

ACR-E-001A
21 April 2009
SUPERSEDING
ACR-E-001
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SECTION C

The Unitized Group Ration – Express™ (UGR-E™) provides a complete meal to 18 individuals. There are four breakfast, eight lunch/dinner, and one holiday menus. 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-1 ITEM DESCRIPTION

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

C-2 ASSEMBLY REQUIREMENTS

A. Components. The components shall be as specified in table I.

TABLE I. Components

Component	Reference
<u>Entrées</u>	
Burgundy Beef Stew – poly tray	<u>PCR-B-044</u>
Chicken Breast in Gravy – poly tray	<u>PCR-C-032</u>
Chicken in a Szechwan Style Sauce – poly tray	<u>PCR-C-065</u>
Chicken Pot Pie Filling – poly tray	<u>PCR-C-072</u>
Cream Gravy with Ground Beef – poly tray	<u>PCR-C-040</u>
Ham Slices in Brine – poly tray	<u>PCR-H-009</u>
Hash, Corned Beef – poly tray	<u>PCR-H-005</u>
Pasta with Ground Hot Italian Sausage – poly tray	<u>PCR-P-041</u>
Pork Carnitas with Gravy – poly tray	<u>PCR-P-044</u>
Pork Sausage Links in Brine – poly tray	<u>PCR-P-015</u>
Pork Sausage in Cream Gravy – poly tray	<u>PCR-P-014A</u>
Pulled Pork in Barbecue Sauce – poly tray	<u>PCR-P-043</u>
Spaghetti with Meatballs in Sauce – poly tray	<u>PCR-S-012</u>
Turkey Sausage Links in Brine – poly tray	<u>PCR-T-006</u>
Turkey Slices in Gravy – poly tray	<u>PCR-T-005</u>

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TABLE I. Components - Continued

Component	Reference
<u>Starches</u>	
Biscuits – poly tray	PCR-B-048
Cornbread Stuffing with Sausage – poly tray	PCR-C-056
Granola, with Milk and Blueberries	PCR-G-003 , Type I
Macaroni and Cheese – poly tray	PCR-M-012
Mashed Potatoes with Chicken Gravy – poly tray	PCR-M-010
Rice – poly tray	PCR-R-004A
Rice, White	Type I
Brown Rice	Type III
<u>Vegetables</u>	
Vegetables – poly tray	PCR-V-007
Carrots, Glazed	Type I
Corn, Mexican Style	Type II
Green Beans, Southern Style	Type III
Peas	Type IV
<u>Desserts and Snacks</u>	
Apple Dessert – poly tray	PCR-A-003
Beef Snacks, Cured, Kippered Beef, Strips (Chopped and Formed), Smoked	A-A-20298A , Type II, Style A, Flavor 1
Blueberry Dessert – poly tray	PCR-B-036
Cakes and Brownies – poly tray	PCR-C-024B , Type I
Devil's Fudge Cake with White Icing	Flavor 4
Walnut Tea Cake	Flavor 7
Dulce de Leche Cake with White Icing	Flavor 9
Breakfast Cake with Maple Flavored Syrup	Flavor 10
Spice Cake with White Icing	Flavor 14
Lemon Cake with White Icing	Flavor 15
Apple Spice Breakfast Cake	Flavor 16
Blueberry Breakfast Cake with Maple Flavored Syrup	Flavor 17

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TABLE I. Components - Continued

