

PKG & QAP (Flexible Pouch)
A-A-20295C
30 September 2009
SUPERSEDING
A-A-20295B
17 August 2004
W/Change 02 25 May 2011

SECTION C

This document covers cookies packaged in a flexible pouch for use by the Department of Defense as a component of operational rations.

C-1 ITEM DESCRIPTION

**PACKAGING REQUIREMENTS AND QUALITY ASSURANCE PROVISIONS FOR
CID A-A-20295C, COOKIES, PACKAGED IN A FLEXIBLE POUCH, SHELF
STABLE**

Types, styles, shapes, flavors, bake types and classes.

Type I -	Regular
Style A -	Shortbread cookies, bake type a – crisp
Flavor 1 -	Plain
Style B -	Wafer cookies, bake type a – crisp
Flavor 5	Chocolate with pecans
Style D -	Sugar cookies, bake type a – crisp
Shape (b) –	Patriotic
Style E -	Sandwich cookies bake type a – crisp
Flavor 2	Peanut butter
Style I -	Oatmeal cookies, bake type a – crisp
Flavor 1 -	Plain
Style J -	Chocolate chip cookies, bake type a – crisp
Flavor 1 -	Plain
Flavor 8 -	Chocolate mint with chocolate chips
Style K -	Kreamsicle cookies, bake type a – crisp
Style L -	Toffee crunch cookies, bake type a – crisp
Style M -	Molasses cookies, bake type b – soft and chewy
Style P -	Fig bar, bake type b – soft and chewy
Style Q -	White chocolate chip cookies, bake type a – crisp
Flavor 1	Raspberry
Style T –	French toast cookies, bake type a – crisp

PKG & QAP (Flexible Pouch)
A-A-20295C
30 September 2009
SUPERSEDING
A-A-20295B
17 August 2004
W/Change 02 25 May 2011

Class 1 – Individual serving package

Packages.

Package A - Meal, Cold Weather (MCW)
Package B - Food Packet, Long Range Patrol (LRP)
Package C - Meal, Ready-to-Eat™ (MRE™)

C-2 PERFORMANCE REQUIREMENTS

A. Product standard. A sample shall be subjected to first article (FA) or product demonstration model (PDM) inspection as applicable, in accordance with the tests and inspections of Section E of this Packaging Requirements and Quality Assurance Provisions. The approved sample shall serve as the product standard. Should the contractor at any time plan to, or actually produce the product using different raw material or process methodologies from the approved product standard, which result in a product non comparable to the product standard, the contractor shall arrange for a new or alternate FA or PDM approval. In any event, all product produced must meet all requirements of this document including product standard comparability.

B. Shelf life. The packaged product shall meet the minimum shelf life requirement of 36 months at 80°F.

C. Appearance.

(1) Style D, shape (b), bake type a crisp – Sugar cookies, Patriotic. The patriotic sugar cookies shall have at least three different patriotic shapes in each package.

(2) Style J, Flavor 1, bake type a crisp – Chocolate chip cookies, plain. The plain chocolate chip cookies shall be a tan to medium brown color.

(3) Style J, Flavor 8, bake type a crisp – Chocolate chip cookies, chocolate mint with chocolate chips. The chocolate mint with chocolate chips cookies shall have a dark brown exterior and interior crumb.

PKG & QAP (Flexible Pouch)
A-A-20295C
30 September 2009
SUPERSEDING
A-A-20295B
17 August 2004
W/Change 02 25 May 2011

(4) Style P, bake type b soft and chewy – Fig bar cookies. The fig bar cookies bakery covering shall be uniform, a golden brown color and shall not be soggy. The fig bar filling shall be uniform and shall be a fig color.

D. Odor and flavor. The packaged cookies shall be free from foreign odors and flavors.

(1) Style A, Flavor 1, bake type a crisp – Shortbread cookies, plain. The shortbread cookies shall have a sweet, buttery odor and flavor.

(2) Style B, Flavor 5, bake type a crisp – Wafers, chocolate with pecans. The chocolate with pecans cookies shall have a slightly sweet, cocoa odor and flavor, and have a mild pecan flavor.

(3) Style D, shape (b), bake type a crisp – Sugar cookies, Patriotic. The sugar cookies shall have a sweet, buttery, and mild vanilla odor and flavor.

(4) Style E, Flavor 2, bake type a crisp – Sandwich cookies, peanut butter. The peanut butter sandwich cookies shall have a peanut butter odor and flavor.

(5) Style I, Flavor 1, bake type a crisp – Oatmeal cookies, plain. The oatmeal cookies shall have a distinct sweet baked oatmeal odor and flavor.

(6) Style J, Flavor 1, bake type a crisp – Chocolate chip cookies, plain. The chocolate chip cookies shall have a distinct chocolate odor and flavor.

(7) Style J, Flavor 8, bake type a crisp – Chocolate chip cookies, chocolate mint with chocolate chips. The chocolate mint with chocolate chips cookies shall have a distinct chocolate mint odor and flavor.

(8) Style K, bake type a crisp – Kreamsicle cookies. The Kreamsicle cookies shall have a sweet, buttery, mild orange odor and flavor, with orange flavored chips.

(9) Style L, bake type a crisp – Toffee crunch cookies. The toffee crunch cookies shall have a sweet, buttery, toffee/vanilla odor and flavor.

(10) Style M, bake type b soft and chewy – Molasses cookies. The molasses cookies shall have a sweet, cooked molasses and mild spices odor and flavor.

PKG & QAP (Flexible Pouch)
A-A-20295C
30 September 2009
SUPERSEDING
A-A-20295B
17 August 2004
W/Change 02 25 May 2011

(11) Style P, bake type b soft and chewy – Fig Bar cookies. The fig bar cookies shall have a sweet, baked fig odor and flavor.

(12) Style Q, Flavor 1, bake type a crisp – White chocolate chip cookies, raspberry. The white chocolate chip raspberry cookies shall have a sweet raspberry and white chocolate odor and flavor.

