

SECTION C

The Meal, Ready-to-Eat (MRE™) provides an operational ration for the individual.

C-1 ITEM DESCRIPTION

ACR-M-029, MEAL, READY-TO-EAT (MRE™), ASSEMBLY REQUIREMENTS

C-2 ASSEMBLY REQUIREMENTS

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

TABLE I. Components

Component	Reference
<u>Entrées</u>	
Beef Enchilada in Sauce	PCR-B-010
Beef Patty, Grilled	PCR-B-029
Beef Ravioli in Meat Sauce	PCR-B-021
Beef Roast with Vegetables	PCR-B-035
Beef Stew	PCR-B-020
Brisket Entrée (Gravy with Seasoned Beef Brisket Slices	PCR-B-050
Cheese Tortellini in Tomato Sauce	PCR-C-020
Chicken and Dumplings	PCR-C-067
Chicken Breast Fillet with Rib Meat, Seasoned	PCR-C-022
Chicken Fajita	PCR-C-055
Chicken, Noodles and Vegetables, in Sauce	PCR-C-021
Chicken Pesto Pasta	PCR-C-069
Chicken, Pulled with Buffalo Style Sauce	PCR-C-074
Chili and Macaroni	PCR-C-027
Chili with Beans	PCR-C-062
Meatballs in Marinara Sauce	PCR-M-015
Penne with Vegetable Sausage Crumbles in Spicy Tomato Sauce	PCR-P-036
Pork Rib, Boneless, Imitation, Smoke Flavoring Added	PCR-P-028
Pork Sausage Patty, Maple Flavored	PCR-P-045
Sloppy Joe Filling	PCR-S-013
Spaghetti with Meat and Sauce	PCR-S-0002

TABLE I. Components (continued)

Component	Reference
Tuna, Flexible Pouch, Chunk, White (Albacore), Water Packed, Regular Salt/Sodium Level	A-A-20155C , Type B, Form I, Color b, Packing Media 1, Salt/Sodium Level (a)
Vegetable Lasagna	PCR-V-008
Veggie Burger in Barbecue Sauce	PCR-V-004
<u>Starches and Soups</u>	
Biscuit	PCR-B-049
Cornbread	PCR-C-075
Cornbread Stuffing	PCR-C-066
Granola, with Milk and Blueberries	PCR-G-003 , Type I
Macaroni and Cheese, Mexican Style	PCR-M-009
Mexican Style Corn	PCR-M-013
Potato Cheddar Soup Flavored with Bacon	PCR-P-046
Potatoes, Mashed	PCR-P-011
Refried Beans	PCR-R-007
Rice	PCR-R-001A
Mexican rice	Type II
Fried rice	Type IV
Snack Bread, Fortified	PCR-S-009A
Wheat snack bread	Type I
Chipotle snack bread	Type III
Tortillas	PCR-T-008
<u>Fruits</u>	
Apple Pieces in Spiced Sauce	PCR-A-001A
Cobbler, Cherry Blueberry	PCR-C-058 , Flavor I
Fruits, Osmotically Dried	A-A-20299A
Sliced Cranberries, Not Fortified	Type VII, Fortification a
Raisins, Not Fortified	Type IX, Fortification a
Fruits, Wet Pack	PCR-F-002B
Pears, Sweetened, Slice or Diced	Type IV
Mixed Fruit, Sweetened	Type V
Applesauce, with Raspberry Puree, Sweetened, Reg.	Type VI
Applesauce, Carbohydrate Enhanced, Sweetened, Reg.	Type VII
Applesauce, with Mango and Peach Puree, Sweet, Reg.	Type VIII

TABLE I. Components (continued)

Component	Reference
<u>Desserts and Snacks</u>	
Beef Snacks, Cured, Kippered Beef Strips, Smoked Cakes and Brownies, and Muffin Tops	A-A-20298A , Type II, Style A, Fl. 1 PCR-C-007C
Cakes	Type I
Vanilla Pound	Flavor 1
Lemon Poppy Seed Pound	Flavor 6
Spice Pound	Flavor 7
Almond Poppy Seed Pound	Flavor 8
Carrot Pound	Flavor 10
Marble Pound	Flavor 11
Brownies	Type II
Fudge Brownie with Chocolate Drops	Flavor 1
Muffin Tops	Type III
Chocolate Banana Nut	Flavor 1
Cheese Spread, Cheddar; Fortified	PCR-C-039
Plain	Type I
With Jalapeno Peppers	Type II
With Bacon	Type III
Cookies, Regular, Individual Serving Package, Crisp	A-A-20295C , Type I, Class 1, Bake Type a
Sugar, Patriotic	Style D, Shape b
Oatmeal, Plain	Style I, Flavor 1
Chocolate Chip, Plain	Style J, Flavor 1
Kreamsicle	Style K
Toffee Crunch	Style L
White Chocolate Chip Raspberry	Style Q
Cookies with Pan Coated Chocolate Disks	PCR-C-031
Crackers, Fortified	PCR-C-037
Plain	Type I
Vegetable	Type II
Dessert Powder, Pudding, Regular, Instant, Nonfat Dry Milk	A-A-20344A , Type I, Preparation C, Style 1
Vanilla	Flavor a
Chocolate	Flavor b

TABLE I. Components (continued)

