY CONDITIONS AND SHOULD NOT BE CONSIDERED OVERAGE BECAUSE OF DATE OF PACK AND THE DATE OF PACK SHOULD NOT BE THE CONTROLLING FACTOR IN DETERMINING ISSUANCE AND UTILIZATION OF THE PRODUCT FURTHER REFRIGERATION IS NOT REQUIRED.

The lettering of the above label shall be 1/4 inch solid letters with the exception of the word "NOTICE" which shall be 1/2 inch solid letters. Alternatively, and solely at the contractor's option, the cCID storage markings as described above may be preprinted on the shipping container sleeves or otherwise marked under any applicable requirements cited for marking of shipping containers. Under this alternative, it is the responsibility of the contractor to determine the quantity, if any, of such preprinted shipping container sleeves that will be necessary and it remains the responsibility of the contractor to properly mark the shipping containers and sleeves as required by contractual documents.

In order to be in compliance with OSHA requirements, the following information must appear on MRE shipping containers which contain FRHs:

"Note: WATER ACTIVATED Flameless Ration Heater,  
NSN 8970-01-321-91 53, supplied in each menu bag."  
(Upper case letters not more than 1/4 inch high; lower  
case letters not less than 3/16 inch high).

**ASSEMBLED RATION UNIT LOADS:**

Unit loads shall be marked in accordance with DSCP 3556 except the identification, contract data and special markings shall not apply, and in lieu thereof, unit loads shall be marked as follows:

- A. GROSS WEIGHT AND CUBE 1/
- B. NUMBER OF SHIPPING CONTAINERS PER LOAD (E.G., 48 CS).

Marking may be accomplished by stenciling, printing or by pressure sensitive labels and shall be positioned on two adjacent sides of the load cap flange. Size of lettering shall be not less than 1/2 inch and shall be black. Markings shall be legible, non-fading and durable.

1/ Gross weight and cube shall include the weight and dimensions of the pallet base. The gross weight and cube may be determined by weighing and measuring 5 or more fully unitized loads (or weighing components separately) for determining the average weight and cube for unit load.

In addition to the above marking requirements, each unit load shall be provided with a Material Safety Data Sheet (MSDS) in accordance with MIL-R-44398. The MSDS shall be placed inside a clear plastic sleeve and securely attached to one side of the unit load with tape or pressure sensitive adhesive. A copy of the MSDS must be included with the shipping papers and a copy must also be placed in the vehicle manifest.

**UNITIZATION:**

Shipping cases shall be palletized in accordance with Type I, Class B, requirements of DSCP FORM 3507. Unit load height shall not exceed 43 inches. 1 2/ 3/

- 1/ Type IV, V, and/or VIII pallets as specified in FS NN-P-71 are authorized for use.
- 2/ Three (3) stringer construction is acceptable regardless of pallet type.
- 3/ Upper edges of bottom deck boards do not require chamfering regardless of pallet type.

**Wooden Pallets:**

All wooden pallets and wood containers produced entirely or in part of non-manufactured softwood (coniferous) species shall be constructed from Heat Treated (HT to 56 degrees Centigrade for 30 minutes) material and certified accordingly by an accredited agency recognized by the American Lumber Standards Committee (ALSC) in accordance with Non-manufactured Wood Packing Policy and Non-manufactured Wood Enforcement Regulations All wooden pallets, and containers, produced entirely of non-manufactured hardwood species only need be identified by a permanent mark of "NC" (non-coniferous), 1.25 inches or greater in height, accompanied by the CAGE code of the contracted manufacturer and the month and year of the contract or month and year material is marked. On pallets, the marking shall be applied to the stringer or block on opposite sides and ends of the pallet and be contrasting and clearly visible. On containers, the marking shall be applied on a side other than the top or bottom, contrasting and clearly visible.

NOTE: Pallet suppliers who are in need of a Commercial and Government Entity (CAGE) code, in order to meet the above cited marking requirement, must submit the following information to the appropriate DSCP-H Contract Administrator through the Prime Contractor:

- (1) Complete Company (Pallet Manufacturer's) Name
- (2) Pallet manufacturer's Full Address
- (3) Pallet manufacturer's Point of Contact (POC)
- (4) Pallet manufacturer's phone number

DSCP-H will advise the Prime Contractor of the Pallet Manufacturer's assigned code.

**B. CFM COMPLEMENTARY COMPONENTS:**

(SEE SEPARATE PART FOR ENTREE/STARCH COMPONENT REQUIREMENTS)

In addition to individual component labeling requirements, all components shall be labeled in accordance with all applicable FDA and USDA requirements, including 'NUTRITION FACTS' labeling in accordance with the Nutrition Labeling And Education Act (NLEA).

When the unit packager/assembler is overwrapping commercially wrapped and labeled product that meets the requirements of the NLEA, it will only be necessary to apply product name and date of pack to the overwrapped pouch.

In lieu of the PACKING, MARKING, AND UNITIZATION REQUIREMENTS cited under individual components in this section, the following PACKING, MARKING, AND UNITIZATION REQUIREMENTS may be utilized for CFM components.

**PACKING:** It shall be the responsibility of the Assembly Contractor to ensure that CFM product shipped to a unit packager and/or to the assembly point is packed such as to assure product compliance with applicable end item requirements.

**MARKING:** Marking of CFM product shipping containers shipped to a unit packager and/or to the assembly point shall be in accordance with applicable Federal and/or State requirements, provided that a production lot number that indicates the production date of the contents is included. The lot number on the shipping container may be in the clear, a Julian date code, or such other code as must be explained in a letter to the Contracting Officer and to the applicable inspection personnel.

**UNITIZATION:** It shall be the responsibility of the Assembly Contractor to ensure that CFM product shipped to a unit packager and/or to the assembly point is unitized or otherwise shipped such as to assure product compliance with applicable end item requirements and to be in accordance with applicable Federal and/or State regulatory requirements.

#### ALTERNATIVE PACKING FOR SHIPMENT TO RATION ASSEMBLER

When the product processing plant and the ration assembler are located in close proximity to each other, and alternative method of conveyance that utilizes reusable containers or totes and is mutually suited to both plant operations, may be submitted to the contracting officer for determination of adequacy and approval for use. Proposals shall include a proposed system of labeling/marketing for maintenance of lot from processor to assembler.

#### **REFERENCE DOCUMENTS FOR ASSEMBLED MREs AND COMPLEMENTARY CFM COMPONENTS:**

##### **Section J:**

ACR-M-023A, Meal, Ready-to-Eat (MRE), Assembly Requirements, 15 April 2002.  
PACKAGING of Food in Flexible Pouches, MIL-PRF-44073F, 4 September 2001.  
Loads, Unit: Preparation of Semiperishable Subsistence Items, DSCP Form 3507, April 1, 2002.  
Marking Instructions for Shipping Cases, Sacks, and Palletized/Containerized Loads of Perishable and Semiperishable Subsistence. DSCP Form 3556, October 2001.  
DSCP Instruction, Procedures for Alternative Skip-Lot End Item Inspection Requirements for Government End-item Verification Inspections for Operational Rations, March 2001.  
Colors, Federal Standard 595B, 11 January 1994.  
Sanitation Requirements for Food Establishments. MIL-STD-3006, 20 August 2000.  
Sampling Procedures and Tables for Inspection by Attributes. ANSI/ASQC Z1.4, 1993.  
Standard Specification for Annealed Aluminum and Aluminum-Alloy for Flexible Barrier Applications. ASTM B 479-00, 2000.  
Standard Practice for Fabrication of Fiberboard Shipping Boxes. ASTM 0 5118-95-1995.  
Standard Practice for Methods of Closing, Sealing and Reinforcing Fiberboard Shipping Containers. ASTM D 1974-98, 1998.  
Standard Specification for Polyethylene Film and Sheeting. ASTM 0 2103-97- 1997.  
Standard Test Method for Seal Strength of Flexible Barrier Materials. ASTM F 88-00, 2000.  
Official Methods of Analysis of AOAC International. 16<sup>th</sup> edition, March 1998; 4<sup>th</sup> revision volumes I & II.  
U.S. Food Chemicals Codex. 4<sup>th</sup> edition, 1996. Committee on Specifications, National Academy Press.  
Individual Product Performance-based contract requirements (PCRs)

**CFM COMPLEMENTARY COMPONENTS:**

- Fruits, Applesauce, Natural**
- Fruits, Applesauce, Raspberry**
- Fruits, Applesauce, Carbohydrate Enhanced**

**SECTION C:**

C-1 DESCRIPTION/SPECIFICATION:

8915-00-149-1074

Applesauce, natural color and flavor, sweetened, regular (comminuted) style, U.S. Grade A, 4.5 oz, flexibly packaged, Type I.

8915-01 -467-1490

Applesauce, with raspberry puree, sweetened, regular style, U.S. Grade A, 4.5 oz, flexibly packaged, Type VI.

8915-01-492-5548

Applesauce, carbohydrate enhanced, sweetened, regular style, U.S. Grade A for all factors except for Color, which shall be U.S. Grade B or better. 4.5 oz, flexibly packaged, Type VII.

C-2 PRIME DOCUMENT PCR-F-002A, 24 October 2001, Fruits, Wet Pack, Packaged in a Flexible Pouch, Shelf Stable.

C-3 DATE OF PACK: Acceptance will be limited to product processed and packed subsequent to date of award.

C-4 MISCELLANEOUS REQUIREMENTS: As above.

C-5 ADDITIONS, DELETIONS, AND/OR SUBSTITUTIONS:

THERE ARE NO CHANGES TO PCR-F-002A, FRUITS, WET PACK, PACKAGED IN A FLEXIBLE POUCH, October 24, 2001.

**SECTION D:**

PACKAGING/LABELING/PACKING/MARKING/UNITIZATION

D-1 PACKAGING: In accordance with D-1 PACKAGING of PCR-F-002A.

D-2 LABELING: In accordance with D-2 Labeling of PCR-F-002A.

D-3 PACKING: In accordance with D-3 Packing of PCR-F-002A.

D-4 MARKING: In accordance with D-4 Marking of PCR-F-002A.

D-5 UNITIZATION In accordance with ASTM D 3951-90 Clause 5.1.5

**Chocolate Chip Cookies, Regular, Plain, Crisp**

**Chocolate Mint Cookie with Chocolate Chips**

**Oatmeal Cookie**

**SECTION C:**

C-1 DESCRIPTION/SPECIFICATION:

8920-01-479-1847

Cookie, Chocolate Chip, Regular, Plain, Crisp, Type I, Style J, Flavor 1, Bake Type A, Class I, Package C.

8920-01 -493-4656

Cookie, Chocolate Mint with Chocolate Chips, Type I, Style J, Flavor 8, Bake Type A, Class 1 Package C.

8920-00-149-0794

Cookie, Oatmeal, Regular, Plain, Crisp, Type I, Style I, Flavor 1 Bake Type A, Class 1, Package C.

C-2 PRIME DOCUMENTS CID A-A-20295, COOKIES, AUGUST 13, 1998. Quality Assurance Provisions And PACKAGING Requirements For CID A-A-20295, Cookies, September 30, 1999.

C-3 DATE OF PACK: Acceptance will be limited to product processed and packed subsequent to date of award.

C-4 MISCELLANEOUS REQUIREMENTS: As above.

C-5 ADDITIONS, DELETIONS, AND/OR SUBSTITUTIONS:

THE FOLLOWING ARE CHANGES TO CID A-A-20295, COOKIES:

Page 3, Style J - Chocolate chip cookies (regular, chunk, or mini chips)  
After Flavor 7, delete "Other" and insert "Peanut butter with chocolate chips"  
Add "Flavor 8 - Chocolate mint with chocolate chips"  
Add "Flavor 9 - Other"

Page 5, Paragraph 3.3.11 - At the end of the paragraph add the following - "Flavor 7 - Peanut butter cookie with chocolate chips shall have a distinct peanut flavor. Flavor 8 - Chocolate mint cookies with chocolate chips shall have a dark chocolate brown color and distinct chocolate mint flavor."

Page 5, Paragraph 3.6.1, line 6 - after "4.0 percent" add "except for Flavor 7 which shall not exceed 7.0 percent and Flavor 8 which shall not exceed 6.0 percent."

THE FOLLOWING ARE CHANGES TO THE QUALITY ASSURANCE PROVISIONS AND PACKAGING REQUIREMENTS FOR CID A-A-20295, COOKIES:

Paragraph D-1, A. (2), sentence #11, delete "5 1/2 inches wide" and insert "6 inches wide"

Table I, footnote 7/ after "7/" insert, "The initial examination shall be a visual examination of the closed package. Any suspected visual evidence of stress cracks in the aluminum foil (streaks, breaks, or other disruptions in the laminated film) shall be verified by the following physical examination."

