

**AMENDMENT OF SOLICITATION/MODIFICATION OF CONTRACT**

1. CONTRACT ID CODE

PAGE OF PAGES  
1 33

2. AMENDMENT/MODIFICATION NO.  
0005

3. EFFECTIVE DATE  
SEPT 03

4. REQUISITION/PURCHASE REQ. NO.

5. PROJECT NO. (If applicable)

6. ISSUED BY CODE

7. ADMINISTERED BY (If other than Item 6) CODE

Defense Supply Center Philadelphia  
700 Robbins Avenue  
Philadelphia, PA 19111-5092  
Directorate of Subsistence, Bldg. 6

8. NAME AND ADDRESS OF CONTRACTOR (No., street, county, State and ZIP Code)

(X)

9A. AMENDMENT OF SOLICITATION NO.

SP0300-03-R-7059

9B. DATED (SEE ITEM 11)

02 APR 03

10A. MODIFICATION OF CONTRACT/ORDER NO.

10B. DATED (SEE ITEM 13)

CODE

FACILITY CODE

**11. THIS ITEM ONLY APPLIES TO AMENDMENTS OF SOLICITATIONS**

The above numbered solicitation is amended as set forth in Item 14. The hour and date specified for receipt of Offers  is extended,  is not extended.

Offer must acknowledge receipt of this amendment prior to the hour and date specified in the solicitation or as amended, by one of the following methods:

(a) By completing Items 8 and 15, and returning \_\_\_\_\_ copies of the amendment; (b) By acknowledging receipt of this amendment on each copy of the offer submitted; or (c) By separate letter or telegram which includes a reference to the solicitation and amendment numbers. FAILURE OF YOUR ACKNOWLEDGMENT TO BE RECEIVED AT THE PLACE DESIGNATED FOR THE RECEIPT OF OFFERS PRIOR TO THE HOUR AND DATE SPECIFIED MAY RESULT IN REJECTION OF YOUR OFFER. If by virtue of this amendment you desire to change an offer already submitted, such change may be made by telegram or letter, provided each telegram or letter makes reference to the solicitation and this amendment, and is received prior to the opening hour and date specified.

12. Accounting and Appropriation Data (If required)

**13. THIS ITEM APPLIES ONLY TO MODIFICATIONS OF CONTRACTS/ORDERS, IT MODIFIES THE CONTRACT/ORDER NO. AS DESCRIBED IN ITEM 14.**

A. THIS CHANGE ORDER IS ISSUED PURSUANT TO: (Specify authority) THE CHANGES SET FORTH IN ITEM 14 ARE MADE IN THE CONTRACT ORDER NO. IN ITEM 10A.

B. THE ABOVE NUMBERED CONTRACT/ORDER IS MODIFIED TO REFLECT THE ADMINISTRATIVE CHANGES (such as changes in paying office, appropriation date, etc). SET FORTH IN ITEM 14, PURSUANT TO THE AUTHORITY OF FAR 43.103(b).

C. THIS SUPPLEMENTAL AGREEMENT IS ENTERED INTO PURSUANT TO AUTHORITY OF:

D. OTHER (Specify type of modification and authority)

E. IMPORTANT: Contractor  is not,  is required to sign this document and return 1 copies to the issuing office.

14. DESCRIPTION OF AMENDMENT/MODIFICATION (Organized by UCF section headings, including solicitation/contract subject matter where feasible.)

I. All terms and conditions of subject solicitation remain the same and in effect except as follows:

(See the following pages for text)

Except as provided herein, all terms and conditions of the document referenced in Item 9A or 10A, as heretofore changed, remains unchanged and in full force and effect.

15A. NAME AND TITLE OF SIGNER (Type or print)

16A. NAME AND TITLE OF CONTRACTING OFFICER (Type or print)

15B. CONTRACTOR/OFFEROR

15C. DATE SIGNED

16B. UNITED STATES OF AMERICA

16C. DATE SIGNED

(Signature of person authorized to sign)

BY

(Signature of Contracting Officer)

**A. The following changes to subject document are provided for all current, pending and future procurements of ACR-M-001:**

Page 3

Table II. Accessory Packet Components

Table II, line 15, after "Salt" insert ", Iodized";  
" " , before "Monograph", insert "Sodium Chloride"

In Table II of same document, opposite "Salt", delete "A-A-20041" and replace with "Sodium Chloride Nonograph".

In Table II of subject document, opposite "Toilet Paper, 1 packet" delete: "MIL-P-43988" and replace with "A-A-59594, Style II, Type A or B, Sheet size b".

Line 17, delete "Paper" and insert "Tissue".

Page 6

Paragraph D-1,A(2), line 8, delete "The dimensions...7-3/8 inches." and insert "Dimensions shall be sufficient to contain all components and be compatible with meal bag."

Page 7

D-4, line 1, after "arranged" delete remainder of paragraph and insert "in unit loads in accordance with Type I, Class B of DSCP Form 3507, Loads, Unit: Preparation of Semiperishable Subsistence Items. At least two boxes in each tier shall be oriented to display the TTI label."

Page 11

Table IV, defect 201, delete "Effective...point." And insert "Closure seal width less than 1/16 inch. 2"

Defect 203, delete in its entirety.

Add new footnote: "2/ An effective seal is defined as any uncontaminated, fusion bonded, continuous path, minimum 1/16 inch wide, producing a hermetically sealed pouch."

Page 12

Defect 104, delete "Meal bag or component".

Defect 201, delete in its entirety.

Defect 104 now reads: "104 Labeling missing, incorrect, or illegible."

Defect 201 now reads: "201 Tear, hole, open seal, or split in meal bag."

Defect 202 now reads: "202 Tear, hole, puncture, or open seal in accessory packet bag."

Defect 203 now reads: "203 Inverted 'V' shaped peel indicator missing or not located as specified."

Defect 204 now reads: "204 Color, when used, incorrect."

Page 13

Delete paragraph "(3)" in its entirety and substitute:

"(3) Seal testing. The pouch seals shall be tested for seal strength or internal pressure resistance as required in a, b, c, or d, as applicable.

- a. Unfilled preformed subassembly packet/accessory packet pouch. The seals of the unfilled preformed pouches for the subassembly packet/accessory packet shall be tested for seal strength in accordance with ASTM F 88, Seal Strength of Flexible Barrier Materials. The lot size shall be expressed in pouches. The sample unit shall be one pouch. The inspection shall be level S-1 and the AQL, expressed in defects per hundred units, shall be 10.0. Three specimens shall be cut from each of the three sealed sides of each pouch in the sample. The average seal strength of any side shall be calculated by averaging the results of the three specimens cut from that side. Any test specimen failing to meet a seal strength of 3 pounds per inch of width shall be scored as a major defect. Any average seal strength of less than 3.5 pounds per inch of width shall be cause for rejection of the lot. Alternatively, the internal pressure resistance shall be determined by pressurizing the pouches while they are restrained between two rigid plates. The sample size shall

be the number of pouches indicated by inspection level S-1. If a three seal tester (one that pressurizes the pouch through an open end) is used, the closure seal shall be cut off for testing the side and bottom seals of the pouch. For testing the closure seal, the bottom seal shall be cut off. The pouches shall be emptied prior to testing. If a four-seal tester (designed to pressurize filled pouches by use of a hypodermic needle through the pouch wall) is used, all four seals can be tested simultaneously. The distance between rigid restraining plates on the four-seal tester shall be equal to the thickness of the product +1/16 inch. Pressure shall be applied at the approximate uniform rate of 1 pound per square inch gage (psig) per second until 14 psig pressure is reached. The 14 psig pressure shall be held constant for 30 seconds and then released. The pouches shall then be examined for separation or yield of the heat seals. Any rupture of the pouch or evidence of seal separation greater than 1/16 inch in the pouch manufacturer's seal shall be considered a test failure. Any seal separation that reduces the effective closure seal width to less than 1/16 inch (see table IV, footnote 2/) shall be considered a test failure. Any test failure shall be cause for rejection of the lot.

b. Unfilled meal bag. The seals of the unfilled meal bags shall be tested for seal strength in accordance with ASTM F 88. The lot size shall be expressed in bags. The sample unit shall be one bag. The sample size shall be the number of bags indicated by inspection level S-1. Three specimens shall be cut from the sealed end of each bag in the sample. Samples shall not be taken from the inverted "V" peel initiation. Any specimen with a seal strength less than 4 pounds per inch of width or greater than 10 pounds per inch of width shall be cause for rejection of the lot.