Component	Reference
First Strike™ Bar	PCR-F-001
Chocolate, Regular	Flavor I, Style A
Apple-Cinnamon, Regular	Flavor II, Style A
Fruit Butter, Regular, Apple	A-A-20348 , Type I, Flavor A
Jelly, Fruit, Standardized, Single, Regular	A-A-20078B , Type I, Style 1,
Apple	Kind A
Grape	Kind L
Nuts, Shelled, Roasted	A-A-20164C
Peanuts, Virginia Type or Runner Type, Dry	Type V, Style A
Roasted, Salted	
Almonds, Smoke Flavored (Unblanched), Salted	Type IX, Style A
Nut and Fruit Mix	PCR-N-003
Nut and Raisins	Type I
Nut and Raisins with Pan Coated Chocolate Disks	Type II
Peanut Butter and Peanut Spread, Regular,	A-A-20328A , Class A, Type a,
Stabilized, Fortified	Fortification b
Peanut Butter, Smooth	Style I, Texture 1
Peanut Butter, Chunky/Crunchy	Style I, Texture 3
Peanut Spread, Smooth, Chocolate	Style II, Texture 1, Flavor 2
Preserves (or Jams), Fruit	A-A-20079B
Single Fruit, Blackberry, Regular,	Type I, Group I, Flavor A Style 1
Single Fruit, Strawberry, Regular	Type I, Group I, Flavor R, Style 1
Ranger Bar	PCR-R-008A
Caramel Apple	Flavor II
Chocolate Covered Chocolate Chip	Flavor III
Cran-apple	Flavor IV
Scone, Cinnamon	PCR-S-014 , Flavor I
Snack Foods	A-A-20195C
Pretzels, Bavarian, Rods, Sticks, Twist or Nuggets	Type II, Style A, B, C, D, or E
Filled Pretzels, Cheddar Cheese or Nacho Cheese	Type II, Style F, Flavor 1 or 2
Baked Snack Cracker, Cheddar Cheese or	Type V, Flavor 1 or 2
Hot and Spicy Cheese	
Cheese Filled Crackers, Cheddar Cheese or	Type VII, Flavor 1 or 2
Pepperoni Pizza	
Toaster Pastry, Regular, Shelf Stable, Not fortified,	A-A-20211B , Type I,
Rectangular, Single Serving	Fort. b, Shape i, Servings a
Frosted Brown Sugar Cinnamon	Style B, Flavor 3
Chocolate Chip	Style B, Flavor 12

TABLE I. Components (cont'd)

Component	Reference
<u>Candy</u>	
Candy and Chocolate Confections	
Toffee, Chocolate Flavored, Roll or Cube 1/	A-A-20177D
Pan Coated Candy	Type II, Style A or B
Disks, Chocolate, Plain	Type VI
Disks, Fruit Flavored, Berry	Shape A, Flavor 1
Disks, Fruit Flavored, Tropical	Shape A, Flavor 2, Fl. Style b
Disks, Peanut Butter	Shape A, Flavor 2, Fl. Style c
Disks, Cinnamon	Shape A, Flavor 4
Oval/Round, Chocolate with Peanuts,	Shape A, Flavor 5
Licorice Style Candy, Bite Size, Cherry	Shape B, Flavor 1
	Type X, Shape B, Flavor 1
<u>Beverages</u>	
Beverage Base, Powdered Flat Pouch	A-A-20098D, Design A
Sweetened with Nutritive Sweetener	Type II
Fortified with Ascorbic Acid and Maltodextrin;	Formulation d
Small Flat Pouch	Design E
Orange	Flavor 1
Lemon-Lime	Flavor 4
Tropical Punch	Flavor 10
Sweetened with Non-nutritive Sweetener	Type III
Non-fortified	Formulation a
Lap or Fin Seal Pouch	Design D
Lemonade	Flavor 8
Raspberry	Flavor 13
Beverage Powder, Carbohydrate Electrolyte, Flat Pouch	PCR-B-013A , Design A
Fruit Punch	Flavor I
Grape	Flavor II
Lemon-Lime	Flavor III
Orange	Flavor IV
Cocoa Beverage Powder, Fortified,	PCR-C-041 , Design B
Flat Interlocking Closure Pouch	
Cocoa Beverage Powder, Sugar Sweetened,	A-A-20189B , Type I, Style B,
Without Marshmallows, Chocolate Hazelnut,	Flavor F, Design B
Flat Interlocking Closure Pouch	

Comment [MN1]: Natick case ES09-127 (DSCP-SS-09-32830) change 03, 09-JUN-09 Delete ",Flat Pouch", Delete ",Design A"

Comment [MN2]: Natick case ES09-127 (DSCP-SS-09-32830) change 03, 09-JUN-09. Insert "Small Flat Pouch", Insert "Design E" to refine packaging citations.

Comment [MN3]: Natick case ES09-127 (DSCP-SS-09-32830) change 03, 09-JUN-09. Insert "Lap or Fin Seal Pouch", Insert "Design D" to refine packaging citations.

TABLE I. Components (cont'd)

Component	Reference
Dairyshake Powder, Fortified with Calcium and Vit. D	PCR-D-002A
Flat Interlocking Closure Pouch	Design B
Vanilla	Flavor I
Chocolate	Flavor II
Strawberry	Flavor III
Strawberry Banana	Flavor IV
Drink Mixes, Coffee (Flavored and Unflavored),	A-A-20336A
Flavored Instant Cappuccino, Regular	Type V, Style A
Flat Interlocking Closure Pouch	Design B
French Vanilla	Flavor 1
Mocha	Flavor 2
Irish Cream	Flavor 4
<u>Other Items</u>	
Bag, Hot Beverage	MIL-PRF-32176
Barbecue Sauce, Plain/Regular, Without Fruit Purees	A-A-20335 , Flavor I, Type B
Fork, Knife and Spoon, Picnic (Plastic), High Impact	A-A-3109B , Type IV, Item 13
Spoon, MRE, 7-inch (Brown)	
Hot Sauce, 1/8 fluid ounce	A-A-20097E
Extra Hot 4x	Type II
Green	Type III
Mayonnaise, Salad Dressing and Tartar Sauce	A-A-20140D
Mayonnaise, Fat Free	Type I, Style C
Natural Butter Flavor Granules, Spray Dried,	A-A-20351 , Type I, Style A,
2 gram packet	Package 1
Picante Sauce, Medium	A-A-20259A , Type II
Ration Supplement, Flameless Ration Heater (FRH)	MIL-R-44398B
Salsa, Tomato-Based and Salsa Verde,	A-A-20210B , Type II,
Salsa Verde, Shelf Stable, Medium, Regular	Preparation A, Pungency 3, Style a
Spices and Spice Blends	A-A-20001A
Red Pepper, Ground	Type I, Class Z, Form 1
Seasoning Blend, Salt Free, with Herbs and Citrus	Type II, Class D, Blend (1)
Barbecue Seasoning	Type II, Class E
Pizza Seasoning	Type II, Class M
Steak Sauce, Regular	A-A-20092C , Flavor 1