Paragraph D-2, A, delete sentence and partial statement: "The information shall be located on the body of the pouch not closer than 1/16 inch to any seal. If a non-contact type printer is used,"

Section D-1, A, Delete and substitute;

A. PACKAGING. Commercially wrapped and labeled Type I, Style A, Shortbread Cookies, and Type I, Style I, Oatmeal Cookies shall be packed in a preformed or form-fill-seal barrier pouch as described below. The commercially wrapped and labeled packages of Type I, Style E, Sandwich Cookies, and Type I, Style J, Chocolate Chip Cookies and one oxygen scavenger packet shall be packed in a preformed or form-fill-seal barrier pouch as described below.

Section E, Table II, footnote 4/ Delete and substitute;

4/ Not applicable to Type I, Style A, Shortbread Cookies, and Type I, Style I, Oatmeal Cookies.

Paragraph D-2, A., (3), after ‘Net weight’ insert “2/”

In Section E, part E-6, C; delete subparagraph (1) entirely and insert:

“(1) Net weight examination. The net weight shall be verified with the label on the commercial package or barrier pouch, as applicable. Product not conforming to the net weight requirement in Section C shall be cause for rejection of the lot.”

Para D-1, A, delete paragraph in its entirety and substitute the following:

“PACKAGING. Type I, Style A, Shortbread Cookies or commercially wrapped and labeled Type I, Style A, Shortbread Cookies shall be packaged in a preformed or form-fill-seal barrier pouch as described below. Type I, Style I, Oatmeal Cookies or commercially wrapped and labeled Type I, Style I, Oatmeal Cookies shall be packaged in a preformed or form-fill-seal barrier pouch as described below. Type I, Style E, Sandwich Cookies and one oxygen scavenger packet or commercially wrapped and labeled Type I, Style E, Sandwich Cookies and one oxygen scavenger packet shall be packaged in a preformed or form-fill-seal barrier pouch as described below. Type I, Style J, Chocolate Chip Cookies and one oxygen scavenger packet or commercially wrapped and labeled Type I, Style J, Chocolate Chip Cookies and one oxygen scavenger packet shall be packaged in a preformed or form-till-seal barrier pouch as described below.”

**SECTION D:**

PACKAGING/LABELING/PACKING/MARKING/UNITIZATION

D-1 PACKAGING In accordance with D-1 PACKAGING of Quality Assurance Provisions and PACKAGING Requirements for CID A-A-20295.

D-2 LABELING In accordance with D-2 Labeling of Quality Assurance Provisions and PACKAGING Requirements for CID A-A-20295.

D-3 PACKING In accordance with D-3 Packing of Quality Assurance Provisions and PACKAGING Requirements for CID A-A-20295.

D-4 MARKING In accordance with D-4 Marking of Quality Assurance Provisions and PACKAGING Requirements for CID A-A-20295.

D-5 UNITIZATION In accordance with ASTM D 3951-90 Clause 5.1.5

**Fig Bar**

**SECTION C:**

C-1 DESCRIPTION/SPECIFICATION: 8920-01-265-1285, Fruit Bar, fig, 3.5 in. lg, 1.7 in. w, 0.7 in. thk, 2 (or 4) fruit bars per bag, 54.0 gm, flexibly packaged, CID A-A-20212, type, III, flavor F, Style a.

C-2 PRIME DOCUMENT: Commercial Item Description, (CID) A-A-20212, Fruit Bars, dated September 7, 1995

C-3 DATE OF PACK: Acceptance will be limited to product processed and packed subsequent to date of award.

C-4 MISCELLANEOUS REQUIREMENTS: As above.

C-5 ADDITIONS, DELETIONS, AND/OR SUBSTITUTIONS TO DOCUMENTS:

THE FOLLOWING CHANGE(S) APPLY TO: A-A-20212, Fruit Bars, Commercial Item Description (CID) USDA, Sept 1995:

Page 1, Paragraph 21;

First line, after “flavors” insert ‘styles,’

Third line, after “flavors” insert “styles”

Page 2, Paragraph 2.1 (continued);  
After “flavor G other” insert,  
“Style A- Bakery covering  
Style b - Cereal covering”

Page 2, paragraph 3.3, line 4, after “soggy”, delete sentence four entirely from “The type III.....27 grams.”

Page 2, paragraph 3.3, fourth sentence (last line), delete “type III” entirely.

Page 2, paragraph 3.3, line 6, after “18.0 percent.”, insert the following:  
“The Type III, flavor F, style a, fruit bar may be a single bar or multiple bars that have dimensions of approximately 0.7 inches (1.78 cm) thick and when laid together are approximately 2 ½ inches (6.35 cm) wide by 3<sup>3/16</sup> inches (8.07 cm) long.”

Page 3, paragraph 3.5.1, delete entirely and insert “3.5.1 Analytical Testing: The sample to be analyzed shall be a composite of eight filled and sealed flexible pouches which have been selected at random from the lot.”

Page 3, paragraph 3.5.2, line 1 between “the” and “sample”, insert “composited”.

Page 7, Paragraph 7.1, second line, after “flavor(s)”, insert. “style(s)”.

THE FOLLOWING CHANGE(S) APPLY TO: Quality Assurance Provisions and PACKAGING Requirements for CID A-A-20212 Fruit Bars, 17 September 1999

26 November 1999, Page 3, Sec D., D-1, A. (2) b., make the following changes:

Line 4, delete sentence 3 “Two or more ... of the pouch.”

Insert” When specified, one or more multiple type III, flavor F, style a, fruit bars shall be placed side-by side, not stacked, into the tray shaped body of the pouch.”

Line 8, after “used.” And before “Pouch closure”, insert the following sentence: “When specified, one commercially packaged, type I, flavor A, B, C, D, or E, style b fruit bar shall be placed in the tray shaped body of the pouch.”

Line 9, delete “parameter”, insert “perimeter”

Line 9, delete “The outside dimensions..., each dimensions).”, insert “The outside dimensions of the pouch shall be not greater than 5-3/8 inches wide by 5-3/8 inches long.”

Line 11-12, delete “4-1/2 inches”, insert “not greater than 4-5/8 inches wide”; delete “(± 1/8 inch in each dimension)”

Line 13, delete “3/8 inch (plus 3/16 inch, minus 1/8 inch)”, insert “a minimum of 1/8 inch.”

Page 5, Sec E., E-5, A., (3) Table I, delete footnote 8/ insert new footnote 8/:

“8/ The initial examination shall be a visual examination of the closed package. Any suspected visual evidence of stress cracks in the aluminum foil (streaks, breaks or other disruptions in the laminated film) shall be verified by the following physical examination. To examine for stress cracks, the inside surface of both tray-shaped bodies shall be placed over a light source and the outside surface observed for the passage of light. Observation of light through the pouch material in the form of a curved or straight line greater than 2 mm in length shall be evidence of the presence of stress cracks in the aluminum foil. Observation of light through the pouch material in the form of a curved or straight line 2 mm in length or smaller or of a single pinpoint shall be

considered a pinhole. Observation of ten or more pinholes per pouch shall be evidence of material degradation.”

27 December 1999:

Page 1, Sec C, C-1, Package, line 1, delete “Ration”, insert “Meat”; delete (RCW) insert “(MCW)”

Page 1, Sec C, C-2, A. (1), line 2, after “calories.”, insert, for Package c (MRE) and 270 calories for Package a (MCW) and Package b (LRP).”

Page 2, Sec D, D-1, A. make the following changes:

- (1) line 4, delete “fruit bar”; after “one”, insert “or multiple fruits bars”
- (2) line 6, after “grams”, insert “for Package c (MRE) and 74 grams for Package a (MCW) and Package b (LRP).”

Page 2, Sec D, D-1, A,(1) b., make the following changes:

- (1) line 2, delete “4”, insert “5”
- (2) line 3, delete “heating”, insert “heat”

Page 2, Sec D, D-1, A,(1) c., make the following changes:

- (1) line 7, after “one”, insert “or multiple”
- (2) line 8, after “grams”, insert “or 74 grams”

Page 3, Sec D. D-1, A. (2) b., line 15, sentence 7, delete “The outside dimensions ... 5-3/8 inches long.”, insert “The outside dimensions of the pouch shall be not greater than 6 inches wide by 8-5/8 inches long.”

18 April 2000, Page 2, Section D-1, A.,(1). a., line 9, delete “Ration, CCID Weather (RCW)” and insert “Meat, CCID Weather (MCW)”

7 November 2000, Page 1, In section C-2, paragraph A (Calorie content), statement (1), line 2:

Delete “270” and insert “260”.

28 November 2000, In Section E, part E-6, B, Table I: delete minor defect 203 entirely.

In Section E, part E-6, 0; delete subparagraph (1) entirely and insert:

“(1) Net weight examination. The net weight shall be verified with the label on the commercial package or barrier pouch, as applicable. Product not conforming to the net weight requirement in Section D shall be cause for rejection of the lot.”

## **SECTION D:**

### **PACKAGING/PACKING/LABELING/UNITIZATION/MARKING**

**PACKAGING.** In accordance with PACKAGING [D-1] of the Quality Assurance Provisions and PACKAGING Requirements for CID A-A-20212 Fruit Bars.

**PACKING.** In accordance with PACKING [D-3] of the Quality Assurance Provisions and PACKAGING Requirements for CID A-A-20212 Fruit Bars.

**LABELING.** In accordance with LABELING [D-2] of the Quality Assurance Provisions and PACKAGING Requirements for CID A-A-20212 Fruit Bars.

When the unit Packager/Assembler is overwrapping commercially wrapped and labeled product that meets the requirements of the Acquisition Document, it will only be necessary to apply product name and Date of Pack to this overwrapped pouch in accordance with the requirements of the Acquisition Document(s) and the Technical Data for the ration being assembled.

UNITIZATION. Shipping cases will be palletized and prepared in unit loads in accordance with Type III, Class C, requirements of DSCP Form 3507 (figure 5), except that fiberboard/polyethylene base pads and fiberboard top pads are required. In addition, the unit load height shall be no greater than 54 inches.

MARKING. In accordance with MARKING [D-4] of the Quality Assurance Provisions and PACKAGING Requirements for CID A-A-20212 Fruit Bars.

**Cookie(s) with Pan Coated Chocolate Disks**

**SECTION C:**

C-1 DESCRIPTION/SPECIFICATION.

8920-01-493-4545

Cookie (s), with Pan Coated Chocolate Disks, flexible pouch, 60 grams.

C-2 PRIME DOCUMENT: PCR-C-031 COOKIE(S), WITH PAN COATED CHOCOLATE DISKS, PACKAGED IN A FLEXIBLE POUCH, SEPTEMBER 30, 1999

C-3 DATE OF PACK: Acceptance will be limited to product processed and packed subsequent to date of award.

C-4 MISC REQUIREMENTS: As above.

C-5 ADDITIONS DELETIONS, AND/OR SUBSTITUTIONS:

THE FOLLOWING ARE CHANGES 10 PCR-C-031, COOKIE (5), WITH PAN COATED CHOCOLATE DISKS, PACKAGED IN A FLEXIBLE POUCH, SEPTEMBER 30, 1999.

Section C-2, make the following changes:

(1) Subpart C., (2). line 1, delete “and shall show no signs of excessive heating materially darkened or scorched)”

(2) delete “I.” insert “H.”

(3) add new subparagraph:

“I. Oxygen content. The oxygen content of the filled and sealed pouch shall not exceed 0.30 percent.”

Section D-1 A., line 2, after “grams”, “insert and one oxygen scavenger packet”

Section D-1, A. (1) c, make the following changes:

(1) line 1, after “disks”, insert “and one oxygen scavenger packet”

(2) (2) line 3, delete “22”, insert “8 to 12”

Section D-1, A. (2). b. make the following changes:

(1) line 4, after disks”, insert “and one oxygen scavenger packet”

(2) (2) line 5, delete “22”. insert “8 to 12”

Section D-1, A., insert new subpart:

“(3) Oxygen scavenger packet. The oxygen scavenger (absorber) shall be constructed of materials that are safe for direct or indirect food contact and shall be suitable for use with edible products. The oxygen scavenger (absorber) shall be in compliance with all applicable FDA and USDA regulations.”

Section E-5. A. (3). Table I, make the following changes:

(1) delete entirely “Defect 109 Evidence of loss of vacuum. 8/”

(2) footnote 7, delete entirely, insert new footnote 7:

“7/ The initial examination shall be a visual examination of the closed package. Any suspected visual evidence of stress cracks in the aluminum foil (streaks, breaks, or other disruptions in the laminated film) shall be verified by the following physical examination. To examine for stress cracks, the inside surface of both tray-shaped bodies shall be placed over a light source and the outside surface observed for the passage of light. Observation of light through the pouch material in the form of a curved or straight line greater than 2 mm in length shall be evidence of the presence of stress cracks. Observation of light through the pouch material in the form of a curved or straight line 2mm in length or smaller or of a single pinpoint shall be considered a pinhole.

