

**AMENDMENT OF SOLICITATION/MODIFICATION OF CONTRACT**

1. CONTRACT NO. CODE

PAGE OF PAGES

1 / 16

2. AMENDMENT/MODIFICATION NO. 0001		3. EFFECTIVE DATE <i>Aug 8, 2002</i>	4. REQUISITION/PURCHASE REQ. NO.	5. PROJECT NO. (If applicable)
6. ISSUED BY CODE	SP0300		7. ADMINISTERED BY (If other than Item 6) CODE	

Defense Supply Center Philadelphia  
700 Robbins Avenue  
Philadelphia, Pa 19111-5092  
DSCP-HRAA (F. TALLENT)  
215-737-2969 FAX: 215-737-7774

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

OFFEROR

(X)	9A. AMENDMENT OF SOLICITATION NO.
	9B. DATED (SEE ITEM 11)
X	10A. MODIFICATION OF CONTRACT/ORDER NO. SP0300-02-R-7049
	10B. DATED (SEE ITEM 13) 29 JULY 2002

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 ONE 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)

MRE XXIII

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

(X)	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.)

See the following pages

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)	
		JAMES A. LECOLLIER	
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)	

NSN 7540-01-152-9070

PREVIOUS EDITION UNUSABLE

PerFORM (DLA)

STANDARD FORM 30 (REV. 10-83)  
Prescribed by GSA  
FAR (48 CFR) 53.243

**CHANGES TO THE TECHNICAL DATA PACKAGE**

**Tab 4, p. 3, Sec. D:** A. Assembled Rations: Packaging: Meal Bags:  
Delete reference to MIL-M-44074 and insert ACR-M-023.

**Tab 4, p. 8-9,** Chocolate Mint Cookie:  
The following change applies to CID A-A-20295, Cookies dated August 13, 1998.

Page 5, Paragraph 3.6.1 – after “4.0 percent” add “... and Flavor 8 which shall not exceed 6.0 percent.”

The following information is contained in the Packaging Requirements and Quality Assurance Provisions (dated 30 October 2001) for CID A-A-20295, Cookies.

Page 1, Section C-2, D. (5) “The net weight of one serving shall be not less than 56 grams”.

Page 2, Section C-2, F. (1) “Calorie count not less than 220 calories”.

Page 2, Section D-1 A. “Type I, Style J, Chocolate Mint with Chocolate Chips Cookies and one oxygen scavenger packet or commercially wrapped and labeled Type I, Style J, Chocolate Mint with Chocolate Chips Cookies and one oxygen scavenger packet shall be packaged in a preformed or form-fill-seal barrier pouch as described below.”

The Packaging information is contained on pages 2- 4, Section D-1 Packaging.

**Tab 4, p. 15:**

For PCR-C-0004, Chocolate Sports Bar:  
Paragraph C-2; F; Delete and substitute:  
F. Size. The sports bar dimensions shall not be greater than 4 ¾ inches long, 2 ¼ inches wide and ¾ inches thick.

**Tab 4, p. 16-17:** Crackers.

The following changes apply to MIL-C-4412D (Crackers, for Meal, Ready-to-Eat) dated 20 September 1993.

page 1, insert new classification paragraph;

“1.2 Classification. the crackers shall be of the following types as specified:

Type I - Plain

Type II- Vegetable”

Page 6, paragraph 3.2.12 insert the following new paragraph:

“3.2.12 Dehydrated Vegetable Blend - The Dehydrated Vegetable Blend shall contain Carrots, Onions, Tomatoes, Celery, red and green Bell Peppers.”

Page 6, paragraph 3.3.1 insert new line 17;

“Dehydrated Vegetable Blend as required 3/”

Page 6, paragraph 3.3.1, footnote 2/, after “grams” and before “per”, insert “of calcium”.

Page 6, paragraph 3.3.1, insert new footnote 3/ as follows:

“3/ add to type II vegetable cracker only in quantity sufficient to achieve a finished product flavor and odor as specified in 3.4.”

Page 7, paragraph 3.4, line 1, after “requirements”, insert “for type I and type II”

Page 7, paragraph 3.4, add the following new requirements;

“k. For type II product only, the surface of the cracker shall contain small, visible, particles of dehydrated vegetables uniformly distributed throughout.