1/ These items, if commercially packaged, shall be overwrapped in a barrier pouch as cited in the Packaging Requirements and Quality Assurance Provisions (PKG&QAP) for A-A-20177D.

B. Accessory components. Accessory components are specified in table II.

TABLE II. Accessory Components

Component	Reference	Acc. Pack
Chewing Gum, Tablet, Regular, Without Caffeine, Xylitol Sweetened, Peppermint or Cinnamon	A-A-20175C , Type I, Size B, Style (1), Class 3, Flavor a or c	All
Hand Cleaner (towelette), Unscented, Water Based	A-A-461B , Type II	All
Matches, Safety	A-A-59489A , Type I, Class B	A, D
Salt, Table, Iodized, 4 grams	NaCl Monograph	All
Toilet Tissue, Institutional	A-A-59594 , Style II, Type A, Sheet b	All
Coffee, Instant, Freeze dried, Reg.	A-A-20184B , Type III, Style A	A, D
Creamer, Non-Dairy, Dry	A-A-20043B	A, D
Sugar, 1/7 ounce	A-A-20135C , Type I, Style A	A
Tea, Instant, Regular, Sweetened, Lemon Flavor, 16 grams	A-A-20183B , Type I, Style B, Flavor 2	B
Beverage Base, Powder, Sweet, Ascorbic acid, Apple Cider, 17 gr.	A-A-20098D , Type II, Formulation b, Flavor 12	C
Sugar Substitutes, Non-Carbohydrate Sucralose	A-A-20178A , Type IV	D

C. Contents. The contents of each meal are specified in table III.

TABLE III. Contents

<u>Menu #1</u>	<u>Menu #2</u>	<u>Menu #3</u>
Chili with beans	Pork rib	Beef ravioli
Mexican style corn	Potato cheddar soup	Toaster pastry <u>1/</u>
Cheese spread, plain	Raisin nut with choc. disks	Cookies <u>4/</u>
Crackers, plain	Peanut butter, smooth	Cheese spread, Jalapeno
Candy III <u>2/</u>	Preserves, Jam <u>1/</u>	Crackers, vegetable
Dairyshake <u>1/</u>	Tortillas	Beef snacks
Spice, red pepper	Beverage, carbo fortified <u>1/</u>	Beverage, carb electro <u>1/</u>
Accessory packet A	Spice, Barbecue sauce	Hot sauce
Spoon	Accessory packet A	Accessory packet D
Flameless ration heater	Spoon	Spoon
Hot beverage bag	Flameless ration heater	Flameless ration heater
	Hot beverage bag	Hot beverage bag

<u>Menu #4</u>	<u>Menu #5</u>	<u>Menu #6</u>
Maple sausage	Chicken breast	Chicken with noodles
Granola, milk, blueberries	Cornbread stuffing	Cheese spread, plain
Fruit butter, apple	Ranger bar <u>1/</u>	Crackers, plain
Crackers, plain	Cheese spread, Jalapeno	Ranger bar <u>1/</u>
Scone, cinnamon	Snack bread, Wheat	Candy II <u>2/</u>
Toaster pastry <u>1/</u>	Candy II <u>2/</u>	Cocoa beverage
Drink, cappuccino, Fr. Van.	Beverage, carbo fortified <u>1/</u>	Hot sauce
Salsa verde	Spice, BBQ seasoning	Accessory packet A
Accessory packet C	Accessory packet B	Spoon
Spoon	Spoon	Flameless ration heater
Flameless ration heater	Flameless ration heater	Hot beverage bag
Hot beverage bag	Hot beverage bag	