Component	Reference
Candy and Chocolate Confections, Pan Coated Candy Disks	A-A-20177E
Chocolate, Plain	Type VI, Shape A, Flavor 1
Peanut Butter, Plain	Type VI, Shape A, Flavor 4
Licorice, Bite Size, Cherry	Type X, Shape B, Flavor 1
Cookies, Regular, Caramel Chocolate Chip, Multiple	A-A-20295B , Type I, Style J
Serving Package, Soft and Chewy – poly tray	Flav 10, Bake type b, Class 2
Dessert Powder, Pudding, Regular, Instant, with Nonfat	A-A-20344A , Type I, Prep. C,
Dry Milk, Vanilla	Style 1, Flavor a
FIRST STRIKE™ Bar, Mini	PCR-F-001 , Style B
Apple-Cinnamon	Flavor II
Cran-Raspberry	Flavor III
Mocha	Flavor V
Fruits, Osmotically Dried, Sliced, Cranberries, Fortified	A-A-20299A , Type VII, Fort. a
Nuts, Shelled, Roasted	A-A-20164C
Almonds, Smoke Flavored (Unblanched), Salted	Type IX, Style A
Nut and Fruit Mix, Nuts and Raisins with Pan Coated	PCR-N-003 , Type II
Chocolate Disks	
Ranger Bar, Caramel Apple	PCR-R-008A , Flavor II
Scones, Apple Strudel with Icing – poly tray	PCR-S-003A , Flavor III
Sweet Rolls, Raspberry Swirl – poly tray	PCR-S-007 , Style II
<u>Beverages</u>	
Beverage Base (Powdered)	A-A-20098E
Flat Interlocking Closure Pouch	Design B
Sweetened with Nutritive Sweetener	Type II
With or Without Ascorbic Acid	Formulation a or b
Orange	Flavor 1
Lemon-Lime	Flavor 4
Lap or fin seal	
Sweetened with Non-nutritive Sweetener	Design D
Non-fortified	Type III
Lemonade	Formulation a
Raspberry	Flavor 8
	Flavor 13

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TABLE I. Components - Continued

Component	Reference
Coffee, Instant, 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, Flat Interlocking Closure Pouch	PCR-D-002A , Design B
Chocolate	Flavor II
Strawberry	Flavor III
Juice, Fruit, Instant, Flat Interlocking Closure Pouch	PCR-J-002 , Design B
Grape, Sweetened	Type I, Style A
Orange, Unsweetened	Type III, Style B
Tea Mixes, Instant, Black Tea, Sweetened with Non-nutritive Sweeteners, Regular, Lemon, Lap or Fin Seal	A-A-20183C , Variety I, Style B, Type 1, Flavor b, Design D
<u>Other Food Items</u>	
Cranberry Sauce, Jellied	8930-01-553-3117
Creamer, Non-Dairy, Dry	A-A-20043B
Hot Sauce	8950-01-E10-0248
Natural Butter Flavor Granules/Sprinkles, Spray-Dried Regular, Granules	A-A-20351 , Type I, Style A, Package 4
Soy Sauce, Fermented	A-A-20087C , Type I
Spices and Spice Blends	A-A-20001A
Italian Seasoning	Type II, Class I
Poultry Seasoning	Type II, Class C
Vegetable Seasoning	8950-01-546-4338
<u>Disposables</u>	
Cutter, Box, Razor-Based with Housing	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, Food Container, Modified, with Biobased Fork, Knife and Spoon	A-A-3012A , Type IV

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TABLE I. Components - Continued

Component	Reference
Gloves, Disposable, Foodservice, Multipurpose, Large, Ambidextrous, Latex Free, Polyethylene, 1.25 mil thick	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	MIL-DTL-32235
Heater Module, Type I: Magnesium and Iron Heater, Assembly Required	MIL-DTL-32235/1

B. Contents. The contents of each meal shall be as specified in table II.

TABLE II. Contents

STANDARD ITEMS

Component	Servings	Quantity
Coffee	1 pouch	18
Creamer	1 pouch	18
Hot Sauce	0.75 fl. oz. bottle	1
Gloves	10 gloves per package	1
Cutter, Box	1 unit	1
Hand Cleaner (towelette)	1 pouch	36
Trays, Mess	1	18
Dining Packets	1	18
Trash Bags	4 per package	1
Heater Module	1 module	1

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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
Biscuits	18 per tray	1
Sweet Rolls, Raspberry Swirls	18 per tray	1
Granola, Milk with Blueberry	1 pouch	18
Ranger Bar, Caramel Apple	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
Hash, Corned Beef	18 per tray	1
Pork Sausage Links in Brine	18 per tray	1
Cake, Breakfast	18 per tray	1
Blueberry Dessert	18 per tray	1
FIRST STRIKE™ Bar, Cran-Raspberry	1 pouch	18
Dairyshake <u>1</u> /	1 pouch	18
Juice Drink, Grape	1 pouch	18
Serving Utensils	2 Spoons, 1 Slotted Spoon, 1 Spatula	