L. FOR TYPE II CRACKER ONLY, THE CRACKER SHALL HAVE THE PRONOUNCED FLAVOR AND ODOR OF THE VEGETABLE BLEND.”

Page 11, table I., Filled and Sealed Bag Defects, major defect 107; after "of" and before "in", delete "flex fractures" and insert "stress cracks or material degradation".

Page 14, table II, insert new defects:

"108 TYPE II CRACKER DOES NOT HAVE SMALL VISIBLE PARTICLES OF DEHYDRATED VEGETABLES UNIFORMLY DISTRIBUTED THROUGHOUT.

type II cracker does not have the pronounced flavor and odor of the vegetable blend."

Page 20, para 5.3.1, delete entirely and substitute the following new paragraph:

"5.3.1 Unit packs. 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 or ingredients. The information shall be located on the body of the pouch 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 pouch (in one complete print), except the closure area. The label shall meet the FDA requirements and shall contain the following information: Product Name (1/8 to 7/16 inch block letters). Product names shall differentiate between type I plain crackers and type II vegetable crackers.

Date 1/

Net Weight

Contractor's Name and Address

Label of FDA "Nutritional Facts" in accordance with the Nutritional Labeling Education Act (NLEA).

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, March 19, 1999 would be coded 9078. The Julian day code shall represent the day the product was packaged in the pouch."

Above line that begins Page 11, Table I., insert:

"Page 10, paragraph 4.5.3, Table I;" and at the end of major defect 107 insert "8/". At end of Table I, add the following new footnote; "8/ Pinholes or breaks inherent to the manufacturing process of the aluminum foil shall not be scored as a defect."

Below line which begins "109";

Add, "Page 17, Paragraph 5.1.1.1, lines 16 – 19; delete "The exterior... FED-STD-595, and insert: The exterior bag color shall conform to number 20219, 30219, 30227, 30279, 30313, 30324, or 30450 of FED-STD-595."

Page 20, paragraph 5.3, delete the first sentence entirely,

"Nutrition Labeling...food."

Page 9, Para 4.5.1.3, at end insert:

"Alternatively, the internal pressure resistance shall be determined by pressurizing the bags while they are restrained between two rigid plates. The sample size shall be the number of bags indicated by inspection level S-1. If a three seal tester (one that pressurizes the bag through an open end) is used, the closure seal shall be cut off for testing the side and bottom seals of the bag. For testing the closure seal, the bottom seal shall be cut off. The bags shall be emptied prior to testing. If a four-seal tester (designed to pressurize filled bags by use of a hypodermic needle through the bag 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 bags shall then be examined for separation or yield of the heat seals. Any rupture of the bag or evidence of seal separation greater than 1/16 inch in the bag 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 I, footnote 4/) shall be considered a test failure and shall be cause for rejection of the lot."

Page 14, Para 4.5.6, at end insert:

"Alternatively, the internal pressure resistance shall be determined by pressurizing the bags while they are restrained between two rigid plates. The sample size shall be the number of

bags indicated by inspection level S-1. If a three seal tester (one that pressurizes the bag through an open end) is used, the closure seal shall be cut off for testing the side and bottom seals of the bag. For testing the closure seal, the bottom seal shall be cut off. The bags shall be emptied prior to testing. If a four-seal tester (designed to pressurize filled bags by use of a hypodermic needle through the bag 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 bags shall then be examined for separation or yield of the heat seals. Any rupture of the bag or evidence of seal separation greater than 1/16 inch in the bag 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 I, footnote 4/) shall be considered a test failure and shall be cause for rejection of the lot."

Page 17, Para 5.1.1.1, make the following change:

(1) line 17, after "bag color", insert "for MRE and LRP applications".

(2) line 18, insert the following new sentence:

"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 17, Para 5.1.1.1.1, line 12, after "4.5.1.3" insert:

"Alternatively, the bag shall exhibit no rupture or seal separation greater than 1/16 inch when tested for internal pressure resistance as specified in 4.5.1.3."

Page 17, Para 5.1.1.1.2, at end insert:

"Alternatively, the filled and sealed bag 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 4.5.6."

Page 18, Para 5.1.1.2.1, line 14, after "4.5.6" insert:

"Alternatively, the filled and sealed bag 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 4.5.6."