Subassembly packet/Accessory packet pouch closure. The closure seals of the pouches for the subassembly packet/Accessory packet shall be tested for seal strength in accordance with ASTM F 88. The lot size shall be expressed in pouches. The sample unit shall be one pouch. The inspection level shall be S-1 and the AQL, expressed in defects per hundred units, shall be 10.0. For the closure seal on preformed pouches, three adjacent specimens shall be cut from the closure seal of each pouch in the sample. For the form-fill-seal pouches, three specimens shall be cut from each side and each end of each pouch in the sample. The average seal strength of any side, end or closure shall be calculated by averaging the three specimens cut from that side, end or closure. Any test specimen failing to meet a seal strength of 3 pounds per inch of width shall be scored as a major defect. Any average seal strength of less than 3.5 pounds per inch of width shall be cause for rejection of the lot. Alternatively, the internal pressure resistance shall be determined by pressurizing the

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pouches while they are restrained between two rigid plates. The sample size shall be the number of pouches indicated by inspection level S-1. If a three seal tester (one that pressurizes the pouch through an open end) is used, the closure seal shall be cut off for testing the side and bottom seals of the pouch. For testing the closure seal, the bottom seal shall be cut off. The pouches shall be emptied prior to testing. If a four-seal tester (designed to pressurize filled pouches by use of a hypodermic needle through the pouch wall) is used, all four seals can be tested simultaneously. The distance between rigid restraining plates on the four-seal tester shall be equal to the thickness of the product +1/16 inch. Pressure shall be applied at the approximate uniform rate of 1 pound per square inch gage (psig) per second until 14 psig pressure is reached. The 14 psig pressure shall be held constant for 30 seconds and then released. The pouches shall then be examined for separation or yield of the heat seals. Any rupture of the pouch or evidence of seal separation greater than 1/16 inch in the pouch manufacturer's seal shall be considered a test failure. Any seal separation that reduces the effective closure seal width to less than 1/16 inch (see table IV, footnote 2/) shall be considered a test failure. Any test failure shall be cause for rejection of the lot.

d. Meal bag closure. The closure seals of the meal bags shall be tested for seal strength in accordance with ASTM F 88. The lot size shall be expressed in bags. The sample unit shall be one bag. The sample size shall be the number of bags indicated by inspection level S-1. Three specimens shall be cut from the closure seal of each bag in the sample. Any specimen with a seal strength less than 4 pounds per inch of width shall be cause for rejection of the lot.

(4) Unfilled meal bag and unfilled preformed subassembly packet/accessory packet pouch seal certification. A certificate of conformance may be accepted as evidence that unfilled bags or pouches conform to the seal strength requirements specified in D-1,A,(1) and (3). When deemed necessary by the USDA, seal testing of the unfilled bags or pouches shall be as specified in E,A,(3), a and b."

**B. THE FOLLOWING CHANGES APPLY TO: MIL-C-44112D (Crackers),  
September 1993:**

Page 12, footnote 6/, delete and substitute:

"6/ The initial examination shall be a visual examination of the closed package. Any suspected visual evidence of stress cracks in the aluminum foil (streaks, breaks, or other disruptions in the laminated film) shall be verified by the

following physical examination. To examine for stress cracks, the inside surface of both tray-shaped bodies shall be placed over a light source and the outside surface observed for the passage of light. Observation of light through the pouch material in the form of a curved or straight line greater than 2 mm in length shall be evidence of stress cracks. Observation of light through the pouch material in the form of a curved or straight line 2 mm in length or smaller of a single point shall be considered a pinhole. Observation of ten or more pinholes per pouch shall be evidence of material degradation."

Page 16, paragraph 5.1.1.1, line 17, after "bag color", insert "for MRE and LRP applications."

" " , line 18, insert the following new sentence: "For MCW the complete exterior of the pouch shall be colored white in the range of 37778 through 37886 of FED-STD-595."

**C. THE FOLLOWING ARE CHANGES TO CID A-A-20177B, CANDY AND CHOCOLATE CONFECTIONS:**

Page 2, Type VI, Shape A, Flavor 6 - Delete "Other" and insert "Cinnamon". Add "Flavor 7 - Other".

Page 5, add the following "5.3.6.1.6 Flavor 6, Cinnamon. The cinnamon flavored disks shall consist of a hard center covered with a hard candy shell. The candies shall be uniformly shaped, red in color, with a hot cinnamon flavor. The count per pound shall not be less than 504, not more than 568. The weight of an individual bag shall be 65.2 g (2.3 oz)."

**D. THE FOLLOWING CHANGE(S) TO: Quality Assurance Provisions and Packaging Requirements for CID A-A-20098B [Beverage Bases] January 2000:**

Page 3, " B. Packaging. When specified for flavor 12, fortification b, package A, B, or C not less than 17 grams or 34 grams, as applicable shall be filled into an envelope having maximum outside dimensions of 4 7/8 inches long by 3 7/16 inches wide. The envelope shall be made from a heat sealable barrier material, one layer of which is a minimum of 0.00035 inch thick aluminum foil. All four edges of the envelope shall be heat-sealed with seals not less than 1/8 inch wide.

The sealed envelope shall show no leakage when examined in accordance with Section E-6, B (1). There shall be no crushed, misshaped or unclean envelopes."

Page 8, "B. Methods of Inspection.

(1) Leakage test. The filled and sealed envelopes shall be tested by placing them in a dry desiccator, or similar apparatus, and subjecting them to a vacuum of 26 inches of mercury (atmospheric pressure is 29.9 inches of mercury) for 30 seconds. Any envelope that does not swell to form a tightly distended package having at least one distorted edge during the test shall be recorded as a leaker. After vacuum testing, the envelopes shall be visually inspected for evidence of delamination and for seal separation. Any leakage, any delamination or any seal separation of more than 1/16 inch from the product edge of any seal shall be recorded as a defect."

"C." Packing

**E. THE FOLLOWING CHANGE(S) APPLY TO: PCR-C-004 Chocolate sports Bar, Packaged in a Flexible Pouch, November 1997:**

November 1997

"F. Size. The Sports Bar dimensions shall be not greater than 4 3/4 inches long, 2 1/4 inches wide, and 3/4 inch thick."

September 1998

"I. The net weight of the sports Bar shall be not greater than 60 grams."

Page 1/12: Pouch construction, line 12, "provided on one outside edge or two opposite edges of the pouch"

Page 9/12: "B. Product Examination. The finished product shall be examined for compliance with the performance requirements specified in Section C of this Performance-based Contract Requirements utilizing the single sampling plans indicated in ANSI/ASQC Z1.4 - 1993. 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 AQL, expressed in defects per hundred units, shall be 1.5 for major defects and 6.5 for minor defects. Defects and defect classifications are listed in table II."

April 2000

Page 1/12, Section D-1, A., a., line 8, delete "Ration Cold Weather (RCW)" and insert "Meal, Cold Weather (MCW)".

May 2000  
Page 10/12, Table II Product defects (added)  
"Weight

205 Unit weight of individual pouch greater than 60 grams."

" , (bottom of page), after "Kilocalories 1/", add  
"(3) Net weight examination.

a. Commercially wrapped product in pouch. The net weight shall be verified with the label on the commercial package. Product not conforming to the net weight requirement shall be cause for rejection of the lot.

b. Without commercially wrapped product in pouch. The net weight of the filled and sealed pouches shall be determined by weighing each sample unit on a suitable scale tared with a representative empty pouch. Results shall be reported to the nearest 0.1 ounce."

