

SECTION C

This document covers chicken chunks packaged in flexible pouches, shelf stable 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-20352 CHICKEN CHUNKS, WHITE, COOKED, CANNED OR IN FLEXIBLE POUCH

Types.

Type VI - Pouch – 198 g (7 oz)

Packages.

Package J - First Strike Ration (FSR)

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 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. The packaged product shall be chunk chicken, various sizes, whole muscle chicken. The exterior color of the chunk chicken shall be light tan. The interior chunk chicken color shall be light tan to pale pink and have a distinct fibrous appearance.

D. Odor and flavor. The odor and flavor of the chunk chicken shall be mild white meat chicken, and may possess a slightly salty taste.

E. Weight.

(1) Net weight. The average net weight shall be not less than 7.0 ounces (198 grams). No individual pouch shall have a net weight of less than 6.7 ounces (189 grams).

(2) Drained weight. The average drained weight shall be not less than 5.8 ounces (164 grams). No individual pouch shall have a drained weight of less than 5.5 ounces (155 grams).

F. Analytical. The salt, fat and protein requirements, procedures and testing shall be in accordance with A-A-20352.

G. 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

The specified product shall be filled into pouches and each pouch without the carton shall be packed in accordance with MIL-PRF-44073, Packaging of Food in Flexible Pouches.

D-2 LABELING

A. Pouches. Each pouch shall be clearly printed or stamped, in a manner that does not damage the pouch, with permanent black ink or any other contrasting color, which is free of carcinogenic elements. Prior to thermal processing of the pouches, the product name, lot number and filling equipment number shall be applied. All other marking may be applied before or after thermal processing.

(1) Product name (not less than 1/8 inch high).

Commonly used abbreviations may be used when authorized by the inspection agency.

(2) Pouch code includes: 1/

Lot Number
Filling equipment identification number
Official establishment number (for example, EST-38)
Retort identification number
Retort cook number

1/ The lot number shall be expressed as a four digit Julian code. The first digit shall indicate the year of production and the next three digits shall indicate the day of the year (Example, 9 November 2006 would be coded as 6313). The Julian code shall represent the day the product was packaged into the pouch and processed. Sub-lotting (when used) shall be represented by an alpha character immediately following the four digit Julian code. Following the four digit Julian code and the alpha character (when used), the other required code information shall be printed in the sequence as listed above. For food products that do not require an establishment number, the Julian code shall be preceded by three capital letters, which represent the packer's name.

NOTE: Commercial pouches [packaging material, construction, and graphics (colors, design and labeling)] shall be submitted to the Contracting Officer for review and approval and to USA RDECOM Natick Soldier Center (AMSRD-NSC-CF-F) for review and recommendation.

Comment [N1]: Natick case ES07-102, change 01 22 June 07, insert highlighted paragraph.

D-3 PACKING

A. Packing for shipment to ration assembler. Seventy-two pouches (of the same product) shall be packed flat or on edge in a snug-fitting fiberboard shipping container conforming to style RSC, type CF, class domestic, 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-4 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 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 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 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.

(2) Conformance inspection. Conformance inspection shall include the product examination 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-20352 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. For drained weight inspection, a separate set of pouches shall be selected from the lot using the same sampling criteria as above.

TABLE I. Product defects 1/ 2/ 3/

Category		Defect
<u>Major</u>	<u>Minor</u>	
101		Product not type as specified.
102		<u>Appearance</u> Bone or bone fragment measuring more than 0.30 inch in any dimension.
	201	Exterior color not light tan.
	202	Interior color not light tan to pale pink.
	203	Broth not a golden translucent color.
	204	Total weight of skin, cartilage, coarse connective tissue, tendons or ligaments, and glandular material more than 1.0 ounce.
	205	Not whole muscle or not a distinct fibrous appearance.
103		<u>Odor and flavor</u> Odor or flavor not mild white chicken meat.
	206	<u>Texture</u> Chicken chunks not moist or not tender or not firm.
	207	Chicken chunks dry or tough or mushy.
	208	<u>Weight</u> Net weight of individual pouch less than 6.7 ounces (189 grams). <u>4/</u>
	209	Drained weight of individual pouch less than 5.5 ounces (155 grams). <u>5/</u>

1/ Presence of any foreign materials such as, but not limited to dirt, insect parts, hair, glass, wood, metal, or mold, or any foreign odors or flavors such as, but not limited to burnt, scorched, rancid, sour, or stale 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/ Type requirements for chicken meat shall be verified by the Certificate of Conformance.

