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SECTION C

The Food Packet, Modular Operational Ration Enhancement™ (MORE™) provides a special purpose enhancement packet for the individual and complements both individual and group rations. This packet of performance enhancing and high carbohydrate foods will help the individual maintain optimal performance levels in extreme operational environments and during high intensity missions.

C-1 ITEM DESCRIPTION

**ACR-F-002B, FOOD PACKET, MODULAR OPERATIONAL RATION
ENHANCEMENT™ (MORE™), ASSEMBLY REQUIREMENTS**

Types

- Type I - High Altitude/Cold Weather
- Type II - Hot Weather

Comment [Sj1]: ES-13-014 (DSCP-SS-13-20764)change 05, 17-Jan-13; p.1, C-1, insert "/Cold Weather" after "Altitude"

C-2 ASSEMBLY REQUIREMENTS

A. Components. The components are specified in table I.

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TABLE I. Components

Component	Reference
Beef and Turkey Snacks, Cured	A-A-20298B
Beef, Moist Cured/Kippered, Chopped and Formed Strips, Smoked	Variety A, Type II, Style a, Class 1, Flavor (a)
Beverage Bases (Powdered)	A-A-20098E
Sweetened with Nutritive Sweetener	Type II,
Fortified Ascorbic Acid and Enhanced Maltodextrin	Formulation e,
Flat Interlocking Closure Pouch	Design B
Orange	Flavor 1
Lemon-Lime	Flavor 4
Grape	Flavor 5
Tropical Punch	Flavor 10
Beverage Powder, Carbohydrate Electrolyte	PCR-B-013A
Flat Interlocking Closure Pouch	Design B
Fruit Punch	Flavor I
Grape	Flavor II
Lemon-Lime	Flavor III
Orange	Flavor IV
Caffeinated Chocolate Pudding	PCR-C-081
Chewing Gum	A-A-20175D
Tablet, Large, with Caffeine, Regular	Type I, Size C, Style (2), Class 1,
Peppermint	Flavor a
Cinnamon	Flavor c
Disk, Regular with Caffeine, Regular	Type VII, Size B, Style (2), Class 1,
Peppermint	Flavor a
Cinnamon	Flavor c
Crackers, Fortified	PCR-C-037
Plain	Type I
Energy Gel	PCR-E-018
Mixed Berry	Flavor I
Lemon Lime	Flavor II
Orange	Flavor III
First Strike™ Bar	PCR-F-001
Chocolate, Regular	Flavor I, Style A
Mocha, Mini	Flavor V, Style B
Fruits, Infused and Dried	A-A-20299B

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Cranberries, Sliced, Plain, Not Fortified, No Sulfur Dioxide Type VII, Style B, Flavor 1, Fortification a, Class (1)

TABLE I. Components - Continued

Component	Reference
Fruits, Wet Pack	PCR-F-002C ,
Applesauce, Carbohydrate Enhanced, Sweetened, Regular Style	Type VII
Applesauce, Carbohydrate Enhanced, Sweetened, Regular Style, Cinnamon	Type IX
Nuts, Shelled, Roasted	A-A-20164D
Almonds (Unblanched), Flavored (Smoked)	Type IX, Style C
Nut and Fruit Mix	PCR-N-003
Nuts and Raisins with Pan Coated Chocolate Disks	Type II
Nuts with Raw Sunflower Kernels and Infused Fruit	Type III
Snack Foods	A-A-20195D
Filled Pretzels, Cheddar Cheese	Type II, Style F, Flavor 1
Baked Snack Crackers, Hot and Spicy Cheese	Type V, Flavor 2
Toasted Corn Kernels, Plain, Salted	Type VI, Flavor 1
Spread Soup Mix	PCR-S-023
Cheddar Potato with Artificial Bacon Bits	Type II
Toaster Pastries	A-A-20211B
Regular, Frosted, Brown Sugar Cinnamon, Without Sprinkles, Enriched Wheat Flour, Not Fortified, Rectangular, Single Serving	Type I, Style B, Flavor 3, Frosting Option (B), Grain Composition (1), Fortification b, Shape i, Servings (a)

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B. Contents. The contents of each food packet type are specified in table II. Refer to Table I for full citation and document number of components.

