

SECTION C

This document covers thermostabilized chili dogs packaged in a polymeric tray for use by the Department of Defense as a component of operational rations.

C-1 ITEM DESCRIPTION

PCR-C-068, CHILI DOGS, PACKAGED IN A POLYMERIC TRAY, SHELF STABLE

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 Performance-based Contract Requirements (PCR) document. 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. Commercial sterility. The packaged food shall be processed until commercially sterile.

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

D. Appearance.

(1) General. The finished product shall be chili dogs (a mixture of coarsely ground beef, red kidney beans, and intact frankfurters in a tomato based sauce with onions, and seasoned with spices). The packaged food shall be free from foreign materials.

(2) Ground beef. The beef shall be a size typically produced by a 3/8 inch grinder plate, and shall be practically free of bone or bone fragments, cartilage, coarse connective tissue, tendons or ligaments, and glandular material. The beef shall be a brown, cooked beef color. There may be a reddish color from absorbed tomato sauce.

(3) Kidney beans. The cooked beans shall be light red kidney beans and shall be intact.

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31 March 2006

W/Change 01 4 May 2007

(4) Frankfurters. The frankfurters shall be USDA certified Institutional Meat Purchase Specifications (IMPS) for Sausage Products, series 800, item No. 800, formula D, ~~±2~~ 10 links per pound and shall meet all the product requirements specified therein. Each tray shall contain not less than 20 frankfurters. After processing and packaging into the polymeric tray, the frankfurters shall be intact, and free of splits or ruptures.

Comment [RV1]: Natick ES case 07-093 change 01 4 May 07 - changed from 12 to 10 to get bigger size hot dogs as in cutting item

(5) Sauce. The sauce shall be dark red, tomato based with pieces of tomatoes and onions with seasonings.

E. Odor and flavor. The packaged food shall have an odor and flavor of frankfurters in a mixture of ground beef, kidney beans, and tomato based sauce with onions and herbs and spices. The sauce shall elicit a sensation of medium heat. The packaged food shall be free from foreign odors and flavors.

F. Texture.

(1) Ground beef. The cooked ground beef shall be moist and tender.

(2) Kidney beans. The kidney beans shall be slightly soft to slightly firm.

(3) Frankfurters. The frankfurters, after processing and packaging into the polymeric tray, shall be moist and slightly soft to moderately firm.

(4) Sauce. The sauce shall be moderately thick.

G. Net weight. The average net weight shall be not less than 88 ounces. No individual polymeric tray shall have a net weight of less than 86 ounces.

H. Drained weight. The drained weight of the frankfurters, ground beef and kidney beans combined in an individual polymeric tray shall be not less than 55.0 ounces or not more than 63.0 ounces.

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

J. Analytical requirements.

(1) Fat content. The fat content shall be not greater than 14.0 percent.

(2) Salt content. The salt content shall be not less than 0.7 percent and not greater than 1.5 percent.

C-3 MISCELLANEOUS INFORMATION

THE FOLLOWING IS INFORMATION ONLY TO PROVIDE THE BENEFIT OF PAST GOVERNMENT EXPERIENCE. THIS IS NOT A MANDATORY CONTRACT REQUIREMENT.

A. Ingredients/formulation for chili con carne with beans. Ingredients and formulation percentages for the chili con carne with beans may be as follows:

<u>Ingredients</u>	<u>Percent by weight</u>
Water <u>1/</u>	32.40
Beans, kidney, light red, dry (soaked) <u>2/</u>	28.22
Beef, ground, blanched <u>1/</u>	27.00
Tomato paste, 31 percent solids <u>3/</u>	3.90
Tomatoes, crushed, 26 percent solids <u>3/</u>	3.30
Paprika, ground	1.30
Chili powder	1.20
Onions, dehydrated flakes	1.00
Starch, waxy maize, modified	0.70
Sugar, white, granulated	0.70
Cumin, seeds, ground	0.10
Garlic powder	0.06
Chili Pepper, red, ground	0.06
Oregano, ground	0.06

1/ The percent by weight of crumbled beef and the percent by weight of water may be adjusted if necessary to ensure compliance with finished product requirements.

2/ The beans shall be combined with the chili mixture and mixed only to the extent necessary to ensure a uniform distribution of the beans throughout the product prior to pumping into the trays. The percent by weight of beans may be adjusted as necessary to ensure compliance with finished product drained weight requirements.

3/ If the specified tomato solids are not available, the tomato solids that are used may be adjusted to bring the solid level to that specified.

