

ACR-E-001
2 April 2007
W/Change 03 20 March 2008

SECTION C

C-1 ITEM DESCRIPTION

ACR-E-001, UNITIZED GROUP RATION – EXPRESS, ASSEMBLY REQUIREMENTS

The Unitized Group Ration – Express (UGR-E) provides a complete meal to 18 individuals. There are six lunch/dinner, two breakfast, and one holiday menus. Assembly of the UGR-E consists of one box. Within the box are a heating module, polymeric trays, beverages, food components, serving utensils, disposable meal trays, and other components.

C-2 ASSEMBLY REQUIREMENTS

A. Components.

(1) Menu components. The components required for menu assembly shall be as specified in Table I.

TABLE I. Menu Components

<u>Component</u>	<u>Reference</u>
<u>Entrees</u>	
Burgundy Beef Stew – poly tray	PCR-B-044
Chicken Breast in Gravy – poly tray	PCR-C-032
Chicken in a Szechwan Style Sauce – poly tray	PCR-C-065
Cream Gravy with Ground Beef – poly tray	PCR-C-040
Ham Slices in Brine – poly tray	PCR-H-009
Hash, Corned Beef – poly tray	PCR-H-005
Pasta with Ground Hot Italian Sausage – poly tray	PCR-P-041
Pork Ribs in Barbecue Sauce – poly tray	PCR-P-019
Pork Sausage Links in Brine – poly tray	PCR-P-015
Spaghetti with Meatballs in Sauce – poly tray	PCR-S-012
Turkey Slices in Gravy – poly tray	PCR-T-005

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TABLE I. Menu Components (cont'd)

Component	Reference
<u>Vegetables</u>	
Vegetables – poly tray	<u>PCR-V-007</u>
Carrots, Glazed	Type I
Corn, Mexican Style	Type II
Green Beans, Southern Style	Type III
Peas	Type IV
<u>Starches</u>	
Biscuits	<u>PCR-B-048</u>
Cornbread Stuffing with Sausage – poly tray	<u>PCR-C-056</u>
Macaroni and Cheese – poly tray	<u>PCR-M-012</u>
Mashed Potatoes with Brown Gravy – poly tray	<u>PCR-M-007</u>
Mashed Potatoes with Chicken Gravy – poly tray	<u>PCR-M-010</u>
Rice – poly tray	<u>PCR-R-004A</u>
Brown Rice	Type III
<u>Desserts and Snacks</u>	
Apple Dessert – poly tray	<u>PCR-A-003</u>
Cakes, Brownies and Mini Loaves – poly tray	<u>PCR-C-024A</u>
Devil's Fudge Cake with White Icing	Type I, Flavor 4
Walnut Tea Cake	Type I, Flavor 7
Dulce de Leche Cake with White Icing	Type I, Flavor 9
Breakfast Cake with Maple Flavored Syrup	Type 1, Flavor 10
Spice Cake with White Icing	Type I, Flavor 14
Lemon Cake with White Icing	Type I, Flavor 15
Candy and Chocolate Confections, Pan Coated Candy	<u>A-A-20177D</u> ,
Chocolate, Plain, Disks	Type VI, Shape A, Flavor 1
Peanut Butter, Plain	Type VI, Shape A, Flavor 5
Pan Coated Chocolate Covered Coffee Beans	Type VI, Shape B, Flavor 2
Licorice, Bite Size, Cherry	Type X, Shape B, Flavor 1
Cookies, Regular, Caramel Chocolate Chip, Multiple Serving Package, Soft and Chewy	<u>A-A-20295B</u> , Type I, Style J Flav 10, Bake type b, Class 2
FIRST STRIKE™ Bar, Cran-Raspberry, Regular	<u>PCR-F-001</u> , Flavor III; Style A

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TABLE I. Menu Components (cont'd)