TABLE II. Contents

Type I - High Altitude/Cold Weather MORE™

<u>Pack 1</u>	<u>Pack 2</u>	<u>Pack 3</u>
Caffeine Chocolate Pudding Nut and Fruit Mix, Type III Toaster Pastry Energy Gel, Mixed Berry Snack, Filled Pretzels, Cheddar	First Strike™ Bar, Chocolate Nut and Fruit Mix, Type II Energy Gel, Lemon Lime Snack, Corn Kernels Beef Snack, Smoked Caffeinated Gum, Cinnamon Beverage, Carb Fortified <u>1/</u>	Cracker Spread Soup Mix Applesauce Snack, Baked Cracker First Strike™ Bar, Mini Mocha Beverage, Carb Fortified <u>1/</u>

Comment [Sj2]: ES13-014 (DSCP-SS-13-20764)change 05, 17-Jan-13; p.4, C-2, B. TABLE II. Contents, Type I heading, insert "/Cold Weather" after "Altitude"

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

Type II – Hot Weather MORE™

<u>Pack 1</u>	<u>Pack 2</u>	<u>Pack 3</u>
Caffeine Chocolate Pudding Dried Cranberries Energy Gel, Mixed Berry Snack, Filled Pretzels, Cheddar Beverage, Carbo Electro (2) <u>2/</u>	First Strike™ Bar, Chocolate Nuts, Almonds, Smoked Energy Gel, Lemon Lime Applesauce Caffeinated Gum, Peppermint Beverage, Carbo Electro (2) <u>2/</u>	Energy Gel, Orange Snack, Corn Kernels Applesauce, Cinnamon Nut and Fruit Mix, Type III First Strike™ Bar, Mini Mocha Beverage, Carbo Electro (2) <u>2/</u>

2/ Flavors shall be procured in equal quantities and assembled in a uniform distribution. When pack contains two beverages, they shall be different flavors.

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SECTION D

D-1 PACKAGING

A. Components.

(1) Time-temperature indicator (TTI) label. The TTI label shall be a 3/4 inch square, bull's-eye type, pressure sensitive adhesive label. The TTI label shall have an activation energy (Ea) of 24–30 kcal/mole, be protected from ultraviolet radiation and have a shelf life of 730 days at 80°F as pivot point.

(2) Assembly package. The assembly package shall be of sufficient thickness and strength to contain the pack components without tearing or spillage of meal contents throughout assembly, packing and distribution. Material will be suitably formulated for use with food packages.

B. Assembly.

(1) Food packet, MORE™ assembly. Each applicable component for each MORE™ food packet as described in table II shall be assembled in a food packet. The food packet shall be shrink wrapped or heat-sealed (as applicable) with material suitably formulated for use with food packages. If closed by heat seal, the seal shall be not less than 1/8 inch wide, and vacuum sealing is permitted. The sealed assembly packet shall not show any evidence of foreign odor. The size of the finished assembly packet shall allow for the packing of 24 food packets into the box.

D-2 LABELING

A. Food packet, MORE™. Each MORE™ food packet shall be correctly and legibly labeled on at least one face with permanent ink or other dark contrasting color. The label shall cite:

Modular Operational Ration Enhancement™ (MORE™)
Type

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Pack number
Contents list
Name and address of assembler

D-3 PACKING

A. Packing. Twenty four food packets, eight of each pack, shall be packed in a fiberboard box. The fiberboard box shall conform to RSC-L, of ASTM D 5118/D 5118M, Standard Practice for Fabrication of Fiberboard Shipping Boxes, grade V2s of ASTM D 4727/D 4727M, Standard Specification for Corrugated and Solid Fiberboard Sheet Stock (Container Grade) and Cut Shapes, except the requirements for dry burst strength shall be minimum 425 psi, the requirement for wet burst strength shall be minimum 250 psi and the laminated board thickness shall be 0.069 inches. [US Army Research, Development, and Engineering Command, Natick Soldier Research, Development, and Engineering Center has found that solid fiberboard shipping container material consisting of two outer facings of 90# wet strength linerboard and an inner ply of 69# linerboard meets the performance criteria of this specification.] The box liner shall be a full inside width box liner fabricated from grade W5c fiberboard in accordance with ASTM D 5118/D 5118M, except the terminal ends of the liner shall overlap a minimum of 2 inches and no fastening of the overlap is required. The box shall be closed in accordance with closure method 2A1 of ASTM D 1974, Standard Practice for Methods of Closing, Sealing, and Reinforcing Fiberboard Boxes, except the gap between the outer flaps shall be not more the 3/4 inch wide. Each box shall be reinforced with two girthwise nonmetallic straps. The inside dimensions of the box shall be 16-11/16 inches in length, 9-1/8 inches in width and 10-1/4 inches in depth.