**F. THE FOLLOWING CHANGE(S) APPLY TO: Packaging requirements and Quality Assurance Provisions for CID A-A-20336, [Coffees Flavored Instant, Powdered]:**

January 2003

Page 1/9, added: "Packages.

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

", added: under C. Dry product.

"(4) Microbiological. The salmonella test shall be negative per 25 grams of product."

Page 2/9, D-1 A. (1) a.. line 8, after "product." insert: "For package A (MCW), the complete exterior of the pouch shall be colored white overall with a color in the range of 37779 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."

**G. THE FOLLOWING CHANGE(S) APPLY TO: PCR-N-002, Nut-Raisin Mix , September 1999:**

November 1999

Add new para D-1A (2) (a-b) as follows:

"(2) Horizontal form-fill-seal pouches.

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

b. Pouch construction. The tray-shaped body and the tray-shaped cover shall be formed by drawing the flexible laminate material into an appropriately shaped cavity. The flat cover shall be in the form of a flat sheet of the barrier material taken from roll stock. The nut raisin mix shall be placed into the tray-shaped body of the pouch and shall be nitrogen flushed or provided with an oxygen scavenger packet to meet the requirements of paragraph C-2 J. The filled pouch body shall be hermetically sealed. Pouch closure shall be effected by heat-sealing together the cover and body along the entire pouch perimeter. The closure seal width shall be a minimum of 1/8 inch. The closure seal shall have an average seal strength of not less than 6 pounds per inch of width and no individual specimen shall have a seal strength of less than 5 pounds per inch of width when tested as specified in E-5,A,(4),b. Alternatively, the filled and sealed pouch shall exhibit no rupture or seal separation greater than 1/16 inch or seal separation that reduces the effective closure seal width to less than 1/16 inch when tested for internal pressure resistance as specified in E-5,A,(4),c. The maximum outside dimensions of the sealed pouch shall be 6 inches wide by 6 inches long. The closure seal width shall be a minimum of 1/8 inch. A

tear nick, a tear notch, or serrations shall be provided on one outside edge or two opposite outside edges of the pouch to facilitate easy opening of the filled and sealed pouch. The sealed pouch shall not show any evidence of material degradation, aluminum stress cracking, delamination or foreign odor. Heat seals shall be free of occluded matter. Seals shall be free of impression or design on the seal surface that would conceal or impair visual detection of seal defects.

(3) Oxygen scavenger packet. The oxygen scavenger (absorber) shall be constructed of materials that are safe for direct and indirect food contact, and shall be suitable for use with edible products. The oxygen scavenger (absorber) shall be in compliance with all applicable FDA and USDA regulations."

Table I, delete Table I and footnotes in entirety and substitute new Table I as follows:

TABLE I. Filled and sealed pouch defects 1/

Category		Defect
<u>Major</u>	<u>Minor</u>	
101		Tear, hole, or open seal.
102		Seal width less than 1/16 inch. <u>2/</u>
103		Presence of delamination. <u>3/</u>
104		Unclean pouch. <u>4/</u>
105		Pouch has foreign odor.
106		Any impression or design on the heat seal surfaces which conceals or impairs visual detection of seal defects. <u>5/</u>
107		Not packed as specified.
108		Presence of stress cracks in the aluminum foil. <u>6/ 7/</u>
	201	Label smudges, is missing, incorrect, or illegible.
	202	Tear nick, notch, or serrations missing or does not facilitate easy opening.
	203	Seal width less than 1/8 inch, but greater than 1/16 inch.

204 Presence of delamination. 3/

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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.

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).

c. Water spots.

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

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

7/ To examine for stress cracks, the inside surface of both tray-shaped bodies shall be placed over a light source and the outside surface observed for the passage of light. Observation of light through the pouch material in the form of a curved or straight line greater than 2 mm in length shall be evidence of the presence of stress cracks. Observation of light through the pouch material in the form of a curved or straight line 2 mm in length or smaller or of a single pinpoint shall be considered a pinhole. Observation of ten or more pinholes per pouch shall be evidence of material degradation.

December 1999

Paragraph D-1 A (2) b. line 16; Delete; "6 inches long"; Insert: "7-1/4 inches long"

February 2000

(a) Paragraph C-2, I, Nutrient content; delete "(1) protein and (2) fat and (3) salt" requirements" and replace with:  
"(1) Sodium content. The sodium content shall be not greater than 50 mg per 100 grams."

(b) Paragraph E-6, B, Table II; the new provisions are as follows:

- i. Under 'Appearance' insert new major defect "105 Nut or raisin percentages not as specified 3/"
- ii. Delete statement for footnote 3/ and insert "The percentage of nut and raisin components shall be determined using the following procedure: The total contents of twenty pouches shall be weighed and the individual ingredients of the composite shall be separated and weighed separately. The percentages of each component shall be determined and the results reported to the nearest 0.1 percent."

(c) Paragraph E-6, C, Methods of inspection; (3) Nutrient content, the new provisions are as follows:

- i. Line 3; delete "protein content"salt" and insert "sodium".
- ii. Lines 7-9; delete Protein, Fat and Salt tests and method numbers and insert "Sodium 985.35,984.27".
- iii. Line 10; delete "0.1 percent" and insert "1.0 mg per 100 grams".

May 2000

a. Section D-1, A., line 1, after "preformed pouch", insert "or form-fill-seal barrier pouch"

b. Section E-5, A.(1), line 13, insert "D-1, A. 2. (a)" to Requirement Paragraph citation for Aluminum Foil Thickness Requirement

June 2000

E-6, B., TABLE II, Footnote 6, Line 2, Delete; "certificate of conformance";

Insert; "USDA Grade Certificate".

**H. THE FOLLOWING CHANGE APPLIES TO PCR-C-007A, CAKES AND BROWNIES, SHELF STABLE, October 16, 2001:**

Page 10 - 11, B. Methods of inspection. (3) Analytical. Delete and substitute: "The sample to be analyzed shall be a composite of the product from eight filled and sealed pouches which have been selected at random from the lot. The composited sample shall be analyzed for moisture and fat content in accordance

with the following methods of the Official Methods of Analysis of AOAC International:

<u>Test</u>	<u>Method Number</u>
Fat	922.06
Moisture	925.45A

Test results shall be reported to the nearest 0.1 percent. Any result not conforming to the analytical requirements shall be cause for rejection of the lot.

**I. THE FOLLOWING ARE CHANGES TO MIL-C-3031J, COCOA BEVERAGE POWDER, FEBRUARY 13, 1987:**

PAGE 6, PARAGRAPH 3.2.10, LINE 10 (ASH): DELETE "16" AND SUBSTITUTE "18".

Page 6, at the end of Paragraph 3.4.2 insert:  
"The cocoa beverage powder shall be Salmonella negative."

PAGE 8, PARA 4.3.1.1, LINE 2, AFTER "CONDITION", ADD "FORMULATION".

PAGE 9, TABLE I, BELOW "REQUIREMENT PARAGRAPH", UNDER "5.1.1.1", ADD "5.1.1.1.2".

PAGE 10, PARA 4.3.2, DELETE ENTIRELY.

PAGE 10, PARA 4.3.3, TABLE III, DEFECT 105; AFTER "NOT CLEAN", ADD "4/"; AT THE END OF THE PARAGRAPH, ADD NEW FOOTNOTE AS FOLLOWS:

"4/. OUTER PACKAGING SHALL BE FREE FROM FOREIGN MATTER WHICH IS UNWHOLESOME, HAS THE POTENTIAL TO CAUSE POUCH DAMAGE (I.E. GLASS, METAL FILINGS, ETC.) OR GENERALLY DETRACTS FROM THE CLEAN APPEARANCE OF THE PACKAGE. THE FOLLOWING EXAMPLES SHALL NOT BE SCORED AS DEFECTS FOR UNCLEAR:

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 PACKAGE 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).