(13) Style T, bake type a crisp – French toast cookies. The french toast cookies shall have a graham cracker, maple, and sweet cinnamon sugar odor and flavor.

F. Texture.

(1) Style A, Flavor 1, bake type a crisp – Shortbread cookies, plain. The shortbread cookies shall have a dense and tender texture.

(2) Style P, bake type b – Fig bar cookies. The fig bar cookies shall have a soft texture.

E. Net weight. The net weight of one serving shall be not less than the following:

Cookie type	Net weight not less than
Style A, Flavor 1, bake type a crisp – Shortbread cookies, plain	43 grams
Style B, Flavor 5, bake type a crisp – Wafers, Chocolate with pecans	56 grams
Style D, shape (b), bake type a crisp – Sugar cookies, Patriotic	56 grams
Style E, Flavor 2, bake type a crisp – Sandwich cookies, peanut butter	54 grams
Style I, Flavor 1, bake type a crisp – Oatmeal cookies, plain	56 grams
Style J, Flavor 1, bake type a crisp – Chocolate chip cookies, plain	60 grams
Style J, Flavor 8, bake type a crisp – Chocolate chip cookies, chocolate mint with chocolate chips	56 grams

PKG & QAP (Flexible Pouch)
A-A-20295C
30 September 2009
SUPERSEDING
A-A-20295B
17 August 2004
W/Change 02 25 May 2011

Cookie type	Net weight not less than
Style K, bake type a crisp – Kreamsicle cookies	56 grams
Style L, bake type a crisp – Toffee crunch cookies	56 grams
Style M, bake type b soft and chewy – Molasses cookies	56 grams
Style P, bake type b soft and chewy – Fig bar cookies	54 grams
Style Q, Flavor 1, bake type a crisp – White chocolate chip cookies, raspberry	56 grams
Style T, bake type a crisp – French toast cookies	50 grams

F. Palatability and overall appearance. The finished product shall be equal to or better than the approved product standard in palatability and overall appearance.

G. Analytical requirements.

(1) Calorie content. The calorie content of one serving shall be not less than the following:

Cookie type	Calorie content not less than
Style A, Flavor 1, bake type a crisp – Shortbread cookies, plain	210 calories
Style B, Flavor 5, bake type a crisp – Wafers, Chocolate with pecans	260 calories
Style D, shape (b), bake type a crisp – Sugar cookies, Patriotic	240 calories
Style E, Flavor 2, bake type a crisp – Sandwich cookies, peanut butter	250 calories
Style I, Flavor 1, bake type a crisp – Oatmeal cookies, plain	280 calories
Style J, Flavor 1, bake type a crisp – Chocolate chip cookies, plain	280 calories
Style J, Flavor 8, bake type a crisp – Chocolate chip cookies, chocolate mint with chocolate chips	220 calories
Style K, bake type a crisp – Kreamsicle cookies	250 calories

PKG & QAP (Flexible Pouch)
A-A-20295C
30 September 2009
SUPERSEDING
A-A-20295B
17 August 2004
W/Change 02 25 May 2011

Cookie type	Calorie content not less than
Style L, bake type a crisp – Toffee crunch cookies	250 calories
Style M, bake type b soft and chewy – Molasses cookies	230 calories
Style P, bake type b soft and chewy – Fig bar cookies	200 calories
Style Q, Flavor 1, bake type a crisp – White chocolate chip cookies, raspberry	250 calories
Style T, bake type a crisp – French toast cookies	230 calories

(2) Oxygen content (not applicable to vacuum packed pouches). The oxygen content of the filled and sealed pouch shall not exceed 0.30 percent.

(3) Moisture content. The moisture content for cookies shall be as specified in A-A-20295C unless listed below:

Cookie type	Moisture content not greater than
Style B, Flavor 5, bake type a crisp – Wafers, Chocolate with pecans	4.0 percent
Style D, shape (b), bake type a crisp – Sugar cookies, Patriotic	3.5 percent
Style J, Flavor 1, bake type a crisp – Chocolate chip cookies, plain	6.0 percent

SECTION D

D-1 PACKAGING

A. Packaging. When specified, the cookie(s) with or without commercial wrapping and labeling shall be packed in a preformed or form-fill-seal barrier pouch as described below in accordance with the packaging conditions specified.

PKG & QAP (Flexible Pouch)
A-A-20295C
30 September 2009
SUPERSEDING
A-A-20295B
17 August 2004
W/Change 02 25 May 2011

Cookie type	Packaging conditions	
	Oxygen scavenger	Vacuum packed
Style A, Flavor 1, bake type a crisp – Shortbread cookies, plain	X	
Style B, Flavor 5, bake type a crisp – Wafers, Chocolate with pecans	X	
Style D, shape (b), bake type a crisp – Sugar cookies, Patriotic	X	
Style E, Flavor 2, bake type a crisp – Sandwich cookies, peanut butter		X
Style I, Flavor 1, bake type a crisp – Oatmeal cookies, plain		X
Style J, Flavor 1, bake type a crisp – Chocolate chip cookies, plain		X
Style J, Flavor 8, bake type a crisp – Chocolate chip cookies, chocolate mint with chocolate chips	X	
Style K, bake type a crisp – Kremsicle cookies		X
Style L, bake type a crisp – Toffee crunch cookies		X
Style M, bake type b soft and chewy – Molasses cookies		X
Style P, bake type b soft and chewy – Fig bar cookies ^{1/}		X
Style Q, Flavor 1, bake type a crisp – White chocolate chip cookies, raspberry	X	
Style T, bake type a crisp – French toast cookies	X	

^{1/} For the fig bars that are vacuum packed: one or more fig bars, shall be inserted into the pouch in a two-high stack or positioned side by side prior to sealing.