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<u>Menu #7</u> Brisket entree Biscuit Cookies 4/ Peanut butter, smooth Jelly 1/ Crackers, plain Candy I 2/ Cocoa Butter granules Spice, barbecue sauce Accessory packet B Spoon Flameless ration heater Hot beverage bag	<u>Menu #8</u> Meatballs marinara sauce Cheddar cheese, plain 2 Snack bread, wheat Nuts 1/ Snack, filled pretzels 1/ Beverage, carb fortified 1/ Spice, pizza seasoning Accessory packet A Spoon Flameless ration heater Hot beverage bag	<u>Menu #9</u> Beef stew Mashed potatoes, plain Cheese spread, plain Crackers, plain Cake 3/ Dairyshake 1/ Hot sauce Accessory packet A Spoon Flameless ration heater Hot beverage bag
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<u>Menu #10</u> Chili and macaroni Fruit, wet pack 1/ Cornbread Cheese spread, Jalapeno Crackers, plain Candy III 2/ Beverage, carbo electro 1/ Spice, red pepper Accessory packet C Spoon Flameless ration heater Hot beverage bag	<u>Menu #11 Vegetarian</u> Vegetable lasagna Fruit, wet pack 1/ Cake 3/ Peanut butter, smooth Snack bread, wheat Cocoa, hazelnut Hot sauce Accessory packet B Spoon Flameless ration heater Hot beverage bag	<u>Menu #12 Vegetarian</u> Veggie burger with BBQ Fruit, dried 1/ Muffin top, Choc. banana 2 Snack bread, wheat Beverage, carb electro 1/ Hot sauce Accessory packet B Spoon Flameless ration heater Hot beverage bag
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<u>Menu #13 Vegetarian</u> Cheese tortellini Spiced apples First Strike™ bar <u>1/</u> Peanut butter, chunky Crackers, plain Candy II <u>2/</u> Beverage, sugar free <u>1/</u> Spice, seasoning blend Accessory packet C Spoon Flameless ration heater Hot beverage bag	<u>Menu #14 Vegetarian</u> Penne, vegetable sausage Fruit, dried <u>1/</u> Cake <u>3/</u> Peanut butter, smooth Crackers, plain Beverage, carb fortified <u>1/</u> Spice, seasoning blend Accessory packet C Spoon Flameless ration heater Hot beverage bag	<u>Menu #15</u> Beef enchilada Refried beans Cookies <u>4/</u> Cheese spread, Jalapeno Crackers, vegetable Beverage, carb fortified <u>1/</u> Picante sauce Spice, Red pepper Accessory packet A Spoon Flameless ration heater Hot beverage bag
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<u>Menu # 16</u> Chicken fajita Cheese spread, plain Tortillas Rice, Mexican Snack, Bake snack cracker <u>1/</u> Drink, Cappuccino, Ir.Cream Spice, seasoning blend Accessory packet C Spoon Flameless ration heater Hot beverage bag	<u>Menu #17</u> Sloppy Joe Cheese spread, Jalapeno Snack bread, wheat Nut raisin mix Brownie Beverage, carbo electro <u>1/</u> Hot sauce Accessory packet D Spoon Flameless ration heater Hot beverage bag	<u>Menu #18</u> Beef patty Mexican mac & cheese Cheese spread with bacon 2 Snack bread, wheat Snack, Cheese fill. cracker <u>1/</u> Beverage, carb fortified <u>1/</u> Spice, barbecue sauce Accessory packet B Spoon Flameless ration heater Hot beverage bag
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<u>Menu #19</u> Beef roast with vegetables Fruit, dried <u>1/</u> Cake <u>3/</u> Peanut spread, chocolate Crackers, plain Beverage, carb fortified <u>1/</u> Steak sauce Accessory packet A Spoon Flameless ration heater Hot beverage bag	<u>Menu #20</u> Spaghetti with meat sauce Cherry blueberry cobbler Cheese spread, plain Snack, Baked sn. cracker <u>1/</u> Snack bread, chipotle Beverage, sugar free <u>1/</u> Hot sauce, green Accessory packet A Spoon Flameless ration heater Hot beverage bag	<u>Menu #21</u> Tuna Tortillas Cookies <u>4/</u> Snack, pretzels Candy I <u>2/</u> Dairyshake <u>1/</u> Mayonnaise, fat free Spice, seasoning blend Accessory packet C Spoon
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<u>Menu #22</u> Chicken and dumplings Peanut butter, chunky Jelly <u>1/</u> Snack bread, wheat Cookies <u>4/</u> Candy I <u>2/</u> Beverage, carb fortified <u>1/</u> Hot sauce Accessory packet A Spoon Flameless ration heater Hot beverage bag	<u>Menu #23</u> Chicken pesto pasta Cheese spread with bacon Snack bread, wheat Fruit, wet pack <u>1/</u> Pudding <u>1/</u> Beverage, carb fortified <u>1/</u> Spice, red pepper Accessory packet A Spoon Flameless ration heater Hot beverage bag	<u>Menu #24</u> Buffalo chicken Fried rice Cookies, sugar patriotic Cheese spread, Jalapeno Snack bread, wheat Candy II <u>2/</u> Drink, cappuccino, Mocha Accessory packet B Spoon Flameless ration heater Hot beverage bag
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1/ Flavors shall be procured in equal quantities and assembled in a uniform distribution. Wet pack fruit (Menus 10, 11, 23) include raspberry applesauce, carbo enhanced applesauce, mango/peach applesauce, pears, and mixed fruit. Nuts (Menu 8) include dry roasted peanuts and smoked almonds. Dairyshakes (Menus 1, 9, 21) include vanilla, chocolate, strawberry-banana and strawberry. Jams (Menu 2) include blackberry and strawberry. Jellies (Menus 7, 22) include apple and grape. Beverages with nutritive sweetener (Menus 2, 5, 8, 14, 15, 18, 19, 22, 23) include orange, lemon-lime and tropical punch. Beverages with carbohydrate electrolyte (Menus 3, 10, 12, 17) include fruit punch, grape, lemon-lime and orange. Beverages with non-nutritive sweetener (Menus 13, 20) include lemonade and raspberry. Dried fruit (Menu 12, 14, 19) include cranberries and raisins. Toaster pastries (Menus 3, 4) include brown sugar cinnamon and chocolate chip. Puddings (Menu 23) include vanilla and chocolate. First Strike™ bars (Menu 13) include chocolate and apple-cinnamon. Ranger bars (Menus 5, 6) include caramel apple, chocolate cover chocolate chip and cran-apple. Filled pretzels (Menu 8) include cheddar cheese and nacho cheese. Baked snack crackers (Menus 16, 20) include cheddar cheese and hot and spicy cheese. Cheese filled crackers (Menu 18) include cheddar cheese and pepperoni pizza.