C. WATER SPOTS.

Page 11, insert the following before Paragraph 4.3.7

"Paragraph 4.3.6.1 Microbiological testing. The finished product shall be tested for Salmonella. Five filled and sealed pouches shall be selected at random from the lot regardless of the lot size. The pouched product shall be individually tested for Salmonella in accordance with the Official Methods of Analysis of the AOAC International, method 986.35, 996.08, and 2000.06 D (c). Verification will be conducted through actual testing by a Government laboratory. Any result not conforming to the microbiological requirements shall be cause for rejection of the lot."

Page 11, insert the following before Paragraph 4.3.7

**Note:** The following conditions apply for salmonella testing:

- (1) 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.
- (2) For bulk product received, the contractor is responsible for end item lot-by-lot testing and USDA will verify end item on a lot-by-lot basis."

PAGE 13, PARAGRAPH 4.3.6, LINE 4; AFTER "OF PRODUCT.)" DELETE THE NEXT TWO SENTENCES, "FOR CLASS I PRODUCT...CONTENT TEST." AND "(THE NONFORTIFIED PRODUCT.....FORTIFIED PRODUCT.)".

PAGE 14, PARAGRAPH 4.3.6, TABLE VI., FOOTNOTE \_3/;

(1). DELETE THE FIRST SENTENCE, "THE VITAMIN CONTENT...SAMPLES."

(2). LINE 5, DELETE "POINTING" AND INSERT "PONTING".

PAGE 15, PARA 4.3.9, ADD THE FOLLOWING NEW MAJOR DEFECT: "NET WEIGHT PER SHIPPING CONTAINER EXCEEDING 40 POUNDS SHIPMENT TO RATION ASSEMBLER."

PAGE 16, PARA 4.3.10, TABLE VII, DEFECT 206, ADD "2/" AT THE END OF THE DEFECT; ADD THE FOLLOWING NEW FOOTNOTE UNDER THE TABLE:

"2/ THE LOT SHALL BE REJECTED IF SAMPLE DATA INDICATES A LOT AVERAGE COUNT LESS THAN THE REQUIRED AMOUNT.

PARA. 5.1.1.1., LINE 2, DELETE ", SEALED". LINE 3, DELETE "5-1/8" AND SUBSTITUTE "4-3/4"; LINE 27, AFTER "NOT PERMITTED." INSERT NEW SENTENCE: "WHEN PROCURED AS A COMPONENT OF THE RATION,

COLD WEATHER, THE COLOR SHALL BE IN THE RANGE OF 37778 TO 37886."

PARA 5.1.1.1 LINE 27, AFTER "NOT PERMITTED" INSERT NEW SENTENCE:  
"WHEN PROCURED AS A COMPONENT OF THE RATION, COLD WEATHER,  
THE COLOR SHALL BE IN THE RANGE OF 37778 TO 37886."

PAGE 17, PARA 5.1.1.1.1, LINE 1, AFTER "CARTON", INSERT "FOR MEAL,  
READY-TO-EAT".

BELOW PARA 5.1.1.1.1, ADD NEW PARAGRAPH AS FOLLOWS:

"5.1.1.1.2. INTERMEDIATE CARTON FOR TRAY PACK MEAL MODULE.  
WHEN SPECIFIED, (SEE 6.1), EIGHTEEN 42.5 GRAM ENVELOPES OF TYPE  
I PRODUCT SHALL BE PACKED IN AN INTERMEDIATE PAPERBOARD BOX  
CONFORMING TO STYLE XI OR XIA, OF PPP-B-566. THE BOX SHALL  
BE MADE WITH A MINIMUM 0.022 INCH THICK CHIPBOARD OR  
CHIPBOARD-KRAFT COMBINATION. THE COVER SHALL BE PROVIDED  
WITH TUCK LOCKS. THE BOX DIMENSIONS SHALL BE 6-5/8 INCHES IN  
LENGTH, 4-7/8 INCHES IN WIDTH, AND 4 INCHES IN DEPTH."

PAGE 19, PARA 5.2.3.1, LINE 7, AFTER "PPP-B-636." INSERT:  
"THE SHIPPING CONTAINER SHALL BE FITTED WITH TOP AND BOTTOM  
PADS, AND A DIVIDER MADE FROM THE SAME MATERIAL AS THE  
CONTAINER. THE DIVIDER SHALL CONSIST OF ONE PIECE OF  
FIBERBOARD, SCORED IN FOUR LOCATIONS TO MAKE THREE EQUAL  
CELLS. THE TERMINAL ENDS OF THE DIVIDER SHALL CONTACT THE  
CONTAINER WALL IN THE LENGTH DIMENSION. THE CENTER CELL WILL  
BE FORMED BY BENDING THE FIBERBOARD AT RIGHT ANGLES SO THAT  
THE OPPOSITE WALL IS CONTACTED BY THE DIVIDER FOR A LENGTH  
EQUAL TO THE TERMINAL END OF THE DIVIDER."

PAGE 20, PARA 5.4.1.2, LINE 5, DELETE "25" AND SUBSTITUTE "18 OR 25".

PAGE 20, PARA 6.1D, LINE 2, AFTER "5.1.1.1.", INSERT: "5.1.1.1.2"; BELOW  
SUBPARAGRAPH E, ADD THE FOLLOWING NEW

SUBPARAGRAPH: "F. QUANTITY OF ENVELOPES REQUIRED (SEE 5.1.1.1.1  
AND 5.1.1.1.2).

Page 17, paragraph 5.1.1., make the following changes:

(1) line 9, delete "The exterior surface of --- except color 30109 is not permitted.",  
insert "The color of the complete exterior of the pouch for the MRE or LRP shall  
be uniformly colored in the range of 20219, 30219, 30227, 30279, 30313, 30324,  
Or 30450 of FED-STD-595."

(2) line 27, delete "Ration", insert "Meal".

**J. THE FOLLOWING CHANGE(S) APPLY TO: MIL-C-595E,  
(Cheese Spread[s])**

November 13, 1990.

PAGE 1, AFTER 1.1 SCOPE, INSERT NEW PARAGRAPH:  
"1.2 CLASSIFICATION. THE CHEESE SPREAD SHALL BE OF THE  
FOLLOWING TYPES AS SPECIFIED (SEE 6.1):

TYPE I - PLAIN  
TYPE II - WITH JALAPENO PEPPERS"

Page 1, 1.2: Add new type: "Type III - With Bacon"

Page 4, Add as new paragraph:

"3.2.12 Bacon. The bacon used in making type III shall be cured with water, salt, sodium erythorbate, sodium nitrite, and may also contain sugar, dextrose, brown sugar, sodium phosphates, potassium chloride, and flavoring (see 6.7)."

PAGE 5:

AFTER 3.2.10 WATER, INSERT NEW INGREDIENT:

"3.2.11 JALAPENO PEPPERS. JALAPENO PEPPERS USED IN MAKING TYPE II PRODUCT SHALL BE DICED, GREEN PACKED IN BRINE. THE JALAPENO PEPPERS SHALL POSSESS A HOT PEPPERY CHARACTERISTIC FLAVOR WITH NO OFF FLAVORS. THE PEPPER DICES SHALL BE NO LONGER THAN 1/8 INCH IN ANY DIMENSION AND SHALL EXHIBIT A UNIFORM LIGHT GREEN COLOR. THE PEPPERS SHALL HAVE A pH NOT GREATER THAN 4.0, AN ACIDITY RANGE FROM 1.5 TO 2.5%, A SALT CONTENT RANGE FROM 6.5 TO 8.5%, AND A MINIMUM HEAT RANGE OF 1500 SCOVILLE HEAT UNITS."

PARAGRAPH 3.3.2, MAKE THE FOLLOWING CHANGES TO SUBPARAGRAPHS:

IN a, LINE 4, AT END INSERT "OR PASTURIZED CHEESE SPREAD WITH FRUITS, VEGETABLE OR MEATS (21 CFR PART 133.176)."

IN c, LINE 2, AFTER "BUTTER" INSERT, "JALAPENO PEPPERS (TYPE II ONLY),".

IN g, LINE 2, DELETE "AND BUTTER", INSERT "BUTTER, AND JALAPENO PEPPERS (TYPE II ONLY)".