#### **Tab 4, 23-24, Snack Foods:**

The following changes apply to Snack Foods (CID A-A-20195B) dated 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."

The following change applies to the Quality Assurance Provisions and Packaging Requirements for CID A-A-20195, Snack Foods, dated September 30, 1999.

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."

Page 34. Insert changed paragraph below between top two paragraphs of Tab 4, page 34 in MRE 23 TDP. Change is underlined.

b. Pouch construction. The pouch shall be a flat style preformed pouch having maximum inside dimensions of 5 inches wide by 7-1/4 inches long ( $\pm 1/8$  inch in each dimension). The pouch shall be made by heat sealing three edges with minimum 1/8 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-5, A,(4),a. 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. A tear nick or tear notch 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. A 1/8 inch ( $\pm 1/16$  inch) wide lip may be incorporated at the open end of the pouch to facilitate opening and filling of the pouch.

**Tab 5, p. 57-59, Rice, Type II:**

Table I of PCR-R-001, Rice, delete protein column.

**Tab 6, p. 21, E-1-B-7(a).** Additional Requirements for Analytical/Nutrient Content Testing: a. Replenishment Sample Lots: If it's a USDA item the contractor pays for the testing; If it's a VETCOM item there is no charge to the contractor.

Will VETCOM charge for testing?

No. VETCOM will continue to test Vet Inspected Items at no charge to contractor.

**Tab 6, p. 32, E-9-B:**

Add at end of first paragraph, "This clause does not apply to unfinished bulk shortbread cookies or unfinished bulk toaster pastries for which receipt inspection by the assembler is optional."

**Tab 7, p.7, D-4 Marking:** c. HDR: figure 1 is included with this amendment.

#### MISC. CHANGES TO BE INCLUDED:

**Tab 4, p.14, Beef Snacks, C-5 ADDITIONS, DELETIONS, AND/OR SUBSTITUTIONS:**

Reference to QA Provisions and Packaging Requirements dated December 17, 1998 should be revised to reflect that new Packaging and Quality Assurance Provisions for CID A-A-20298, Beef Snacks, Cured dated 23 May 2002 has been issued. The new document contains changes to date previously listed.

Tab 4, p.22, (b) Paragraph E-6 (for PCR-N-002, Nut Raisin Mix), Table II: Delete Major Defect 105 entirely.

Section E-6, Table II, Footnote 3, at end, insert "Any nonconformance shall be cause for rejection of the lot."

The following changes are applicable to Tab 6, Section E of the Technical Data Package: Meal, Ready-to-Eat (MRE) Humanitarian Daily Ration (HDR):

Page 18, Clause E-1-A-10. At the end of clause delete "Snacks" and insert "Snacks" will apply, as applicable."

Page 28, Clause E-7., B., 2. Food Safety and Foreign Material:. At end of paragraph 2. insert: "Retesting/reinspection/rework of product that tested positive for food borne pathogens (salmonella, E. Coli, etc.) is not authorized."

Page 47, Clause E-13. Delete clause and insert:

**"E-13. Operational Ration Component Lot Number and Lot Inspection**

The component lot number for thermostabilized (retorted) products packaged in flexible pouches shall be defined as the Julian lot number assigned at the origin manufacturer's plant and the inspection lot shall include only product produced in one workshift. For products packaged in tray pack containers (metal/poly) and other products (including the FRH and final assembled lots), a lot number is defined as the quantity of finished product produced/assembled within a production day (Julian date) and the inspection lot shall include product produced in no more than one production/assembly day. The Government QAR reserves the right to separate an inspection lot into smaller inspection lots. The Sample for Government and contractor's end item lot inspection may be drawn after all units comprising the lot have been produced or samples may be drawn during production of the lot. If stratified sampling is utilized (drawing subsamples from each subplot/subcode during production of the lot), the subsamples must be drawn at random from the subplot and not inspected until all the subsamples are combined to makeup the complete sample for the applicable lot size (the formation of the lot and lot size is defined as the manner in which the lot is to be presented for Government end item verification inspection)."