Component	Reference
Fruits, Osmotically Dried, Cranberries, Fortified	A-A-20299A , Type VII, Fort. a
Nut and Fruit Mix, Nuts and Raisins with Pan Coated	PCR-N-003 , Type II
Chocolate Disks	
Ranger Bar, Caramel Apple	PCR-R-008 , Flavor II
Sweet Rolls, Packaged in a Polymeric Tray, Shelf Stable	PCR-S-007 , Style I
Raspberry Swirl	
<u>Beverages</u>	
Beverage Bases, Powdered, Nutritive Sweetener, With or Without Ascorbic Acid, Flat Interlocking Closure Pouch	A-A-20098D , Type II, Formul. a or b, Design B, Flavors 1 or 4
Orange or Lemon-Lime	
Coffee, Soluble, Freeze Dried, Regular, Lap or Fin Seal	A-A-20184B , Type III, Style A, Pack 2
Dairyshake Powder, Fortified with Calcium and Vitamin D, Chocolate or Strawberry, Flat Interlocking Closure Pouch	PCR-D-002 , Flavors II or III, Design B
Tea, Instant, Regular, Non-nutritive Sweetener, Lemon Lap or Fin Seal	A-A-20183B , Style C, Flavor 2 Design D
Juice, Fruit, Instant, Flat Interlocking Closure Pouch	PCR-J-002 Design B
Grape, Sweetened	Type I, Style A
Orange, Unsweetened	Type III, Style B
<u>Other Food Items</u>	
Cranberry Jelly	8930-01-553-3117
Creamer, Non-Dairy, Dry	A-A-20043B
Hot Sauce, 0.75 fl. oz.	8950-01-E10-0248
Natural Butter Flavor Granules, Spray-Dried	A-A-20351 , Type I, Style A, Package 1
Regular, Granules, 2 oz.	
Soy Sauce, Fermented, 5 oz. bottle	A-A-20087C , Type I
Spices and Spice Blends	A-A-20001A
Italian Seasoning	Type II, Class H I
Poultry Seasoning	Type II, Class C
Vegetable Seasoning	8950-01-546-4338

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TABLE I. Menu Components (cont'd)

Component	Reference
<u>Disposables</u>	
Box Cutter	8970-01-545-6830
Serving Spoon	8970-01-545-6826
Slotted Serving Spoon	8970-01-545-6828
Spatula	8970-01-545-6831
Bag, Plastic, Trash	8105-01-521-6616
Dining Packet	7360-01-509-3586
Gloves, Disposable, Foodservice, Multipurpose, Ambidextrous, Latex Free, Polyethylene, 1.25 mil Thick, Size Large	8415-01-541-5392
Hand Cleaner (Pre-moistened Towelette), Unscented, Water Based	A-A-461B , Type II
Tray, Mess, 3 Compartment Tray; Tan or Sand	A-A-52217B , Type II, Class 3
Heater Module, General Specification for Heater Module, Type I: Magnesium and Iron Heater, Assembly Required	MIL-DTL-32235 MIL-DTL-32235/1

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(2) Menu contents. The menu contents shall be as specified in Table II.

TABLE II. Menu Contents

STANDARD ITEMS		
Component	Servings	Quantity
Coffee	1 pouch	18 <u>1/</u>
Creamer	1 pouch	18 <u>1/</u>
Hot Sauce	0.75 fl. oz. bottle	1
Gloves	1 pair	1
Box Cutter	1 unit	1
Hand Cleaner (towelette)	1 pouch	36 <u>2/</u>
Trays, Mess	1	18 <u>1/</u>
Dining Packets	1	18 <u>1/</u>
Trash Bags	4 per package	1
Heater Module	1 module	1

1/ Either 1 bag of 18 or two bags of 9 are acceptable.

2/ Two bags of 18 each.