Observation of ten or more pinholes per pouch shall be evidence of material degradation.”

(3) delete footnote 8 entirely:

“8/ The filled and sealed pouches ... a major defect.”

Section E-6, B., Table II, delete Defect 101 “Evidence of excessive... scorched).”, insert new Defect 101:

“Pouch does not contain one intact oxygen scavenger packet.”

Section E-6, C., (1), make the following changes:

(1) line 1, delete “of the filled and sealed pouches”

(2) line 3, after “pouch”, insert “and an oxygen scavenger packet”

Section E-6, C., insert new subparagraph:

(5) Oxygen content testing. Eight filled and sealed pouches shall be randomly selected from each lot and individually tested for oxygen content in accordance with any USDA approved test method. Testing shall be accomplished after the filled and sealed pouches have been allowed to equilibrate at room temperature for not less than 48 hours from the time of sealing. Results shall be reported to the nearest 0.01 percent. Any oxygen content test exceeding 0.30 shall be cause for rejection of the lot.”

#### **SECTION D:**

##### **PACKAGING/LABELING/PACKING/MARKING/UNITIZATION**

D-1 PACKAGING In accordance with D-1 PACKAGING of PCR-C-031.

D-2 LABELING In accordance with D-2 Labeling of PCR-C-031.

D-3 PACKING In accordance with D-3 Packing of PCR-C-031.

D-4 MARKING In accordance with D-4 Marking of PCR-C-031.

D-5 UNITIZATION In accordance with ASTM D 3951-90 Clause 5.1.5

#### **Vanilla Sugar Cream Wafer Cookie**

##### **SECTION C:**

**C-1 DESCRIPTION/SPECIFICATION:** 8920-01-493-4577 Cookie, Vanilla Sugar Cream Wafer, flexible pouch, 40 grams.

**C-2 PRIME DOCUMENT:** PCR-C-046, COOKIE, VANILLA SUGAR CREAM WAFER, PACKAGED IN A FLEXIBLE POUCH, SHELF STABLE, OCTOBER 24, 2001.

**C-3 DATE OF PACK:** Acceptance will be limited to product processed and packed subsequent to date of award.

**C-4 MISCELLANEOUS REQUIREMENTS:** As above.

C-5 ADDITIONS, DELETIONS, AND/OR SUBSTITUTIONS:

There are no changes to PCR-C-046, Cookie, Vanilla Sugar Cream Wafer, packaged in a flexible pouch, shelf stable, October 24, 2001.

SECTION D:

PACKAGING/LABELING/PACKING/MARKING/UNITIZATION

D-1 PACKAGING In accordance with D-1 PACKAGING of PCR-C-046.

D-2 LABELING In accordance with D-2 Labeling of PCR-C-046.

D-3 PACKING In accordance with D-3 Packing of PCR-C-046.

D-4 MARKING In accordance with D-4 Marking of PCR-C-046.

D-5 UNITIZATION In accordance with ASTM D 3951-90 Clause 5.1.5

**Beef Snacks, Cured**

**SECTION C:**

C-1 DESCRIPTION/SPECIFICATION: 8940-01-429-7067, Beef Snacks, Kippered Beef, Strips (Chopped and Formed), Smoked, .80 ounce, flexibly packaged, Type II, Style A, Flavor 1.

C-2 PRIME DOCUMENT CID A-A-20298, BEEF SNACKS, CURED, SEPTEMBER 30, 1998 and Quality Assurance Provisions and PACKAGING Requirements for CID A-A-20298, dated December 17, 1998.

C-3 DATE OF PACK: Acceptance will be limited to product processed and packed subsequent to date of award.

C-4 MISCELLANEOUS REQUIREMENTS. As above.

C-5 ADDITIONS, DELETIONS, AND/OR SUBSTITUTIONS

The following are changes to the Quality Assurance Provisions and PACKAGING Requirements for CID A-A-20298, Beef Snacks, Cured, December 17, 1998:

Para D-1, A-2, b., line 13, delete "3-5/8", insert "5-5/16".

**Add new page 4:**

Page 4 of 11  
April 5, 1999

D-2 LABELING

A. Pouches. Each pouch shall be clearly printed or stamped, in a manner that does not damage the pouch, with permanent black ink or any other contrasting color, which is free of carcinogenic elements or ingredients. The information shall be located on the body of the pouch not closer than 1/16 inch to any seal. If a non-contact type printer is used, the information may be located anywhere on the pouch (in one complete print), except the closure seal area. The label shall contain the following information:

- (1) Product name (1/8 to 7/16 inch block letters)
- (2) Date 1/
- (3) Net Weight 2/
- (4) Contractor's name and address

1/Date of pack shall be a four-digit code beginning with the final digit of the current year followed by the three digit Julian day code. For example, July 1, 1997 would be coded as 7182. The Julian day code shall represent the day the product was packaged into the pouch.

2/ Shall appear on the commercial package or the barrier pouch as applicable.

### D-3 PACKING

A. Packing for shipment to ration assembler. Not more than 40 pounds of pouched product shall be packed flat in layers in a fiberboard box constructed and closed in accordance with style RSC-L, class domestic, variety SW, grade 200 of ASTM D 5118, Standard Practice for Fabrication of Fiberboard Shipping Boxes. Each container shall be securely closed in accordance with ASTM D 1974, Standard Practice for Methods of Closing, Sealing, and Reinforcing Fiberboard Shipping Containers.

### D-4 MARKING

A. Shipping containers. Shipping containers shall be marked in accordance with DSCP Form 3556, Marking Instructions for Shipping Cases, Sacks, and Palletized/Containerized Loads of Perishable and Semiperishable Subsistence.

Footnote 7, before “To examine...”, insert new sentences:

“The initial examination shall be a visual examination of the closed package. Any suspected visual evidence of stress cracks in the aluminum foil (streaks, breaks, or other disruptions in the laminated film) shall be verified by the following physical examination.”

### **SECTION D:**

#### PACKAGING/LABELING/PACKING/MARKING/UNITIZATION

D-1 PACKAGING: In accordance with D-1 PACKAGING of Quality Assurance Provisions and PACKAGING Requirements for CID A-A-20298.

D-2 LABELING: In accordance with D-2 Labeling of Quality Assurance Provisions and PACKAGING Requirements for CID A-A-20298.

D-3 PACKING: In accordance with D-3 Packing of Quality Assurance Provisions and PACKAGING Requirements for CID A-A-20298.

D-4 MARKING: In accordance with D-4 Marking of Quality Assurance Provisions and PACKAGING Requirements for CID A-A-20298.

D-5 UNITIZATION In accordance with ASTM D 3951-90 Clause 5.1.5

### **Chocolate Sports Bar**

#### **SECTION C:**

C-1 DESCRIPTION/SPECIFICATION: 8920-01-450-8596, Sports Bar, Chocolate Chewy; w/crisp rice; max 4 ¼ in. long by 2 ¼ in. wide by ¾ in. thk; flexibly packaged, PCR-C-0004.

C-2 PRIME DOCUMENTS: PCR-C-0004, November 5, 1997 and Quality Assurance and PACKAGING Requirements for PCR-C-0004, November 5, 1997.

C-3 DATE OF PACK: Acceptance will be limited to product processed and packed subsequent to date of award.

C-4 MISCELLANEOUS REQUIREMENTS: As above.

#### C-5 ADDITIONS, DELETIONS, AND/OR SUBSTITUTIONS TO DOCUMENTS:

THE FOLLOWING CHANGE(S) APPLY TO: PCR-C-004 Chocolate Sports Bar, Packaged in a Flexible Pouch, November 5, 1997.

November 1997: Size changed as follows:

“F. Size. The Sports Bar dimensions shall be not be greater than 4-½ inches long, 2 inches wide, and ¾ inch thick.”

September 1998: Weight added as follows:  
“I. The net weight of the Sports Bar shall be not greater than 60 grams”

THE FOLLOWING CHANGE(S) APPLY TO: Quality Assurance and PACKAGING Requirements for PCR-C-0004, November 5, 1997:

September 1998, page 9 of 12: “ B. Product examination. The finished product shall be examined for compliance with the performance requirements specified in Section C of this Performance-based Contract Requirements utilizing the single sampling plans indicated in ANSI/ASQC Z1.4 - 1993. The lot size shall be expressed in pouches. The sample unit shall be the contents of one pouch. The inspection level shall be S-3 and the AQL, expressed in terms of defects per hundred units, shall be 1.5 for major defects and 6.5 for minor defects. Defects and defect classifications are listed in table II.”

December 1998, page 1 of 12: Pouch construction, line 12, provided on one outside edge or two opposite outside edges of the pouch”

April 2000, Section D-1,A., a., line 8, delete “Ration, Cold Weather (RCW)” and insert “Meal, Cold Weather (MCW)”.

May 2000, page 10 of 12: Table II. Product defects (added):

Weight

205 Net weight of individual pouch greater than 60 grams.

May 2000, page 10 of 12 (bottom of page), after “Kilocalories 1/” add:  
“(3) Net weight examination.

a. Commercially wrapped product in pouch. The net weight shall be verified with the label on the commercial package. Product not conforming to the net weight requirement shall be cause for rejection of the lot.

b. Without commercially wrapped product in pouch. The net weight of the filled and sealed pouches shall be determined by weighing each sample unit on a suitable scale tared with a representative empty pouch. Results shall be reported to the nearest 0.1 ounce.”

#### **SECTION D:**

##### PACKAGING/PACKING/LABELING/UNITIZATION/MARKING.

PACKAGING: Overwrapped in a trilaminate pouch in accordance with PACKAGING D-1 of the Quality Assurance Provisions and PACKAGING Requirements for PCR-C-0004.

PACKING: In accordance with Packing D-3 of the Quality Assurance Provisions and PACKAGING Requirements for PCR-C-0004.

LABELING: In accordance with Labeling D-2 of the Quality Assurance Provisions and PACKAGING Requirements for PCR-C-0004.

UNITIZATION: Unitization shall be in accordance with paragraph 5.1.5 of ASTM D 3951.

MARKING: In accordance with Marking D-4 of the Quality Assurance Provisions and PACKAGING Requirements for PCR-C-0004.

#### **Crackers, Plain and Vegetable**

##### SECTION C:

##### C-1 DESCRIPTION/SPECIFICATION:

8925-00-149-0795

Crackers, Plain, Approx. 4 in. square, partially scored but not separated, 2 crackers per bag, flexibly and vacuum packaged, Type I, Military Specification MIL-C-441 12D, September 20, 1993.

8920-01-450-1921

Crackers, Vegetable, Approx. 4 in. square, partially scored but not separated, 2 crackers per bag, flexibly and vacuum packaged, Type II, Military Specification MIL-C-441 12D, September 20, 1993.

C-2 PRIME DOCUMENT:

Crackers, for Meal, Ready-To-Eat, September 20, 1993.

C-3 DATE OF PACK: Acceptance will be limited to product processed and packed subsequent to date of award.

C-4 MISCELLANEOUS REQUIREMENTS: As above.

C-5 ADDITIONS, DELETIONS, AND/OR SUBSTITUTIONS TO DOCUMENTS

THE FOLLOWING CHANGES APPLY TO MIL-C-441 12D, SEPTEMBER 20, 1993.

PAGE 12 FOOTNOTE 6/ delete and substitute:

6/ The initial examination shall be a visual examination of the closed package. Any suspected visual evidence of stress cracks in the aluminum foil (streaks, breaks, or other disruptions in the laminated film) shall be verified by the following physical examination. To examine for stress cracks, the inside surface of both tray-shaped bodies shall be placed over a light source and the outside surface observed for the passage of light. Observation of light through the pouch material in the form of a curved or straight line greater than 2 mm in length shall be evidence of the presence of stress cracks. Observation of light through the pouch material in the form of a curved or straight-line 2mm in length or smaller or of a single pinpoint shall be considered a pinhole. Observation of ten or more pinholes per pouch shall be evidence of material degradation.”

Para 5.1.1.1, make the following change:

(1) line 17, after bag color’, insert “for MRE and LRP applications”.

(2) line 18, insert the following new sentence:

“For MCW the complete exterior surface of the pouch shall be colored white overall with a color in the range of 37778 through 37886 of FED-STD-595.”

SECTION D:

PACKAGING/PACKING/ LABELING/MARKING/UNITIZATION

D-1 PACKAGING: In accordance with Section 5 of MIL-C-44112D.

D-2 PACKING: In accordance with Section 5.2 of MIL-C-441120.

