

SECTION C

This document covers fortified peanut butter packaged in a flexible pouch for use by the Department of Defense as a component of operational rations.

C-1 ITEM DESCRIPTION

PACKAGING REQUIREMENTS AND QUALITY ASSURANCE PROVISIONS FOR CID A-A-20328, PEANUT BUTTER AND PEANUT BUTTER SPREAD

Type, Class, Texture, Style, Grade, Fortification.

Type I - Peanut Butter

Class 1 - Regular.

Texture A - Creamy.

Style 1 - Stabilized.

Grade - US Grade A.

Fortification b - Fortified.

Packages.

Package A - Meal, Cold Weather (MCW)

Package B - Food Packet, Long Range Patrol (LRP)

Package C - Meal, Ready-To-Eat (MRE)

Package D - Meal Module, Tray Pack (MM)

C-2 PERFORMANCE REQUIREMENTS

A. Product standard. A sample shall be subjected to first article or product demonstration model inspection, as applicable, in accordance with the tests and inspections of Section E of this Packaging Requirements and Quality Assurance Provisions document.

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

C. Net weight. The net weight shall be 1.5 ounces.

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

E. Fortification. Peanut butter shall be fortified with 2500 IU Vitamin A, 1.1 mg pyridoxine hydrochloride (vitamin B6), 0.8 mg thiamine hydrochloride (vitamin B1) and 37.5 mg ascorbic acid (vitamin C) per 1.5 ounces of peanut butter.

F. Aflatoxin content. The aflatoxin content of the peanut butter shall be negative.

SECTION D

D-1 PACKAGING

A. Packaging. One and one half ounces of product shall be filled into a preformed barrier pouch.

(1) Pouch material. The preformed pouch shall be fabricated from 0.002 inch thick ionomer or polyethylene film laminated or extrusion coated to 0.00035 inch thick primed

aluminum foil which is then laminated to 0.0005 inch thick polyester. All tolerances for thickness of pouch material shall be plus or minus 20 percent. The material shall show no evidence of delamination, degradation, or foreign odor when heat sealed or fabricated into pouches. The material shall be suitably formulated for food packaging and shall not impart an odor or flavor to the product. 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), package C (MRE) and package D (MM), 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.

(2) Pouch construction. The pouch shall be a flat style pouch having maximum inside dimensions of 2-7/8 inches wide by 5-3/8 inches long. The pouch shall be made by heat sealing three edges with 3/8 inch (-1/8 inch, +3/16 inch) wide seals. The heat seals shall be made in a manner that will assure hermetic seals. The side and bottom seals 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-6,A,(4),a. Alternatively, the pouch shall exhibit no rupture or seal separation greater than 1/16 inch or seal separation that reduces the effective seal width to less than 1/16 inch when tested for internal pressure resistance as specified in E-6,A,(4),c. A tear notch shall be provided to facilitate opening of the filled and sealed pouch. A 1/8 inch wide lip may be incorporated at the open end of the pouch to facilitate opening and filling of the pouch.

(3) Pouch filling and sealing. One and one half ounces of product shall be filled into the pouch and the pouch sealed. The closure seal shall be free of foldover wrinkles or entrapped matter that reduces the effective closure seal width to less than 1/16 inch. Seals shall be free of impression or design on the seal surface that would conceal or impair visual detection of seal defects. The average seal strength shall be not less than 6 pounds per inch of width and no individual specimen shall have a seal strength of less than 5 pounds per inch of width when tested as specified in E-6,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-6,A,(4),c.

D-2 LABELING

A. Pouches. Each pouch shall be clearly printed or stamped, in a manner that does not damage the pouch, with permanent black ink or other, dark, contrasting color which is free of carcinogenic elements. The information may be located anywhere on the pouch (in one complete print), except the closure seal area. The label shall contain the following information:

Name of product (letters not less than 1/8 inch high)
Ingredients
Date 1/
Net weight
Contractor's name and address
"Nutrition Facts" label in accordance with the Nutrition Labeling
and Education Act (NLEA) and all applicable FDA/USDA regulations
KNEAD PACKAGE BEFORE OPENING

1/ Each pouch shall have the date of pack noted by using a four-digit code beginning with the final digit of the current year followed by the three digit Julian day code. For example, 2 June 2000 would be coded as 0154. The Julian day code shall represent the day the product was packaged into the pouch.

D-3 PACKING

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

Standard Practice for Fabrication of Fiberboard Shipping Boxes. Each container shall be securely closed in accordance with ASTM D 1974, Standard Practice for Methods of Closing, Sealing, and Reinforcing Fiberboard Shipping Containers.