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UGR E LUNCH/DINNER MENU 1

Component	Servings	Quantity
Pasta with Sausage	9 per tray	2
Peas	18 per tray	1
Spice Cake	18 per tray	1
Italian Seasoning	0.75 oz. container	1
Butter Granules	2 oz. package	1
Nut Raisin Mix with Chocolate Disks	1 pouch	18
Dairyshake <u>1</u> /	1 pouch	18
Sugar Free Ice Tea	1 pouch	18
Serving Utensils	1 Spoon, 1 Slotted Spoon, 1 Spatula	

UGR E LUNCH/DINNER MENU 2

Component	Servings	Quantity
Chicken Breast in Gravy	18 per tray	1
Cornbread Stuffing	18 per tray	1
Corn	18 per tray	1
Devil's Fudge Cake	18 per tray	1
Butter Granules	2 oz. package	1
Cranberries	1 pouch	18
Beverage <u>1</u> /	1 pouch	18
Serving Utensils	2 Spoons, 1 Slotted Spoon, 1 Spatula	

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UGR E LUNCH/DINNER MENU 3

Component	Servings	Quantity
Burgundy Beef Stew	18 per tray	1
Green Beans	18 per tray	1
Mashed Potatoes with Brown Gravy	18 per tray	1
Walnut Tea Cake	18 per tray	1
Pan Coated Chocolate Disks	1 pouch	18
Vegetable Seasoning	0.75 oz. container	1
Dairyshake <u>1</u> /	1 pouch	18
Sugar Free Ice Tea	1 pouch	18
Serving Utensils	2 Spoons, 1 Slotted Spoon, 1 Spatula	

UGR E LUNCH/DINNER MENU 4

Component	Servings	Quantity
Barbecue Pork Ribs	18 per tray	1
Macaroni and Cheese	18 per tray	1
Corn	18 per tray	1
Dulce de Leche Cake	18 per tray	1
Pan Coated Peanut Butter Disks	1 per pouch	18
Butter Granules	2 oz. package	1
Dairyshake <u>1</u> /	1 pouch	18
Sugar Free Ice Tea	1 pouch	18
Serving Utensils	2 Spoons, 1 Slotted Spoon, 1 Spatula	

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UGR E LUNCH/DINNER MENU 5

Component	Servings	Quantity
Szechwan Chicken	18 per tray	1
Brown Rice	18 per tray	1
Carrots	18 per tray	1
Caramel Chocolate Chip Cookies	18 per tray	1
Chocolate Covered Coffee Beans	1 pouch	18
Butter Granules	2 oz. package	1
Soy Sauce	5 oz. bottle	1
Beverage <u>1</u> /	1 pouch	18
Serving Utensils	2 Spoons, 1 Slotted Spoon	

UGR E LUNCH/DINNER MENU 6

Component	Servings	Quantity
Spaghetti with Meatballs	9 per tray	2
Green Beans	18 per tray	1
Lemon Cake	18 per tray	1
Cherry Licorice	1 pouch	18
Italian Seasoning	0.75 oz. container	1
Vegetable Seasoning	0.75 oz. container	1
Dairyshake <u>1</u> /	1 pouch	18
Sugar Free Ice Tea	1 pouch	18
Serving Utensils	1 Spoon, 1 Slotted Spoon, 1 Spatula	

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UGR E BREAKFAST MENU 1

Component	Servings	Quantity
Creamed Ground Beef	18 per tray	1
Sliced Ham	18 per tray	1
Biscuit	18 per tray	1
Raspberry Swirls	18 per tray	1
Caramel Apple Bar	1 pouch	18
Dairyshake <u>1</u> /	1 pouch	18
Juice, Orange	1 pouch	18
Serving Utensils	1 Spoon, 1 Slotted Spoon, 2 Spatulas	

UGR E BREAKFAST MENU 2

Component	Servings	Quantity
Corned Beef Hash	18 per tray	1
Sausage	18 per tray	1
Breakfast Cake	18 per tray	1
Apple Dessert	18 per tray	1
FIRST STRIKE™ Bar, Cran-Raspberry	1 pouch	18
Dairyshake <u>1</u> /	1 pouch	18
Juice, Grape	1 pouch	18
Serving Utensils	2 Spoons, 1 Slotted Spoon, 1 Spatula	