AT END, INSERT NEW PROCEDURE:

"k. JALAPENO PEPPERS. THE AMOUNT OF JALAPENO PEPPERS  
(PEPPER SOLIDS AND LIQUID BRINE) USED IN TYPE II PRODUCT

SHALL BE OF SUFFICIENT QUANTITY TO ACHIEVE A FINISHED PRODUCT  
FLAVOR AND ODOR AS SPECIFIED IN 3.4.2."

Page 5, 3.3.2 c, line 2: After "(type II only)", insert "and bacon (type III)".

3.3.2 g, line 2: After "(type II only)", insert "and bacon (type III)".

Page 6, 3.3.2: Add new subparagraph:

"3.3.2.1. Bacon. The amount of bacon used in type III product shall be of  
sufficient quantity to achieve a finished product flavor and odor as specified in  
3.4.2."

Page 6, 3.4.1, line 1: Delete "(types I and II)" and insert "(types I, II, and III)".

3.4.1, line 7: Delete "II" and "insert "II".

3.4.1, line 9: After "throughout", add new sentence: "The color of type III product  
shall be a uniform light yellow-orange which falls between No. 6 and No. 10 on  
the National Cheese Institute color standards with no evidence of mottling,  
browning, or color fading and shall exhibit small pieces of brown to reddish brown  
bacon uniformly dispensed throughout."

3.4.2, line 5: After "sensation", add new sentence: "The type III product shall  
have a slightly meaty, slightly smoky flavor and odor."

PAGE 7:

PARAGRAPH 3.4.1, MAKE THE FOLLOWING CHANGES:

IN LINE 1, AFTER "CHEESE SPREAD" INSERT "(TYPES I AND II)".

IN LINE 4, AFTER "COLOR" INSERT "OF TYPE I PRODUCT".

IN LINE 7, AFTER "FADING" INSERT:

"THE COLOR OF TYPE II PRODUCT MAY POSSESS A SLIGHT  
GREEN/GREY HUE AND SHALL EXHIBIT VISIBLE GREEN PEPPER  
PARTICLES UNIFORMLY DISPERSED THROUGHOUT."

PARAGRAPH 3.4.2, LINES 1 AND 3, AFTER "CHEESE SPREAD" INSERT  
"(TYPE I PRODUCT ONLY)".

PARAGRAPH 3.4.2, LINE 3, AFTER "TASTE" INSERT:

"THE TYPE II PRODUCT SHALL HAVE A PRONOUNCED JALAPENO PEPPER FLAVOR AND ODOR AND SHALL IMPART A MODERATE HEAT OR MOUTH BURNING SENSATION."

Page 7, 3.4.3 b: Delete entirely and insert:

"3.4.3. b. The fat content shall be not less than 38.0 percent nor greater than 42.0 percent for Types I and II. The fat content shall be not less than 38.0 percent nor greater than 42.5 percent for Type III."

3.4.3 c: Delete entirely and insert:

"3.4.3 c. The salt content shall be not less than 1.6 percent nor greater than 2.2 percent for Types I and II. The salt content shall be not less than 3.0 percent nor greater than 3.7 percent for Type III."

PAGE 8:

PARAGRAPH 3.4.3 b, DELETE "(ON A DRY WEIGHT BASIS)".

PARAGRAPH 3.4.3 d, DELETE "NOR" AND INSERT "NOT GREATER".

PAGE 10:

PARAGRAPH 4.5.3, TABLE I, UNDER CRITICAL 3 DEFECT, LINE 4, DELETE "1/6" AND INSERT "1/16".

Page 10, 4.5.6, Table II: Add new defects:

"110 Type III product does not have a slightly smoky and slightly meaty flavor and odor."

"111 Type III product does not have visible bacon pieces uniformly dispersed throughout."

PAGE 12:

PARAGRAPH 4.5.5, TABLE II, MAKE THE FOLLOWING CHANGES:

IN DEFECT 102, AFTER "FADIN" INSERT "(TYPE I ONLY)".

IN DEFECT 106, BEFORE "TYPICAL" INSERT "NOT".

IN DEFECT 106, AFTER "CHEESE" INSERT "(TYPE I ONLY)".

INSERT NEW DEFECTS AS FOLLOWS:

"108 TYPE II PRODUCT DOES NOT HAVE A PRONOUNCED CHARACTERISTIC JALAPENO FLAVOR AND ODOR AND DOES NOT IMPART A MODERATE HEAT OR MOUTH BURNING SENSATION"

"109 TYPE II PRODUCT DOES NOT HAVE VISIBLE GREEN PEPPER PARTICLES UNIFORMLY DISPERSED THROUGHOUT"

PAGE 13:  
PARAGRAPH 4.5.7, MAKE THE FOLLOWING CHANGES:  
LINE 3, DELETE "+1/16 INCH" AND INSERT "PLUS OR MINUS 1/16 INCH".

LINE 17, DELETE "AND THE AQL...SHALL BE 1.5" ENTIRELY.

Page 13, 5.1.1, line 1, Delete "or", after "type II" and insert "or type III".

PAGE 15:  
PARAGRAPH 4.5.10, UNDER THE THIRD MAJOR DEFECT "FOR SHIPMENT TO RATION ASSEMBLER FOR MRE", DELETE "NUMBER OF ...CONTAINER" ENTIRELY AND INSERT "NUMBER OF POUCHES PER SHIPPING CONTAINER IS LESS THAN REQUIRED".

Page 15, 5.3.1, line 14, After, "CHEESE SPREAD, CHEDDAR, WITH JALAPENO PEPPERS, (TYPE II) (OPERATIONAL RATION COMPONENT)", insert the following:

"or  
CHEESE SPREAD, CHEDDAR, WITH BACON, (TYPE III) (OPERATIONAL RATION COMPONENT)"

PAGE 16:  
PARAGRAPH 5.1.1, LINE 1, AFTER "OF" INSERT "TYPE I OR TYPE II".

PARAGRAPH 5.1.1, LINES 6-9, DELETE THE COLOR...FED-STD-595 AND INSERT:  
THE POUCH COLOR SHALL CONFORM TO NUMBER 20219, 30219, 30227, 30279, 30313, 30324, or 30450 of FED-STD-595.

PARAGRAPH 5.1.1, LINE 8, SENTENCE 4, AFTER "THE POUCH COLOR", INSERT "FOR MRE AND LRP APPLICATIONS"

PARAGRAPH 5.1.1, LINE 9, AFTER SENTENCE 4, INSERT THE FOLLOWING:  
"FOR 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."

Page 16, Add as a new paragraph:  
"6.7 Bacon. Bacon Bits EDP# 2555834743 manufactured by Hormel Foods, Corp., Austin, Minnesota 55912-3680 meets the requirements of 3.2.12 and performs satisfactorily in this product."

PAGE 17:  
PARAGRAPH 5.3.1, LINE 14, DELETE "CHEESE SPREAD CHEDDAR"  
INSERT:

"CHEESE SPREAD, CHEDDAR, PLAIN, (TYPE I)  
(OPERATIONAL RATION COMPONENT)

OR  
"CHEESE SPREAD, CHEDDAR, WITH JALAPENO PEPPERS, (TYPE II)  
(OPERATIONAL RATION COMPONENT)"

PAGE 17:

PARAGRAPH 5.3.1, LINE 17 AFTER LETTERS INSERT:  
BELOW. THE COLOR OF THE PRINTING INK SHALL CONFORM TO  
NUMBER 20045, 20122, 30045, 30099, 30108, 30111, OR 30140 OF FED-STD-  
595.

PAGE 18:  
PARAGRAPH 6.1, INSERT NEW REQUIREMENT:  
"f. TYPE OF PRODUCT REQUIRED (SEE 1.2)."

PAGE 20:  
DELETE FIGURE 1 AND REPLACE WITH NEW FIGURE ONE ENCLOSED.