D-4 MARKING

A. Shipping containers. Shipping containers shall be marked in accordance with DPSC 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. When required, the manufacturer shall be required to 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)
Natick, MA 01760-5018

One lot shall be randomly selected during each calendar month of production. Six (6) sample units of each item produced shall be randomly selected from that one production lot. The six (6) sample units shall be shipped to Natick within two (2) working days upon completion of all USDA inspection requirements. The sample units will be evaluated for the characteristics of appearance, odor, flavor, texture and overall quality. Failure of samples to conform to all such characteristics may be cause for rejection.

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

E-5 QUALITY ASSURANCE PROVISIONS (PRODUCT)

A. Product examination. The finished product shall be examined for compliance with the performance requirements specified in Section C of the Packaging Requirements and Quality Assurance Provisions document and A-A-20328 utilizing the double 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 acceptable quality level (AQL), expressed in terms of defects per hundred units, shall be 1.5 for major defects and 4.0 for minor defects. Defects and defect classifications are listed in table I.

TABLE I. Product defects 1/ 2/

Category		Defect
<u>Major</u>	<u>Minor</u>	
101		Product not the type, class, texture, style, grade and fortification specified.
		<u>Appearance</u>
	201	Product not a light brown color with a slight sheen.
		<u>Odor and flavor</u>
102		Product does not possess a freshly roasted and freshly ground peanut odor or flavor.
		<u>Texture</u>
	202	Product does not possess a finely ground even texture.
	203	Product not free of grainy peanut particles.
	204	Product does not have a soft spreadable consistency.
	205	Product mouthfeel not slightly sticky.
	206	Product does not spread easily without tearing bread.
		<u>Net weight</u>
	207	Net weight of an individual pouch less than 1.5 ounces.
		<u>Other</u>
	208	Product exhibits oil separation.

1/ The presence of foreign material for example, dirt, insect parts, hair, wood, glass, metal or mold, or 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.

B. Methods of inspection.

(1) Shelf life. The contractor shall provide a certificate of conformance that the product has a 3 year shelf life when stored at 80°F. Government verification may include storage for 6 months at 100°F or 36 months at 80°F. Upon completion of either storage period, the product will be subjected to a sensory evaluation panel for appearance and

palatability and must receive an overall score of 5 or higher based on a 9 point hedonic scale to be considered acceptable.

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

(3) Fortification. The sample to be analyzed shall be a composite of eight filled and sealed pouches that have been selected at random from the lot. The composited sample shall be prepared (see Note below) and analyzed in accordance with the following methods of the Official Methods of Analysis of AOAC International:

<u>Test</u>	<u>Method number</u>
Vitamin A	992.06 <u>1/</u>
Pyridoxine hydrochloride (Vitamin B6)	985.32 <u>1/</u>
Thiamine hydrochloride (Vitamin B1)	986.27 <u>1/</u>
Ascorbic acid (Vitamin C)	984.26 <u>1/</u>

Test results shall be reported to the nearest milligram or microgram, as applicable.

NOTE: The USDA will use AOAC Method 983.18 for preparation of the sample.

1/ Tests will be conducted for Vitamins A, B1, B6 and C on the first production lot and USDA will certify the formula. A certificate of conformance will be provided on all future lots. If the formula is changed, another set of tests shall be conducted.

(4) Aflatoxin content. Using the same composited sample, the USDA shall test for aflatoxin in accordance with the Official Methods of Analysis of AOAC International, Method 968.22. Test results shall be reported to the nearest ppb. Any detection of aflatoxin will be cause for rejection of the lot.

"NOTE: The following conditions apply for aflatoxin testing on peanut butter spread:

- (1) For prepackaged peanut butter received from a supplier and is not further processed, the contractor will furnish a Certificate of Analysis that the product represented is not greater than 15 ppb for aflatoxin.
- (2) For bulk peanut butter received, the contractor is responsible for providing a USDA certificate of analysis stating that the bulk product is not greater than 15 ppb in aflatoxin. When end item lots are manufactured using that bulk peanut butter and both the bulk and end item lots' identities have been preserved, then no further aflatoxin testing is required.
- (3) If peanut butter is received in bulk, and the conditions in (2) above are not met, each end-item lot must be sampled and tested by USDA. End item lots determined to be not greater than 15 ppb in aflatoxin as evidenced by USDA Certificate will be considered acceptable. Bulk peanut butter with aflatoxin greater than 15 ppb shall not be used as an ingredient."