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UGR-E™ BREAKFAST MENU 3

Component	Servings	Quantity
Cream Gravy with Ground Beef	18 per tray	1
Turkey Sausage	18 per tray	1
Cake, Blueberry Breakfast with Maple	18 per tray	1
Biscuits	18 per tray	1
FIRST STRIKE™ Bar, Apple-Cinnamon	1 pouch	18
Granola, Milk with Blueberry	1 pouch	18
Juice, Orange	1 pouch	18
Serving Utensils	2 Spoons, 1 Slotted Spoon, 1 Spatula	

UGR-E™ BREAKFAST MENU 4

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

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UGR-E™ LUNCH/DINNER MENU 1

Component	Servings	Quantity
Pasta with Ground Hot Italian Sausage	9 per tray	2
Peas	18 per tray	1
Cake, Spice	18 per tray	1
Spices, Italian Seasoning	0.75 oz. container	1
Butter Granules	57 g. package	1
Candy, Licorice, Cherry	1 pouch	18
Dairyshake <u>1</u> /	1 pouch	18
Beverage, Sugar Free <u>1</u> /	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, Mexican Style	18 per tray	1
Cake, Devil's Fudge	18 per tray	1
Butter Granules	57 g. package	1
Fruit, Cranberries, Dried	1 pouch	18
Beverage <u>1</u> /	1 pouch	18
Serving Utensils	2 Spoons, 1 Slotted Spoon, 1 Spatula	

UGR-E™ LUNCH/DINNER MENU 3

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Component	Servings	Quantity
Burgundy Beef Stew	18 per tray	1
Green Beans, Southern Style	18 per tray	1
Rice, White	18 per tray	1
Cake, Walnut Tea	18 per tray	1
Candy, Pan Coated Chocolate Disks	1 pouch	18
Spices, Vegetable Seasoning	0.75 oz. container	1
Butter Granules	57 g. package	1
Dessert Powder, Pudding, Vanilla	1 pouch	18
Beverage, Sugar Free <u>1/</u>	1 pouch	18
Serving Utensils	2 Spoons, 1 Slotted Spoon, 1 Spatula	

UGR-E™ LUNCH/DINNER MENU 4

Component	Servings	Quantity
Pulled Pork in Barbeque Sauce	18 per tray	1
Macaroni and Cheese	18 per tray	1
Corn, Mexican Style	18 per tray	1
Cake, Dulce de Leche	18 per tray	1
Candy, Pan Coated Peanut Butter Disks	1 per pouch	18
Butter Granules	57 g. package	1
Beverage <u>1/</u>	1 pouch	18
Beverage, Sugar Free <u>1/</u>	1 pouch	18
Serving Utensils	2 Spoons, 1 Slotted Spoon, 1 Spatula	

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Component	Servings	Quantity
Chicken Szechwan	18 per tray	1
Rice, Brown Rice	18 per tray	1
Carrots	18 per tray	1
Cookies, Caramel Chocolate Chip	18 per tray	1
Nuts, Smoked Almonds	1 pouch	18
Butter Granules	57 g. package	1
Soy Sauce	5 oz. bottle	1
Beverage <u>1/</u>	1 pouch	18
Beverage, Sugar Free <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
Cake, Lemon	18 per tray	1
Nut Raisin Mix with Chocolate Disks	1 pouch	18
Spices, Italian Seasoning	0.75 oz. container	1
Spices, Vegetable Seasoning	0.75 oz. container	1
Dairyshake <u>1/</u>	1 pouch	18
Beverage, Sugar Free <u>1/</u>	1 pouch	18
Serving Utensils	1 Spoon, 1 Slotted Spoon, 1 Spatula	