**K. THE FOLLOWING ARE CHANGES TO CID A-A-20295, COOKIES:**

Page 3, Style J - Chocolate chip cookies (regular, chunk, or mini chips)  
After Flavor 7, delete "Other" and insert "Peanut butter with chocolate chips"  
Add "Flavor 8 - Chocolate mint with chocolate chips"  
Add "Flavor 9 - Other"

Page 5, Paragraph 3.3.11 - At the end of the paragraph add the following -  
"Flavor 7 - Peanut butter cookie with chocolate chips shall have a distinct peanut  
flavor. Flavor 8 - Chocolate mint cookies with chocolate chips shall have a dark  
chocolate brown color and distinct chocolate mint flavor."

Page 5, Paragraph 3.6.1, line 6 - after "4.0 percent" add "except for Flavor 7  
which shall not exceed 7.0 percent and Flavor 8 which shall not exceed 6.0  
percent."

THE FOLLOWING CHANGE(S) APPLIES TO  
THE PKGQA FOR CID A-A-20295A, COOKIES DATED 27 NOVEMBER 2002:

Paragraph D-1, A, 2(b), line 5, delete "15 to 17" and substitute "8 to 12".

**L. THE FOLLOWING CHANGES APPLY TO:  
Military Specification MIL-C-44072C, Cookies, Oatmeal; and Brownies,  
Chocolate Covered, 30 Apr 90:**

- Paragraph 5.1.2.1.1, delete in its entirety and substitute:  
" Pouch construction. The tray-shaped body and the tray-shaped cover shall be  
formed by drawing the flexible laminate material into an appropriately

shaped cavity. The flat cover shall be in the form of a flat sheet of the barrier material taken from roll stock. When specified, one unit of product shall be placed in the tray-shaped body of the pouch. The filled pouch body shall be hermetically sealed with a vacuum level of not less than 22 inches of mercury. Pouch closure shall be effected by heat sealing together the cover and body along the entire pouch perimeter. The closure seal width shall be a minimum of 1/8 inch. Pouch integrity and air tightness of the closure seals shall be tested in accordance with 4.5.3.3. The closure seal shall have an average seal strength of not less than 6 pounds per inch of width and no individual specimen shall have a seal strength of less than 5 pounds per inch of width when tested as specified in 4.5.5. Alternatively, the filled and sealed pouch shall exhibit no rupture or seal separation greater than 1/16 inch or seal separation that reduces the effective closure seal width to less than 1/16 inch when tested for internal pressure resistance as specified in 4.5.5.1. The maximum outside dimensions of the sealed pouch shall be 4 to 5-1/2 inches wide by 5-1/4 to 6 inches long. A tear notch or serrations shall be provided on one outside edge or two opposite outside edges of the pouch to facilitate easy opening of the filled and sealed pouch. The sealed pouch shall not show any evidence of material degradation, aluminum stress cracking, delamination or foreign odor. Heat seals shall be free of occluded matter. Seals shall be free of impression or design on the seal surface that would conceal or impair visual detection of seal defects.”

Table I and associated footnotes, delete in its entirety and substitute new Table I and associated footnotes as follows:

TABLE I. Filled and sealed pouch defects 1/

<u>Category</u>		<u>Defect</u>
<u>Major</u>	<u>Minor</u>	
101		Tear, hole, or open seal.
102		Seal width less than 1/16 inch. <u>2/</u>
103		Presence of delamination. <u>3/</u>
104		Unclean pouch. <u>4/</u>
105		Pouch has foreign odor.
106		Any impression or design on the heat seal surfaces which conceals or impairs visual detection of seal defects. <u>5/</u>
107		Not packaged as specified.
108		Presence of stress cracks in the aluminum foil. <u>6/ 7/</u>
	201	Label missing, incorrect, or illegible.
	202	Tear notch or serrations missing or does not facilitate opening.
	203	Seal width less than 1/8 inch but greater than 1/16 inch.
	204	Presence of delamination. <u>3/</u>

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

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

3/ Delamination defect classification:

Major - Delamination of the outer ply in the pouch seal area that can be propagated to expose aluminum foil at the food product edge of the pouch after manual flexing of the delaminated area. To flex, the delaminated area shall be held between the thumb and forefinger of each hand with both thumbs and forefingers touching each other. The delaminated area shall then be rapidly flexed 10 times by rotating both hands in alternating clockwise- counterclockwise directions. Care shall be exercised when flexing delaminated areas near the tear notches to avoid tearing the pouch material. After flexing, the separated outer ply shall be grasped between thumb and forefinger and gently lifted toward the food product edge of the seal or if the separated area is too small to be held between thumb and forefinger, a number two stylus shall be inserted into the delaminated area and a gentle lifting force applied against the outer ply. If separation of the outer ply can be made to extend to the product edge of the seal with no discernible resistance to the gentle lifting, the delamination shall be classified as a major defect. Additionally, spot delamination of the outer ply in the body of the pouch that is able to be propagated beyond its initial borders is also a major defect. To determine if the laminated area is a defect, use the following procedure: Mark the outside edges of the delaminated area using a bold permanent marking pen. Open the pouch and remove the contents. Cut the pouch transversely not closer than 1/4 inch ( $\pm 1/16$  inch) from the delaminated area. The pouch shall be flexed in the area in question using the procedure described above. Any propagation of the delaminated area, as evidenced by the delaminated area exceeding the limits of the outlined borders, shall be classified as a major defect.

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

4/ Outer packaging shall be free from foreign matter which is unwholesome, has the potential to cause pouch damage (for example, glass, metal filings) or

generally detracts from the clean appearance of the pouch. The following examples shall not be classified as defects for unclean:

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

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

c. Water spots.

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

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

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

Table II, delete defect 109 and associated footnotes 4/ and 5/.

Page 1, paragraph 1.2, line 4, delete "bars" and insert "s" after "cookie".

Page 2, delete line 6 "Military" and line 7 "MIL-C-10928...Confections".

Page 4, paragraph 3.2.1, line 3, after "sugar", and before "to", insert "in the brownie formula".

Paragraph 3.2.3, line 3, delete "cookie bar" and insert "oatmeal cookies".

Page 5, paragraph 3.2.4, line 3, delete "All.....excluded." and substitute "Coconut and palm kernel oils may be used only in the coating."

Page 6, paragraph 3.2.14, delete entirely.

Page 7, below 3.2.17, add the following new paragraphs:

3.2.18 Emulsifiers. Lecithin, Polyoxyethylene (20) Sorbitan Monostearate, and Sorbitan Monostearate shall comply with the Food Chemicals Codex.

3.2.19 Fat. Vegetable fat for the chocolate coating shall be natural or hydrogenated coconut, palm kernel, Babasu, Tucum, or other high Lauric acid oils or mixtures thereof, or a mixture of one or more of these with not more than 25 percent hydrogenated peanut oil or cottonseed oil, or both combined. The fats shall have a minimum stability of 100 hours when measured by the Active Oxygen Method (AOM). They shall retain satisfactory odor, flavor, and color after heating to a temperature of 400 degrees F. The free fatty acid content shall be not greater than 0.08 percent prior to the addition of an antioxidant mixture or 0.11 percent after the addition of antioxidant mixture a, b, c, d, or e specified in 3.2.19.1. The moisture and volatile matter shall not exceed 0.1 percent after the addition of anti oxidant mixture a, b, c, d, or e. The fat shall be adequately protected against oxidative rancidity at time of manufacture or by the processor by the addition of 0.1 percent by weight of an antioxidant mixture specified in 3.2.19.1. The melting point and solid fat indices shall be as follows:

Wiley Melting Point: 117 degrees F to 119 degrees F

Solid Fat Index:	Degrees F	Percent Solid
	50	68
	70	58
	80	52
	92	30
	110	12 maximum.

3.2.19.1 Antioxidant mixture. Antioxidant mixtures shall consist of ingredients in the proportion specified as follows:

Ingredient	Percent of mixture				
	a	b	c	d	e
Edible solvent, not more than	70	74	60	67	70
Butylated hydroxyanisole, not less than	20	20	20	4	20
Butylated hydroxytoluene, not less than	--	--	20	20	--
Citric acid	4	6	--	4	4
Propyl gallate, not less than	6	--	--	5	--
TBHQ (Tertiary butylhydroquinone), not less than	--	--	--	--	6

Any one of the mixtures may be used. Antioxidants shall comply with the Food Chemicals Codex."

