

**SECTION C**

This document covers thermostabilized turkey slices in gravy packaged in polymeric trays for use by the Department of Defense as a component of operational rations.

**C-1 ITEM DESCRIPTION**

**PCR-T-005, TURKEY SLICES IN GRAVY, 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 turkey slices in gravy. Each individual polymeric tray shall contain not less than ~~36~~ 18 intact turkey slices. The packaged food shall be free from foreign materials.

**Comment [p1]:** Natick case ES08-098 change 01, 06-JUN-08, Delete 36 and insert 18

(2) Turkey slices. The turkey slices shall be prepared from chunked and formed turkey logs of natural proportion white and dark turkey meat. The turkey slices shall be intact and uniform in size and shape. The turkey slices shall be practically free of skin, bone or bone fragment, cartilage, coarse connective tissue, tendons or ligaments, and discolored meat. The turkey slices shall be free of finely ground, flaked, or otherwise comminuted product. There shall be no void area or air pocket that measures more than 1/2 by 1/2 inch in the turkey slices. The turkey slices shall have a cooked color.

(3) Gravy. The gravy shall be an opaque light tan to golden color and may contain visible flecks of spices.

E. Odor and flavor.

(1) General. The packaged food shall have an odor and flavor typical of cooked turkey slices in gravy. The packaged food shall be free from foreign odors and flavors.

(2) Gravy. The gravy shall have the odor and flavor of cooked turkey/chicken broth seasoned with herbs and spices.

F. Texture.

(1) Turkey slices. The turkey slices shall be moist and tender.

(2) Gravy. The gravy shall be smooth.

G. Viscosity. The viscosity of the gravy shall be not less than 6.0 cm per ten seconds or not greater than 22.0 cm per ten seconds.

H. Net weight. The average net weight shall be not less than 92 ounces. No individual polymeric tray shall have a net weight of less than 90 ounces.

I. Drained weight. The average drained weight shall be not less than 54.0 ounces. The drained weight of ~~36~~ 18 intact turkey slices in an individual polymeric tray shall be not less than 52.0 ounces.

**Comment [p2]:** Natick case ES08-098 change 01, 06-JUN-08, Delete 36 and insert 18

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

K. Analytical requirements.

(1) Fat content. The fat content shall be not greater than 12.0 percent.

(2) Salt content. The salt content shall be not less than 0.5 percent and not greater than 1.2 percent.

**C-3 MISCELLANEOUS INFORMATION**

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

A. Ingredients/formulation. Ingredients and formulation percentages for the turkey log may be as follows:

<u>Ingredients</u>	<u>Percent by weight</u>
Turkey meat “natural proportions of white and dark meat”	96.50
Ice or ice water	2.19
Salt	1.00
Sodium tripolyphosphate	0.25
Ground white pepper	0.04
Garlic powder	0.02

B. Ingredients/formulation. Ingredients and formulation percentages for the gravy may be as follows:

<u>Ingredients</u>	<u>Percent by weight</u>
Turkey or chicken broth/stock <u>1/</u>	92.98
High opacity modified starch <u>2/</u>	5.50
Onion powder	0.80
Lecithin	0.25
Vegetable oil	0.20
Salt <u>3/</u>	0.10
Ground white pepper	0.05
Ground celery seed	0.04
Garlic powder	0.03
Ground sage	0.02
Ground turmeric	0.01
Ground marjoram	0.01
Thyme flavoring	0.01

1/ The turkey or chicken broth/stock with different soluble solids content should be adjusted to the 3.0 to 3.5 percent solids.

2/ The total amount of starch in the formula should be adjusted, as necessary, to ensure compliance with the finished product viscosity requirements.

3/ The total amount of salt in the gravy formula may be adjusted as necessary to produce a product that complies with the finished product salt content requirement.

**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, 3 June 2003 would be coded as 3154). 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.

(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:

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).

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.

YIELD: Serves 18 portions of (2 **1** slice plus approximately 2 ounces of gravy).

**Comment [p3]**: Natick case ES08-098 change 01, 06-JUN-08, Delete 2 and insert 1

### **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 D5118/D5118M-95 (2001), 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 D1974-98, 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 Shipping Cases, Sacks and Palletized/Containerized 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 Soldier & Biological Chemical Command  
Soldiers System Ctr., Natick Soldier Center  
Attn: AMSSB-RCF-F(N)  
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/

Category		Defect
<u>Major</u>	<u>Minor</u>	
		<u>Appearance</u>
101		Product not turkey slices in gravy.
102		Bone or bone fragment measuring more than 0.3 inch in any dimension.
	201	Turkey slices not prepared from chunked and formed turkey logs.
	202	Turkey slices not intact or not uniform in size and shape.
	203	Total weight of skin, cartilage, coarse connective tissue, tendons or ligaments, and discolored meat is more than 1.0 ounce.
	204	Turkey slices contain finely ground, flaked, or otherwise comminuted product.
	205	Turkey slice contains void area or air pocket that measures more than 1/2 by 1/2 inch.
	206	Turkey slices not a cooked color.
	207	Gravy not a opaque light tan to golden color.
		<u>Odor and flavor</u>
103		The packaged food does not have an odor or flavor typical of turkey slices in gravy.
104		The gravy does not have the odor or flavor of turkey/chicken broth seasoned with herbs and spices.