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Component	Servings	Quantity
Pork Carnitas	18 per tray	1
Rice, Brown Rice	18 per tray	1
Corn	18 per tray	1
Cake, Dulce de Leche	18 per tray	1
Butter Granules	57 g. package	1
Beef Snacks	1 pouch	18
Dessert Powder, Pudding, Vanilla	1 pouch	18
Beverage, Sugar Free <u>1</u> /	1 pouch	18
Serving Utensils	2 Spoons, 1 Slotted Spoon, 1 Spatula	

UGR-E™ LUNCH/DINNER MENU 8

Component	Servings	Quantity
Chicken Pot Pie Filling	18 per tray	1
Mashed Potatoes with Chicken Gravy	18 per tray	1
Green Beans	18 per tray	1
Scones, Apple with Icing	18 per tray	1
Butter Granules	57 g. package	1
Candy, Licorice	1 pouch	18
Spices, Vegetable Seasoning	0.75 oz. container	1
Dairyshake <u>1</u> /	1 pouch	18
Beverage, Sugar Free <u>1</u> /	1 pouch	18
Serving Utensils	2 Spoons, 1 Slotted Spoon, 1 Spatula	

UGR-E™ LUNCH/DINNER MENU - HOLIDAY

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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 Stuffing with Sausage	18 per tray	1
Nut Raisin Mix with Chocolate Disks	1 pouch	18
Spices, Poultry Seasoning	0.75 oz. container	1
Cranberry Sauce	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. The dairyshakes include chocolate and strawberry. The beverages with nutritive sweetener include orange and lemon-lime. The sugar free beverages include lemonade, raspberry and lemon ice tea.

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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. Components may be intermediate packaged.

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 shall be assembled into a box. Each box shall be constructed in accordance with style RSC of ASTM D 5118/D 5118M, Standard Practice for Fabrication of Fiberboard Shipping Boxes. The fiberboard shall conform to type CF, class D, variety SW, grade V3c of ASTM D 4727/D 4727M, Standard Specification for Corrugated and Solid Fiberboard Sheet Stock (Container Grade) and Cut Shapes, or equivalent. The maximum outside dimensions of the box shall be 20 by 16 by 10-1/4 inches except the 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.

D-4 UNITIZATION

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A. Unit loads. Boxes shall be arranged in unit loads in accordance with Type I, Class A of DSCP FORM 3507, Loads, Unit: Preparation of Semiperishable Items.

D-5 MARKING

A. Shipping boxes and unit loads. Marking of shipping boxes 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

In addition, mark on every box:

KITCHEN IN A CARTON™

Comment [C1]: Natick ES09-147, change 01, 20-AUG-09 to add registered term.

The shipping container shall be 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

SECTION E INSPECTION AND ACCEPTANCE

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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.

TABLE III. UGR-E™ assembled menus defects 1/

Category	Defect
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<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 missing or incorrect or illegible.
	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:

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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.

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.

SECTION J REFERENCE DOCUMENTS

Unless otherwise specified, the issues of these documents are those active on the date of the solicitation or contract.

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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) www.asq.org

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

ASTM INTERNATIONAL www.astm.org

D 1974 Standard Practice for Methods of Closing, Sealing, and
Reinforcing Fiberboard Boxes

D 4727/D 4727M Standard Specification for Corrugated and Solid Fiberboard
Sheet Stock (Container Grade) and Cut Shapes

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

For DSCP Website Posting

RDNS-CFF

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TO: DSCP-FTSA

SUBJECT: ES09-147; Update for Trademarked “Kitchen in a Carton” for ACR-E-001A, Unitized Group Ration – Express™ (UGR-E™), Assembly Requirements

1. Recently the phrase “KITCHEN IN A CARTON” received trademark status.
2. This phrase for the UGR-E™ shall now be part of the marking on every box.
3. The following change to ACR-E-001A is recommended:

D-5 MARKING. After “Holiday Menu” insert on the next line:

“In addition, mark on every box:

KITCHEN IN A CARTON™”

4. These changes have been incorporated into the document as Change 01 to ACR-E-001A. Natick recommends that DSCP cite Change 01 to ACR-E-001A for current, pending and future UGR-E™ contracts.