PKG & QAP (Flexible Pouch)
A-A-20295C
30 September 2009
SUPERSEDING
A-A-20295B
17 August 2004
W/Change 02 25 May 2011

(1) Preformed pouches.

a. Pouch material. The preformed pouch shall be fabricated from 0.002 inch thick ionomer or polyethylene film laminated or extrusion coated to 0.00035 inch thick aluminum foil which is then laminated to 0.0005 inch thick polyester. Tolerances for thickness of plastic films shall be plus or minus 20 percent and tolerance for foil layer shall be plus or minus 10 percent. The material shall show no evidence of delamination, degradation, or foreign odor when heat sealed or fabricated into pouches. The material shall be suitably formulated for food packaging and shall not impart an odor or flavor to the product. For package A (MCW) the complete exterior surface of the pouch shall be colored white overall with a color in the range of 37778 through 37886 of FED-STD-595, Colors Used in Government Procurement. For package B (LRP) and package C (MRE™), the complete exterior surface of the pouch shall be uniformly colored in the range of 20219, 30219, 30279, 30313, 30324, or 30450 of FED-STD-595.

b. Pouch construction. The pouch shall be a flat style preformed pouch having maximum inside dimensions of 5 inches wide by 7 inches long. The pouch shall be made by heat sealing three edges with 3/8 inch (- 1/8, + 3/16 inch) wide seals. The side and bottom seals shall have an average seal strength of not less than 6 pounds per inch of width and no individual specimen shall have a seal strength of less than 5 pounds per inch of width when tested as specified in E-6,B,(1),a. Alternatively, the pouch shall exhibit no rupture or seal separation greater than 1/16 inch or seal separation that reduces the effective closure seal width to less than 1/16 inch when tested for internal pressure resistance as specified in E-6,B,(1),c. A tear nick, notch, or serrations shall be provided to facilitate opening of the filled and sealed pouch. A 1/8 inch wide lip may be incorporated at the open end of the pouch.

c. Pouch filling and sealing. When specified in D-1,A, product shall be inserted into the pouch and the filled pouch shall be sealed under a vacuum level of 8 to 12 inches of mercury with a minimum 1/8 inch wide heat seal. When specified in D-1, A, the commercially wrapped and labeled package of cookie(s) and one oxygen scavenger shall be inserted into the pouch. The filled pouch shall be sealed. The closure seal shall be free of foldover wrinkles or entrapped matter that reduces the effective closure seal width to less than 1/16 inch. Seals shall be free of impression or design on the seal surface that would conceal or impair visual detection of seal defects. The average seal strength shall be not less than 6 pounds per inch of width and no individual specimen shall have a seal strength of less than 5 pounds per inch of width when tested as specified in E-6,B,(1),b. Alternatively, the filled and sealed pouch shall exhibit no rupture or seal separation greater than 1/16 inch or

PKG & QAP (Flexible Pouch)
A-A-20295C
30 September 2009
SUPERSEDING
A-A-20295B
17 August 2004
W/Change 02 25 May 2011

seal separation that reduces the effective closure seal width to less than 1/16 inch when tested for internal pressure resistance as specified in E-6,B,(1),c.

(2) Horizontal form-fill-seal pouches.

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

b. Pouch construction. The tray-shaped body and the tray-shaped cover shall be formed by drawing the flexible laminate material into an appropriately shaped cavity. The flat cover shall be in the form of a flat sheet of the barrier material taken from roll stock. When specified, the cookie(s) shall be placed in the tray-shaped body of the pouch. The filled pouch body shall be hermetically sealed with a vacuum level of 12 to 14 inches of mercury. For pouches with three or more cookies, the filled pouch body shall be hermetically sealed with a vacuum level of 8 to 12 inches of mercury. When specified, the unit of commercially wrapped and labeled package of cookie(s) and one oxygen scavenger shall be placed into the

PKG & QAP (Flexible Pouch)
A-A-20295C
30 September 2009
SUPERSEDING
A-A-20295B
17 August 2004
W/Change 02 25 May 2011

tray-shaped body of the pouch. Pouch closure shall be effected by heat sealing together the cover and body along the entire pouch perimeter. The closure seal width shall be a minimum of 1/8 inch. The closure seal shall be free of entrapped material (bread crumbs, moisture, etc.) that reduces the effective closure seal to less than 1/16 inch wide. The closure seal shall have an average seal strength of not less than 6 pounds per inch of width and no individual specimen shall have a seal strength of less than 5 pounds per inch of width when tested as specified in E-6,B,(1),b. Alternatively, the filled and sealed pouch shall exhibit no rupture or seal separation greater than 1/16 inch or seal separation that reduces the effective closure seal width to less than 1/16 inch when tested for internal pressure resistance as specified in E-6,B,(1),c. The maximum outside dimensions of the sealed pouch shall be 6 inches wide by 8-5/8 inches long. A tear nick, notch or serrations shall be provided to facilitate opening of the filled and sealed pouch. The sealed pouch shall not show any evidence of material degradation, aluminum stress cracking, delamination or foreign odor. Seals shall be free of impression or design on the seal surface that would conceal or impair visual detection of seal defects.

B. Oxygen scavenger. The oxygen scavenger shall be constructed of materials that are safe for direct and indirect food contact, and shall be suitable for use with edible products. The oxygen scavenger shall be in compliance with all applicable FDA regulations.

D-2 LABELING

A. Pouches. Each pouch shall be correctly and legibly labeled. Printing ink shall be permanent black ink or other, dark, contrasting color which is free of carcinogenic elements. The label shall contain the following information:

- (1) Name and flavor of product (letters not less than 1/8 inch high)
- (2) Ingredients
- (3) Date 1/
- (4) Net Weight 2/
- (5) Name and address of packer
- (6) "Nutrition Facts" label in accordance with the Nutrition Labeling and Education Act (NLEA) and all applicable FDA regulations.

1/ Each pouch shall have the date of pack noted by using a four-digit code beginning with the final digit of the current year followed by the three digit Julian day code. For example, 14

PKG & QAP (Flexible Pouch)
A-A-20295C
30 September 2009
SUPERSEDING
A-A-20295B
17 August 2004
W/Change 02 25 May 2011

February 2010 would be coded as 0045. The Julian day code shall represent the day the product was packaged into the pouch.