D-3 LABELING: In accordance with Section 5.3 of MIL-C-44112D.

D-4 MARKING: In accordance with Section 5.3 of MIL-C-44112D.

D-5 UNITIZATION: In accordance with ASTM D 3951-90 Clause 5.1.5

**Noodles, Chow Mein**

SECTION C:

C-1 DESCRIPTION/SPECIFICATION: 8920-01-349-4467,

Noodles, Chow Mein, 1 oz flexibly packaged, CID-A-A-20112B, June 6 2000.

C-2 PRIME DOCUMENTS

Noodles, Chow Mein. A-A-201 128, Commercial Item Description (CID). USDA, June 6, 2000 and PACKAGING and Quality Assurance Provisions dated 6 October 2000.

C-3 DATE OF PACK: Acceptance will be limited to product processed and packed subsequent to date of award.

C-4 MISCELLANEOUS REQUIREMENTS: As above

C-5 ADDITIONS, DELETIONS, AND/OR SUBSTITUTIONS:

THE FOLLOWING ARE CHANGES TO CID A-A-20112B, NOODLES, CHOW MEIN, JUNE 6, 2000.

Page 3, Paragraph 5.2.2 Samples, change the first sentence to read, "Eight randomly selected samples from each lot shall be individually analyzed for moisture, fat, and salt." Delete the second sentence in its entirety.

SECTION D:

PACKAGING/LABELING/PACKING/MARKING/UNITIZATION

D-1 PACKAGING: In accordance with D-1 PACKAGING of PKGQA 20112.

D-2 LABELING: In accordance with D-2 Labeling of PKGQA 20112.

D-3 PACKING: In accordance with D-3 Packing of PKGQA 20112.

D-4 MARKING: In accordance with D-4 Marking of PKGQA 20112.

D-5- UNITIZATION: In accordance with ASTM D 3951-90 Clause 5.1.5.

**Nuts, Peanuts, Dry Roasted, Salted**

SECTION C:

C-1 DESCRIPTION/SPECIFICATION:

8925-01-450-4234

Nuts, Peanuts, Dry Roasted, Salted, 1 oz flexibly packaged, Type V, Style A, CID-A-A-20164B, February 29, 1996.

C-2 PRIME DOCUMENTS:

Nuts, Shelled, Roasted, Commercial Item Description (CID) A-A-20164B, February 29, 1996, and PACKAGING and QA Provisions dated September 17, 1999.

C-3 DATE OF PACK: Acceptance will be limited to product processed and packed subsequent to date of award.

C-4 MISCELLANEOUS REQUIREMENTS: As above.

C-5 ADDITIONS, DELETIONS, AND/OR SUBSTITUTIONS TO DOCUMENTS:

THE FOLLOWING ARE CHANGES TO THE PACKAGING REQUIREMENTS AND QUALITY ASSURANCE PROVISIONS FOR CID A-A-20164B, NUTS, SHELLED, ROASTED, SEPTEMBER 17, 1999.

Page 3, Sec D., D-1, A. (2) b., line 7,

After "bag", insert "perimeter. The outside dimensions of the pouch shall not be"

Page 5, Sec E., E-5, a., (3) table I, delete footnote 8/ insert new footnote 8/:

"8/ The initial examination shall be a visual examination of the closed package. Any suspected visual evidence of stress cracks in the aluminum foil (streaks, breaks, or other disruptions in the laminated film) shall be verified by the following physical examination. To examine for stress cracks, the inside surface of both tray-shaped bodies shall be placed over a light source and the outside surface observed for the passage of light. Observation of light through the pouch material in the form of a curved or straight line greater than 2 mm in length shall be evidence of the presence of stress cracks in the aluminum foil. Observation of light through the pouch material in the form of a curved or straight-line 2mm in length or smaller or of a single pinpoint shall be considered a pinhole. Observation of one or more pinholes per pouch shall be evidence of material degradation."

SECTION D.

PACKAGING/LABELING/PACKING/MARKING/UNITIZATION

D-1 PACKAGING In accordance with D-1 PACKAGING of PACKAGING Requirements and Quality Assurance Provisions for CID A-A-20164B.

D-2 LABELING In accordance with D-2 Labeling of PACKAGING Requirements and Quality Assurance Provisions for CID A-A-20164B.

D-3 PACKING In accordance with D-3 Packing of PACKAGING Requirements and Quality Assurance Provisions for CID A-A-20164B.

D-4 UNITIZATION In accordance with ASTM D 3951-90 Clause 5.1.5

D-5 MARKING In accordance with D-5 Marking of PACKAGING Requirements and Quality Assurance Provisions for CID A-A-20164B.

**Nut Raisin Mix**

**SECTION C:**

C-1 DESCRIPTION/SPECIFICATION: 8940-01-458-7305, Nut Raisin Mix shelled nuts (62% to 67%, Virginia, or Spanish peanuts, 8% to 12% walnut pieces, 4% to 70% each of whole almonds and whole filberts) and 13% to 17% Raisins, mm 56.0 gm, flexibly packaged, PCR-N-002, Style C (for MEAL, READY-TO-EAT [MRE]).

C-2 Prime Document: PCR-N-002, NUT RAISIN MIX, September 1999

C-3 Date of Pack: Acceptance will be limited to product processed and packed from the latest season's crop.

C-4 MISCELLANEOUS REQUIREMENTS. As above.

C-5 ADDITIONS, DELETIONS, AND/OR SUBSTITUTIONS TO DOCUMENTS.

THE FOLLOWING CHANGE(S) APPLY TO: POR-N-002, NUT RAISIN MIX, September 1999.

15 November 1999, Add new para D-1A (2) (a-b) as follows:

“(2) Horizontal form-fill-seal pouches.

a. Pouch material. The horizontal form-fill-seal pouch shall consist of a formed tray-shaped body with a flat sheet, heat sealable cover or a tray-shaped body with a tray-shaped heat sealable cover. The tray-shaped body and the tray-shaped cover shall be fabricated from a 3-ply flexible laminate barrier material consisting of, from outside to inside, 0.0009 inch thick oriented polypropylene bonded to 0.0007 inch thick aluminum foil with 10 pounds per ream pigmented polyethylene or adhesive and bonding the opposite side of the aluminum foil to 0.003 inch thick ionomer or a blend of not less than 50 percent linear low density polyethylene and polyethylene. The linear low density polyethylene portion of the blend shall be the copolymer of ethylene and octene-1 having a melt index range of 0.8 to 1.2 g/10 minutes in accordance with ASTM D 1238, Flow Rates of Thermoplastics by Extrusion Plastimeter and a density range of 0.918 to 0.922 g/cc in accordance with ASTM D 1505, Density of Plastics by Density Gradient Technique. Alternatively, 0.0005-inch thick polyester may be used in place of the oriented polypropylene as the outer ply of the laminate. The flat sheet cover shall be made of the same 3-ply laminate as specified for the tray-shaped body except the aluminum foil thickness may be 0.00035 inch. All tolerances for thickness of pouch materials shall be plus or minus 20 percent. The color requirements of the exterior (oriented polypropylene or polyester side) of the laminate shall be as specified in D-1, A., (1), a. The material shall show no evidence of delamination, degradation, or foreign odor when heat-sealed or fabricated into pouches. The material shall be suitably formulated for food PACKAGING and shall not impart any odor or flavor to the product.

b. Pouch construction. The tray-shaped body and the tray-shaped cover shall be formed by drawing the flexible laminate material into an appropriately shaped cavity. The flat cover shall be in the form of a flat sheet of the barrier material taken from roll stock. The nut raisin mix shall be placed into the tray-shaped body of the pouch and shall be nitrogen flushed or provided with an oxygen scavenger packet to meet the requirements of paragraph C-2 J. The filled pouch body shall be hermetically sealed. Pouch closure shall be effected by heat-sealing together the cover and body along the entire pouch perimeter. The closure seal width shall be a minimum of 1/8 inch. The closure seal shall have an average seal strength of not less than 6 pounds per inch of width and no individual specimen shall have a seal strength of less than 5 pounds per inch of width when tested as specified in E-5,A,(4),b. Alternatively, the filled and sealed pouch shall exhibit no rupture or seal separation greater than 1/16 inch or seal separation that reduces the effective closure seal width to less than 1/16 inch when tested for internal pressure resistance as specified in E-5,A,(4).c. The maximum outside dimensions of the sealed pouch shall be 6 inches wide by 6 inches long. The closure seal width shall be a minimum of 1/8 inch.. A tear nick, a tear notch, or serrations shall be provided on one outside edge or two opposite outside edges of the pouch to facilitate easy opening of the filled and sealed pouch. The sealed pouch shall not show any evidence of material degradation, aluminum stress cracking, delamination or foreign odor. Heat seals shall be free of occluded matter. Seals shall be free of impression or design on the seal surface that would conceal or impair visual detection of seal defects.

(3) Oxygen scavenger packet. The oxygen scavenger (absorber) shall be constructed of materials that are safe for direct and indirect food contact, and shall be suitable for use with edible products. The oxygen scavenger (absorber) shall be in compliance with all applicable FDA and USDA regulations.”

Table I, delete Table I and footnotes in entirety and substitute new Table I as follows:

TABLE I. Filled and sealed pouch defects 1/

Category		Defect
<u>Major</u>	<u>Minor</u>	
101		Tear, hole, or open seal.
102		Seal width less than 1/16 inch. <u>2/</u>
103		Presence of delamination. <u>3/</u>
104		Unclean pouch. <u>4/</u>
105		Pouch has foreign odor.
106		Any impression or design on the heat seal surfaces which conceals or impairs visual detection o seal defects. <u>5/</u>
107		Not packed as specified.
108		Presence of stress cracks in the aluminum foil. <u>6/ 7/</u>
	201	Label smudges, is missing, incorrect, or illegible.
	202	Tear nick, notch, or serrations missing or does not facilitate easy opening.
	203	Seal width less than 1/ 8 inch, but greater than 1/16 inch.
	204	Presence of delamination. <u>3/</u>

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1/ Any evidence of rodent or insect infestation shall be cause for rejection of the lot.

2/ The effective closure seal is defined as any uncontaminated, fusion bonded, continuous path, minimum 1/16 inch wide, from side seal to side seal that produces a hermetically sealed pouch.

3/ Delamination defect classification:

Major - Delamination of the outer ply in the pouch seal area that can be propagated to expose aluminum foil at the food product edge of the pouch after manual flexing of the delaminated area. To flex, the delaminated area shall be held between the thumb and forefinger of each hand with both thumbs and forefingers touching each other. The delaminated area shall then be rapidly flexed 10 times by rotating both hands in alternating clockwise- counterclockwise directions. Care shall be exercised when flexing delaminated areas near the tear notches to avoid tearing the pouch material. After flexing, the separated outer ply shall be grasped between thumb and forefinger and gently lifted toward the food product edge of the seal or if the separated area is too small to be held between thumb and forefinger, a number two stylus shall be inserted into the delaminated area and a gentle lifting force applied against the outer ply. If separation of the outer ply can be made to extend to the product edge of the seal with no discernible resistance to the gentle lifting, the delamination shall be classified as a major defect. Additionally, spot delamination of the outer ply in the body of the pouch that is able to be propagated beyond its initial borders is also a major defect.

To determine if the laminated area is a defect, use the following procedure: Mark the outside edges of the delaminated area using a bCID permanent marking pen. Open the pouch and remove the contents. Cut the pouch transversely not closer than 1/4 inch (+1/16 inch) from the delaminated area. The pouch shall be flexed in the area in question using the procedure described above. Any propagation of the delaminated area, as evidenced by the delaminated area exceeding the limits of the outlined borders, shall be classified as a major defect.

Minor - Minor delamination of the outer ply in the pouch seal area is acceptable and shall not be classified as a minor defect unless it extends to within 1/16 inch of the food product edge of the seal. All other minor outer ply delamination in the pouch seal area or isolated spots of delamination in the body of the pouch that do not propagate when flexed as described above shall be classified as minor defects.

4/ Outer PACKAGING shall be free from foreign matter which is unwholesome, has the potential to cause pouch damage (for example, glass, metal filings) or generally detracts from the clean appearance of the pouch. The following examples shall not be classified as defects for unclean:

- a. Foreign matter which presents no health hazard or potential pouch damage and which can be readily removed by gently shaking the package or by gently brushing the pouch with a clean dry cloth.
- b. Dried product which affects less than 1/8 of the total surface area of one pouch face (localized and aggregate).
- c. Water spots.

5/ If doubt exists as to whether or not the sealing equipment leaves an impression or design on the closure seal surface that could conceal or impair visual detection of seal defects, samples shall be furnished to the Contracting Officer for a determination as to acceptability.

6/ Applicable to form-fill-seal pouches only.