D-4 UNITIZATION

A. Unit loads. Forty-eight boxes shall be arranged in unit loads in accordance with type I, class C of DLA Troop Support Form 3507, Loads, Unit: Preparation of Semiperishable Subsistence Items. At least two boxes in each tier shall be oriented to display the TTI label.

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D-5 MARKING

A. Shipping containers. Shipping containers shall be marked in accordance with DLA Troop Support Form 3556, Marking Instructions for Boxes, Sacks, and Unit Loads of Perishable and Semiperishable Subsistence and as specified in the contract with the following exceptions:

(1) Identification markings normally placed on an end of the shipping container shall read from top to bottom, left to right, when the shipping container is rotated from its upright position onto its side for palletization. The major flaps of the shipping container closure immediately to the right of the marked end of the shipping container shall bear the following marking:

Contract data and other required markings
Date of pack
Lot number
U.S. GOVERNMENT PROPERTY – COMMERCIAL RESALE IS UNLAWFUL

Time Temperature Indicator label shall be centrally positioned on the panel. A minimum distance (quiet zone) of 1/4 inch from the nearest identification marking shall be maintained.

(2) One side panel of shipping container shall be marked "Food Packet, Modular Operational Ration Enhancement™ (MORE™)" in letters not less than 1-1/4 inches high. The marked end panel shall read "Food Packet, MORE™ High Altitude/Cold Weather" or "Food Packet, MORE™ Hot Weather" in addition to other required markings. ~~In addition, the type shall also be marked on the box.~~

B. Unit loads. Unit loads shall be marked in accordance with DLA Troop Support Form 3556.

Comment [Sj3]: ES13-014 (DSCP-SS-13-20764)change 05, 17-Jan-13; p.7, D-5, A.(2), after "high." insert "The marked end panel shall read "Food Packet, MORE™ High Altitude/Cold Weather" or "Food Packet, MORE™ Hot Weather" in addition to other required markings." and delete "In addition, the type shall also be marked on the box."

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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 food packets examination.** The filled and sealed food packets shall be inspected for the defects listed in table III. The lot size shall be expressed in packets. The sample unit shall be one packet. The inspection level shall be S-4 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. A minimum of 50 samples shall be examined for critical defects. The finding of any critical defect shall be cause for rejection of the lot. The inspection sample shall contain a proportionate amount of packets.

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TABLE III. Assembled food packet defects

Category			Defect
<u>Critical</u>	<u>Major</u>	<u>Minor</u>	
1			Tear or hole or open seal in spread soup mix or energy gel or pudding or applesauce.
2			Swollen spread soup mix or energy gel or pudding or applesauce.
	101		Food packet not type or not pack as specified.
	102		Component missing or incorrect pack for packet.
	103		Packet not clean or outer packaging of contents not clean. <u>1/</u>
	104		Foreign odor.
	105		Label missing or incorrect or illegible.
	106		Tear or hole or open seal in component packages.
	107		Crushed or broken component. <u>2/</u>
	201		Tear or hole or open seal in packet. <u>3/</u>

1/ 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 from the clean appearance of the 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 dry cloth.

b. Localized dried product which affects less than 1/8 of the total surface area of one pouch face, or an aggregate of scattered dried product which affects less than 1/4 of the total

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surface area of one pouch face.

2/ For definition of crushed or broken, refer to applicable ration component document.