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

D-3 PACKING

~~A. **Packing.** Not more than 40 pounds of product shall be packed in a fiberboard shipping box constructed in accordance with style RSC-L 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 200 of ASTM D 4727/D 4727M, Standard Specification for Corrugated and Solid Fiberboard Sheet Stock (Container Grade) and Cut Shapes. Each box shall be closed in accordance with ASTM D 1974, Standard Practice for Methods of Closing, Sealing, and Reinforcing Fiberboard Boxes.~~

Packing. Not more than 40 pounds of product shall be packed in a fiberboard shipping box constructed in accordance with style RSC-L 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, burst grade 200 or ECT grade 32 of ASTM D 4727/D 4727M, Standard Specification for Corrugated and Solid Fiberboard Sheet Stock (Container Grade) and Cut Shapes. Each box shall be closed in accordance with ASTM D 1974, Standard Practice for Methods of Closing, Sealing, and Reinforcing Fiberboard Boxes.

Comment [MTF1]: Natick case ES11-082 (DSCP-SS-11-45317), change 02, 25 May 11
Section D-3, A., delete the current section entirely and insert the following new section:
"Packing. Not more than 40 pounds of product shall be packed in a fiberboard shipping box constructed in accordance with style RSC-L 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, burst grade 200 or ECT grade 32 of ASTM D 4727/D 4727M, Standard Specification for Corrugated and Solid Fiberboard Sheet Stock (Container Grade) and Cut Shapes. Each box shall be closed in accordance with ASTM D 1974, Standard Practice for Methods of Closing, Sealing, and Reinforcing Fiberboard Boxes."

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.

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.

PKG & QAP (Flexible Pouch)
A-A-20295C
30 September 2009
SUPERSEDING
A-A-20295B
17 August 2004
W/Change 02 25 May 2011

(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. Classification of inspections. The inspection requirements specified herein are classified as follows:

(1) Product standard inspection. The first article or product demonstration model shall be inspected in accordance with the provisions of this document and evaluated for overall appearance and palatability. Any failure to conform to the performance requirements or any appearance or palatability failure, shall be cause for rejection of the lot. The approved first article or product demonstration model shall be used as the product standard for periodic review evaluations. All food components that are inspected by the USDA shall be subject to periodic review sampling and evaluation. The USDA shall select sample units during production of contracts and submit them to the following address for evaluation:

US Army Research, Development and Engineering Command
Natick Soldier Research, Development, and Engineering Center
RDNS-CFF
15 Kansas Street
Natick, MA 01760-5018

One lot shall be randomly selected during each calendar month of production. Six (6) sample units of each item produced shall be randomly selected from that one production lot. The six (6) sample units shall be shipped to Natick within five working days from the end of the production month and upon completion of all USDA inspection requirements. The sample units will be evaluated for the characteristics of appearance, odor, flavor, texture and overall quality.

PKG & QAP (Flexible Pouch)
A-A-20295C
30 September 2009
SUPERSEDING
A-A-20295B
17 August 2004
W/Change 02 25 May 2011

(2) Conformance inspection. Conformance inspection shall include the examinations and the methods of inspection cited in this section.

E-5 QUALITY ASSURANCE PROVISIONS (PRODUCT)

A. Product examination. The finished product shall be examined for compliance with the performance requirements in A-A-20295C and specified in Section C of the Packaging Requirements and Quality Assurance Provisions document utilizing the double sampling plans indicated in ANSI/ASQ Z1.4. The lot size shall be expressed in pouches. The sample unit shall be the contents of one pouch. The inspection level shall be S-3 and the acceptable quality level (AQL), expressed in terms of defects per hundred units, shall be 1.5 for major defects and 4.0 for minor defects. Defects and defect classifications are listed in table I.

TABLE I. Product defects 1/ 2/

Category		Defect
Major	Minor	
		<u>General</u>
101		Product not type or style or shape or flavor or bake type or class as specified.
102		Pouch does not contain one intact oxygen scavenger if specified. 3/ 4/
103		Crushed cookie(s). 5/
	201	Broken cookie(s). 6/
		<u>Net weight</u>
	202	Net weight of an individual pouch not as specified.

PKG & QAP (Flexible Pouch)
A-A-20295C
30 September 2009
SUPERSEDING
A-A-20295B
17 August 2004
W/Change 02 25 May 2011

TABLE I. Product defects 1/ 2/ – Continued

Category	Defect
<u>Major</u>	<u>Minor</u>
	<u>Style A, Flavor 1, bake type a crisp – Shortbread cookies, plain</u>
104	Shortbread cookie(s) not a sweet or not a buttery odor or flavor.
105	Shortbread cookie(s) not a dense or not a tender texture.
	203 Exterior color of the shortbread cookie(s) not light tan to medium brown.
	204 Interior crumb of the shortbread cookie(s) not a lighter color than the surface.
	<u>Style B, Flavor 5, bake type a crisp – Wafers, chocolate with pecans</u>
106	Chocolate with pecans cookie(s) not crisp or not tender or have a crumbly texture.
107	Chocolate with pecans cookie(s) not a disk shape with a rounded top.
108	Chocolate with pecans cookie(s) not a slightly sweet, cocoa odor and flavor or not a mild pecan flavor.
	205 Chocolate with pecans cookie(s) exterior not a dark brown color.
	206 Chocolate with pecans cookie(s) interior crumb not a dark brown color or not with pecan pieces throughout.
	<u>Style D, shape (b), bake type a crisp – Sugar cookies, Patriotic</u>
109	Sugar cookie(s) not sweet or not buttery or not with a mild vanilla odor or flavor.