7/ To examine for stress cracks, the inside surface of both tray-shaped bodies shall be placed over a light source and the outside surface observed for the passage of light. Observation of light through the pouch material in the form of a curved or straight line greater than 2 mm in length shall be evidence of the presence of stress cracks. Observation of light through the pouch material in the form of a curved or straight line 2 mm in length or smaller or of a single pinpoint shall be considered a pinhole. Observation of ten or more pinholes per pouch shall be evidence of material degradation.

14 December 1999, Paragraph D-1 A (2) b. line 16; Delete; “6 inches long”; Insert: “7-1/4 inches long”

17 February 2000;

(a) Paragraph C-2, I, Nutrient content; delete “(1) protein and (2) fat and (3) salt” requirements” and replace with:

“(1) Sodium content. The sodium content shall be not greater than 50 mg per 100 grams.”

(b) Paragraph E-6, B, Table II; the new provisions are as follows:

i. Under “Appearance” insert new major defect “105 Nut or raisin percentages not as specified 3/“

ii. Delete statement for footnote 3/ and insert “The percentage of nut and raisin components shall be determined using the following procedure: The total contents of twenty pouches shall be weighed and the individual ingredients of the composite shall be separated and weighed separately. The percentages of each component shall be determined and the results reported to the nearest 0.1 percent.”

(c) Paragraph E-6, C, Methods of inspection; (3) Nutrient content, the new provisions are as follows:

i. Line 3; delete “protein content... salt” and insert “sodium”.

ii. Lines 7-9; delete Protein, Fat and Salt tests and method numbers and insert “Sodium 985.35984.27”

iii. Line 10; delete “0.1 percent” and insert “1.0mg per 100 grams”.

15 May 2000;

a. Section D-1, A., line 1, after “preformed pouch”, insert “or form-fill-seal barrier pouch”

b. Section E-5, A.(1), line 13, insert “D-1, A. 2. (a)” to Requirement Paragraph citation for Aluminum Foil Thickness Requirement

1 June 2000;

E-6, B., TABLE II, Footnote 6, Line 2, Delete; “certificate of conformance”; Insert; “USDA Grade Certificate”.

#### SECTION D:

##### PACKAGING/PACKING/LABELING/UNITIZATION/MARKING

PACKAGING: In accordance with D-1 PACKAGING of PCR-N-002, NUT RAISIN MIX

PACKING: In accordance with D-3 PACKING of PCR-N-002, NUT RAISIN MIX

LABELING: In accordance with D-2 LABELING of PCR-N-002, NUT RAISIN MIX

UNITIZATION: Shipping cases will be palletized and prepared in unit loads in accordance with Type III, Class 0, requirements of DSCP Form 3507 (figure 5), except that fiberboard/polyethylene base pads and fiberboard top pads are required. In addition, the unit load height shall be no greater than 54 inches.

MARKING: In accordance with D-4 MARKING of PCR-N-002, NUT RAISIN MIX

**Snack Foods, Potato Sticks**

**Snack Foods, Pretzels**

**Snack Foods, Filled Pretzels, Cheddar or Nacho Cheese**

SECTION C:

C-1 DESCRIPTION/SPECIFICATION:

8940-0 1 -349-4468

Snack Food, Potato Sticks, 1 oz (28.35 gm), flexibly packaged, Type I, CID A-A-20195B, August 14, 1996.

8940-01-426-2494

Snack Food, Pretzels, Bavarian, 1 oz (28.35 gm), flexibly packaged, Type II, Style A, CID A-A-20195B, August 14, 1996.

8940-01-426-2496

Snack Food, Pretzels, Rods, 1 oz (28.35 gm), flexibly packaged, Type II, Style B, CID A-A-20195B, August 14, 1996.

8940-01 -426-2499

Snack Food, Pretzel, Sticks, 1 oz (28.35 gm), flexibly packaged, Type II, Style C, CID A-A-20195B, August 14, 1996.

8940-01 -426-2497

Snack Food, Pretzels, Twist, 1 oz (28.35 gm), flexibly packaged, Type II, Style D, CID A-A-20195B, August 14, 1996.

8940-01-426-2498

Snack Food, Pretzels, Nuggets, 1 oz (28.35 gm), flexibly packaged, Type II, Style E, CID A-A-20195B, August 14, 1996.

8940-01-479-1850

Snack Food, Cheese Filled, Cheddar and Nacho, 1.8 oz (51.03 gm), flexibly packaged, Type II, Style F, Flavors 1 and 2, CID A-A-20195B, August 14, 1996.

C-2 PRIME DOCUMENT:

Snack Foods, A-A-20195B, Commercial Item Description (CID), USDA, August 14, 1996.

C-3 DATE OF PACK: Acceptance will be limited to product processed and packed subsequent to date of award.

C-4 MISCELLANEOUS REQUIREMENTS: As above.

C-5 ADDITIONS, DELETIONS, AND/OR SUBSTITUTIONS TO DOCUMENTS:

THE FOLLOWING ARE CHANGES TO THE QUALITY ASSURANCE PROVISIONS AND PACKAGING REQUIREMENTS FOR CID A-A-20195B, SNACK FOODS, AUGUST 14, 1996.

Page 5, Sec E., E-5, A., (3) Table I, delete footnote 8/, insert new footnote 8/:

“8/ The initial examination shall be a visual examination of the closed package. Any suspected visual evidence of stress cracks in the aluminum foil (streaks, breaks, or other disruptions in the laminated film) shall be verified by the following physical examination. To examine for stress cracks, the inside surface of both tray-shaped bodies shall be placed over a light source and the outside surface observed for the passage of light. Observation of light through the pouch material in the form of a curved or straight line greater than 2 mm in length shall be evidence of the presence of stress cracks in the aluminum foil. Observation of light through the pouch material in the form of a curved or straight-line 2mm in length or smaller or of a single pinpoint shall be considered a pinhole. Observation of ten or more pinholes per pouch shall be evidence of material degradation.”

Section D, D-1, A. (1) b., line 2, delete “4”, insert “5”.

Section D, part D-1, A, subpara (1) b, line 2: delete “7” and insert “7 ¼”

Section D, part D-1: delete para A and insert:

A. Packaging. For type I and type II (styles A-E), one ounce (+1/2 ounce, -1/8 ounce) of product shall be packed in a preformed or form-fill-seal barrier pouch as described below. For type II (style F), flavors 1 and 2, 1.8 ounces of product and one oxygen scavenger packet shall be packed in a preformed or form-fill-seal barrier pouch as described below.’

Section D, part D-1, A. subpara (1) c, line 2: after “packet” insert”, if applicable”.

Section D, part D-1, A, subpara (2) b, line 6; after “packet” insert”, if applicable,”.

Section E, part E-6, para B, Table II, defect ~15; at end insert(applicable to type II, Style F only)”.

Section C-2, D. line 2. delete “3.0”, insert “5.0’

Section C, part C-2: delete para E and insert:

“E. Oxygen content. For type II (style F), flavors

SECTION D:

PACKAGING/LABELING/PACKING/MARKING/UNITIZATION

D-1 PACKAGING In accordance with D-1 Packaging of Quality Assurance Provisions and Packaging Requirements for CID A-A-20195B.

D-2 LABELING In accordance with 0-2 Labeling of Quality Assurance Provisions and Packaging Requirements for CID A-A-20195B.

D-3 PACKING In accordance with D-3 Packing of Quality Assurance Provisions and Packaging Requirements for CID A-A-20195B.

D-4 MARKING In accordance with D-4 Marking of Quality Assurance Provisions and Packaging Requirements for CID A-A-20195B

D-5 UNITIZATION In accordance with ASTM D 3951-90 Clause 5.1.5

**Coffee, Flavored, Instant Cappuccino, Powdered, Mocha or French Vanilla**

**SECTION C:**

C-1 DESCRIPTION/SPECIFICATION:

8955-01-484-9676, CAPPUCINO, INST, PDR. French vanilla, 1 oz (28.35gm) pg, 25 pgs/co, CID A-A-20336, type II, style A, flavor 1,

8955-01-484-9677, CAPPUCINO, INST, PDR, mocha, 1 oz (28.34 gm) pg, 25 pgs/co, CID A-A-20336, type II, style A, flavor 2.

C-2 Prime Documents: Commercial Item Description, Coffees, Flavored, Instant, A-A-20336, December 20, 2000 and Packaging Requirements and Quality Assurance Provisions for CID A-A-20336, Coffees, Flavored, Instant, November 15, 2000.

C-3 Date of Pack: Acceptance will be limited to product processed and packed subsequent to date of award.

C-4 MISCELLANEOUS REQUIREMENTS: As above.

C-5 ADDITIONS, DELETIONS, AND/OR SUBSTITUTIONS TO DOCUMENTS

THE FOLLOWING CHANGE(S) APPLY TO: Commercial Item Description. Coffees, Flavored, Instant. A-A-20336, December 2000.

No changes at this time.

THE FOLLOWING CHANGE(S) APPLY TO PACKAGING Requirements and Quality Assurance Provisions for CID A-A-20336, Coffees, Flavored, Instant.

No changes at this time.

**SECTION D:**

PACKAGING/PACKING/LABELING/UNITIZATION/MARKING:

**PACKAGING:** In accordance with PACKAGING [D-1] of the PACKAGING Requirements and Quality Assurance Provisions for CID A-A-20336, Coffees, Flavored, Instant.

**PACKING:** In accordance with PACKING [D-3] of the PACKAGING Requirements and Quality Assurance Provisions for CID A-A-20336, Coffees, Flavored, Instant.

**LABELING:** In accordance with LABELING [D-2] of the PACKAGING Requirements and Quality Assurance Provisions for CID A-A-20336, Coffees, Flavored, Instant.

**UNITIZATION:** In accordance with paragraph 5.1.5 of ASTM D 3951.

**MARKING:** In accordance with MARKING [D-4] of the PACKAGING Requirements and Quality Assurance Provisions for CID A-A-20336, Coffees, Flavored, Instant.

**Dairyshake Powder, Fortified with Calcium and Vitamin D, Vanilla, Chocolate or Strawberry**

**SECTION C:**

C-1 DESCRIPTION/SPECIFICATION: 8910-01-487-1640, DAIRYSHAKE PDR, VANILLA, fortified w/calcium and vitamin D, 100 gm, flexibly packaged, PCR-D-002, flavor 1 (for MEAL READY-TO-EAT).

8910-01-487-1644, DAIRYSHAKE PDR, CHOCOLATE, fortified w/calcium and vitamin D, 100 gm, flexibly packaged, PCR-D-002, flavor 2 (for MEAL READY-TO-EAT).

8910-01-487-1623, DAIRYSHAKE PDR, STRAWBERRY, fortified w/calcium and vitamin D, 100 gm, flexibly packaged, PCR-D-002, flavor 3 (for MEAL READY-TO-EAT).

C-2 Prime Document: PCR-D-002 Dairyshake Powder, Fortified with Calcium and Vitamin D, Packaged in a Flexible Pouch, Shelf-Stable, 21 November 2000

C-3 Date of Pack: Acceptance will be limited to product processed and packed subsequent to award.

C-4 MISCELLANEOUS REQUIREMENTS: As above.

C-5 ADDITIONS, DELETIONS, AND/OR SUBSTITUTIONS TO DOCUMENTS:

THE FOLLOWING CHANGE(S) APPLY TO: PCR-D-002 Dairyshake Powder, Fortified with Calcium and Vitamin D, Packaged in a Flexible Pouch, Shelf-Stable, 21 November 2000.

29 November 2001

- a. Section C-2, C., insert the following new requirement:  
“(4) Instant nonfat dry milk. The dairy shake formula shall contain not less than 35 percent U.S. Extra Grade instant nonfat dry milk”
- b. Section C-2, H., (5) Calcium content, line 2, delete  
“500”, insert “650”
- c. Section E-5, Table I, make the following changes:
  - (1) In the table header, insert “4/”
  - (2) At the end of table, insert new footnote:  
“4/ Percentage of instant nonfat dry milk shall be verified by producer’s formulation. The Grade of instant nonfat dry milk shall be certified by a USDA Grade Certificate.”

#### **SECTION D:**

##### PACKAGING/PACKING/LABELING/UNITIZATION/MARKING

PACKAGING In accordance with PACKAGING [D-1] of PCR-D-002 Dairyshake Powder, Fortified with Calcium and Vitamin D, Packaged in a Flexible Pouch, Shelf Stable

PACKING: In accordance with PACKING [D-3] of PCR-D-002 Dairyshake Powder, Fortified with Calcium and Vitamin D, Packaged in a Flexible Pouch, Shelf Stable

LABELING: In accordance with LABELING [D-2] of PCR-D-002 Dairyshake Powder, Fortified with Calcium and Vitamin D, Packaged in a Flexible Pouch, Shelf Stable

When the Packager/Assembler is overwrapping commercially wrapped and labeled product that meets the requirements of the Acquisition Document, it will only be necessary to apply product name and date of pack to this overwrapped pouch in accordance with the requirements of the Acquisition Document(s) and the technical data for the ration being assembled.