2/ Candy I (Menus 7, 21, 22) include chocolate toffee rolls, toffee chocolate cube and plain chocolate disks; Candy II (Menus 5, 6, 13, 24) include plain and chocolate with peanuts and peanut butter; and Candy III (Menus 1, 10) include tropical and berry fruit disks, licorice and red hot cinnamon disks; shall be procured in equal quantities and assembled in a uniform distribution. Candy I, if commercially packaged, shall be overwrapped in a barrier pouch as cited in A-A-20177D PKG & QAP.

3/ Cakes; vanilla, lemon poppy, spice, almond poppy, carrot and marble; shall be procured in equal quantities and assembled in a uniform distribution in Menus 9, 11, 14 and 19. Not more than two meals in any shipping container shall contain the same flavor of pound cake.

4/ Cookies: oatmeal, chocolate chip, kreamsicle, toffee crunch, white chocolate raspberry and pan coated chocolate disks; shall be procured in equal quantities and assembled in a uniform distribution within Menus 3, 7, 15, 21 and 22.

SECTION D

D-1 PACKAGING

A. Components.

(1) Subassembly packet/accessory packet. The subassembly/accessory packet shall be a preformed packet or a form-fill-seal packet. Dimensions shall be sufficient to contain all components. Seals shall be a minimum 1/8 inch wide. A tear nick, notch or serrations shall be provided to facilitate opening the filled and sealed pouch. The average seal strength of the packet seals shall be not less than 3.5 pounds per inch of width and no individual specimen shall have a seal strength of less than 3.0 pounds per inch of width. As an alternative to the seal strength requirement, the filled and sealed packet shall exhibit no rupture or seal separation greater than 1/16 inch or seal separation that reduces the effective seal width to less than 1/16 inch when tested for internal pressure resistance. The packet shall be made from polymeric films or film combinations with adequate strength and thickness to contain and protect the components. The water vapor transmission rate (WVTR) of the film shall not exceed 6.2 gm/m²/24hrs/90%rh/100°F when tested in accordance with ASTM F 372, Standard Test Method for Water Vapor Transmission Rate of Flexible Barrier Materials Using an Infrared Detection Technique; ASTM E 96, Standard Test Methods for Water Vapor Transmission of Materials or Method 3030 of FED-STD-101, Test Procedures for Packaging Materials. The exterior color of the packet shall be clear or tan.

(2) 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 1100 days at 80°F as pivot point.

(3) Meal bag. The meal bag shall be made from food grade, low density polyethylene (LDPE) tubing or tubing made from a blend of food grade, low density polyethylene (LDPE) and linear-low density polyethylene (LLDPE). Additives may be used in order to improve sealability, peelability, tear resistance or other attributes provided all additives are food grade and are certified by the FDA as approved for food contact. Polyethylene shall have a minimum thickness of 0.010 inch. Inside dimensions of the bag shall not exceed 8-1/8 by 12-1/2 inches. The color of the bag shall conform to number 20219, 30219, 30227, 30279, 30313, 30324 or 30450 of FED-STD-595, Colors Used in Government Procurement. One seal shall be a minimum 1/8 inch wide, continuous, peelable seal that forms a hermetic closure. The seal shall be designed with an inverted “V” shaped peel indicator along the seal path. There shall be a minimum of 1/2 inch between the apex of the “V” and the end of the bag. The seal strength of the peelable seal shall be not less than 4 pounds per inch of width and shall be not greater than 10 pounds per inch of width. Alternative bag construction, bag materials, and material thicknesses may be used provided that the alternative method can be demonstrated to meet or exceed the requirements of this document and military abuse testing and controlled pest testing. Samples may be submitted to the contracting officer to be qualified on a case by case basis.

B. Assembly.

(1) Subassembly/accessory packet assembly. One of each applicable component as described in table II shall be inserted in a packet. If a subassembly is used, additional components may also be inserted in the packet. For a preformed packet, contents shall be inserted in the pouch and the pouch shall be closed with a heat seal not less than 1/8 inch wide. For a form-fill-seal packet, components shall be placed in the body and the cover applied by heat sealing with a seal not less than 1/8 inch wide. The closure seal shall be free of foldover wrinkles or entrapped matter that reduces the effective seal width to less than 1/16 inch. The average seal strength of the packet seals shall be not less than 3.5 pounds per inch of width and no individual specimen shall have a seal strength of less than 3.0 pounds per inch of width. As an alternative to the seal strength requirement, 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.

(2) Meal assembly. Each applicable component for each meal as described in table III shall be inserted in a meal bag. The bag shall be closed with a heat seal not less than 1/8 inch wide. The closure seal shall have an average seal strength of not less than 4 pounds per inch

of width with no individual specimen test result less than 3 pounds per inch of width. The sealed meal bag shall not show any evidence of foreign odor.

D-2 LABELING

A. Subassembly/accessory packet. The subassembly/accessory packet shall be labeled on one face in permanent dark contrasting color ink with 'A', 'B', 'C' or 'D', as applicable. Alternatively, the packet letter may be embossed in the seal of the packet.

B. Meal bag. Each meal bag shall be correctly and legibly labeled on at least one face with permanent ink or other dark contrasting color with the information contained in accordance with Figures 1, 2 or 3, as applicable. The label shall cite the correct Menu number, name of entrée, name and address of assembler, and cite "Vegetarian" for Menus 11-14. Menus 1-4, and 13-16 shall be printed in accordance with Design 1 (Figure 1). Menus 5-8 and 17-20 shall be printed in accordance with Design 2 (Figure 2). Menus 9-12 and 21-24 shall be printed in accordance with Design 3 (Figure 3).