4/ Sample average net weight less than 7.0 ounces (198 grams) shall be cause for rejection of the lot.

5/ Sample average drained weight of chicken less than 5.8 ounces (164 grams) shall be cause for rejection of the lot.

B. Methods of inspection.

(1) Commercial sterility. Commercial sterility shall be verified in accordance with USDA/FSIS regulations.

(2) 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.

(3) 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 ounce or to the nearest gram.

(4) Drained weight. The pouch contents shall be poured into a flat-bottom container. A minimum of three times the pouch's volume of not less than 140°F water shall be added to the container so as to cover the contents. The contents and water shall be gently agitated so as to liquify rendered fat without breaking the chicken. The contents shall then be poured into a U.S. Standard No. 7 sieve in a manner that will distribute the product over the sieve without breaking the chicken. The sieve area shall be such that the distributed product does not completely cover all the openings of the sieve. The sieve shall be tilted at such an angle to assure complete drainage and allowed to drain for 2 minutes before determining the drained weight by subtracting the sieve tare weight from the gross weight. The drained weight shall be reported to the nearest 0.1 ounce or to the nearest gram.

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

A. Packaging and labeling.

(1) Pouch material testing. The pouch material shall be examined for the characteristics listed in table II. The lot size, sample unit, and inspection level criteria are provided for each of the test characteristics. Any test failure shall be classified as a major defect and shall be cause for rejection of the lot.

TABLE II. Pouch material quality assurance criteria

Characteristic	Lot size expressed in	Sample unit	Inspection level
Oxygen transmission rate	yards	1/2 yard	S-1
Water vapor transmission rate	yards	1/2 yard	S-1
Camouflage	yards	1/2 yard	S-1
Thermal processing	pouches	1 pouch	S-2
Environmental conditions	pouches	1 pouch	S-2

(2) Pouch examination. The pouches shall be examined for the defects listed in table II of MIL-PRF-44073. The lot size shall be expressed in pouches. The sample unit shall be one thermal processed pouch. The inspection level shall be I and the AQL, expressed in terms of defects per hundred units, shall be 0.65 for major A defects, 2.5 for major B defects, and 4.0 for minor defects. Two hundred sample units shall be examined for critical defects. The finding of any critical defect shall be cause for rejection of the lot.

B. 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	Contents more or less than specified.

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

DSCP FORMS

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

MILITARY SPECIFICATIONS

MIL-PRF-44073F Packaging of Food in Flexible Pouches

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

**PKG & QAP
A-A-20352
9 November 2006
W/CHANGE 01 22 June 2007**

For DSCP Website Posting

AMSRD-NSC-CF-F

22 June 2007

TO: DSCP-FTSL

SUBJECT: ES07-102, Technical Inquiry; First Strike Ration (FSR), Packaging Requirements and Quality Assurance Provisions (PKG&QAP) for CID A-A-20352 Chicken Chunks, White, Cooked, Canned or in Flexible Pouch.

1. DSCP has made a contract modification for all current, pending, and future procurements until subject document is formally amended or revised to include the following change, which is highlighted in the attached Change 01 to subject document:

Add the following after D-2,A(2) footnote 1/:

NOTE: Commercial pouches [packaging material, construction, and graphics (colors, design and labeling)] shall be submitted to the Contracting Officer for review and approval and to USA RDECOM Natick Soldier Center (AMSRD-NSC-CF-F) for review and recommendation.