UNITIZATION: In accordance with paragraph 5.1.5 of ASTM D 3951.

MARKING: In accordance with MARKING [D-4] of PCR-D-002 Dairyshake Powder, Fortified with Calcium and Vitamin D, Packaged in a Flexible Pouch, Shelf Stable.

#### **Barbecue Sauce**

##### **SECTION C:**

C-1 DESCRIPTION/SPECIFICATION: 8950-01-487-1628, BARBACUE SAUCE, plain, w/o added fruit purees, 1 oz pg, CID A-A-20335, flavor 1 type B (for Meal, Ready-To-Eat).

C-2 PRIME DOCUMENTS: Commercial Item Description Barbecue Sauce, November 2000, USDA, and PACKAGING Requirements and Quality Assurance Provisions for CID A-A-20335 Barbecue Sauce. (November 2000).

C-3 DATE OF PACK: Acceptance will be limited to product processed and packed subsequent to award.

C-4 MISCELLANEOUS REQUIREMENTS. As above.

##### C-5 ADDITIONS, DELETIONS, AND/OR SUBSTITUTIONS TO DOCUMENTS:

THE FOLLOWING CHANGE(S) APPLY TO: Commercial Item Description Barbecue Sauce, November 2000, USDA.

The technical requirements for Barbecue Sauce, CID A-A-20335 are changed as follows:

Page 2, paragraph 6.1.1 Soluble solids., lines 1-2 delete “30 0”,insert “47.0”; delete ”39.0”. insert “49.5”.

Page 3, paragraph 6.1 .3 Titratable acidity (as Acetic)., line 1, delete “1 .20” insert “1.70”.

THE FOLLOWING CHANGE(S) APPLY TO: PACKAGING Requirements and Quality Assurance Provisions for CID A-A-20335 Barbecue Sauce. (November 2000)

Sec C-2, B., delete entirely.

Sec C-2. F (2), delete entirely.

Sec C-2 F.(3), delete entirely.

Sec D., D-1, b., delete entirely, insert the following:

“b. Pouch construction. The pouch shall be a flat style preformed pouch having maximum inside dimensions of 2-9/16 inches wide by 5-5/16 inches long. The pouch shall be made by heat sealing three edges with 3/8 inch (-1/8 inch, +3/16 inch) wide seals. The heat seals shall be made in a manner that will assure hermetic seals. The side and bottom seals shall have an average seal strength of not less than 6 pounds per inch of width and no individual specimen shall have a seal strength of less than 5 pounds per inch of width when tested as specified in E-6, A.(4),a. Alternatively, the filled and sealed pouch shall exhibit no rupture or seal separation greater than 1/16 inch or seal separation that reduces the effective closure seal width to less than 1/16 inch when tested for internal pressure resistance as specified in E-6, A,(4),c. A tear nick or tear notch or serrations shall be provided on one outside edge or two opposite outside edges of the pouch to facilitate easy opening of the filled and sealed pouch. A 1/8 inch (+1/16 inch) wide lip may be incorporated at the open end of the pouch to facilitate opening and filling of the pouch.

Sec D., D-1, c., delete entirely, insert the following:

c. Pouch filling and sealing One ounce of barbeque sauce shall be filled into the pouch and the filled pouch shall be sealed. The filled pouch shall be sealed. The closure seal shall be free of foldover wrinkles or entrapped matter that reduces the effective closure seal width to less than 1/16 inch. Seals shall be free of impression or design on the seal surface that would conceal or impair visual detection of seal defects. The average seal strength shall be not less than 6 pounds per inch of width and no individual specimen shall have a seal strength of less than 5 pounds per inch of width when tested as specified in E-6,A,(4),b. Alternatively, the filled and sealed pouch shall exhibit no rupture or seal separation greater than 1/16 inch or seal separation that reduces the effective closure seal width to less than 1/16 inch when tested for internal pressure resistance as specified in E-6.A,(4),c.”

Sec E-5, B.(1), delete entirely.

Sec E-5. B (4), make the following changes:

Line 7, delete test for Soluble solids and method number 932.14.

Line 8, delete test for Acidity and method number 942.15.

Line 9. delete Soluble solids and

Line 10, delete Tests results for acidity...percent”.

Sec E-6, A (4), line 2, delete “a or b” insert “a, b, or c.”

Sec E-6, A (4), add the following new paragraph c.:

“c. Internal pressure test. The internal pressure resistance shall be determined by pressurizing the pouches while they are restrained between two rigid plates. The sample size shall be the number of pouches indicated by inspection level S-i. If a three seal tester (one that pressurizes the pouch through an open end) is used, the closure seal shall be cut off for testing the side and bottom seals of the pouch. For testing the closure seal, the bottom seal shall be cut off. The pouches shall be emptied prior to testing. If a four-seal tester (designed to pressurize filled pouches by use of a hypodermic needle through the pouch wall) is used, all four seals can be tested simultaneously. The distance between rigid restraining plates on the four-seal tester shall be equal to the thickness of the product +1/16 inch. Pressure shall be applied at the approximate uniform rate of

1 pound per square inch gage (psig) per second until 14 psig pressure is reached. The 14 psig pressure shall be held constant for 30 seconds and then released. The pouches shall then be examined for separation or yield of the heat seals. Any rupture of the pouch or evidence of seal separation greater than 1/16 inch in the pouch manufacturers seal shall be considered a test failure. Any seal separation that reduces the effective closure seal width to less than 1/16 inch (see table II, footnote 2/) shall be considered a test failure. Any test failure shall be cause for rejection of the lot.”

**SECTION D:**

**PACKAGING/PACKING/LABELING/UNITIZATION/MARKING:**

**PACKAGING:** In accordance with PACKAGING D-1 of the PACKAGING Requirements and Quality Assurance Provisions for CID A-A-20335 Barbecue Sauce.

**PACKING:** In accordance with Packing D-3 of the PACKAGING Requirements and Quality Assurance Provisions for CID A-A-20335 Barbecue Sauce.

**LABELING:** In accordance with Labeling D-2 of the PACKAGING Requirements and Quality Assurance Provisions for CID A-A-20335 Barbecue Sauce.

**UNITIZATION:** In accordance with paragraph 5.1.5 of ASTM D 3951.

**MARKING** In accordance with Marking D-4 of the PACKAGING Requirements and Quality Assurance Provisions for CID A-A-20335 Barbecue Sauce.

**Picante Sauce**

**SECTION C:**

**C-1 DESCRIPTION/SPECIFICATION:** 8950-01-487-1633, PICANTE SAUCE, medium, 1.5 oz pg, CID A-A-20259, type II (for MEAL, READY-TO-EAT).

**C-2 Prime Document:** Commercial Item Description, Picante Sauce, A-A-20259, July 1997. and PACKAGING Requirements and Quality Assurance Provisions for CID A-A-20259 Picante Sauce. (November 2000).

**C-3 Date of Pack:** Acceptance will be limited to product processed and packed subsequent to award. Additionally, all shipments of product from a producer to destination shall not be older than three months at time of shipment.

**C-4 MISCELLANEOUS REQUIREMENTS:** As above.

**C-5 ADDITIONS, DELETIONS, AND/OR SUBSTITUTIONS TO DOCUMENTS:**

**THE FOLLOWING CHANGE(S) APPLY TO:** Commercial Item Description, Picante Sauce, A-A-20259, July 1997 and PACKAGING Requirements and Quality Assurance Provisions for CID A-A-20259 Picante Sauce. (November 2000).

Soluble solids: not less than 9.5 percent and not more than 11.5 percent.

Acetic acid: not less than 0.90 percent and not more than 1.15 percent.

The following changes are provided to the PACKAGING Requirements and Quality Assurance Provisions dated 15 Nov 2000 for CID A-A-20259 Picante Sauce;

Sec C-2, B., delete entirely.

Sec C-2, 1(2), line 2. delete “10.5”, insert “11. 5”

Sec C-2 1. (3), line 2, delete “10.5”, insert “11.5”

Sec D., D-1, b., delete entirely, insert the following:

“b. Pouch construction. The pouch shall be a flat style preformed pouch having maximum inside dimensions of 2-9/16 inches wide by 5-5/16 inches long. The pouch shall be made by heat sealing three edges with 3/8 inch (-1/8 inch, +3/16 inch) wide seals, The heat seals shall be made in a manner that will assure hermetic seals. The side and bottom seals shall have an average seal strength of not less than 6 pounds per inch of width and no individual specimen shall have a seal strength of less than 5 pounds per inch of width when tested as specified in E-6,A,(4).a. Alternatively, the filled and sealed pouch shall exhibit no rupture or seal separation greater than 1/16 inch or seal separation that reduces the effective closure seal width to less than 1/16 inch when tested for internal pressure resistance as specified in E-6,A,(4),c. A tear nick or tear notch or serrations shall be provided on one outside edge or two opposite outside edges of the pouch to facilitate easy opening of the filled and sealed pouch. A 1/8 inch (+1/16 inch) wide lip may be incorporated at the open end of the pouch to facilitate opening and filling of the pouch.”

Sec D., D-1, c., delete entirely, insert the following:

“c. Pouch filling and sealing One and one-half ounces of picante sauce shall be filled into the pouch and the filled pouch shall be sealed. The filled pouch shall be sealed. The closure seal shall be free of foldover wrinkles or entrapped matter that reduces the effective closure seal width to less than 1/16 inch. Seals shall be free of impression or design on the seal surface that would conceal or impair visual detection of seal defects. The average seal strength shall be not less than 6 pounds per inch of width and no individual specimen shall have a seal strength of less than 5 pounds per inch of width when tested as specified in E-6A(4).b. Alternatively, the filled and sealed pouch shall exhibit no rupture or seal separation greater than 1/16 inch or seal separation that reduces the effective closure seal width to less than 1/16 inch when tested for internal pressure resistance as specified in E-6,A,(4),c.”

Sec E-5, B.(1), delete entirely.

Sec E-6, A (4), line 2, delete “a or b,” insert “a, b, or c,”

Sec E-6, A (4), add the following new paragraph c.:

c. Internal pressure test. The internal pressure resistance shall be determined by pressurizing the pouches while they are restrained between two rigid plates. The sample size shall be the number of pouches indicated by inspection level S-i. If a three seal tester (one that pressurizes the pouch through an open end) is used, the closure seal shall be cut off for testing the side and bottom seals of the pouch. For testing the closure seal, the bottom seal shall be cut off. The pouches shall be emptied prior to testing. If a four-seal tester (designed to pressurize filled pouches by use of a hypodermic needle through the pouch wall) is used, all four seals can be tested simultaneously. The distance between rigid restraining plates on the four-seal tester shall be equal to the thickness of the product +1/16 inch. Pressure shall be applied at the approximate uniform rate of 1 pound per square inch gage (psig) per second until 14 psig pressure is reached. The 14 psig pressure shall be held constant for 30 seconds and then released. The pouches shall then be examined for separation or yield of the heat seals. Any rupture of the pouch or evidence of seal separation greater than 1/16 inch in the pouch manufacturer’s seal shall be considered a test failure. Any seal separation that reduces the effective closure seal width to less than 1/16 inch (see table II, footnote 2/) shall be considered a test failure. Any test failure shall be cause for rejection of the lot.”

## **SECTION D:**

### **PACKAGING/PACKING/LABELING/UNITIZATION/MARKING**

**PACKAGING:** In accordance with PACKAGING [D-1] of the PACKAGING Requirements and Quality Assurance Provisions for CID A-A-20259 Picante sauce.

PACKING: In accordance with PACKING [D-3] of the PACKAGING Requirements and Quality Assurance Provisions for CID A-A-20259 Picante sauce

LABELING: In accordance with LABELING [D-2] of the PACKAGING Requirements and Quality Assurance Provisions for CID A-A-20259 Picante sauce

UNITIZATION: Unitization shall be in accordance with paragraph 5.1.5 of ASTM D 3951.

MARKING: In accordance with MARKING [D-41] of the PACKAGING Requirements and Quality Assurance Provisions for CID A-A-20259 Picante sauce.

### **Ration Supplement, Flameless Ration Heater (FRH)**

#### **SECTION C:**

C-1 DESCRIPTION/SPECIFICATION: 8970-01 -349-7049, Ration Supplement, Flameless Heater, for Meal, Ready-to-Eat, for Ration assembly only, MIL-R-44398

C-2 PRIME DOCUMENTS MIL-R-44398 Ration Supplement, Flameless Heater, for Meal, Ready-to-Eat, Military Specification MIL-R-44398b, 20 Sep 1993; PACKAGING Requirements & Quality Assurance Provisions for MIL-R-44398, Ration Supplement, Flameless Ration Heater for Assembly of Meal, Ready-to-Eat, Individual for Pre-positioned Stock, 14 November 2000; Drawing 6-1-8920 (heater bag label).