PKG & QAP (Flexible Pouch)
A-A-20295C
30 September 2009
SUPERSEDING
A-A-20295B
17 August 2004
W/Change 02 25 May 2011

TABLE I. Product defects 1/ 2/ – Continued

Category		Defect
<u>Major</u>	<u>Minor</u>	
110		Sugar cookie(s) not crisp or not tender.
	207	Sugar cookie(s) not a uniform pale gold to tan color.
	208	Sugar cookie(s), shape (b) package does not contain at least three different patriotic shapes.
		<u>Style E, Flavor 2, bake type a crisp – Sandwich cookies, peanut butter</u>
111		Peanut butter sandwich cookie(s) not flat.
112		Peanut butter sandwich cookie(s) do not contain at least 20 percent, by weight, of filling. <u>7/</u>
113		Peanut butter sandwich cookie(s) not a peanut butter odor or flavor.
114		Peanut butter sandwich cookie(s) not a tender crispness.
	209	Peanut butter sandwich cookie(s) not tan to medium brown color.
	210	Peanut butter sandwich cookie(s) filling not creamy or not evenly distributed.
		<u>Style I, Flavor 1, bake type a crisp – Oatmeal cookies, plain</u>
115		Oatmeal cookies(s) not a sweet, baked oatmeal odor or flavor.
116		Oatmeal cookie(s) not crispy or not crunchy or not slightly crumbly or not with a firm bite.
	211	Oatmeal cookie(s) exterior or crumb not light tan to medium

PKG & QAP (Flexible Pouch)
A-A-20295C
30 September 2009
SUPERSEDING
A-A-20295B
17 August 2004
W/Change 02 25 May 2011

TABLE I. Product defects 1/ 2/ – Continued

Category		Defect
<u>Major</u>	<u>Minor</u>	
		brown.
		<u>Style J, Flavor 1, bake type a crisp – Chocolate chip cookies, plain</u>
117		Chocolate chip cookie(s) not a distinct chocolate odor or flavor.
118		Chocolate chip cookie(s) not crispy or not crunchy or not slightly crumbly or not with a firm bite.
	212	Chocolate chip cookie(s) not tan to medium brown color.
	213	Chocolate chip cookie(s) do not have a uniform distribution of chocolate chips.
		<u>Style J, Flavor 8, bake type a crisp – Chocolate chip cookies, chocolate mint with chocolate chips</u>
119		Chocolate mint with chocolate chips cookie(s) not a distinct mint chocolate odor or flavor.
120		Chocolate mint with chocolate chips cookie(s) not crispy or not crunchy or not slightly crumbly or not with a firm bite.
	214	Exterior color of chocolate mint with chocolate chips cookie(s) not dark brown.
	215	Interior crumb of chocolate mint with chocolate chips cookie(s) not dark brown.
	216	Chocolate mint with chocolate chips cookie(s) do not have a uniform distribution of chocolate chips.
		<u>Style K, bake type a crisp – Kremsicle cookies</u>

PKG & QAP (Flexible Pouch)
A-A-20295C
30 September 2009
SUPERSEDING
A-A-20295B
17 August 2004
W/Change 02 25 May 2011

TABLE I. Product defects 1/ 2/ – Continued

Category		Defect
<u>Major</u>	<u>Minor</u>	
121		Kreamsicle cookie(s) not a sweet or not a buttery or not a mild orange odor or flavor cookie or not with orange flavored chips.
122		Kreamsicle cookie(s) not firm or not crisp.
	217	Exterior color of Kreamsicle cookie(s) not uneven pale to medium golden brown or not with some surface cracking.
	218	Interior crumb of Kreamsicle cookie(s) not pale gold with evenly distributed orange colored chips.
		<u>Style L, bake type a crisp – Toffee crunch cookies</u>
123		Toffee crunch cookie(s) not sweet or not buttery or not toffee/vanilla odor or flavor with toffee chips.
124		Toffee crunch cookie(s) not firm or not crisp.
	219	Toffee crunch cookie(s) not uneven pale to medium golden brown exterior or crumb not with evenly distributed pieces of melted toffee candy bits or not with some surface cracking.
		<u>Style M, bake type b soft and chewy – Molasses cookies</u>
125		Molasses cookie(s) not slightly soft or not chewy.
126		Molasses cookie(s) not sweet or not cooked molasses flavor or not with odor or flavor of mild spices.
	220	Exterior color of molasses cookie(s) not dark gold to brown.
	221	Interior crumb of molasses cookie(s) not dark gold to brown.

PKG & QAP (Flexible Pouch)
A-A-20295C
30 September 2009
SUPERSEDING
A-A-20295B
17 August 2004
W/Change 02 25 May 2011

TABLE I. Product defects 1/ 2/ – Continued

Category	Defect
<u>Major</u>	<u>Minor</u>
	<u>Style P, bake type b soft and chewy – Fig bar</u>
127	Fig bar cookie(s) bakery covering not uniform or soggy.
128	Fig bar cookie(s) does not contain at least 50 percent, by weight, of fig filling. <u>7/</u>
129	Fig bar cookie(s) not a sweet, baked fig odor or flavor.
	222 Fig bar cookie(s) filling not uniform or not a fig color. <u>8/</u>
	223 Fig bar bakery covering not golden brown color.
	224 Fig bar cookie(s) not soft.
	<u>Style Q, Flavor 1, bake type a crisp – White chocolate chip cookies, raspberry</u>
130	The white chocolate chip raspberry cookie(s) not sweet raspberry or not white chocolate odor or flavor.
131	White chocolate chip raspberry cookie(s) not crispy or not crunchy or not slightly crumbly or not with a firm bite.
	225 Exterior color of white chocolate chip raspberry cookie(s) not light tan to medium brown.
	226 Interior crumb of white chocolate chip raspberry cookie(s) not tan to medium brown.
	227 White chocolate chips not a soft bite or not uniformly distributed throughout surface and interior crumb.
	<u>Style T, bake type a crisp – French toast cookies</u>

PKG & QAP (Flexible Pouch)
A-A-20295C
30 September 2009
SUPERSEDING
A-A-20295B
17 August 2004
W/Change 02 25 May 2011

TABLE I. Product defects ^{1/} ^{2/} – Continued

Category		Defect
<u>Major</u>	<u>Minor</u>	
132		French toast cookie(s) not square shaped with two small indents on the side edges to impart the appearance of a slice of bread.
133		French toast cookie(s) top surface not with cinnamon sugar crystals.
134		French toast cookie(s) not a graham cracker, or not a maple, or not a sweet cinnamon sugar odor or flavor.
	228	Exterior color of french toast cookie(s) not light tan to medium brown.
	229	Interior crumb of french toast cookie(s) not lighter than surface.
	230	French toast cookie(s) not crisp or not tender.

