

PKG & QAP
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SECTION C

This document covers flavored cappuccino 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-20336A, DRINK MIXES, COFFEE (FLAVORED AND UNFLAVORED)

Type, style, and flavors.

Type V – Flavored, instant, Cappuccino

Style A – Regular

Flavor 1 – French vanilla

Flavor 2 – Mocha

Flavor 4 – Irish cream

Designs.

Design A – Flat pouch (discontinued)

Design B – Flat, interlocking closure pouch

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 the 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

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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. Dehydrated product.

(1) Appearance. The packaged product shall be free from foreign materials.

a. French vanilla. French vanilla color shall be an off white or a dark brown combination.

b. Mocha. Mocha color shall be a pale tan or a dark brown combination.

c. Irish cream. Irish cream color shall be a pale tan or a dark brown combination.

(2) Net weight. The net weight of an individual pouch shall be not less than 28.0 grams.

(3) Analytical requirements.

a. Moisture content. The moisture content shall be not greater than 3.0 percent.

b. Fat content. The fat content shall be not greater than 12.0 percent.

c. Calorie content. The product shall contain not less than 120 calories per serving.

(4) Microbiological requirement. The Salmonella requirements, procedures, and testing shall be in accordance with A-A-20336A and the NOTE cited in Section E-5.

(5) Analytical testing. The moisture and fat content procedures and testing shall be in accordance with A-A-20336A.

D. Rehydrated product.

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(1) Appearance. The rehydrated product shall be a medium cream brown color.

(2) Hydration. The product shall fully dissolve within two minutes in hot or cold water with constant stirring or shaking and show no evidence of undissolved floating particles.

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

SECTION D

D-1 PACKAGING

A. Packaging. Twenty-eight grams of product shall be filled into preformed pouches as described below.

(1) Design B Flat interlocking closure pouch. The pouch will be used as a package and as a hydrating pouch for the cappuccino powder.

a. Pouch material. The interlocking closure preformed pouch shall be fabricated from 0.002 inch thick ionomer or polyethylene film inner layer laminated or extrusion coated to 0.00035 inch thick aluminum foil which is then bonded to 0.0005 inch thick polyester. The three plies may be laminated with nylon on the exterior of the pouch. 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. The material shall be approved for addition of hot water (less than or equal to 212°F). 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, 30227, 30279, 30313, 30324, or 30450 of FED-STD-595.

b. Pouch construction. The pouch shall be a flat design preformed pouch with an interlocking closure. The design and dimensions shall be as indicated in Figure 1. The pouch shall be made by heat sealing the sides and top of the pouch with 3/8 inch ($\pm 1/8$, $-1/4$ inch) wide seals. The pouch shall exhibit no rupture or seal separation greater than 1/16 inch when

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tested for internal pressure resistance as specified in E-6,B,(1),b. The interlocking closure of the pouch shall not leak more than 15 ml when tested in accordance with E-6,B,(2). A tear nick or notch shall be provided on one or two opposite edges of the pouch above the interlocking closure 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.

(2) Pouch filling and sealing. Product shall be inserted into the pouch and the filled pouch shall be sealed with a 1/8-to 1 inch wide heat seal. The closure seal shall be applied not more than 1/2 inch from the open end of the pouch. 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),a. Alternatively, the pouch shall exhibit no rupture or seal separation greater than 1/16 inch when tested for internal pressure resistance as specified in E-6,B,(1),b.

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
- (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
- (7) Directions for Design B flat interlocking closure pouch: Allow water just chemically purified to stand 30 minutes before adding to cappuccino powder.

TEAR POUCH AT NOTCHES. OPEN ZIPPER, FOR HOT OR COLD CAPPUCCINO ADD HOT OR COLD WATER (6 OZ OR 1/4 CANTEEN CUP) TO FILL LINE. CLOSE ZIPPER. SHAKE TO MIX. *SINGLE USE ONLY.*

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Fill line for Design B flat interlocking closure pouch: A 6 ounce fill line (not less than 1/32 inch thick, not less than 2 inches long and centered) shall be placed on the pouch or label for 6-ounce fill at ~~4 1/8 ± 1/4 inches from inside edge of closure seal~~
4.0 ± 1/4 from the inside edge of the closure seal.