C-3 DATE OF PACK: Acceptance will be limited to product processed and packed subsequent to date of award.

#### C-4 MISCELLANEOUS REQUIREMENTS:

##### Health Hazard Assessment:

In accordance with paragraph 3.9 of MIL-R-44398. In addition, the manufacturer shall submit any reports of prior toxicity studies or use tests, conducted by private testing agencies, covering the toxicity of the formulation. Information so furnished will be regarded as Commercial Confidential” in accordance with 18 USC section 1905.

The government shall require a minimum of 45 days from receipt of the complete FRH pad formula information to complete the evaluation.

Failure to furnish the above information with the offer may result in the rejection of an otherwise acceptable offer.

The government reserves the right to prohibit the use of any Ration Heater not approved by USAHEA.

During the course of the contract, no change in the FRH manufacturer’s compound nor a change in manufacturing shall be permitted unless prior approval is given by the contracting officer. Any such request for approval shall be accompanied with an agreement in accordance with the provisions stated above.

Should the FRH manufacturer already be in possession of an approved health hazard assessment, and there have been no changes in the FRH compound formulation for which the approved assessment represents, the offeror may submit the agreement with the offer in lieu of the aforementioned agreement.

##### Manufacturing Plant Safety and Fire Protection:

In order to assure a safe, uninterrupted supply of the Flameless Ration Heater (FRH), adherence to the following National Fire Protection Association (NFPA) Standards is required in all FRH manufacturing plants.

NFPA 86 STANDARDS FOR OVENS AND FURNACES:

Chapter 1, Paragraph 1-6 Operator and maintenance personnel training.

Chapter 4, Paragraph 4-1 General

Paragraph 4-1.1 Excess temperature limit controller.

Chapter 9, (all) Inspection and maintenance.

Chapter 10, Paragraph 10-3.1 Extinguishers

Paragraph 10-3.3 Means of access

Paragraph 10-4 Maintenance of fire protection equipment

NFPA 480 STORAGE, HANDLING, AND PROCESSING OF MAGNESIUM SOLIDS AND POWDERS

Chapter 4, paragraph 4-6 Safety precautions

Chapter 5, paragraph 5-1 General precautions

Paragraph 5-2 Requirements for machinery

Paragraph 5-3 Start-up operations

Paragraph 5-4 Charging and discharging

Paragraph 5-5 Packing and storage

Chapter 6, paragraph 6-1 Containers

Chapter 7, paragraph 7-1 General

Paragraph 7-2 Cleaning frequency

Chapter 8, paragraph 8-8 Storage of magnesium powder

Subparagraphs 8.3, 8.4, 8.5, 8.7, 8.8

Chapter 9, paragraph 9-1.3 Extinguishing agents

Paragraph 9.1-4 Sprinkler restrictions

Paragraph 9-4 Emergency procedures

Paragraph 9-5 Fire fighting procedures

Paragraph 9-6 Employee instruction

Paragraph 9-7 Periodic inspection

Compliance with the above standards does not relieve the FRH manufacturer from complying with applicable federal, state, and local safety and fire protection requirements.

C-5 ADDITIONS, DELETIONS, AND/OR SUBSTITUTIONS TO DOCUMENTS

THE FOLLOWING CHANGE(S) APPLY TO Ration Supplement, Flameless Heater, for Meal, Ready-to-Eat, Military Specification MIL-R-44398b, 20 Sep 1993

Page 2, paragraph 2.2, (non-government publications) delete “ASTM D-775 drop test for loaded boxes” and substitute “ASTM D-5276 standard test method for drop test of loaded containers by free fall.”

Delete documents no longer referenced and add ASTM D 5118, ASTM D 4727 and ASTM D 1974 in para 2.2.

Page 4, paragraph 3.2.3, delete in entirety and substitute: ‘Protective Cover. The heater element shall be sealed within a protective cover constructed of a gas and water permeable, material. The color of the cover shall be either a natural tan color like unbleached Kraft paper or

shall be colored a light green approximating the color of the instruction label as specified in 3.6 or green in the range of 34127 through 34159 (excluding 34138) or 34226 through 34258 or 34583 of FED-STD-595. Alternatively, the protective cover may be a white color if provided in a heater bag that is printed or colored overall, on both sides of the bag with a color as specified in 3.6 to neutralize or mask the visual reflectivity of the white, non-woven, polyester material.

Page 4, Para. 3.2.3.1, line 1, delete “paperboard and substitute protective”;  
line 6, after “one side of the” delete remainder of sentence and substitute “protective cover.”

Page 5, paragraph 3.2.4, at end of paragraph insert, “alternatively, when the heater element is provided in white, polyester, protective cover, the polyethylene heater bag shall be printed or colored overall, on both sides with a color as specified in 3.2.3 to neutralize or mask the visual reflectivity of the white polyester material.”

Page 5, paragraph 3.3, line 1, delete first sentence and substitute, “the heater element shall consist of supercoroding Mg-Fe alloy powder and an electrolyte together with flow and wetting agents.”

Page 5, paragraph 3.4.1, delete entirely and substitute “the heater element materials shall be uniformly blended and fixed in a matrix that will assure conformity to the performance requirements. Heater pads shall not exceed maximum dimensions of 4-3/4 inches in length by 3-3/4 inches in width and ~16 inches in thickness when examined as specified in 4.4.3. Heater raw materials, excluding cover and bag shall not exceed 24 grams when examined as specified in 4.4.1.2.”

Page 5, paragraph 3.4.2, delete entirely and substitute “heater element protective covering. heater elements shall be contained in a protective cover as specified in 3.2.3. Covers shall be heat sealable or sealed with hot melt adhesive.”

Page 5, paragraph 3.4.3, line 1, delete “pad” and “paperboard”

Page 6, paragraph 3.6.1, insert new subparagraph “Alternate Label Design. Alternate label designs shall be furnished to the Contracting Officer for determination of suitability.”

Page 7, paragraph 4.3.1, line 4, delete “775” and substitute “5276”

Page 8, paragraph 4.4.1.2, delete in its entirety and substitute, “Heater Element Weight Examination. Heater elements shall be weighed without protective cover and heater bag. The lot size shall be expressed in units of heaters. The sample unit shall be one heater. The inspection level shall be S-2. Each heater element shall be weighed to the nearest 1 gram. Any sample unit failing to meet the weight limit specified in 3.4.1 shall be cause for rejection of the lot.”

Page 8, paragraph 4.4.2, line 1 after “the heaters”, delete “heater pad sealed”

Page 8, paragraph 4.4.2, table I:

Defect 101, delete “pad”

Defect 110, delete “paperboard” and substitute “protective”

Defect 111, delete in entirety

Page 9, table I, footnote 1/line 1, after “in which the”, delete “paperboard” and insert “protective”.  
line 2 after “contents or the”, delete “paperboard” and insert “protective”.

Page 10, paragraph 4.5.1 title and line 1, delete “pad” from title and line 1

Page 10, paragraph 4.5.2. line 1, delete “pad”

Page 11, paragraph 4.5.3, title and line 1 delete “pad” from title and line 1

Page 12, paragraph 5.1.1, line 2. delete “heater pads” and substitute “heaters”  
para 5.1.1, second sentence, delete” polyethylene bag conforming to type H, style 1 of PPP-B-26.” and substitute “bag fabricated from 0.003 inch polyethylene.” line 7 and 8, delete “as specified in PPP-B-26.”

Page 12, paragraph 5.2.1, lines 17-20. delete “the approximate inside dimensions...as a guide only.” para 5.2.1, line 3, delete “PPP-B-636” and substitute “ASTM D 5118’ line 12, 13, 14, delete the sentence in its entirety and substitute “The box liner and top and bottom pads shall be fabricated with grade V3c fiberboard in accordance ASTM D 4723.”

line 21, delete “method III. taped in accordance with method V” and substitute” method 2A2, sealed”

line 23, delete “PPP-B-636” and substitute “ASTM D 1974”

Page 12, paragraph 5.2.2, line 1, delete “not more than 384 heaters” and substitute “heaters”  
para 13, para 5.2.2 continued, line 8, delete “the appendix of PPP-B-636.” and substitute “ASTM D1974.

Page 13, paragraph 5.3, line 12-13, delete “pallet pattern shall ....MIL-STD-147.”  
para 5.3. delete and substitute: “5.3 Palletization. Shipping containers shall be arranged in unit loads on a 40 x 48 inch or 48 x 40 inch double-wing partial 4-way entry commercial wood pallet. A 40 x 48 inch commercial fiberboard pad shall be positioned on the pallet before loading. Each load shall be bonded with shrink or stretch film. When shrink or stretch film is used, it must be applied low enough on the pallet to bond the load to the pallet. When stretch wrap is used, the pallet load shall be weather protected by placing a short pallet bag or plastic shroud over the top of the load after the completion of the first (bottom to top) wrap. Unit load dimensions shall not exceed 43 inches in width, and 54 inches in height. Each palletized unit load shall be provided with a MSDS securely attached to adjacent sides inside a clear plastic sleeve with tape or by using a self-adhering clear photo sleeve. In addition to the MSDS, the shipping papers must accompany the shipment and a copy must be placed in the vehicle manifest.”

Page 14, paragraph 6.2. and insert new subparagraph:  
“e. When ordering for Pre-positioned Stock, reference the PACKAGING Requirements & Quality Assurance Provisions for MIL-R-44398, Ration Supplement, Flameless Ration Heater for Assembly of Meal, Ready-to-Eat, Individual for Pre-positioned Stock.”

Drawing 6-1-8920, heater bag label; delete the window of information stating “Special Instructions For Frozen MRE: ‘in its entirety and insert the following:  
“DO NOT THROW UNACTIVATED HEATERS IN THE TRASH! ONLY USED HEATERS MAY BE DISPOSED OF AS REGULAR TRASH. UNACTIVATED HEATERS MUST BE RECYCLED OR DISPOSED OF IN ACCORDANCE WITH ENVIRONMENTAL REGULATIONS. FOLLOW UNIT POLICY FOR COLLECTION AND DISPOSAL PROCEDURES.”

THE FOLLOWING CHANGE(S) APPLY TO: PACKAGING Requirements & Quality Assurance Provisions for MIL-R-44398, Ration Supplement, Flameless Ration Heater for Assembly of Meal, Ready-to-Eat, Individual for Pre-positioned Stock, 14 November 2000.

January 2001:

A. PACKAGING. The PACKAGING of the heaters and heater bags into the preformed pouches shall occur in the heater manufacturer's plant. Heaters and heater bags shall be packaged into the preformed pouches within 48 hours of production or shall be stored in a controlled environment (not to exceed 50 percent relative humidity) prior to PACKAGING into preformed bags

Page 2, footnote 1/,line 3, after "0103).", delete "The Julian...the pouch." and replace with" The Julian day code on the overwrap pouch shall reflect the date the heater/heater bag assembly was produced and assembled."

#### PACKAGING/PACKING/LABELING/UNITIZATION/MARKING

PACKAGING In accordance with paragraphs 3.2.3 and 3.2.4 of MIL-R-44398.

LABELING: In accordance with paragraph 3.6 of MIL-R-44398. In addition the heater bags shall be legibly marked with the production date of the enclosed heaters, expressed as a four digit Julian date with the first digit signifying the year and the next three digits signifying the day of the year. Ex: July 16, 1992 would be coded as 2198.

The 'Do Not Eat' Pictograph, (figure 1) prepared in accordance with drawing 13-1-184, shall be printed onto the protective cover in accordance with paragraph 3.2.3.1 of MIL-R-44398.

PACKING: In accordance with paragraph 5.2.2 of MIL-R-44398.

MARKING: In accordance with paragraph 5.4 of MIL-R-44398 and DSCP Form 3556. In addition, the following information shall be included:

"For Meal, Ready-to-Eat. Individual." The lot number printed on the heater bag shall be the identical marking used to identify the lot number on the shipping case.

The following regulatory markings are required on one side of each level "C" shipping case [manufacturer(s) to Ration Assembler(s)]:

"Dangerous When Wet" (capital letters NLT 3/8 inch high)

"Substances which in contact with water emit flammable gases, solid, N. O. S., UN 2813, PG. I (magnesium/iron/polyethylene mixture)". (capital letters NLT 3/8 high, lower case letters NLT 1/4 inch high)

"Water Activated" (capital letters NLT 1/4 inch high)

"Note:" (capital letters NLT 3/16 high)" In case of fire involving Magnesium, flood with large amounts of water with fog nozzle (not a solid stream)" (lower case letters NLT 1/4 inch high)

UNITIZATION: Shipping cases shall be palletized and prepared in unit loads in accordance with DSCP Form 3507 (figure 5), except that fiberboard/polyethylene base pads and fiberboard top pads are required. In addition, the unit load height shall be no greater than 54 inches.