^{1/} Presence of any foreign materials such as, but not limited to, dirt, insect parts, hair, wood, glass, metal or mold, or any foreign odors or flavors such as, but not limited to burnt, scorched, rancid, sour, stale, musty or moldy, or foreign color shall be cause for rejection of the lot.

^{2/} Finished product not equal to or better than the approved product standard in palatability and overall appearance shall be cause for rejection of the lot.

^{3/} Construction of the oxygen scavenger and compliance with FDA regulations will be verified by Certificate of Conformance (CoC).

^{4/} The oxygen scavenger requirement is applicable to the following cookies:

- Style A, Flavor 1, bake type a crisp – Shortbread cookies, plain
- Style B, Flavor 5, bake type a crisp – Wafers, chocolate with pecans
- Style D, shape (b), bake type a crisp – Sugar cookies, Patriotic
- Style J, Flavor 8, bake type a crisp – Chocolate chip cookies, chocolate mint with

PKG & QAP (Flexible Pouch)
A-A-20295C
30 September 2009
SUPERSEDING
A-A-20295B
17 August 2004
W/Change 02 25 May 2011

chocolate chips

Style Q, Flavor 1, bake type a crisp – White chocolate chip cookies, raspberry

Style T, bake type a crisp – French toast cookies

5/ Ten grams of cookie crumbs, i.e., not discernible pieces, per pouch. For fig bar cookie(s) more than 1/4 of cookie(s) is crushed.

6/ For a pouch with one or two cookies, more than three broken pieces per cookie. For pouches with three or more cookies, more than half the cookies broken into three or more pieces. For fig bar cookie(s), more than 1/4 of cookie(s) is broken.

7/ Weight of filling for the cookie shall be verified with a Certificate of Conformance (CoC).

8/ Exposed fig filling that extends more than 1/4 the length of the cookie shall be scored a defect. A hairline crack that may or may not expose the fig filling shall not be scored a defect.

B. Methods of inspection.

(1) Shelf life. The contractor shall provide a Certificate of Conformance that the product has a 36 month shelf life when stored at 80°F. Government verification may include storage for 6 months at 100°F or 36 months at 80°F. Upon completion of either storage period, the product will be subjected to a sensory evaluation panel for appearance and palatability and must receive an overall score of 5 or higher based on a 9 point hedonic scale to be considered acceptable.

(2) Net weight.

a. Commercially wrapped product with oxygen scavenger. The net weight shall be verified with the label on the commercial package. Product not conforming to the net weight requirement in Section C of this Packaging Requirements and Quality Assurance Provisions document shall be cause for rejection of the lot.

b. Vacuum packed pouch. The net weight of the filled and sealed pouches shall be determined by weighing each sample unit on a suitable scale tared with a representative empty pouch. Results shall be reported to the nearest 1 gram.

PKG & QAP (Flexible Pouch)
A-A-20295C
30 September 2009
SUPERSEDING
A-A-20295B
17 August 2004
W/Change 02 25 May 2011

c. Commercially wrapped vacuum packed product pouch. The net weight shall be verified with the label on the vacuum packed commercial package. Product not conforming to the net weight requirement in Section C of this Packaging Requirements and Quality Assurance Provisions document shall be cause for rejection of the lot.

d. Filled pouch with oxygen scavenger. The net weight shall be determined by weighing each sample unit on a suitable scale tared with a representative empty pouch and an oxygen scavenger. Results shall be reported the nearest 1 gram.

(3) Calorie content. The calorie content shall be verified by the NLEA “Nutrition Facts” label. Product not conforming to the calorie content as specified in Section C of this document shall be cause for rejection of the lot.

(4) Oxygen content testing (not applicable to vacuum packed pouches). Eight filled and sealed pouches shall be randomly selected from one production lot and individually tested for oxygen content. Testing shall be accomplished after the filled and sealed pouches have been allowed to equilibrate at room temperature for not less than 48 hours from the time of sealing. Test results shall be reported to the nearest 0.01 percent. Government verification will be conducted through actual testing by a Government laboratory. Any individual result not conforming to the oxygen content requirement shall be cause for rejection of the lot.

(5) Moisture content testing. Moisture content testing shall be in accordance with A-A-20295C.

E-6 QUALITY ASSURANCE PROVISIONS (PACKAGING AND PACKING MATERIALS)

A. Packaging.

(1) Pouch material certification. The pouch material shall be tested for these characteristics. A Certificate of Conformance (CoC) may be accepted as evidence that the characteristics conform to the specified requirements.

<u>Characteristic</u>	<u>Requirement paragraph</u>	<u>Test procedure</u>
Thickness of films for laminated material	D-1,A,(1)a and D-1,A,(2)a	ASTM D 2103 <u>1</u> /

PKG & QAP (Flexible Pouch)
A-A-20295C
30 September 2009
SUPERSEDING
A-A-20295B
17 August 2004
W/Change 02 25 May 2011

Aluminum foil thickness	D-1,A,(1)a and D-1,A,(2)a	ASTM B 479 <u>2/</u>
Laminated material Identification and construction	D-1,A,(1)a and D-1,A,(2)a	Laboratory evaluation
Color of laminated material	D-1,A,(1)a and D-1,A,(2)a	FED-STD-595 <u>3/</u>

1/ ASTM D 2103 Standard Specification for Polyethylene Film and Sheeting

2/ ASTM B 479 Standard Specification for Annealed Aluminum and Aluminum-Alloy Foil for Flexible Barrier, Food Contact, and Other Applications

3/ FED-STD-595 Colors Used in Government Procurement

(2) Unfilled preformed pouch certification. A CoC may be accepted as evidence that unfilled pouches conform to the requirements specified in D-1,A,(1) a and b. When deemed necessary by the USDA, testing of the unfilled preformed pouches for seal strength shall be as specified in E-6,B,(1),a.