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UGR E LUNCH/DINNER MENU - HOLIDAY

Component	Servings	Quantity
Turkey Slices in Gravy	18 per tray	1
Carrots	18 per tray	1
Mashed Potato with Chicken Gravy	18 per tray	1
Cornbread and Sausage Stuffing	18 per tray	1
Raisin Nut Mix with Chocolate Disks	1 pouch	18
Poultry Seasoning	0.75 oz. container	1
Cranberry Jelly	1 pouch	18
Beverage <u>1/</u>	1 pouch	18
Serving Utensils	3 Spoons, 1 Slotted Spoon	

1/ Flavors shall be procured in equal quantities and assembled in a uniform distribution.

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SECTION D

D-1 PACKAGING

A. Menu assembly. The components of each menu specified in Table II shall be packaged. The heater module shall be completely assembled, as described in the appropriate MIL-DTL-32235 specification sheet. Components may be prepackaged or sub-assembled.

B. Loading sequence. The heater module shall be loaded in the box. Then the other components shall be loaded into the box.

C. Unit packaging. Components shall be packaged in accordance with documents referenced in Table I.

D. Intermediate packaging. When applicable, components shall be intermediate packaged in accordance with Table I and Table II.

D-2 LABELING

A. Components. Components shall be labeled in accordance with documents referenced in Table I.

D-3 PACKING

A. Packing. Each complete menu, as cited in Table II, shall be assembled into a box. Each box shall be fabricated in accordance with style RSC, grade V3c or equivalent of ASTM D 5118/D 5118M, Standard Practice for Fabrication of Fiberboard Shipping. The maximum outside dimensions of the box shall be 20 by 16 by 10-1/4 inches, except breakfast menus which shall have maximum outside dimensions of 20 by 16 by 11-3/4 inches. Boxes shall be free from evidence of rodent or insect infestation. Boxes may be assembled by gluing or taping. Each container shall be closed and then sealed (H-taped) in accordance with methods B or C of ASTM D 1974, Standard Practice for Methods of Closing, Sealing, and Reinforcing Fiberboard Boxes.

Comment [CN1]: Natick case ES08-060, change 03, 20-Mar-08, to allow larger box for breakfast menus.

D-4 UNITIZATION

A. Unit loads. A unit load consists of 18 boxes. Six boxes fit on one tier of a 40 by 48-inch pallet. There are three tiers per pallet. Boxes shall be arranged in unit loads in accordance with Type I, Class A of DSCP FORM 3507, Loads, Unit: Preparation of Semiperishable Items.

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D-5 MARKING

A. Shipping containers and unit loads. Marking of shipping containers and unit loads shall be as specified in DSCP FORM 3556, Marking Instructions for Boxes, Sacks, and Unit Loads of Perishable and Semiperishable Subsistence. Item name, in letters not less than 1 inch, shall be as follows:

UGR – Express L/D (Lunch/Dinner) MENU NUMBER No. ___

or

UGR – Express B (Breakfast) MENU NUMBER No. ___

or

UGR – Express Holiday Menu

The shipping container shall also be marked with special marking:

FOR OUTDOOR USE ONLY

DO NOT ROUGH HANDLE WHEN FROZEN (0°F or below)

NOTE: This case contains WATER-ACTIVATED Flameless Heaters

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SECTION E INSPECTION AND ACCEPTANCE

The following quality assurance criteria, utilizing ANSI/ASQ Z1.4, Sampling Procedures and Tables for Inspection by Attributes, are required. Unless otherwise specified, single sampling plans indicated in ANSI/ASQ Z1.4 will be utilized. When required, the manufacturer shall provide the certificate(s) of conformance to the appropriate inspection activity. Certificate(s) of conformance not provided shall be cause for rejection of the lot.

A. Definitions.

(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.

B. Conformance inspection. Conformance inspection shall include the examinations/tests and the methods of inspection cited in this section.