Comment [U1]: Natick case ES08-147 (DSCP-SS-08-19888) change 01, 17-DEC-08 Delete "4-1/8 ± 1/4 inches from the bottom open end of the pouch" and insert "4.0 ± 1/4 from the inside edge of the closure seal."

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 February 2007 would be coded as 7045. The Julian day code shall represent the day the product was packaged into the pouch.

D-3 PACKING

A. Packing for shipment to ration assembler. Not more than 40 pounds of pouched product shall be packed flat in layers in a fiberboard shipping container constructed in accordance with style RSC-L, class domestic, variety SW, grade 200 of ASTM D 5118/D 5118M, Standard Practice for Fabrication of Fiberboard Shipping Boxes. Each container shall be securely 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.

(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

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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
AMSRD-NSC-CF-F
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 two (2) working days upon completion of all USDA inspection requirements. The sample units will be evaluated for the characteristics of appearance, odor, flavor, texture and overall quality. Failure of samples to conform to all such characteristics may be cause for rejection.

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

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E-5 QUALITY ASSURANCE PROVISIONS (PRODUCT)

A. Product examination. The finished product shall be examined for compliance with the performance requirements specified in A-A-20336A and 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
<u>Major</u>	<u>Minor</u>
	<u>Dehydrated product</u>
	<u>Appearance</u>
101	Product not the type or style or flavor as specified.
	201
	French vanilla color not off white or not a dark brown combination.
	202
	Mocha or Irish cream colors not pale tan or not a dark brown combination.
	<u>Odor</u>
102	Odor not characteristic of type or style or flavor specified.
	<u>Texture</u>
	203
	Cappuccino not free flowing or not fine grained.
	204
	Presence of hard lumps. <u>3/</u>
	<u>Weight</u>
	205
	Net weight of individual pouch less than 28.0 grams.

TABLE I. Product defects 1/ 2/ cont'd

Category		Defect
<u>Major</u>	<u>Minor</u>	
		<u>Rehydrated product</u> <u>4/</u>
		<u>Appearance</u>
103		Product not smooth or not free of discernible lumps or sedimentation.
	206	Product not a medium cream brown color.
	207	Product does not exhibit a layer of milky white froth on top.
		<u>Odor and flavor</u>
104		Product does not have a strong sweetened coffee with cream odor.
105		Flavor not characteristic for the applicable type, style, flavor specified.
		<u>Texture</u>
	208	Product does not completely disperse with constant stirring or shaking.
	209	Product has undissolved floating particles.

1/ The presence of any foreign materials such as but not limited to, dirt, insect parts, hair, wood, glass, metal, or mold or the presence of any foreign odors or flavors such as, but not limited to burnt, scorched, rancid, sour, stale, musty or moldy shall be cause for rejection of the lot. Foreign flavor is not applicable to dehydrated product.

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. Palatability is not applicable to dehydrated product.

3/ Lumps that do not fall apart under light pressure between the fingers shall be scored as a defect.

4/ Prior to conducting the rehydrated product examination, the cappuccino shall be rehydrated per label instructions. Product that does not fully dissolve within 2 minutes with constant stirring or shaking shall be cause for rejection of the lot.

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. The net weight of the filled and sealed pouches shall be determined by weighing each sample on a suitable scale tared with a representative empty pouch. Results shall be reported to the nearest 0.1 gram.

(3) Analytical. The calories shall be verified by the NLEA "Nutrition Facts" label. Product not conforming to the calorie content as specified in Section C of this Packaging Requirements and Quality Assurance Provisions document shall be cause for rejection of the lot.

(4) Microbiological testing.

NOTE: The following conditions apply for salmonella and microbiological testing:

- (a) For prepackaged product received from a supplier and is not further processed, the contractor will furnish a Certificate of Analysis that the product represented is Salmonella Negative and meets all microbiological requirements.
- (b) For bulk product received, the contractor is responsible for providing a certificate of analysis stating that the bulk product is Salmonella negative and meets all microbiological requirements. USDA salmonella and additional microbiological testing is required for each

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end item lot and shall be the basis for lot acceptance with respect to Salmonella and other microbiological testing requirements.