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

A. Packaging.

(1) Pouch material certification. Material listed below may be accepted on the basis of a contractor's certification of conformance to the indicated requirements. In addition, compliance to the requirements for inside pouch dimensions and dimensions of manufacturer's seals may be verified by certificate of conformance.

Requirement	Requirement paragraph	Test procedure
Thickness of films for laminated material	D-1,A,(1)	ASTM D 2103 <u>1/</u>
Aluminum foil thickness	D-1,A,(1)	ASTM B 479 <u>2/</u>
Laminated material identification and construction	D-1,A,(1) and D-1,A(2)	Laboratory evaluation
Color of laminated material	D-1,A,(1)	Visual evaluation by FED-STD-595 <u>3/</u>

1/ ASTM D 2103 Specification for Polyethylene Film and Sheeting

2/ ASTM B 479 Specification for Annealed Aluminum Foil for Flexible Barrier Application

3/ FED-STD-595 Colors Used in Government Procurement

(2) Unfilled preformed pouch certification. A certificate of conformance may be accepted as evidence that unfilled pouches conform to the requirements specified in D-1,A,(1). When deemed necessary by the USDA, testing of the unfilled preformed pouches for seal strength shall be as specified in E-6,A,(4),a.

(3) Filled and sealed pouch examination. The filled and sealed pouches shall be examined for the defects listed in table II. The lot size shall be expressed in pouches. The sample unit shall be one pouch. The inspection level shall be I and the AQL, expressed in terms of defects per hundred units, shall be 0.65 for major defects and 2.5 for minor defects.

TABLE II. Filled and sealed pouch defects 1/

Category		Defect
<u>Major</u>	<u>Minor</u>	
101		Tear, 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>
	201	Label smudges, is missing, incorrect, or illegible.
	202	Tear notch missing or does not facilitate opening.
	203	Seal width less than 1/8 inch but greater than 1/16 inch.
	204	Presence of delamination. <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 (+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.

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

a. Unfilled preformed pouch seal testing. The seals of the unfilled preformed pouch 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 size shall be the number of pouches indicated by inspection level S-1. Three adjacent 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 three specimens cut from that side. Any average seal strength of less than 6 pounds per inch of width or any test specimen with a seal strength of less than 5 pounds per inch of width shall be cause for rejection of the lot.

b. Pouch closure seal testing. The closure seals of the pouches shall be tested for seal strength in accordance with ASTM F 88. The lot size shall be expressed in pouches. The sample size shall be the number of pouches indicated by inspection level S-1. Three adjacent specimens shall be cut from the closure seal of each pouch in the sample. The average seal strength of the closure shall be calculated by averaging the three specimens cut from that closure. Any average seal strength of less than 6 pounds per inch of width or any test specimen with a seal strength of less than 5 pounds per inch of width shall be cause for rejection of the lot.

c. 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 uniform rate of 1 pound per square inch gage (psig) per second until 14 psig pressure is reached. The 14 psig pressure shall be held constant for 30 seconds and then released. The pouches shall then be examined for separation or yield of the heat seals. Any rupture of the pouch or evidence of seal separation greater than 1/16 inch in the pouch manufacturer's seal shall be considered a test failure. Any seal separation that reduces the effective closure seal width to less than 1/16 inch (see table II, footnote 2/) shall be considered a test failure. Any test failure shall be cause for rejection of the lot.

B. Packing.

(1) Shipping container and marking examination. The filled and sealed shipping containers shall be examined for the defects listed in table III below. The lot size shall be expressed in shipping containers. The sample unit shall be one shipping container fully packed. The inspection level shall be S-3 and the AQL, expressed in terms of defects per hundred units, shall be 4.0 for major defects and 10.0 for total defects.

TABLE III. Shipping container and marking defects

Category		Defect
<u>Major</u>	<u>Minor</u>	
101		Marking omitted, incorrect, illegible, or improper size, location sequence or method of application.
102		Inadequate workmanship. <u>1/</u>
	201	More than 40 pounds of product

1/ Inadequate workmanship is defined as, but not limited to, incomplete closure of container flaps, loose strapping, inadequate stapling, improper taping, or bulged or distorted container.