2. **Tab 4, page 9:** Fig bar. C-2 PRIME DOCUMENT, add "and Quality Assurance Provisions and Packaging Requirements for CID A-A-20212 Fruit Bars, 17 September 1999.
3. **Tab 4, page 23:** Snack Foods. C-2 PRIME DOCUMENT, add "and Quality Assurance Provisions and Packaging Requirements for CID A-A-20195, Snack Foods, August 14, 1996.
4. **Tab 5, page 13:** Beef Roast with Vegetables. Below bolded title add: "Applicable document is now PCR-B-035  
24 October 2001  
W/Changes 25 Jul 02."

**The following change applies to PCR-C-007A, Cakes and Brownies, Shelf Stable, 16 October 2001.**

Page 10, 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

The 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.

**CHANGES TO THE SOLICITATION**

**Add the following CFM items to pages 9 and 20:**

Applesauce/Carbo Enhanced  
Fig Bar  
Nut Raisin Mix

Page 9 After Pretzels-Cheese Filled insert Chdr and delete Dhdr. Replace MIL-M-44074 with ACR-M-023A.

Pages 11-12 Delete the table and refer to page 17.

Pages 18-21 If the items listed here have more than one flavor each flavor may be priced separately.

Pages 19-20 insert Minestrone; Western Beans. Delete one of the duplicates of Chow Mein noodles.

Pages 46 thru 49 Delete clause 52.246-9P31 and refer to this clause in the Technical Data Package on page 42.

**The following 8 pages contain changes to PCR-B-035, Beef Roast with Vegetables, packaged in a Flexible Pouch, Shelf Stable. (Changes are in bold print)**

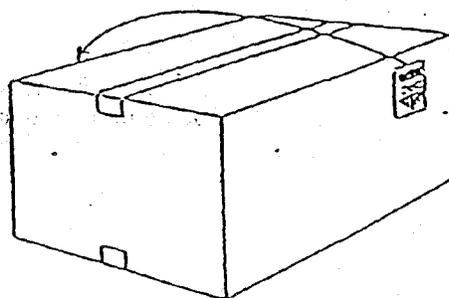
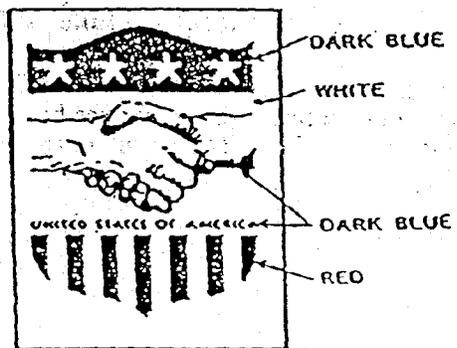


FIGURE 1. handclasp emblem

SECTION C

This document covers thermostabilized beef roast with vegetables packaged in a flexible pouch for use by the Department of Defense as a component of operational rations.

C-1 ITEM DESCRIPTION

PCR-B-035, BEEF ROAST WITH VEGETABLES, PACKAGED IN A FLEXIBLE POUCH, SHELF STABLE

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 Performance-based Contract Requirements document.

B. Commercial sterility. The packaged food shall be processed until commercially sterile.

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

D. Appearance.

(1) General. The finished product shall be a single intact whole muscle beef roast portion with carrots, potatoes, and mushrooms in sauce. The packaged food shall be free from foreign materials.

~~(1) General. The finished product shall be an intact piece of cooked, chunked and formed beef typical of braised beef roast with carrots, potatoes, and mushrooms in sauce. The packaged food shall be free from foreign materials.~~

(2) Beef. The beef roast shall be typically produced from boneless beef that has been portion cut into uniform dimension portions and visually exhibits natural muscle shred structure. The beef shall be practically free of bone or bone fragments, cartilage, coarse connective tissue, tendons or ligaments, and glandular material. The beef shall be a roasted beef color.

~~(2) Beef. The beef shall be chunked and formed beef typical of braised beef and shall be practically free of bone or bone fragments, cartilage, coarse connective tissue, tendons or ligaments, and glandular material. The beef shall be a cooked beef color.~~

(3) Vegetables. The vegetables shall be as follows:

a. Potatoes. Potatoes shall be typically produced 1/4 by 3/8 by 3/4 inch standard size. The diced potatoes shall have a cooked potato color.

b. Carrots. Carrots shall be dice sizes typically produced by a 3/8 inch dicer setting. The cut carrots shall have a cooked carrot color.

c. Mushrooms. The mushrooms slices shall be tan to brownish gray color.