Page 7, paragraph 3.3, line 1, delete "and cookie Bar" and substitute ", oatmeal cookie and chocolate coating".

Page 7, paragraph 3.3.1, line 7, after "4/" add ", 5/".

Page 8, paragraph 3.3.1, after "preparation." and prior to paragraph 3.3.2 add, "5/ Whole eggs, dried, may be substituted for whole eggs (liquid basis) by following the manufacturer's recommended rehydration and mixing procedures and shall have no less than the equivalent amount of whole egg solids as the liquid basis. The water shall be adjusted to ensure compliance with moisture requirements of the baked brownie prior to coating."

Page 8, paragraph 3.3.5, line 2, delete "(see 3.2.14)" and substitute "(see 3.3.10 and 3.3.11)".

Page 9, paragraph 3.3.6, line 1, prior to "formula", delete "cookie bar" and insert "oatmeal cookie".

Page 9, paragraph 3.3.7, line 1, delete "cookie bar" and insert "oatmeal cookie"; line 3, delete "cookie bars" and insert "oatmeal cookies".

Paragraph 3.3.8, line 1, delete "cookie bar" and insert "oatmeal cookie".

Paragraph 3.3.9, line 1, prior to "coating", delete "cookie bar" and insert "oatmeal cookie"; prior to "shall", delete "cookie bars" and insert "oatmeal cookies".

Below 3.3.9, add the following new paragraphs:

"3.3.10. Chocolate coating formula. The formula for the chocolate coating shall be as follows:

Ingredient <sup>1/</sup>	Percent by weight
Cocoa powder, medium	not less than 8.0
Nonfat dry milk	not less than 12.0
Added fat	not less than 30.0
Lecithin	not more than 0.2
Sorbitan monostearate	not more than 0.5
Polyoxyethylene (20) sorbitan monostearate	not more than 0.5
Sugar	not more than 48.5
Salt (per 100 pounds of coating)	2 ounces
Vanillin (per 100 pounds of coating)	1 ounce

<sup>1/</sup> The coating shall be enriched with vitamins as specified in not less than the following amounts:

Thiamine (as thiamine mononitrate)	8.0 mg per pound
Pyridoxine (as pyridoxine hydrochloride)	8.0 mg per pound
Ascorbic acid (Vitamin C)	320.0 mg per pound
Vitamin A	20,000 I. U. per pound

(NOTE: Estimated loss of vitamins due to processing is approximately 15 percent for all but thiamine which is about 30 percent. The amounts cited above shall represent after-processing values.)

3.3.11 Chocolate coating preparation. The formula for chocolate coating shall be blended on a dry-solids basis. Sorbitan monostearate and polyoxyethylene (20) sorbitan monostearate shall be melted, mixed with the added fat and the dry-solids blend and brought to a temperature of not less than 150 degrees F. The mixture shall be held at that temperature or higher for a period of at least 30 minutes. The coating shall be refined (20 microns or less, 7/10,000 inch) so that it has a smooth mouth feel without grittiness. The coating shall be such that, when the vacuum packaged product (at least 72 hours after manufacture) is held at a temperature of 100 degrees f for two hours, the product can be easily removed from the bag without loss of coating. The product shall be allowed to cool at a temperature between 40 and 70 degrees F for resolidification to occur for approximately one hour prior to performing the test. The chocolate coating shall be Salmonella free (see 4.5.1.4)."

Page 9, paragraph 3.4, line 1, delete "cookie bars" and insert "oatmeal cookies".

Page 10 paragraph 3.4g delete entirely and substitute,  
"g. The weight of the coated brownie shall be not less than 46 grams.";

Paragraph 3.4k delete entirely and substitute,  
"k. The weight of the coated oatmeal cookie shall be not less than 43 grams."

Page 10, paragraph 3.4i, and 3.4j, line 1, delete "cookie bar" and insert "oatmeal cookie".

Page 10, paragraph 3.4, below subparagraph k, add the following new subparagraph:

"l. The chocolate coating shall be free from cracks, chips, or rough spots."

Page 12, below paragraph 4.5.1.3, insert the following new para:

"4.5.1.4 Chocolate coating microbiological certification. The chocolate coating shall be Salmonella free when tested in accordance with the Official Methods of Analysis of the AOAC, method 967.26. The chocolate coating may be accepted on a contractor's Certificate of Compliance to the Salmonella requirement in 3.3.11. Any nonconformance to the requirement in 3.3.11 shall be cause for rejection of the component lot or any involved product."

Page 12, paragraph 4.5.2.2, lines 1, 2, 7, and 11, delete "cookie bar" and insert "oatmeal cookie".

Paragraph 4.5.2.3, line 1, insert "oatmeal" prior to "cookies"; line 2, delete "cookie bars" and substitute "oatmeal cookies", line 3, delete "individually".

Page 13 paragraph 4.5.3.1. line 4, delete "Any individual sample unit having a net weight.....shall be classified as a minor defect." and substitute "Any individual sample unit having a net weight of less than 46 grams for brownies or less than 43 grams for oatmeal cookie shall be classified as a minor defect."

Page 13, paragraph 4.5.3.1, line 6, delete "cookie bars" and insert "oatmeal cookies".

Page 13, Table I. :

Add new major defect, 111 - Presence of stress cracks or material degradation in the aluminum foil 4/;

Add new footnote, 4/ To examine for stress cracks, the inside surface of each side shall be placed over a light source and the outside surface observed for the passage of light. Observation of light through the bag material in the form of a curved or straight line greater than 2mm in length or smaller or of a single pinpoint of light shall be considered a pinhole. Observation of 10 or more pinholes per bag shall be evidence of material degradation.

Page 13, Move major defect 111 and the associated footnote from Table I. Filled and sealed bag defects to Table II. Product defects.

Add new minor defect, 204 - Presence of delamination 2/

Delete footnote 2/ entirely and insert, 2/ 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 bag 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 bag 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 discernable 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 bag that is able to be propagated beyond its initial borders is also a major defect. To determine if the delaminated area is a defect, use the following procedure: Mark the outside edges of the delaminated area using a bold permanent-marking pen. Open the bag and remove the contents. Cut the bag transversely not closer than 1/4 inch (+1/16

inch from the delaminated area. The bag 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 bag 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 bag seal area or isolated spots of delamination in the body of the bag that do not propagate when flexed as described above shall be classified as minor defects.

Page 15, paragraph 4.5.3.4, Table II, add the following defects under major:

"107                      Coating adheres to bag.  
108                      Coating not free from cracks, chips, or rough  
                             spots."

Page 15, Table II, Major 102, 105, 106 and Minor 102, delete "cookie bar" and substitute "oatmeal cookie".

Page 16, paragraph 4.5.4, Table III, add the following defects under "Major":  
"107                      Coating adheres to bag.

108                      Coating not free from cracks, chips, or rough spots."

Page 16, paragraph 4.5.4, line 3, delete "cookie bars" and insert "oatmeal cookies"; line 4, delete "cookie bar" and insert "oatmeal cookies".

Table III, Major 102, 105, 106 and Minor 201 and 203, delete "cookie bar" and insert "oatmeal cookies".

Page 17, Add paragraph 4.5.5.1

4.5.5.1 Internal pressure test. The internal pressure resistance shall be determined by pressurizing the pouches while they are restrained between two rigid plates. The sample size shall be the number of pouches indicated by inspection level S-1. If a three seal tester (one that pressurizes the pouch through an open end) is used, the closure seal shall be cut off for testing the side and bottom seals of the pouch. For testing the closure seal, the bottom seal shall be cut off. The pouches shall be emptied prior to testing. If a four seal tester (designed to pressurize filled pouches by use of a hypodermic needle through the pouch wall) is used, all four seals can be tested simultaneously. The distance between rigid restraining plates on the four seal tester shall be equal to the thickness of the product +1/16 inch. Pressure shall be applied at the approximate 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 shall be considered a test failure. Any test failure shall be cause for rejection of the lot.