B. Product preparation. The chili dogs may be formulated as follows:

<u>Ingredient</u>	<u>Percent by weight</u>
Chili con carne with bean mixture	66.60
Beef Frankfurters	33.40

SECTION D

D-1 PACKAGING

A. Preservation. Product shall be filled into polymeric trays and the trays with protective sleeves shall conform to the requirements of section 3 of MIL-PRF-32004, Packaging of Food in Polymeric Trays. Verification testing and inspection of trays, lids and sleeves shall be in accordance with Section 4 of MIL-PRF-32004 and the Quality Assurance Provisions of Section E of this Performance-based Contract Requirements document.

B. Polymeric tray closure. The filled, sealed, and processed tray shall be securely closed.

D-2 LABELING

A. Polymeric tray body. The polymeric tray body shall be clearly printed or stamped, in a manner that does not damage the tray, with permanent ink of any contrasting color, which is free of carcinogenic elements. One end of the polymeric tray (see figure 1 of MIL-PRF-32004) shall be marked with the product name and number of portions. If the tray body end markings are not readily legible in low light conditions, a small, easily legible label shall be applied, but not over any existing tray markings. All other markings may be applied along the tray body side. To avoid erroneous marking of trays, the product name, lot number and filling equipment number shall be applied prior to processing. Additional tray marking may be applied before or after processing. 1/

Tray body markings shall include:

- (1) Product name. Commonly used abbreviations may be used when authorized by the inspection agency.
- (2) Tray code includes: 2/
 - Lot Number
 - Filling equipment identification number
 - Retort identification number
 - Retort cook number

1/ As an alternate method, tray body markings may be clearly printed or stamped onto the polymeric tray lid prior to processing, in a manner that does not damage the lid, with permanent ink of any contrasting color, which is free of carcinogenic elements, provided that the required markings are applied onto the tray body after processing.

2/ 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, 30 March 2006 would be coded as 6090). The Julian code shall represent the day the product was packaged into the tray and processed. Sublotting (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.

B. Polymeric tray lid. The lid shall be clearly printed or stamped, in a manner that does not cause damage. Permanent ink of any contrasting color, which is free of carcinogenic elements, shall be used. As an alternate labeling method, a pre-printed self-adhering 0.002 inch thick clear polyester label printed with indelible contrasting color ink may be used.

Note: The font tested by Natick was Microsoft Helvetica. The font used shall be similarly clear/easy to read as Helvetica. The recommended font sizes are as follows: 22 for the product name, 14 for "yield" and "to heat in water." If an additional note is required on the label, such as "fluff before serving," it should also be in font size 14. All other information should be in font size 9.

(1) Lid labeling shall include:

- Product name
- Ingredients
- Net weight
- Name and address of packer
- Official establishment number (for example, EST 38) or a three letter code identifying the establishment

(2) Lid labeling shall also show the following statements:

YIELD: Serves 10 portions of 2 frankfurters each plus approximately 2/3 cup of chili.

TO HEAT IN WATER: Submerge unopened tray in water. Bring water to a boil. Simmer gently 35-40 minutes. Avoid overheating (tray shows evidence of bulging).

Note: Stir chili before serving.

WARNING: Do not heat tray in oven.

TO TRANSPORT AFTER HEATING: Insert tray back into protective sleeve to protect during transport. If sleeve is unavailable, stack trays lid-to-lid with fiberboard pads in between.

CAUTION: Use care when opening as pressure may have been generated within the tray.

TO OPEN: Using a clean knife, cut the lidding around the inside perimeter of the tray seals.

SUGGESTION: Cut lid along 3 sides and fold over uncut portion. Fold back to keep unused portions protected.

D-3 PACKING

A. **Packing for shipment to ration assembler.** Four filled, sealed, processed and sleeved polymeric trays shall be packed in a snug fitting fiberboard box conforming to style RSC-L, type CF, grade 275 of ASTM D 5118/D 5118M, Standard Practice for Fabrication of Fiberboard Shipping Boxes. The sleeved trays shall be placed flat with the first two trays placed with the lids together and the next two trays with the lids together. The box shall be closed in accordance with ASTM D 1974, Standard Practice for Methods of Closing, Sealing, and Reinforcing Fiberboard Boxes.

D-4 UNITIZATION

A. **Unit loads.** Unit loads shall be as specified in DSCP FORM 3507, Loads, Unit: Preparation of Semiperishable Subsistence Items.