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

A. Packaging.

(1) Pouch material certification. A Certificate of Conformance (CoC) may be accepted as evidence that the characteristics listed below conform to the specified requirements. Compliance to 21 CFR substances in contact with hot water (less than or equal to 212°F) may be verified by CoC.

<u>Requirement</u>	<u>Requirement paragraph</u>	<u>Test procedure</u>
Thickness of films for laminated material	D-1,A,(1),a	As specified in ASTM D 2103 <u>1/</u>
Aluminum foil thickness	D-1,A,(1),a	As specified in ASTM B479 <u>2/</u>
Laminated material identification and construction	D-1,A,(1),a	Laboratory evaluation
Color of laminated material	D-1,A,(1),a	Visual evaluation by 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 certification of conformance 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 and b.

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(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. 2/
103	Presence of delamination. 3/
104	Unclean pouch. 4/
105	Pouch has foreign odor.
106	Any impression or design on the heat seal surfaces which conceals or impairs visual detection of seal defects. 5/
107	Pouch fill line missing or does not measure within $\pm 1/4$ inch of $4 \frac{3}{4}$ inches from the inside edge of the closure seal.
108	Not packaged as specified.
201	Label missing or incorrect or illegible.
202	Tear nick or notch missing or does not facilitate opening.
203	Seal width less than 1/8 inch but greater than 1/16 inch.
204	Presence of delamination. 3/
205	Pouch does not meet design or dimensions cited in Figure 1.
206	Fill line on pouch not required thickness or length.

Comment [U2]: Natick case ES08-147 (DSCP-SS-08-19888) change 01, 17-DEC-08 Delete "within $\pm 1/4$ inch of 4-3/4 ; insert "4.0 $\pm 1/4$ "

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207 Design B pouch closure seal more than 1/2 inch from the open end of the pouch.

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 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.

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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.

B. Methods of inspection.

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

a. Pouch closure seal test. The closure seals of the pouches 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 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. 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 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. 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

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testing the side and top of the pouch. When testing the closure seal, the top and interlocking closure 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.

(2) Interlocking closure test. The interlocking closure of the pouch shall be tested. The lot size is expressed in pouches. The sample unit shall be one pouch. The sample size shall be the number of pouches indicated by inspection level S-2. Open a filled and sealed interlocking closure pouch and prepare beverage in accordance with instructions using 70°F (±5°F) water. Close pouch. Invert pouch and suspend pouch for 15 seconds. Collect and measure any liquid that drips. A pouch that leaks more that 15 ml shall be 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. <u>1/</u>
	201	More than 40 pounds of product.

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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.