SECTION J REFERENCE DOCUMENTS

DSCP FORM

DPSC FORM 3556 Marking Instructions for Shipping Cases, Sacks and Palletized/Containerized Loads of Perishable and Semiperishable

Subsistence

FEDERAL STANDARD

FED-STD-595 Colors Used in Government Procurement

NON-GOVERNMENTAL STANDARDS

AMERICAN SOCIETY FOR QUALITY (ASQ)

ANSI/ASQCZ1.4-1993 Sampling Procedures and Tables for Inspection by Attributes

AMERICAN SOCIETY FOR TESTING AND MATERIALS (ASTM)

- B 479 Specification for Annealed Aluminum Foil For Flexible Barrier Application
- D 1238 Flow Rates of Thermoplastics by Extrusion Plastometer
- D 1505 Density of Plastics by Density Gradient Technique
- D 1974 Standard Practice for Methods of Closing, Sealing, and Reinforcing Fiberboard Shipping Containers
- D 2103 Specification for Polyethylene Film and Sheetting
- D 5118 Standard Practice for Fabrication of Fiberboard Shipping Boxes
- F 88 Seal Strength of Flexible Barrier Materials

AOAC INTERNATIONAL

Official Methods of Analysis of the AOAC International

AMSSB-RCF-FN (Valvano/4259)

14 August 2003

TO: DSCP-HRAC (Lowry/7773)

Subject: ES 03-094; DSCP-SS-03-03266; Document changes; inserting new verification conditions for microbiological and aflatoxin requirements

Date recv'd: 3 Apr 03

Date due: 24 Apr 03

Date extended: OPEN

Date replied: 14 August 03

Refs:

(a) Conference call (Natick/USDA/DSCP/User Services Reps/Vetcom), Feb 10, 2003, subject: Salmonella Testing, discuss issue from JSORF on salmonella testing of commercial vs. military products

(b) Follow up to ES02-189; dated 4 Mar 03, subject: Document changes, PCR-D-002 Dairyshake Powder, Fortified with Calcium and Vitamin D, Packaged in a Flexible Pouch; A-A-20043A Creamer, Nondairy, Dry; PKGQAP for A-A-20336 Coffees, Flavored, Instant, Powdered; MIL-C-3031J Cocoa Beverage Powder, inserting new verification conditions for Salmonella negative requirements

(c) Govt meeting at R&DA May 29 03, subject: Discuss verification for Salmonella, aflatoxin, and microbiology requirements

1. Based on the ref case, DSCP requested that Natick apply the same verification criteria for microbiological testing methods in the subject documents as well. Aerobic plate and standard plate and coliform counts and aflatoxin levels would be covered using this new verification process. The documents affected are as follows:

PKG&QAP for A-A-20043A Creamer, Nondairy, Dry

PKG&QAP for A-A-20336 Coffees, Flavored, Instant, Powdered

MIL-C-3031J Cocoa Beverage Powder

PCR-D-002 Dairyshake Powder, Fortified with Calcium and Vitamin D, Packaged in a Flexible Pouch

PCR-N-002 Nut Raisin Mix

PKG&QAP for A-A-20164B Nuts, Shelled

PKG&QAP for A-A-20328 Peanut Butter and Peanut Spread

2. In ref a and c, the discussion on Salmonella determined:

(a) Services restated the requirement that salmonella negative was a valid requirement; and

(b) Differences exist between product received in packets (and product not further processed except for overwrapping or placement in accessory or meal bag), and product received in bulk and filled into packets for assembly, and whether a certificate of analysis (COA) is acceptable in lieu of testing.

3. Based on a review of the subject case and ref a and c, it was decided to include MICROBIOLOGICAL VERIFICATION with the salmonella statement. Separate statements will also be added for those items needing AFLATOXIN NEGATIVE VERIFICATION testing. These will be additional verifications added to the documents, which may already include the salmonella version.

4. Natick requests DSCP implement the changes cited below for the subject documents for all current, pending, and future procurements until the documents are formally amended or revised:

(a) In the documents (coffee flavored, cocoa beverage powder, nondairy creamer & dairyrshake powder) section where the microbiological testing paragraph is specified, delete the current "salmonella statement" and insert the following statements at the end:

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"NOTE: The following conditions apply for salmonella and microbiological 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 and meets all microbiological requirements.
- (2) For bulk product received, the contractor is responsible for providing a certificate of analysis stating that the bulk product is Salmonella negative and meets all microbiological requirements. USDA salmonella and additional microbiological testing is required for each end item lot and shall be the basis for lot acceptance with respect to Salmonella and other microbiological testing requirements."