D-5 MARKING

A. **Shipping containers and unit loads.** Marking of shipping containers and unit loads shall be as specified in 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/ASQC Z1.4-1993, Sampling Procedures and Tables for Inspection by Attributes, are required. Unless otherwise specified, Single Sampling Plans indicated in ANSI/ASQC Z1.4-1993 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. Two (2) sample units of each item produced shall be randomly selected from that one production lot. The two (2) 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 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 specified in Section C of this Performance-based Contract Requirements document utilizing the double sampling plans indicated in ANSI/ASQC Z1.4 - 1993. The lot size shall be expressed in trays. The sample unit shall be the contents of one tray. The inspection level shall be S-3 and the acceptable quality level (AQL), expressed in terms of defects per hundred units, shall be 4.0 for major defects and 6.5 for minor defects. Defects and defect classifications are listed in table I below. The trays shall be heated in accordance with the heating instructions from the tray label prior to conducting any portion of the product examination. The samples for drained weight inspection shall be selected using the same sampling criteria as above.

TABLE I. Product defects 1/ 2/ 3/ 4/ 5/

Category		Defect
<u>Major</u>	<u>Minor</u>	<u>Appearance</u>
101		Product not chili dogs (a mixture of coarsely ground beef, red kidney beans, and intact frankfurters in a tomato based sauce with onions, and seasoned with spices).
	201	Frankfurters split or ruptured. <u>6/</u>
102		Bone or bone fragment measuring more than 0.3 inch in any dimension.
	202	Ground beef not a brown, cooked beef color. <u>7/</u>
	203	Kidney beans not intact. <u>8/</u>

TABLE I. Product defects 1/ 2/ 3/ 4/ 5/ cont'd

<u>Category</u>		<u>Defect</u>
<u>Major</u>	<u>Minor</u>	
	204	Sauce not dark red or not tomato based with pieces of tomatoes and onions with seasonings.
	205	Total weight of cartilage, coarse connective tissue, tendons or ligaments, and glandular material more than 2.0 ounces.
		<u>Odor and flavor</u>
103		The packaged food does not have an odor or flavor of frankfurters in a mixture of ground beef and kidney beans in tomato based sauce.
104		The sauce does not have an odor or flavor of tomatoes, onions and herbs and spices.
	206	The sauce does not elicit a sensation of medium heat.
		<u>Texture</u>
	207	Frankfurters not moist or not slightly soft to moderately firm.
	208	Ground beef not moist or not tender.
	209	Kidney beans not slightly soft to slightly firm.
	210	Sauce not moderately thick.
		<u>Net weight</u>
	211	Net weight of an individual polymeric tray less than 86 ounces. <u>9/</u>
		<u>Drained weight</u>
	212	Drained weight of the frankfurters, ground beef and kidney beans (combined) in an individual polymeric tray less than 55.0 ounces or more than 63.0 ounces.

1/ 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, 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/ Grinder plate size requirement for ground beef and kidney bean type shall be verified by Certificate of Conformance.

4/ Conformance of beef frankfurters to all the requirements of IMPS series 800, item no. 800, formula D, ~~12~~ 10 links per pound, shall be verified by a Certificate of Conformance.

Comment [p2]: Natick ES case 07-093 change 01 4 May 07. footnote 4 - line 3, delete "12" and insert "10"

5/ The finding of any individual polymeric tray containing less than 20 frankfurters shall be cause for rejection of the lot.

6/ Splits and ruptures which occur as a result of frankfurters expansion during retorting shall not measure more than 1/2 inch in any dimension. Peeler marks, indentations, or slight lengthwise scores shall not be scored as defects.

7/ Reddish color absorbed from tomato sauce shall not be scored as a defect.

8/ Kidney beans shall be considered conforming if either whole or half.

9/ Sample average net weight less than 88 ounces 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 tray shall be determined by weighing each sample unit on a suitable scale tared with a representative empty tray and lid. Results shall be reported to the nearest 1 ounce.

(4) Drained weight. To determine drained weight, the contents shall be poured into a flat bottom container. A minimum of three times the polymeric tray'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 agitated so as to fully dissolve the sauce without undue breakup of the frankfurters and kidney beans. The contents shall then be poured into a U.S. Standard No. 7 sieve in a manner that will distribute the product evenly over the sieve. 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 of liquid from the product. Drain product 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 0.5 ounce.

(5) Analytical. The sample to be analyzed shall be a one-pound composite of three filled and sealed polymeric trays that have been selected at random from one production lot. The composite sample shall be prepared and analyzed in accordance with the following Official Methods of Analysis (OMA) of AOAC International.

<u>Test</u>	<u>Method Number</u>
Fat	985.15
Salt	935.47

Test results shall be reported to the nearest 0.1 percent. Verification will be conducted through actual testing by a Government laboratory. Any result not conforming to the analytical requirements shall be cause for rejection of the lot.