Page 17, paragraph 5, line 1 after "Meal, Ready-to-Eat Individual", add "/Food Packet, Long Range Patrol"

" " line 6, delete "Ration", insert "Meal"

" " line 9, delete "RCW", insert "MCW"

Page 17, paragraph 5.1.1, lines 1 and 2, delete "cookie bar" and insert "oatmeal cookie".

Page 17, paragraph 5.1.1.1, line 6, sentence 4, after "The exterior bag color", insert "for MRE and LRP applications"

" " , line 8, sentence 5, delete "RCW" and insert "MCW"

Page 18, paragraph 5.1.1.1.2, line 1, delete "cookie bar" and insert "oatmeal cookie".

Pages 18 and 19, paragraph 5.1.2.1.1, line 3, delete "cookie bar" and insert "oatmeal cookie"; line 15, between "4" and "inches", insert "to 5-1/2"; between "5-1/4" and "inches", insert "to 5-1/2"; before "1/16", delete "+" and insert "+/-".

Paragraph 5.1.2.1.1 Bag forming, filling, and sealing., sentence 8, delete entirely "by 5-1/4 to 5-1/2 inches long (+1/16 inch)." and insert "by 5-1/4 to 6 inches long (+1/8 inch).

Page 19, paragraph 5.2, delete title and substitute: "Level C packing."

Paragraph 5.2.1 line 1, prior to "and", delete "cookie bars" and insert "oatmeal cookies"; prior to "or", delete "cookie bars" and insert "oatmeal cookies".

Para 5.2.2, delete entirely.

Page 20, paragraph 5.3.1, delete entirely. Insert new para. 5.3.1 as follows:  
"5.3.1 Unit packs. Each unit (see 5.1.1) shall be clearly printed or stamped, in a manner that does not damage the pack, with permanent ink in large letters, which is free of carcinogenic elements or ingredients. The color of the printing ink shall conform to number 20045, 20122, 30045, 30099, 30108, 30111, or 30140, of FED-STD-595. The information shall be located on the body of the pack not closer than 1/16 inch to any seal. If a non-contact type printer is used, the information may be located anywhere on the pack (in one complete print), except the closure seal area. The label shall contain the following information:

Product name, Date 1/, Net weight, Contractor's name and address, FDA label of "Nutritional Facts" in accordance with the NLEA.

1/ Each pack 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, March 19, 1995 would be coded as 5078. The Julian day code shall represent the day the product was packaged into the pouch.

Paragraph 5.3.2, lines 3-5, delete "In addition...5.3.2.1."

Paragraph 5.3.2.1, delete entirely.

Page 21, paragraph 6.5, line 2, delete "bars, dessert".

Page 22, Figure 1, Preformed bag, delete bag width "3-3/4" and substitute "3-1/4".

**M. THE FOLLOWING CHANGE(S) ARE TO:**

**Quality Assurance Provisions & Packaging requirements for CID A-A-20098B Beverage Bases, Powdered:**

September 2002

D-1 Packaging, insert new paragraph:

"B. Packaging. When specified for flavor 12, fortification b, package A, B or C not less than 17 grams or 34 grams, as applicable shall be filled into an envelope having maximum outside dimensions of 4-7/8 inches long by 3-7/16 inches wide. The envelope shall be made from a heat sealable barrier material, one layer of which is a minimum of 0.00035 inch thick aluminum foil. All four edges of the envelope shall be heat-sealed with seals not less than 1/8 inch wide. The sealed envelope shall no leakage when examined in accordance with Section E-6, B. (1). There shall be no crushed, misshapen or unclean envelopes."

**N. THE FOLLOWING ARE CHANGES TO CID A-A-20195B (SNACK FOODS) AUGUST 14, 1996:**

Page 2, paragraph 3.2, line 5, delete "25", and substitute "50"

Page 3, paragraph 3.4, line 6, delete "25", and substitute "50"

Page 2, paragraph 3.1, Type I, Potato Sticks, line 11, delete "not less than 31.0 percent and"

Page 2, paragraph 3.1 Type I, Potato Sticks, line 10, delete "The moisture content...2.5 percent." insert "The average moisture content shall not exceed 3.4 percent with no individual sample greater than 3.9 percent."

Page 2, paragraph 3.2, Type II, Pretzels, line 6, delete "The moisture content... 5.5 percent." insert "The average moisture content shall not exceed 5.5 percent with no individual sample greater than 6.0 percent."

Page 2, paragraph 3.3 Type III, Crunchy cheese-flavored curls line 10, delete "The moisture content ...2.2 percent." insert "The average moisture content shall not exceed 2.9 percent with no individual sample greater than 3.4 percent."

Page 3, paragraph 3.4, Type IV, Corn Chips, line 7, delete "The moisture... 1.7 percent." Insert "The average moisture content shall not exceed 2.6 percent with no individual sample greater than 3.1 percent."

Delete "17 October 1996" from second bolded title and insert "September 30, 1999" Delete language "Page ... broken" Add the following sentence: "See Quality Assurance Provisions and Packaging Requirements for CID A-A-20195 DATED September 30, 1999."

**O. THE FOLLOWING ARE CHANGES TO THE QUALITY ASSURANCE PROVISIONS AND PACKAGING REQUIREMENTS FOR CID A-A-20195B, SNACK FOODS, SEPTEMBER 30, 1999:**

Page 1, C-1, Add "Packages, Package A - Meal, Cold, Weather (MCW), Package B - Food Packet, Long Range Patrol (LRP), Package C - Meal, Ready-to-Eat (MRE)" after Types, styles, and flavors section.

Page 2, D-1, A., (1), a. Pouch material, Line 6, Delete "The complete exterior surface - Government Procurement" and Add "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."

Page 5, Sec E., E-5, A., (3) Table I, delete footnote 8/, insert new footnote 8/:

8/ The initial examination shall be a visual examination of the closed package. Any suspected visual evidence of stress cracks in the aluminum foil (streaks, breaks, or other disruptions in the laminated film) shall be verified by the following physical examination. To examine for stress cracks, the inside surface

of both tray-shaped bodies shall be placed over a light source and the outside surface observed for the passage of light. Observation of light through the pouch material in the form of a curved or straight line greater than 2 mm in length shall be evidence of the presence of stress cracks in the aluminum foil. Observation of light through the pouch material in the form of a curved or straight-line 2mm in length or smaller or of a single pinpoint shall be considered a pinhole. Observation of ten or more pinholes per pouch shall be evidence of material degradation.”

Section D, D-1, A. (1) b., line 2, delete “4”, insert “5”.

Section D, part D-1, A, subpara (1) b, line 2: delete “7” and insert “7 ¼”

Section D, part D-1: delete para A and insert:  
“A. Packaging. For type I and type II (styles A-E), one ounce (+1/2 ounce, -1/8 ounce) of product shall be packed in a preformed or form-fill-seal barrier pouch as described below. For type II (style F), flavors 1 and 2, 1.8 ounces of product and one oxygen scavenger packet shall be packed in a preformed or form-fill-seal barrier pouch as described below.”

Section D, part D-1, A, subpara (1) c, line 2: after “packet” insert “, if applicable,”.

Section D, part D-1, A, subpara (2) b, line 6: after “packet” insert “, if applicable,”.

Section E, part E-6, para B, Table II, defect 115: at end insert “(applicable to type II, Style F only)”.

Section C-2, D. line 2, delete “3.0”, insert “5.0”

Page 1, Section C, part C-2: delete paragraph E and insert:  
“E. Oxygen content. For type II (Style F), flavors 1 and 2, the oxygen content of the filled and sealed pouch shall not exceed 0.30 percent.”

**P. The following changes to subject solicitation are applicable:**

1. Addendum 52.212-1(b) – #1 - Faxed offers are authorized for this solicitation. Mark second block with an “x”.
2. Addendum 52.212-1(c) – #2 - Period for acceptance of offers: Mark box with an “x”
3. Addendum 52.212-1(h) - #4 – Multiple Awards – The Government intends to make one award. Mark first block with an “x”.