D-3 PACKING

A. Packing. Twelve meals shall be packed in a fiberboard box. Case "A" shall contain meals 1 through 12, and case "B" shall contain meals 13 through 24. The fiberboard box shall conform to RSC-L of ASTM D 5118/D 5118M, Standard Practice for Fabrication of Fiberboard Shipping Boxes and 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 found that solid fiberboard shipping container material consisting of two outer facings of 90 pound 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 DSCP FORM 3507, Loads, Unit: Preparation of Semiperishable Subsistence Items. Each load shall have 24 "A" cases and 24 "B" cases. At least two boxes in each tier shall be oriented to display the TTI label.

D-5 MARKING

A. Shipping containers. Shipping containers shall be marked in accordance with DSCP 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
Case A or B, as applicable
U.S. GOVERNMENT PROPERTY – COMMERCIAL RESALE IS UNLAWFUL
NOTE: WATER ACTIVATED Flameless Ration heater,
NSN 8970-01-321-9153, supplied in each MRE bag

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 "MEAL, READY-TO-EAT, INDIVIDUAL" in letters not less than 1-1/4 inches high. Underneath the ration nomenclature, in letters not less than 1 inch, the shipping container shall be marked "DO NOT ROUGH HANDLE WHEN FROZEN (0°F or below)".

B. Unit loads. Unit loads shall be marked in accordance with DSCP FORM 3556. In addition, each unit load shall be provided with a Material Safety Data Sheet (MSDS), in accordance with MIL-R-44398. The MSDS shall be packaged and attached to one side of the

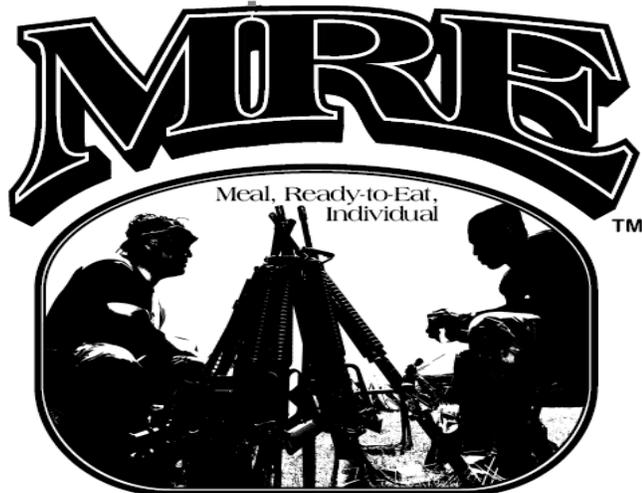
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unit load. A copy of the MSDS must be included with the shipping papers and a copy must also be placed in the vehicle manifest.

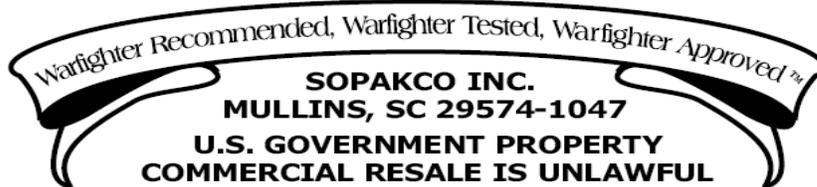


FIGURE 1. Design 1 of Meal Bag Graphics

Peelable Seal ↑



MENU 18
Meatballs
in Marinara
Sauce



FLAMELESS RATION HEATERS ARE PROHIBITED ON COMMERCIAL AIRLINES UNLESS SEALED IN ORIGINAL MRE MENU BAG

FIGURE 2. Design 2 of Meal Bag Graphics

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Peelable Seal ↑



**MENU 18
MEATBALLS
IN MARINARA SAUCE**

MRE™
MEAL, READY-TO-EAT, INDIVIDUAL

**Warfighter Recommended,
Warfighter Tested,
Warfighter Approved™**

**AMERIQUAL PACKAGING
EVANSVILLE, IN 47710**

**U.S. GOVERNMENT PROPERTY
COMMERCIAL RESALE IS UNLAWFUL**

**FLAMELESS RATION HEATERS ARE PROHIBITED ON COMMERCIAL
AIRLINES UNLESS SEALED IN ORIGINAL MRE MENU BAG**

FIGURE 3. Design 3 of Meal Bag Graphics

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 of Conformance (CoC) to the appropriate inspection activity. CoCs 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) Pouch material certification. A CoC may be accepted as evidence that the characteristics listed below conform to the specified requirements.

<u>Requirement</u>	<u>Requirement para</u>	<u>Test procedure</u>
Thickness of meal bag	D-1,A,(3)	ASTM D 2103 <u>1/</u>
Color of meal bag and subassembly/accessory packet	D-1,A,(1) and D-1,A,(3)	Visual evaluation and FED-STD-595, as applicable <u>2/</u>
Water vapor transmission rate	D-1,A,(1)	ASTM F 372, ASTM E 96 or Method 3030, FED-STD-101 <u>3/</u>

- 1/ ASTM D 2103 Standard Specification for Polyethylene Film and Sheeting
- 2/ FED-STD-595 Colors Used in Government Procurement
- 3/ ASTM E 96 Standard Test Methods for Water Vapor Transmission of Materials
 ASTM F 372 Standard Test Method for Water Vapor Transmission Rate of Flexible Barrier Materials Using an Infrared Detection Technique
 FED-STD-101 Test Procedures for Packaging Materials

(2) Subassembly/accessory packet examination. The filled and sealed packets shall be examined for the defects listed in table IV. 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.

TABLE IV. Subassembly/accessory packet defects

Category		Defect
<u>Major</u>	<u>Minor</u>	
101		Not clean. <u>1/</u>
	201	Seal width less than 1/16 inch. <u>2/</u>
	202	Tear nick or notch or serrations missing or does not facilitate opening.
	203	Tear or hole or open seal.
	204	Label missing or incorrect or illegible.
	205	Pouch not sealed on four sides.