		<u>Texture</u>
Category	<u>Minor</u>	
<u>Major</u>	<u>Minor</u>	
	208	Turkey slices not moist or not tender.
	206 <del>9</del>	Gravy not smooth.
		<u>Net weight</u>
	207 <del>10</del>	Net weight of an individual polymeric tray is less than 90 ounces. <u>5</u> /
		<u>Drained weight</u>
	208 <del>11</del>	Drained weight of <del>36</del> <b>18</b> intact turkey slices in an individual polymeric tray is less than 52.0 ounces. <u>6</u> /

**Comment [p4]:** Natick case ES08-098 change 01, 06-JUN-08, renumber the minor defects in table I. Change minor 206 "Gravy not smooth" to 209. Change minor 207 "Net weight..." to 210, and change minor 208 "Drained weight..." to 211. In defect 211 and 4 change 36 to 18. Page 10, paragraph B, (4), line 11 delete Thirty-six and insert Eighteen.

1/ Presence of any foreign material 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, 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/ The natural proportion of white and dark meat in preparation of the turkey log shall be verified by a certificate of conformance.

4/ The finding of any individual polymeric tray containing less than ~~36~~ **18** intact turkey slices shall be cause for rejection of the lot.

5/ Sample average net weight less than 92 ounces shall be cause for rejection of the lot.

6/ Sample average drained weight less than 54.0 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 3 year shelf life when stored at 80<sup>0</sup>F. Government verification may include

storage for 6 months at 100<sup>0</sup>F or 36 months at 80<sup>0</sup>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 polymeric 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 gravy in the polymeric tray shall be poured off, strained through a U.S. Standard No. 8 sieve, and individually reserved for viscosity determinations. The remaining contents shall be poured into a flat-bottom container. A minimum of three times the polymeric tray's volume of 180<sup>0</sup> to 190<sup>0</sup>F water shall be added to the container so as to cover the contents. The contents and water shall be agitated so as to liquefy rendered fat and remove the gravy without breaking the turkey slices. The contents shall then be poured into the U.S. Standard 1/4 inch sieve in a manner that will distribute the product over the sieve without breaking the turkey slices. 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 approximately a 45<sup>0</sup> angle and allowed to drain for two minutes before determining the drained weight. ~~Thirty-six~~ **Eighteen** intact turkey slices shall be weighed to determine the drained weight. The drained weight shall be reported to the nearest 0.5 ounce.

(5) Gravy viscosity. Viscosity testing shall be performed by collecting the free liquid from each of the samples used to determine the drained weight. The gravy temperature at time of testing shall be 100<sup>0</sup>F  $\pm$  1<sup>0</sup>F (37.8<sup>0</sup>C  $\pm$  0.5<sup>0</sup>C). Any result not conforming to the requirements specified in Section C of this Performance-based Contract Requirements shall be cause for rejection of the lot.

(6) 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 of AOAC International (OMA).

<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>			
<u>Characteristic</u>	<u>Lot size expressed in</u>	<u>Sample unit</u>	<u>Inspection level</u>
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>			
<u>Characteristic</u>	<u>Lot size expressed in</u>	<u>Sample unit</u>	<u>Inspection level</u>
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
<u>After processing cont'd</u>			
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

<u>Category</u>		<u>Defect</u>
<u>Major A</u>	<u>Minor</u>	
101		Polymeric tray lid or body labeling missing, 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 D3330/D3330M-00 Standard Test Method for Peel Adhesion of Pressure-Sensitive Tape. In lieu of testing, a certificate of conformance (COC) 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

<u>Category</u>		<u>Defect</u>
<u>Major</u>	<u>Minor</u>	
101		Marking omitted, incorrect, illegible, or improper size, location sequence or method of application.
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 Shipping Cases, Sacks and Palletized/Containerized 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

D1974-98                     Standard Practice for Methods of Closing, Sealing,  
                                 and Reinforcing Fiberboard Boxes  
D3330/D3330M-00         Standard Test Method for Peel Adhesion of  
                                 Pressure-Sensitive Tape  
D5118/D5118M-95 (2001)   Standard Practice for Fabrication of Fiberboard  
                                 Shipping Boxes

AOAC INTERNATIONAL

Official Methods of Analysis of the AOAC International (OMA)

## For DSCP Website Posting

AMSRD-NSC-CF-F

6 Jun 2008

TO: DSCP-FTRU

SUBJECT: ES08 098; Technical Inquiry, Turkey slices in a poly tray PCR-T-005

Date received: 28 May 08

Date due: ASAP

Date replied: 6 June 08

1. Wornick has submitted a specification change request for PCR-T-005, Turkey Slices in Gravy. USDA has recently failed lot 7289 (1,276 trays) due to count requirement for slices per tray. Wornick is requesting the following changes: "Page 1, paragraph D. (1), delete 36 and insert 18; Page 2, paragraph I, delete 36 and insert 18; Page 5, last paragraph, Yield, delete 2 slices and insert 1 slice".
2. Natick will also make a change to renumber the minor defects in table I. Change minor 206 "Gravy not smooth" to 209. Change minor 207 "Net weight..." to 210, and change minor 208 "Drained weight..." to 211. In defect 211 and 4 change 36 to 18. Page 10, paragraph B, (4), line 11 delete Thirty-six and insert Eighteen.
3. Previously Wornick had made many acceptable trays for the UGR-E program which contained 18 slices.
4. Natick concurs with changing the slice count requirement and renumbering the 3 minor defects for PCR-T-005, Turkey Slices in Gravy.
5. Natick recommends that DSCP implement these changes for the current UGR 08, pending and future procurements until the subject document is formally amended or revised.