(3) Filled and sealed pouch examination. The filled and sealed pouches shall be examined for the defects listed in table II. The lot size shall be expressed in pouches. The sample unit shall be one pouch. The inspection level shall be I and the AQL, expressed in terms of defects per hundred units, shall be 0.65 for major defects and 2.5 for minor defects.

TABLE II. Filled and sealed pouch defects 1/

Category		Defect
<u>Major</u>	<u>Minor</u>	
101		Tear or hole or open seal.
102		Seal width less than 1/16 inch. <u>2/</u>
103		Presence of delamination. <u>3/</u>

PKG & QAP (Flexible Pouch)
A-A-20295C
30 September 2009
SUPERSEDING
A-A-20295B
17 August 2004
W/Change 02 25 May 2011

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

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

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

3/ Delamination defect classification:

Major - Delamination of the outer ply in the pouch seal area that can be propagated to expose aluminum foil at the food product edge of the pouch after manual flexing of the delaminated area. To flex, the delaminated area shall be held between the thumb and forefinger of each hand with both thumbs and forefingers touching each other. The delaminated area shall then be rapidly flexed 10 times by rotating both hands in alternating clockwise- counterclockwise directions. Care shall be exercised when flexing delaminated areas near the tear notches to avoid tearing the pouch material. After flexing, the separated outer ply shall be grasped between thumb and forefinger and gently lifted toward the food product edge of the seal or if the separated area is too small to be held between thumb and

PKG & QAP (Flexible Pouch)
A-A-20295C
30 September 2009
SUPERSEDING
A-A-20295B
17 August 2004
W/Change 02 25 May 2011

forefinger, a number two stylus shall be inserted into the delaminated area and a gentle lifting force applied against the outer ply. If separation of the outer ply can be made to extend to the product edge of the seal with no discernible resistance to the gentle lifting, the delamination shall be classified as a major defect. Additionally, spot delamination of the outer ply in the body of the pouch that is able to be propagated beyond its initial borders is also a major defect. To determine if the laminated area is a defect, use the following procedure: Mark the outside edges of the delaminated area using a bold permanent marking pen. Open the pouch and remove the contents. Cut the pouch transversely not closer than 1/4 inch ($\pm 1/16$ inch) from the delaminated area. The pouch shall be flexed in the area in question using the procedure described above. Any propagation of the delaminated area, as evidenced by the delaminated area exceeding the limits of the outlined borders, shall be classified as a major defect.

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

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

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

b. Dried product which affects less than 1/8 of the total surface area of one pouch face (localized and aggregate).

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

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

PKG & QAP (Flexible Pouch)
A-A-20295C
30 September 2009
SUPERSEDING
A-A-20295B
17 August 2004
W/Change 02 25 May 2011

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

B. Methods of inspection.

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

a. Unfilled preformed pouch seal testing. The seals of the unfilled preformed pouch shall be tested for seal strength in accordance with ASTM F 88, Standard Test Method for Seal Strength of Flexible Barrier Materials. The lot size shall be expressed in pouches. The sample unit shall be one unfilled pouch. The sample size shall be the number of pouches indicated by inspection level S-1. Three adjacent 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 three specimens cut from that side. Any average seal strength of less than 6 pounds per inch of width or any test specimen with a seal strength of less than 5 pounds per inch of width shall be classified as a major defect and shall be cause for rejection of the lot.

b. Pouch closure seal testing. The closure seals of the pouches 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 filled and sealed pouch. The sample size shall be the number of pouches indicated by inspection level S-1. 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 adjacent 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 average seal strength of less than 6 pounds per inch of width or any test specimen with a seal strength

PKG & QAP (Flexible Pouch)
A-A-20295C
30 September 2009
SUPERSEDING
A-A-20295B
17 August 2004
W/Change 02 25 May 2011

of less than 5 pounds per inch of width shall be classified as a major defect and shall be cause for rejection of the lot.

c. Internal pressure test. The internal pressure resistance shall be determined by pressurizing the pouches while they are restrained between two rigid plates. The lot size shall be expressed in pouches. The sample unit shall be one pouch. 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 II, footnote 2/) shall be considered a test failure. Any test failure shall be classified as a major defect and shall be cause for rejection of the lot.

C. Packing.

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

Category		Defect
<u>Major</u>	<u>Minor</u>	
101		Marking missing or incorrect or illegible.
102		Inadequate workmanship. 1/

PKG & QAP (Flexible Pouch)
A-A-20295C
30 September 2009
SUPERSEDING
A-A-20295B
17 August 2004
W/Change 02 25 May 2011

201 More than 40 pounds of product.

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.

SECTION J REFERENCE DOCUMENTS

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

DSCP FORMS

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

FEDERAL STANDARD

FED-STD-595 Colors Used in Government Procurement

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

B 479 Standard Specification for Annealed Aluminum and Aluminum-Alloy Foil for Flexible Barrier, Food Contact, and Other Applications

D 1238 Standard Test Method for Melt Flow Rates of Thermoplastics by Extrusion Plastometer

D 1505 Standard Test Method for Density of Plastics by the Density-Gradient Technique

PKG & QAP (Flexible Pouch)
A-A-20295C
30 September 2009
SUPERSEDING
A-A-20295B
17 August 2004
W/Change 02 25 May 2011

D 1974	Standard Practice for Methods of Closing, Sealing, and Reinforcing Fiberboard Boxes
D 2103	Standard Specification for Polyethylene Film and Sheeting
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
F 88	Standard Test Method for Seal Strength of Flexible Barrier Materials

PKG & QAP (Flexible Pouch)
A-A-20295C
30 September 2009
SUPERSEDING
A-A-20295B
17 August 2004
W/Change 02 25 May 2011