1/ Outer packaging shall be free from foreign matter, which is unwholesome, has the potential to cause package damage (for example, glass, metal fillings, 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 surface area of one pouch face.

2/ An effective seal is defined as any uncontaminated, fusion bonded, continuous path, minimum 1/16 inch wide, producing a hermetically sealed pouch.

(3) Subassembly/accessory packet contents examination. The filled and sealed packets shall be examined for the defects listed in table V (this examination may be performed on the preformed packets after filling and prior to sealing). The lot size shall be expressed in packets. The sample unit shall be one packet, open or sealed. The inspection level shall be S-4 and the AQL, expressed in terms of defects per hundred units, shall be 1.5 for major defects and 4.0 for minor defects.

TABLE V. Subassembly/accessory packet contents defects

Category		Defect
<u>Major</u>	<u>Minor</u>	
101		Component not clean. <u>1/</u>
	201	Missing or unserviceable component.
	202	Plastic shrink film missing from around screw cap of hot sauce bottle or hot sauce bottle leaking, as applicable.

1/ Outer packaging shall be free from foreign matter, which is unwholesome, has the potential to cause package damage (for example, 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 package face, or an aggregate of scattered dried product which affects less than 1/4 of the total surface area of one package face.

(4) Assembled meal bag examination. The filled and sealed meal bags shall be inspected for the defects listed in table VI. The lot size shall be expressed in bags. The sample unit shall be one bag. The inspection level shall be S-4 and the 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 each of the meals.

TABLE VI. Assembled meal bag defects

Category			Defect
<u>Critical</u>	<u>Major</u>	<u>Minor</u>	
1			Tear or hole or puncture through carton or open carton causing a hole in the pouch or obviously wet or stained carton due to leaking pouch. <u>1/</u>
2			Tear or hole or open seal in cheese spread.
3			Swollen cheese spread pouch, or swollen pouch or carton of thermostabilized item.
4			Tear or hole or puncture in uncartoned thermostabilized pouch.
	101		Tear or hole in carton exposing pouch to potential damage.
	102		Menu component missing or incorrect assortment for menu. <u>4/</u>
	103		Meal bag not clean or outer packaging of its contents not clean. <u>2/</u>
	104		Foreign odor.
	105		Labeling missing or incorrect or illegible.
	106		Swollen peanut butter or jelly or jam pouch.
	107		Tear or hole or open seal in component packages.
	108		Crushed or broken component. <u>3/</u>
	109		Broken spoon.
	110		Chocolate toffee rolls or cubes not packaged in barrier pouch.

TABLE VI. Assembled meal bag defects (continued)

Category			Defect
<u>Critical</u>	<u>Major</u>	<u>Minor</u>	
		201	Tear or hole or open seal or split in meal bag.
		202	Tear or hole or open seal in subassembly/accessory packet.
		203	Thermostabilized carton flaps open or tear or hole in carton not exposing pouch to potential damage.
		204	Inverted "V" shaped peel indicator missing or not located as specified.
		205	Plastic shrink film missing from around screw cap of hot sauce bottle or hot sauce bottle leaking, as applicable.
		206	Labeling graphics of meal bag not correct.

1/ Applies to cartoned items.

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 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 surface area of one pouch face.

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

4/ A missing entrée shall be cause for rejection of the lot.

D. Methods of inspection.

(1) Seal testing. The pouch seals shall be tested for seal strength or internal pressure resistance as required in a, b, c, or d, as applicable.

a. Unfilled preformed subassembly/accessory packet pouch. The seals of the unfilled preformed pouches for the subassembly/accessory packet shall be tested for seal strength in accordance with ASTM F 88, Seal Strength of Flexible Barrier Materials. The lot size shall be expressed in pouches. The sample unit shall be one pouch. The inspection shall be level S-1 and the AQL, expressed in defects per hundred units, shall be 10.0. Three specimens shall be cut from each of the three sealed sides of each pouch in the sample. The average seal strength of any side shall be calculated by averaging the results of the three specimens cut from that side. Any test specimen failing to meet a seal strength of 3 pounds per inch of width shall be scored as a major defect. Any average seal strength of less than 3.5 pounds per inch of width shall be cause for rejection of the lot. Alternatively, 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-1. 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 IV, footnote 2/) shall be considered a test failure. Any test failure shall be a major defect and shall be cause for rejection of the lot.

b. Unfilled meal bag. The seals of the unfilled meal bags shall be tested for seal strength in accordance with ASTM F 88. The lot size shall be expressed in bags. The sample unit shall be one bag. The sample size shall be the number of bags indicated by inspection level S-1. Three specimens shall be cut from the sealed end of each bag in the sample. Samples shall not be taken from the inverted "V" peel initiation. Any specimen with a seal strength less than 4 pounds per inch of width or greater than 10 pounds per inch of width shall be a major defect and shall be cause for rejection of the lot.

c. Subassembly/accessory packet pouch closure. The closure seals of the pouches for the subassembly/accessory packet shall be tested for seal strength in accordance with ASTM F 88. The lot size shall be expressed in pouches. The sample unit shall be one pouch. The inspection level shall be S-1 and the AQL, expressed in defects per hundred units, shall be 10.0. For the closure seal on preformed pouches, three adjacent specimens shall be cut from the closure seal of each pouch in the sample. For the form-fill-seal pouches, three specimens shall be cut from each side and each end of each pouch in the sample. The average seal strength of any side, end or closure shall be calculated by averaging the three specimens cut from that side, end or closure. Any test specimen failing to meet a seal strength of 3 pounds per inch of width shall be scored as a major defect. Any average seal strength of less than 3.5 pounds per inch of width shall be cause for rejection of the lot. Alternatively, 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-1. 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 IV, footnote 2/) shall be considered a test failure. Any test failure shall be a major defect and shall be cause for rejection of the lot.

d. Meal bag closure. The closure seals of the meal bags shall be tested for seal strength in accordance with ASTM F 88. The lot size shall be expressed in bags. The sample unit shall be one bag. The sample size shall be the number of bags indicated by inspection level S-1. Three specimens shall be cut from the closure seal of each bag in the sample. The average seal strength shall be calculated by averaging the three test specimens cut from that seal (the sample unit). Any test specimen result less than 3 pounds per inch of width shall be cause for rejection of the lot. Any average seal strength of less than 4 pounds per inch of width shall be cause for rejection of the lot.