(b) In the documents (nuts shelled & nut raisin mix & peanut butter spread) section where the aflatoxin testing paragraph is specified, insert the following statements at the end:

"NOTE: The following conditions apply for aflatoxin testing on nuts shelled:

- (1) For prepackaged product received from a supplier and is not further processed, the contractor will furnish a Certificate of Analysis that the aflatoxin in the roasted peanuts (in the case of roasted peanuts end item) represented is not greater than 15 parts per billion (ppb). No additional testing is required.
- (2) For roasted peanuts received in bulk (to be used in roasted peanuts end item), the contractor shall have the bulk shipment sampled and tested by USDA. If (a) the bulk shipment is not more than 2 ppb for aflatoxin as evidenced by a USDA Certificate, (b) the end item lots are manufactured using that bulk product, and (c) both the bulk and end item lots' identities have been preserved, then no further aflatoxin testing is required.
- (3) If roasted peanuts are received in bulk (to be used in roasted peanuts end item), and the conditions in (2) above are not met, each end-item lot must be sampled and tested by USDA. End item lots determined to be not greater than 15 ppb in aflatoxin as evidenced by a USDA Certificate will be considered acceptable. Bulk roasted peanuts with aflatoxin greater than 15 ppb shall not be used as ingredients."

"NOTE: The following conditions apply for aflatoxin testing on nut raisin mix:

- (1) For prepackaged product received from a supplier and is not further processed, the contractor will furnish a Certificate of Analysis that the aflatoxin in the roasted peanuts (in the case of roasted peanuts end item) represented is not greater than 15 parts per billion (ppb). No additional testing is required.
- (2) For roasted peanuts received in bulk (to be used in nut raisin mix end item), the contractor shall have the bulk shipment sampled and tested by USDA. If (a) the

bulk shipment is not more than 2 ppb for aflatoxin as evidenced by a USDA Certificate, (b) the end item lots are manufactured using that bulk product, and (c) both the bulk and end item lots' identities have been preserved, then no further aflatoxin testing is required.

- (3) If roasted peanuts are received in bulk (to be used in nut raisin mix end item), and the conditions in (2) above are not met, the bulk roasted peanut product may not be used as an ingredient. Rework or segregation of portions of the bulk lot, and further testing may be considered on a case by case basis."

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"NOTE: The following conditions apply for aflatoxin testing on peanut butter spread:

- (4) For prepackaged peanut butter received from a supplier and is not further processed, the contractor will furnish a Certificate of Analysis that the product represented is not greater than 15 ppb for aflatoxin.
- (5) For bulk peanut butter received, the contractor is responsible for providing a USDA certificate of analysis stating that the bulk product is not greater than 15 ppb in aflatoxin. When end item lots are manufactured using that bulk peanut butter and both the bulk and end item lots' identities have been preserved, then no further aflatoxin testing is required.
- (6) If peanut butter is received in bulk, and the conditions in (2) above are not met, each end-item lot must be sampled and tested by USDA. End item lots determined to be not greater than 15 ppb in aflatoxin as evidenced by a USDA Certificate will be considered acceptable. Bulk peanut butter with aflatoxin greater than 15 ppb shall not be used as an ingredient.

(c) With regard to the MRE components using roasted peanuts, the following note should be included in those applicable DSCP contracts in order that the end item contain the most recent crop of product:

"Note: A USDA certificate of analysis on roasted peanuts from the most recent crop year which have been kept in cold storage (between approximately 40-50 deg. F at low humidity) is acceptable. Contractor must attest to these storage conditions. If storage conditions for roasted peanuts are not established, a USDA certificate of analysis on roasted peanuts will be considered current if not more than 30 days have elapsed since the date of the analysis."

5. The changes will be made to the Natick prepared documents either in the item document or the PKGQAP supplement, as applicable. For DSCP prepared documents, the following notes apply:

(a) For A-A-20043A Creamer Nondairy Dry and A-A-20336 Coffees Flavored, Instant, the microbiological testing for standard plate and coliform counts is specified in the CID. Normally DSCP would need to make a change to the CID; however, in this case, Natick will insert the salmonella and microbiological verification in the PKGQAP for these items in the methods of inspection section.

(b) For A-A-20164B Nuts, Shelled and A-A-20328 Peanut Butter, the aflatoxin testing is specified in the CID. Normally DSCP would need to make a change to the CID; however, in this case, Natick will insert aflatoxin verification in the PKGQAP for these items in the methods of inspection section.

6. The updated applicable document files are attached with this message.

7 attachments

DONALD A. HAMLIN
Team Leader
Food Engineering Services Team
Combat Feeding Directorate

R Valvano
CF: NSC:

Aylward	Trottier	CF: DSCP & SVCs:
Bennett	Valvano	Anthony Beward
Friel	Arcidiocona	Arthur Malason
Hamlin		Ferrante Miller
Hill		Galligan Richardson H.
Richards		Kavanagh Salerno
Sherman	Lowry	