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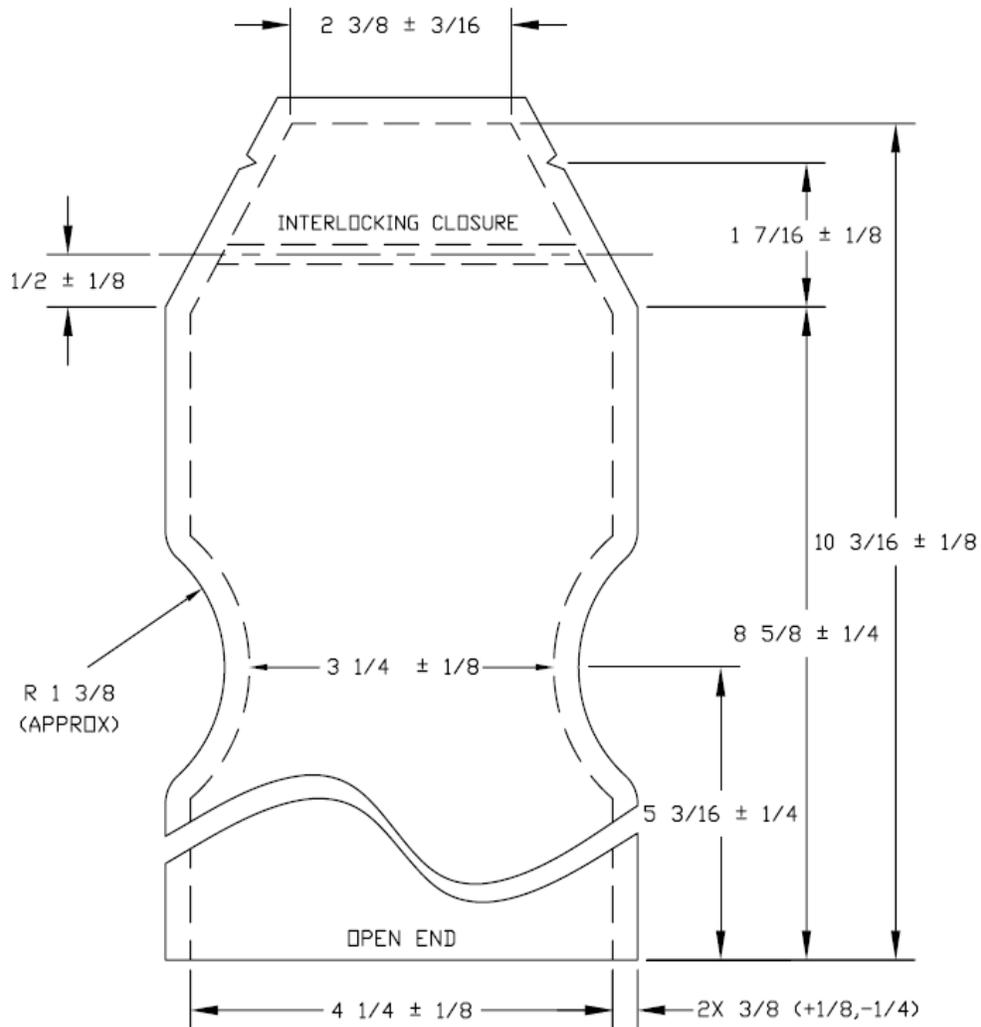


FIGURE 1. Design B Flat, Interlocking Closure Pouch
(Not actual size)

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SECTION J REFERENCE DOCUMENTS

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)

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

ASTM INTERNATIONAL

B 479-06 Standard Specification for Annealed Aluminum and
Aluminum-Alloy Foil For Flexible Barrier , Food Contact,
and Other Applications

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

F 88-07 Standard Test Method for Seal Strength of Flexible Barrier
Materials

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For DSCP Website Posting

AMSRD-NSR-CF-F

17 December 2008

TO: DSCP-FTRE

SUBJECT: ES08-147 (DSCP-SS-08-19888) Review of Interlocking Closure Pouch, Design B, Packaging changes for PKG&QA for A-A-20336A Drink Mixes, Coffees, (Flavored and Unflavored).

Date received: 30 September 2008

Date due: 29 October 2008

Date extended: Open

Date replied: 17 December 2008

1. Natick reviewed the interlocking closure pouch requirements for the subject document and evaluated submitted samples from the vendor.

Samples obtained were measured and fill lines tested. The original measurements from the 2007 memo do need a small adjustment.

3. Although the 2007 changes have been posted on the DSCP web site, the vendor's fill line for the flavored coffees are not in compliance with the requirement and the average distance from the fill line to the inside edge of the closure seal is 3.49 inches. The vendor's ideal fill line distance for the pouch they manufacture would be approximately 3.84 inches from the inside edge of the closure seal. Currently this company is the only vendor making the flavored coffees

4. Natick submits the following change to PKG&QA for A-A-20336A for all current, pending and future contracts until the document is formally amended or revised:

a. Section D-2, A. (9) Fill line paragraph. Delete "4-1/8 \pm 1/4 inches from the bottom open end of the pouch" and insert "4.0 \pm 1/4 inches from the inside edge of the closure seal."

b. Section E-6, A. 3. Table II. Defect 107, delete "within \pm 1/4 inch of 4-3/4"; insert "4.0 \pm 1/4"