(4) Sauce. The sauce shall be glossy and translucent with reddish brown color and may contain flecks of seasonings and spices.

E. Odor and flavor.

(1) General. The packaged food shall have an odor and flavor of cooked beef, potatoes and vegetables. The packaged food shall be free from foreign odors and flavors.

(2) Sauce. The sauce shall have a beef with tomato odor and flavor.

F. Texture.

(1) Beef. The cooked beef shall be moist and tender. The cooked beef shall have pull apart muscle fiber tendencies representative of whole muscle roasted beef.

~~(1) Beef. The cooked beef shall be moist and tender, typical of braised not ground beef.~~

(2) Vegetables. The vegetables shall be slightly soft to slightly firm.

(3) Sauce. The sauce shall be smooth and moderately thin.

G. Weight.

(1) Net weight. The average net weight shall be not less than 8.0 ounces. No individual pouch shall have a net weight of less than 7.5 ounces.

(2) Drained weight.

a. Beef. The average drained weight of beef shall be not less than 3.0 ounces. The drained weight of the beef in an individual pouch shall be not less than 2.8 ounces.

b. Vegetables. The average drained weight of the vegetables shall be not less than 2.5 ounces. The drained weight of the vegetables in an individual pouch shall be not less than 2.3 ounces.

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

I. Analytical requirements.

(1) Fat content. The fat content shall be not greater than 10.0 percent.

(2) Salt content. The salt content shall be not less than 0.5 percent and not greater than 1.3 percent.

C-3 MISCELLANEOUS INFORMATION

THE FOLLOWING INGREDIENTS ARE FOR INFORMATION ONLY. THIS IS NOT A MANDATORY CONTRACT REQUIREMENT.

A. Ingredients. Ingredients may be as follows:

Beef Portion [beef, water, seasoning (modified food starch {corn & tapioca}, corn syrup solids, salt, sodium phosphate, spices, beef stock, disodium inosinate & disodium guanylate, yeast extract, grill favor {maltodextrin, salt, grill flavor [from partially hydrogenated soybean/cottonseed oil], modified food starch, corn syrup solids, smoke flavoring, tricalcium phosphate}, xanthan gum) seasoning (flavoring, dextrose, dry molasses{molasses, wheat starch, calcium stearate, soy flour, hydroxylated lecithin}, hydrolyzed soy protein, spices, onion powder, garlic powder), modified food starch, caramel color], Water, onions, Mushrooms, Carrots, Dehydro-frozen Potatoes, Tomatoes, Tomato Paste, Food Starch - Modified with Erythorbic Acid added, Beef Base (Roasted Beef including Beef Juices, Salt, Hydrolyzed Vegetable Protein {Corn, Wheat, Soy}, Flour, Caramel Color, Corn Oil, Natural Flavorings and Sugar), Caramel Color.

SECTION D

D-1 PACKAGING

Product shall be filled into pouches and each pouch shall be packed in a carton in accordance with MIL-PRF-44073, Packaging of Food in Flexible Pouches.

D-2 LABELING

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

(1) Product name (not less than 1/8 inch high). Commonly used abbreviations may be used when authorized by the inspection agency.

(2) Pouch code includes: 1/

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

1/ The lot number shall be expressed as a four digit Julian code. The first digit shall indicate the year of production and the next three digits shall indicate the day of the year (Example, 6 September 2001 would be coded as 1249). The Julian code shall represent the day the product was packaged into the pouch and processed. Sub-lotting (when used) shall be represented by an alpha character immediately following the four digit Julian code. Following the four digit Julian code and the alpha character (when used), the other required code information shall be printed in the sequence as listed above.

B. Cartons.

(1) The cartons shall be clearly printed on one of the largest panels with permanent black ink as follows:

- Product name (7/32 to 9/32 inch block letters)
- Ingredients
- Net weight
- Name and address of packer
- Code (same as pouch code, see pouches) 1/ 2/
- USDA official inspection legend for the packer's plant
- "Nutrition Facts" label in accordance with the Nutrition Labeling and Education Act (NLEA) and all applicable FDA/USDA regulations

1/ Code may be ink printed on any outside carton panel. Code may be embossed on any outside carton panel except the largest panels of the carton.