(2) Unfilled meal bag and unfilled preformed subassembly/accessory packet pouch seal certification. A CoC may be accepted as evidence that unfilled bags or pouches conform to the seal strength requirements specified in D-1,A,(1) and (3). When deemed necessary by the government inspector, testing of the unfilled preformed pouches for seal strength shall be as specified in E,D(1)a.

E. Packing.

(1) Shipping container and marking examination. The filled and sealed shipping containers shall be examined for the defects listed in table VII. 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.

TABLE VII. 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 meal. <u>2/</u>
105		Not one of each menu specified.
	201	Time-temperature indicator missing or not centrally located on panel.
	202	Time-temperature indicator 1/4-inch quiet zone not maintained.
	203	Meal bag graphics do not coincide with specified design.

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 meal is a defect.

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(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 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 as a major defect.

F. 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

DSCP FORMS

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

MILITARY SPECIFICATIONS

MIL-PRF-32176	Bag, Hot Beverage
MIL-R-44398B	Ration Supplement, Flameless Ration Heater (FRH)

FEDERAL STANDARDS

FED-STD-101	Test Procedures for Packaging Materials
FED-STD-595	Colors Used in Government Procurement

NON-GOVERNMENTAL STANDARDS

AMERICAN SOCIETY FOR QUALITY (ASQ)
ANSI/ASQ Z1.4-2003 Sampling Procedures and Tables for Inspection by Attributes

ASTM INTERNATIONAL

D 1974-98 (2003)	Standard Practice for Methods of Closing, Sealing, and Reinforcing Fiberboard Boxes
D 2103-05	Standard Specification for Polyethylene Film and Sheeting
D 4727/D 4727M-07	Standard Specification for Corrugated and Solid Fiberboard Sheet Stock (Container Grade) and Cut Shape
D 5118/D 5118M-05ae1	Standard Practice for Fabrication of Fiberboard Shipping Boxes
E 96/E 96M-05	Standard Test Methods for Water Vapor Transmission of Materials
F 88-07a	Standard Test Method for Seal Strength of Flexible Barrier Materials
F 372-99 (2003)	Standard Test Method for Water Vapor Transmission Rate of Flexible Barrier Materials Using an Infrared Detection Technique

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For DSCP Website Posting

RDNS-CFF

9 June 2009

TO: DSCP-FTRE

SUBJECT: ES09-127 (DSCP-SS-09-32830); Document Change Request for ACR-M-029, Meal, Ready-to-Eat (MRE™) Assembly Requirements; and PKG & QAP for A-A-20098D, Beverage Bases, Powdered, Drawings/Graphics needed for pouch designs and changes to PKG & QAP for A-A-20098D.

1. In reviewing ACR-M-029, A contractor noticed a discrepancy for the GFM beverages regarding the reference to the design of the pouch required.
 - a. CID A-A-20098 Beverage Base, Powdered, Sweetened with Nutritive, Sweetener, Fortified with Ascorbic Acid and Maltodextrin, Type II is in a Design E pouch (small flat pouch).
 - b. CID A-A-20098 Beverage Base, Powdered, Sweetened with Non-nutritive Sweetener, Type III is in a Design D pouch (lap or fin seal pouch).
2. The current ACR-M-029 requires Type II and Type III to be Design A (large flat pouch). The contractor is receiving the above mentioned design pouches on those two types of beverage base.
3. Natick concurs with the contractors findings and that the ACR-M-029 needs to be changed to cite the correct pouch designs for Types II and III.
4. Natick submits the following changes for to ACR-M-029 for all current, pending and future procurements until the subject document is formally amended or revised.
 - a. Section C-2, A, Table I, Beverages, make the following changes:
 - (1) Under "Component":
 - (a) Line 1, Beverage Base, after "Powdered" delete ", Flat Pouch"
 - (b) Line 3, insert new line after "Maltodextrin" insert "Small Flat Pouch"
 - (c) Line 9, insert new line after "Non-fortified" insert "Lap or Fin Seal Pouch"
 - (2) Under "Reference":

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- (a) Line 1, after “20098D” delete “, Design A”
- (b) Line 3, insert new line after “Formulation d” insert “Design E”
- (c) Line 9, insert new line after “Formulation a” insert “Design D”

5. Natick non-concurs with DSCP’s request to include a drawing of the flat pouch (Design A) in the PKG & QAP for A-A-20098D. These pouches have been procured based on the requirements paragraphs without problems.
6. Natick non-concurs with DSCP’s request to change PKG & QAP for A-A-20098D, Paragraph C-2, E. (1) to show that the flat pouch (Design A) has been reinstated. Design A is not applicable to Type II beverage bases.
7. DSCP inquired about the difference between Design A flat pouch and Design E small flat pouch. The difference between Design A flat pouch and Design E small flat pouch are the pouch measurements which are stated in PKG & QAP for CID A-A-20098D, Beverage Bases, Powdered, section D-1, A. (1) Design A Flat Pouch b. Pouch construction and D-1, A. (5) Design E Small flat pouches b. pouch construction.
8. Attached is ACR-M-029, Change 03, dated 9 June 09 with changes highlighted.