3/ The holes provided in shrink wrap to allow venting of air to facilitate effective application of shrink wrap are permitted and shall not be scored as defects.

D. Packing.

(1) Shipping container and marking examination. The filled and sealed shipping containers shall be examined for the defects listed in table IV. The lot size shall be expressed in shipping containers. The sample unit shall be one shipping container fully packed. The inspection level shall be S-3 and the AQL, expressed in terms of defects per hundred units, shall be 4.0 for major defects and 10.0 for total defects.

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TABLE IV. Shipping container and marking defects

Category		Defect
<u>Major</u>	<u>Minor</u>	
101		Marking missing or incorrect or illegible.
102		Outer flaps do not completely meet, leaving an opening greater than 3/4 inch between flap ends.
103		Inadequate workmanship. <u>1/</u>
104		Missing food packet. <u>2/</u>
105		Not eight of each pack specified.
106		Not correct type food packet.
	201	Twenty four food packets do not fit in box.
	202	Time-temperature indicator missing or not centrally located on panel.
	203	Time-temperature indicator 1/4-inch quiet zone not maintained.

1/ Inadequate workmanship is defined as, but not limited to, incomplete closure of container flaps, loose strapping, inadequate stapling, improper taping, or bulged or distorted container.

2/ Each missing food packet is a defect.

(2) Flap closure testing. The lot size shall be expressed in shipping containers. The sample unit shall be one shipping container. The inspection level shall be S-2 and the AQL, expressed in terms of defects per hundred units, shall be 4.0. The closure of the four outer flaps of the container shall be tested separately. A 90 degree angular bar with each leg approximately 5 inches long by 3 inches wide by 1/8 inch thick shall be used to test the flap closures. Insert one leg of the angular bar full length under the center of one outer flap. Insertion shall be made through the open slot between the outer flaps. Lift the container vertically by the other leg of the bar until the container is suspended. The complete upper

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surface of the inserted leg shall be in contact with the inner surface of the flap during the lifting and suspension of the container. Complete separation of the adhesive bond of one or more of the outer flaps, showing no evidence of fiber tear, shall be scored a major defect.

F. Unit load examination. The unit load shall be examined in accordance with the requirements of DLA Troop Support Form 3507. Any nonconformance shall be classified as a major defect.

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SECTION J REFERENCE DOCUMENTS

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

DLA Troop Support Forms

Form 3507	Loads, Unit: Preparation of Semiperishable Subsistence Items
Form 3556	Marking Instructions for Boxes, Sacks, and Unit Loads of Perishable and Semiperishable Subsistence

NON-GOVERNMENTAL STANDARDS

AMERICAN SOCIETY FOR QUALITY (ASQ) 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

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For DLA Website Posting

RDNS-CFF

17 January 2013

TO: DLA-FTRE

SUBJECT: ES13-014 (DSCP-SS-13-20764); Document change request to ACR-F-002B, Food Packet, Modular Operational Ration Enhancement™ (MORE™), Assembly Requirements to modify the existing case label to state the full description of the type of Food Packet, MORE™

1. The subject document does not specify the end panel marking for the MORE™ shipping container.
2. Army Service Representative requested to modify the existing case labeling specification to require the vendor to state the full description of the type of MORE™ (High Altitude/Cold Weather and Hot Weather) on the end panel to ensure the Warfighter is able to easily identify the type of MORE™ assembled within each case.
3. Natick submits the following change to subject document for all current, pending and future procurements until the document is formally amended or revised:
 - a. Page 1, Section C-1, Types, Type I; insert “/Cold Weather” after “Altitude”.
 - b. Page 4, Section C-2, B, TABLE II. Contents, Type I; insert “/Cold Weather” after “Altitude”.
 - c. Page 7, Section D-5, A(2), after “high.”; insert “The marked end panel shall read “Food Packet, MORE™ High Altitude/Cold Weather” or “Food Packet, MORE™ Hot Weather” in addition to other required markings.” and delete “In addition, the type shall also be marked on the box.”
4. Attached is Change 5, ACR-F-002B, Food Packet, Modular Operational Ration Enhancement™ (MORE™), Assembly Requirements, dated 17 January 2013, with changes highlighted.