2/ Official establishment number not required in carton code.

(2) Military nutrition information entitled "Military Rations Are Good Performance Meals" shall be printed on the entrée cartons large panel opposite to the panel printed with the data in D-2, B, (1) above. The information, provided by the contracting officer, shall be clearly printed with permanent black ink in an area no smaller than 4-1/4 inches by 6-3/4 inches.

D-3 PACKING

A. Packing for shipment to ration assembler. Seventy-two pouches (of the same product) in cartons shall be packed flat or on edge in a snug-fitting fiberboard shipping container conforming to style RSC, type CF, class domestic, grade 200 of ASTM D 5118, 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 provide the certificate(s) of conformance to the appropriate inspection activity. Certificate(s) of conformance not provided shall be cause for rejection of the lot.

A. Definitions.

(1) Critical defect. A critical defect is a defect that judgment and experience indicate would result in hazardous or unsafe conditions for individuals using, maintaining, or depending on the item; or a defect that judgment and experience indicate is likely to prevent the performance of the major end item, i.e., the consumption of the ration.

(2) Major defect. A major defect is a defect, other than critical, that is likely to result in failure, or to reduce materially the usability of the unit of product for its intended purpose.

(3) Minor defect. A minor defect is a defect that is not likely to reduce materially the usability of the unit of product for its intended purpose, or is a departure from established standards having little bearing on the effective use or operation of the unit.

B. Classification of inspections. The inspection requirements specified herein are classified as follows:

(1) Product standard inspection. The first article or product demonstration model shall be inspected in accordance with the provisions of this document and evaluated for overall appearance and palatability. Any failure to conform to the performance requirements or any appearance or palatability failure, shall be cause for rejection of the lot. The approved first article or product demonstration model shall be used as the product standard for periodic review evaluations. All food components that are inspected by the USDA shall be subject to periodic review sampling and evaluation. The USDA shall select sample units during production of contracts and submit them to the following address for evaluation:

US Army Soldier & Biological Chemical Command  
Soldiers System Ctr., Natick Soldier Center  
Attn: AMSSB-RCF-F(N)  
15 Kansas Street  
Natick, MA 01760-5018

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

(2) Conformance inspection. Conformance inspection shall include the examinations/tests and methods of inspection cited in this section and in Section 4 of MIL-PRF-44073.

E-5 QUALITY ASSURANCE PROVISIONS (PRODUCT)

A. Product examination. The finished product shall be examined for compliance with the performance requirements specified in Section C of this Performance-based Contract Requirements document utilizing the double sampling plans indicated in ANSI/ASQC Z1.4 - 1993. The lot size shall be expressed in pouches. The sample unit shall be the contents of one pouch. The inspection level shall be S-3 and the acceptable quality level (AQL), expressed in terms of defects per hundred units, shall be 1.5 for major defects and 4.0 for minor defects. Defects and defect classifications are listed in table I. For drained weight inspection, a separate set of pouches shall be selected from the lot using the same sampling criteria as above. The pouches shall be immersed in 140°F to 190°F water for 10 minutes prior to conducting the product examination and the drained weight inspection.

TABLE I. Product defects 1/ 2/ 3/

Category		Defect
Major	Minor	
		<u>Appearance</u>
101		Product not a single intact whole muscle beef roast portion with natural muscle shred structure and with carrots, potatoes, and mushrooms in sauce. <del>Product not an intact piece of cooked, chunked and formed beef typical of braised beef roast with carrots, potatoes, and mushrooms in sauce.</del>
102		Bone or bone fragment measuring more than 0.3 inch in any dimension.
	201	Beef not a roasted beef color. <del>Beef not a cooked beef color.</del>
	202	Total weight of cartilage, coarse connective tissue, tendons or ligaments, and glandular material more than 0.35 ounces.
	203	Potato dices do not have a cooked potato color.
	204	Carrot dices do not have a cooked carrot color.
	205	Mushrooms do not have a tan to brownish gray color.
	206	Sauce not glossy and translucent with reddish brown color.
		<u>Odor and flavor</u>
103		Odor or flavor not cooked beef, potatoes and vegetables.