C. Packaging examination.

(1) Assembled menus examination. The assembled menus shall be examined for the defects specified in Table III. The lot size shall be expressed in assembled menus. The sample unit shall be one fully assembled menu. The inspection level shall be S-2 and the Acceptable Quality Level (AQL), expressed in terms of defects per hundred units shall be 2.5 for major defects and 4.0 for minor defects. Five assembled menus shall be randomly selected from the lot and examined for critical defects. The finding of a critical defect shall be cause for rejection of the lot.

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TABLE III. UGR assembled menus defects 1/

Category			Defect
<u>Critical</u>	<u>Major</u>	<u>Minor</u>	
1			Any canned food product (including trays) leaking or damaged so as to expose contents.
	101		Bottled product leaking or damaged.
	102		Boxed product leaking or damaged.
	103		Pouched product leaking or damaged.
	104		Component not clean. <u>2/</u>
	105		Box not as specified.
	106		Markings not as specified.
	107		Box not closed as specified.
	108		Item missing.
	109		Heater module damaged.
		201	More than 5 percent of the quantity of any disposable (except heater module) is crushed or damaged so as to be unusable.
		202	Intermediate bag has tear or open seam.

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

2/ Outer packaging shall be free from foreign matter which is unwholesome, has the potential to cause package damage (i.e. glass, metal filings, etc.), or generally detracts for the clean appearance of the components package. The following examples shall not be scored as defects for unclean:

a. Foreign matter which presents no health hazard or potential package damage and which can be readily removed by gently shaking the package or by gently brushing the package with a clean cloth.

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b. Water spots.

c. Very thin grease, oil, or product residue that is discernible by touch, but is not readily discernible by visual examination.

(2) Unit load examination. The unit load shall be examined in accordance with the requirements of DSCP FORM 3507. Any nonconformance shall be classified as a major defect.

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SECTION J REFERENCE DOCUMENTS

MILITARY SPECIFICATIONS

MIL-DTL-32235 Heater Module, General Specification for

MIL-DTL-32235/1 Heater Module, Type I: Magnesium and Iron Heater, Assembly
Required

DSCP FORMS

DSCP FORM 3556 Marking Instructions for Boxes, Sacks, and Unit Loads of
Perishable and Semiperishable Subsistence

DSCP FORM 3507 Loads, Unit: Preparation of Semiperishable Items

NON-GOVERNMENTAL STANDARDS

AMERICAN SOCIETY FOR QUALITY CONTROL (ASQC)

ANSI/ASQ Z1.4-2003 – Sampling Procedures and Tables for Inspection by Attributes

AMERICAN SOCIETY FOR TESTING AND MATERIALS (ASTM)

D 1974-98 (2003) - Standard Practice for Methods of Closing, Sealing, and
Reinforcing Fiberboard Boxes

D 5118/D 5118M-05ae1 - Standard Practice for Fabrication of Fiberboard Shipping
Boxes

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For DSCP web site posting

AMSRD-NSR-CF-F

20 March 2008

TO: DSCP-FTRA

Subject: ES08-060; Document Change; ACR-E-001, Unitized Group Ration – Express Assembly; Larger Box for Breakfast Menus

1. Based on the excessive volume of items cited for Breakfast 1 and 2, an increase in the box height dimensions has been recommended by the assembler. Natick concurs with a 1-1/2 inch increase in box height.

2. Natick recommends that DSCP implement the following change for current, pending and future contracts until the document is formally amended or revised:

Para D-3, A. Packing. After “10-1/4 inches” insert”, except breakfast menus shall have maximum outside dimensions of 20 by 16 by 11-3/4 inches”.

2. Natick recommends that DSCP implement the following change to ACR-E-001 for current, pending and future contracts until the document is formally amended or revised:

Para D-3, A. Packing. After “10-1/4 inches” insert: “except breakfast menus which shall have maximum outside dimensions of 20 by 16 by 11-3/4 inches.”

3. The reference for Italian Seasoning was also updated.

4. ACR-E-001, Change 03, dated 20 March 2008, cites these changes.