#### COMMINGLING OF LOTS SHIPPED TO ASSEMBLERS:

1. In order to facilitate lot traceability at a ration assembler's plant, the following is required:
  - A. Origin manufacturers are required to ship only entire tots, equaling one day's production to one assembler. Production lots will not be separated on different delivery vehicles unless the quantity in the lot exceeds the capacity of the vehicle used.
  - B. Lots shall be shipped on a first produced (and accepted)-first out basis.
  - C. Each shipping case shall, normally, contain only one production lot. If a partial

shipping case remains at the end of the production day, dunnage shall be used to fill the remainder of the case and the outside of the case shall be marked indicating the number of Flameless Ration Heaters (FRHs) within. See paragraph 2 for exceptions.

- D. Each unit load shall, as a rule, contain only one production lot. However, when a partial unit load remains at the end of a production day, the manufacturer is permitted to complete the unit load with product from another lot, in this instance, a unit load may consist of two lots to facilitate shipment.
  - E. When two lots are incorporated on one pallet, the lots shall be distinctly separated by the use of paper or other material suitable for this purpose. Whenever this occurs, the manufacturer shall affix a unit load placard on two adjacent sides of the unit load, identifying each lot number on this unit load, identifying each lot number on the load and the quantities of FRHs within each lot.
2. In addition the above, the following requirements shall apply to the shipment of “mixed code lots”:
- A. A “mixed code lot” is defined as a lot consisting of small quantities of FRHs representing different lots. These FRHs usually accumulate as a result of DCMAO standby samples, manufacturing reference samples. or similar reasons.
  - B. Unit loads containing “mixed code lots” shall be identified by the use of unit load placards. These placards shall list all the lots and quantities of FRHs within each lot contained on the pallet. These placards shall also be affixed on two adjacent sides of the unit load. Lot numbers shall also be included on the corresponding shipping/receiving documentation, e. g. DD Form 250.
  - C. Mixed code lots shall be periodically shipped to the assembler(s). Mixed code lots shall be shipped only when an entire unit load of that single item is completed, or a on as quarterly basis, whichever occurs first. Mixed code lot shipments may be less than a full unit load.
  - D. When the quantity of FRHs from one production lot is less than needed to fill a normal shipping container, product from more than one production lot may be used to fill a case. However, product from one production lot may not be used to partially fill more than one case. When a shipping case contains product from more than one production lot, a placard will be placed on the outside of the case indicating the lot numbers and quantity for each lot.

#### SECTION J:

##### REFERENCE DOCUMENTS

Material Safety Data Sheets, Preparation and Submission of, Federal Standard 313D, April 3, 1996.

Colors, Federal Standard #. 595B, 11 January 1994

American National Standard for Calibration Systems. ANSI/ASQC M1, June 1987.

Quality Systems Model for Quality Assurance in Production, Installation, and Servicing.

NSI/ASQC 09002,1994

Loads, Unit: Preparation of Semiperishable Subsistence Items. DSCP Form 3507, December 1998.

Standard Specification for Corrugated and Solid Fiberboard Sheet Stock (Container Grade) and Cut Shapes. ASTM D 4727-98. 1998.

Standard Test Methods for Flammability of Treated Paper and Paperboard. ASTM D-777. 1997.

Method for Vibration Testing of Shipping Containers, ASTM D-999-96, 1996.

Sampling Procedures and Tables by Attributes. ANSI/ASQC Z1.4, 1993  
Palletized Unit Loads. MIL-HDBK-774, 25 March 1996.  
Standard Specification for Polyethylene Film and Sheeting. ASTM D 2 103-97, April 1997.  
Standard Specification for Annealed Aluminum and Aluminum-Alloy for Flexible Barrier, Food Contact, and Other Applications. ASTM B 479-00, 2000.  
Standard Test Method for Seal Strength of Flexible Barrier Materials. ASTM F-88-00, 2000.  
Standard Test Method for Drop test of Loaded Containers by Free Fall. ASTM D-5276-98, 1998.  
Standard Test Method for Surface Flammability of Material Using a Radiant Heat Energy Source, ASTM E-162-98, 1998.  
Standard Test Method for Specific Optical Density of Smoke Generated by Solid Materials, ASTM E-662-97, 1997.  
Storage, Handling and Processing of Magnesium Solids and Powders. National Fire Protection Association Standard 480.  
Standards for Ovens and Furnaces (1990). National Fire Protection Association Standard 86.

## **Hot Sauce**

### **SECTION C:**

C-1 DESCRIPTION/SPECIFICATION: 8950-01-101-9897 HOT SAUCE, 1/8 fluid oz. glass bottle, CID A-A-20097, Type II, (for Meal, Ready-To-Eat, Individual).

C-2 PRIME DOCUMENTS: Commercial Item Description A-A-20097C, HOT SAUCE, MAY 27, 1997.

C-3 DATE OF PACK Acceptance will be limited to product processed and packed subsequent to date of award

C-4 MISCELLANEOUS REQUIREMENTS: As above.

### C-5 ADDITIONS, DELETIONS, AND/OR SUBSTITUTIONS TO DOCUMENTS.

THE FOLLOWING CHANGE(S) APPLY TO: Commercial Item Description A-A-200970, Hot Sauce, May 27, 1997  
No changes at this time.

### **SECTION D.**

#### PACKAGING/PACKING/LABELING/UNITIZATION/MARKING

**PACKAGING**: For the Meal, Ready-to-Eat, 1/8 fluid ounce glass bottles shall be packed in accordance with paragraphs 5.1, 5.1.1, and 5.1.1.1 of ASTM D 3951. Screw caps shall be secured to the bottles with a band of plastic shrink film or plastic adhesive tape.

**LABELING**: In accordance with commercial labeling complying with the Federal Food, Drug and Cosmetic Act and regulations promulgated thereunder. In addition, each bottle shall be labeled with a production lot number that indicates the date of pack (i.e., the date the product was placed in the bottle). The lot number will be expressed as a Julian date code. The first digit will indicate the year of production; the next three digits will indicate the day of the calendar year. For example, an item produced on the second day of 1997 would be coded 7002. If desired, the producer may use additional numbers and letters to code other information such as shift or batch number,

**PACKING**: 300 to 500 1/8 fluid ounce glass bottles shall be packed into a shipping container fabricated in accordance with an appropriate Style, Type, Class, and Grade of ASTM 5118 – “Standard Practice for Fabrication of Fiberboard Shipping Boxes”. The fiberboard shipping box shall be fitted with inner PACKAGING to afford protection to the bottles in accordance with paragraph 5.1.4.2 of ASTM D 3951 — “Standard Practice for Commercial PACKAGING”. The shipping container shall be closed with an appropriate method as described in ASTM D 1974 – “Standard Practice for Methods of Closing, Sealing, and Reinforcing Fiberboard Shipping

Containers” This shipping container will be shipped at the lowest transportation rate for the product.

MARKING: Marking shall be in accordance with DSCP Form 3556, except shelf life data shall not apply. The following shall be included: “for Meal, Ready-to-Eat”. The lot number shall be the production lot number from the individual package as described above.

UNITIZATION: Unitization shall be in accordance with paragraph 5.1.5 of ASTM D 3951.

### **Red Pepper, Ground**

#### **SECTION C:**

C-1 DESCRIPTION/SPECIFICATION: 8950-01-487-1582, PEPPER, RED, GRD, 2gm foil laminate pg, CID A-A-20001 (for MEAL, READY-TO-EAT).

C-2 PRIME DOCUMENTS Spices, Ground and Whole, and Spice Blends. CID A-A-20001. January 28, 1988, PACKAGING Requirements and Quality Assurance provisions for CID A-A-20001, Species, Ground and Whole, and Spice Blends, November 2000.

C-3 DATE OF PACK Acceptance will be limited to product processed and packed no more than 10 months prior to date of delivery.

C-4 MISCELLANEOUS REQUIREMENTS As above.

#### C-5 ADDITIONS, DELETIONS AND/OR SUBSTITUTIONS TO DOCUMENTS:

THE FOLLOWING CHANGE(S) APPLY TO: Spices, Ground and Whole, and Spice Blends. CID A-A-20001, January 28, 1988

Page 10, paragraph A. Commercial PACKAGING, line 2: delete “glass or plastic bottle: and substitute: “glass bottle or polypropylene jar”; line5: delete “0.18 g” and substitute “0.15 g”.  
THE FOLLOWING CHANGES APPLY TO: PACKAGING Requirements and Quality Assurance provisions for CID A-A-20001, Species, Ground and Whole, and Spice Blends, November 2000.  
No changes at this time.

#### **SECTION D:**

##### PACKAGING/PACKING/LABELING/MARKING/UNITIZATION

PACKAGING: In accordance with PACKAGING [D-1] of the PACKAGING Requirements and Quality Assurance Provisions for CID A-A-20001, Spices, Ground and Whole, and Spice Blends.

PACKING: In accordance with PACKING [D-3] of the PACKAGING Requirements and Quality Assurance Provisions for CID A-A-20001: Spices, Ground and Whole, and Spice Blends.

LABELING: In accordance with LABELING [D-2] of the PACKAGING Requirements and Quality Assurance Provisions for CID A-A-20001, Spices, Ground and Whole, and Spice Blends.

When the unit packager/Assembler is overwrapping commercially wrapped and labeled product that meets the requirements of the Acquisition Document, it will only be necessary to apply product name and date of pack to this overwrapped pouch in accordance with the requirements of the Acquisition Document(s) and the Technical Data for the Ration being assembled.

MARKING: In accordance with MARKING [D-4] of the PACKAGING Requirements and Quality Assurance Provisions for CID A-A-20001, Spices, Ground and Whole, and Spice Blends.

UNITIZATION In accordance with paragraph 5.1.5 of ASTM D 3951.

### **Seasoning Blend, Salt Free**

#### **SECTION C:**

C-1 DESCRIPTION/SPECIFICATION: 8950-01-787-1626, SEASONING BLEND, SALT FREE, 0.6 gm foil laminate pg, CID A-A-20001 (for MEAL, READY-TO-EAT).

C-2 PRIME DOCUMENTS: Spices, Ground and Whole, and Spice Blends. CID A-A-20001, January 28, 1988, PACKAGING Requirements and Quality ASSURANCE provisions for CID A-A-20001, Species, Ground and Whole, and Spice Blends, November 2000.

C-3 DATE OF PACK: Acceptance will be limited to product processed and packed no more than 10 months prior to date of delivery.

C-4 MISCELLANEOUS REQUIREMENTS As above.

C-5 ADDITIONS, DELETIONS AND/OR SUBSTITUTIONS TO DOCUMENTS

THE FOLLOWING CHANGE(S) APPLY TO Spices, Ground and Whole, and Spice Blends. CID A-A-20001, January 28, 1988.

Page 10. paragraph A. Commercial PACKAGING, line 2: delete “glass or plastic bottle: and substitute: “glass bottle or polypropylene jar”: line 5: delete “0.18 g” and substitute “0.15 g”.

THE FOLLOWING CHANGES APPLY TO: PACKAGING Requirements and Quality Assurance provisions for CID A-A-20001, Species, Ground and Whole, and Spice Blends, November 2000. No changes at this time.

**SECTION D:**

PACKAGING/PACKING/LABELING/MARKING/UNITIZATION

PACKAGING: In accordance with PACKAGING [D-1] of the PACKAGING Requirements and Quality Assurance Provisions for CID A-A-20001, Spices, Ground and Whole, and Spice Blends.

PACKING: In accordance with PACKING [D-3] of the PACKAGING Requirements and Quality Assurance Provisions for CID A-A-20001 Spices, Ground and Whole, and Spice Blends.

LABELING: In accordance with LABELING [D-2] of the PACKAGING Requirements and Quality Assurance Provisions for CID A-A-20001, Spices, Ground and Whole, and Spice Blends.

When the unit packager/Assembler is overwrapping commercially wrapped and labeled product that meets the requirements of the Acquisition Document, it will only be necessary to apply product name and date of pack to this overwrapped pouch in accordance with the requirements of the Acquisition Document(s) and the Technical Data for the Ration being assembled

MARKING: In accordance with MARKING [D-4] of the PACKAGING Requirements and Quality Assurance Provisions for CID A-A-20001, Spices, Ground and Whole, and Spice Blends.

UNITIZATION: In accordance with paragraph 5.1.5 of ASTM D 3951.