- 207 Sauce not beef with tomato odor and flavor.
- Texture
- 208 Beef not moist or not tender.
- 209 **Beef does not have pull apart muscle fiber tendencies representative of whole muscle roasted beef.**
- 210 Vegetables not slightly soft to slightly firm.
- 211 Sauce not smooth or not moderately thin.
- Weight
- 212 Net weight of an individual pouch less than 7.5 ounces. 4/
- 213 Drained weight of beef in an individual pouch less than 2.8 ounces. 5/
- 214 Drained weight of vegetables in an individual pouch less than 2.3 ounces. 6/

1/ Presence of any foreign material such as, but not limited to dirt, insect parts, hair, glass, wood, 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.

**3. Dicer setting or slice requirement for vegetables and boneless beef portion shall be verified with the producer's certificate of conformance.**

~~3/ Dicer setting or slice requirement for vegetables shall be verified with the producer's certificate of conformance.~~

4/ Sample average net weight less than 8.0 ounces shall be cause for rejection of the lot.

5/ Sample average drained weight of beef less than 3.0 ounces shall be cause for rejection of the lot.

6/ Sample average drained weight of vegetables less than 2.5 ounces shall be cause for rejection of the lot.

B. Methods of inspection.

(1) Commercial sterility. Testing for commercial sterility shall be in accordance with MIL-PRF-44073.

(2) 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.

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

(4) Drained weight. The pouch contents shall be poured into a flat-bottom container. A minimum of three times the volume of the pouch of 180°F to 190°F water shall be added to the container so as to cover the contents. The contents and water shall be gently agitated so as to liquefy rendered fat and to remove the sauce without breaking the beef or vegetables. The contents shall then be poured into a U.S. Standard No. 7 sieve in a manner that will distribute the product over the sieve without breaking the beef or vegetables. The sieve area shall be such that the distributed product does not completely cover all the openings of the sieve. The sieve shall be tilted at such an angle to assure complete drainage of liquid from the product. Drain product for two minutes before determining the drained weight by subtracting the sieve tare weight from the gross weight. The drained weight shall be reported to the nearest 0.1 ounce.

(5) Analytical. The sample to be analyzed shall be a composite of eight filled and sealed pouches that have been selected at random from one production lot. The composite sample shall be prepared and analyzed in accordance with the latest edition of the Official Methods of Analysis of AOAC International (OMA). Test results shall be reported to the nearest 0.1 percent. Verification will be conducted through actual testing by a Government laboratory. Any result not conforming to the analytical requirements shall be cause for rejection of the lot.

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

A. Packaging and labeling.

(1) Pouch material testing. The pouch material shall be examined for the characteristics listed in table I of MIL-PRF-44073. The lot size, sample unit, and inspection level criteria for each of the test characteristics are listed below. Any test failure shall be classified as a major defect and shall be cause for rejection of the lot.

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

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

(3) Examination of pouch and carton assembly. The completed pouch and carton assemblies shall be examined for the defects listed in table III of MIL-PRF-44073. The lot size shall be expressed in units of completed assemblies. The sample unit shall be one pouch and carton assembly. The inspection level shall be S-3 and the AQL, expressed in terms of defects per hundred units, shall be 0.65 for major defects and 2.5 for minor

defects. Fifty sample pouch and carton assemblies shall be examined for critical defects. The finding of any critical defect shall be cause for rejection of the lot.

B. Packing.

(1) Shipping container and marking examination. The filled and sealed shipping containers shall be examined for the defects listed in table II 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 II. Shipping container and marking defects

Category		Defect
Major	Minor	
101		Marking omitted, incorrect, illegible, or improper size, location sequence or method of application.
102		Inadequate workmanship. <u>1/</u>
	201	Contents more or less than specified.

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

SECTION J REFERENCE DOCUMENTS

DPSC FORMS

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

MILITARY SPECIFICATIONS

MIL-PRF-44073 Packaging of Food in Flexible Pouches

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)

D 1974 Standard Practice for Methods of Closing, Sealing, and Reinforcing Fiberboard Shipping Containers

D 5118 Standard Practice for Fabrication of Fiberboard Shipping Boxes

AOAC INTERNATIONAL Official Methods of Analysis of the AOAC International