For DLA Troop Support - Subsistence Website Posting

RDNS-CFF

25 May 2011

TO: DLA Troop Support- Subsistence DSCP-FTRE

SUBJECT: ES11-082 (DSCP-SS-11-45317); Request for Document Changes to the D-3 Packing Requirements for the new Meal, Ready, to Eat™ (MRE™) Bakery Component, Solicitation SPM3S1-11-R-7076; MRE™ Bakery Components (cookies, ranger bars, tortillas, muffins, brownies, and pound cake); PCR-C-007D, Cakes, Brownies, and Muffin Tops, Packaged in a Flexible Pouch, Shelf Stable; PCR-R-008B, Ranger Bar, Packaged in a Flexible Pouch, Shelf Stable; PCR-T-008, Tortillas, Packaged in a Flexible Pouch, Shelf Stable; PCR-C-031 Cookies(s), with Pan Coated Chocolate Disks, Packaged in a Flexible Pouch; and Packaging Requirements and Quality Assurance Provisions (PKG & QAP) for CID A-A-20295C, Cookies, Packaged in a Flexible Pouch, Shelf Stable; Sterling Foods

1. Natick has reviewed and evaluated the subject request and concurs. The fiberboard industry has developed another grading system for fiberboard that cites the Edge Crush Test (ECT) value. Fiberboard produced with a burst grade of 200 or an ECT grade of 32 is equivalent. The cited ASTM standard D 4727/D 4727M is applicable to both the specified fiberboard material description (grade 200) and the proposed fiberboard material description (ECT grade 32) and makes no distinction as to performance between the two methods of evaluation in terms of performance of the end item. Both methods are acceptable for establishing performance of shipping container material for the intended purpose of the bakery components documents.

2. Natick submits the following changes to the subject documents for all current, pending and future procurements until the documents are formally amended or revised:

a. For PCR-C-007D, Cakes, Brownies, and Muffin Tops, Packaged in a Flexible Pouch, Shelf Stable make the following change:

(1) Section D-3, A., delete the current section entirely and insert the following new section:

PKG & QAP (Flexible Pouch)
A-A-20295C
30 September 2009
SUPERSEDING
A-A-20295B
17 August 2004
W/Change 02 25 May 2011

“Packing. Not more than 40 pounds of product shall be packed in a fiberboard shipping box constructed in accordance with style RSC-L 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, burst grade 200 or ECT grade 32 of ASTM D 4727/D 4727M, Standard Specification for Corrugated and Solid Fiberboard Sheet Stock (Container Grade) and Cut Shapes. Each box shall be closed in accordance with ASTM D 1974, Standard Practice for Methods of Closing, Sealing, and Reinforcing Fiberboard Boxes.”

b. For PCR-R-008B, Ranger Bar, Packaged in a Flexible Pouch, Shelf Stable make the following change:

(1) Section D-3, A., delete the current section entirely and insert the following new section:

“Packing. Not more than 40 pounds of product shall be packed in a fiberboard shipping box constructed in accordance with style RSC-L 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, burst grade 200 or ECT grade 32 of ASTM D 4727/D 4727M, Standard Specification for Corrugated and Solid Fiberboard Sheet Stock (Container Grade) and Cut Shapes. Each box shall be closed in accordance with ASTM D 1974, Standard Practice for Methods of Closing, Sealing, and Reinforcing Fiberboard Boxes.”

c. For PCR-T-008, Tortillas, Packaged in a Flexible Pouch, Shelf Stable make the following change:

(1) Section D-3, A., delete the current section entirely and insert the following new section:

“Packing. Not more than 40 pounds of product shall be packed in a fiberboard shipping box constructed in accordance with style RSC-L 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, burst grade 200 or ECT grade 32 of ASTM D 4727/D 4727M, Standard Specification for Corrugated and Solid Fiberboard Sheet Stock (Container Grade) and Cut Shapes. Each box shall be closed in accordance with ASTM D 1974, Standard Practice for Methods of Closing, Sealing, and Reinforcing Fiberboard Boxes.”

d. For PCR-C-031 Cookies(s), with Pan Coated Chocolate Disks, Packaged in a Flexible Pouch make the following change:

(1) Section D-3, A. delete the current section entirely and insert the following new section:

PKG & QAP (Flexible Pouch)
A-A-20295C
30 September 2009
SUPERSEDING
A-A-20295B
17 August 2004
W/Change 02 25 May 2011

“Packing. Not more than 40 pounds of product shall be packed in a fiberboard shipping box constructed in accordance with style RSC-L 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, burst grade 200 or ECT grade 32 of ASTM D 4727/D 4727M, Standard Specification for Corrugated and Solid Fiberboard Sheet Stock (Container Grade) and Cut Shapes. Each box shall be closed in accordance with ASTM D 1974, Standard Practice for Methods of Closing, Sealing, and Reinforcing Fiberboard Boxes.”

e. For PKG & QAP for CID A-A-20295C, Cookies, Packaged in a Flexible Pouch, Shelf Stable make the following change:

(1) Section D-3, A. delete the current section entirely and insert the following new section:

“Packing. Not more than 40 pounds of product shall be packed in a fiberboard shipping box constructed in accordance with style RSC-L 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, burst grade 200 or ECT grade 32 of ASTM D 4727/D 4727M, Standard Specification for Corrugated and Solid Fiberboard Sheet Stock (Container Grade) and Cut Shapes. Each box shall be closed in accordance with ASTM D 1974, Standard Practice for Methods of Closing, Sealing, and Reinforcing Fiberboard Boxes.”

3. Attached are the following documents with changes highlighted: PCR-C-007D, Cakes, Brownies, and Muffin Tops, Packaged in a Flexible Pouch, Shelf Stable dated 25 May 2011; PCR-R-008B, Ranger Bar, Packaged in a Flexible Pouch, Shelf Stable dated 25 May 2011; PCR-T-008, Tortillas, Packaged in a Flexible Pouch, Shelf Stable dated 25 May 2011; PCR-C-031 Cookies(s), with Pan Coated Chocolate Disks, Packaged in a Flexible Pouch dated 25 May 2011; and PKG & QAP for CID A-A-20295C, Cookies, Packaged in a Flexible Pouch, Shelf Stable dated 25 May 2011.