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

A. Packaging and labeling.

(1) Polymeric tray testing. For purposes of clarification, the polymeric tray without the lid will be referred to as the "tray" and the polymeric tray with the lid shall be referred to as the "container". The polymeric tray with protective sleeve and polymeric tray material shall be examined for the characteristics listed in table I of MIL-PRF-32004, Packaging of Food in Polymeric Trays. The lot size, sample unit, and inspection level criteria are provided in table II below 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. For rough handling survivability at frozen temperature, polymeric tray survival rate shall be at least 85 percent.

TABLE II. Polymeric tray quality assurance criteria

<u>Prior to processing</u>			
Characteristic	Lot size expressed in	Sample unit	Inspection level
Tray configurations and dimensions	Trays	1 tray	S-1
Oxygen gas transmission rate of tray	Trays	1 tray	S-1
Oxygen gas transmission rate of lid	Yards	1/2 yard	S-1
Water vapor transmission rate of tray	Trays	1 tray	S-1
Water vapor transmission rate of lid	Yards	1/2 yard	S-1
Camouflage	Containers	1 container	S-1
<u>After processing</u>			
Characteristic	Lot size expressed in	Sample unit	Inspection level
Processing	Trays	1 tray	S-2
Rough handling survivability	Test containers	1 container	S-2
Protective sleeve	Containers	1 container	S-1
Residual gas	Containers	1 container	S-1
Closure seal	Containers	1 container	S-1
Internal pressure	Containers	1 container	S-1
Lid opening	Containers	1 container	S-1

(2) Examination of container. The container with protective sleeve removed shall be examined for the defects listed in table II of MIL-PRF-32004 and the labeling defects listed in table III below. The lot size shall be expressed in containers. The sample unit shall be one processed and labeled container. 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.

TABLE III. Container labeling defects

Category		Defect
<u>Major A</u>	<u>Minor</u>	
101		Polymeric tray lid or body labeling missing or incorrect or illegible.
	201	When a pre-printed self adhering label is used, the label not adhering to tray lid (for example, label raised or peeled back from edge to corner) or presence of any areas of gaps along the perimeter of the label where the label is not properly adhered.

(3) Label adhesive examination. When self-adhering labels are used, the adhesive shall be tested in accordance with ASTM D 3330/D 3330M, Standard Test Method for Peel Adhesion of Pressure-Sensitive Tape. In lieu of testing, a Certificate of Conformance shall be provided.

B. Packing.

(1) Shipping container and marking examination. The filled and sealed shipping containers shall be examined for the defects listed in table IV 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 IV. 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	Arrangement or number of polymeric trays not as 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.

C. Unitization.

(1) Unit load examination. The unit load shall be examined in accordance with the requirements of DSCP FORM 3507, Loads, Unit: Preparation of Semiperishable Subsistence Items. Any nonconformance shall be classified as a major defect.

SECTION J REFERENCE DOCUMENTS

DSCP FORMS

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

MILITARY SPECIFICATIONS

- MIL-PRF-32004 Packaging of Food in Polymeric Trays

GOVERNMENT PUBLICATIONS

- Federal Food, Drug, and Cosmetic Act and regulations promulgated thereunder
(21 CFR Parts 1-199) and (9 CFR Parts 1-391)

NON-GOVERNMENTAL STANDARDS

AMERICAN SOCIETY FOR QUALITY (ASQ)

- ANSI/ASQCZ1.4-1993 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 3330/D 3330M-04 Standard Test Method for Peel Adhesion of
Pressure-Sensitive Tape
- D 5118/D 5118M-05a Standard Practice for Fabrication of Fiberboard
Shipping Boxes

AOAC INTERNATIONAL

- Official Methods of Analysis (OMA) of the AOAC International

For DSCP web site posting

AMSRD-NSC-CF-F (Valvano/5907)

4 May 2007

TO: DSCP- FTRU (Charya/3832)

Subject: ES07-093; PCR-C-068 Chili Dogs, Packaged in a Polymeric Tray, Shelf Stable; Wornick Company; Contract SPM3S1-07-D-Z192; change request for 10 vs 12 links per pound.

Date received: 1 May 07

Date due: ASAP

Date replied: 4 May 07

1. Contractor requested that Natick make a change to frankfurter size to 10 links versus 12. Their cutting product had this size in it and was found acceptable.
2. The Army representative at ACES was contacted and they concur with the change.
3. Natick recommends that DSCP implement the following changes for all current, pending, and future procurements until the subject document is formally amended or revised:
 - (a) Sec C, C-2, D (4) – line 3, delete “12” and insert “10”.
 - (b) Sec E, E-5, Table I, footnote 4 - line 3, delete “12” and insert “10”.
4. Changes are highlighted in the attached document.