

TECHNICAL DATA FOR ENTREES, STARCHES, SOUPS

C-1 DESCRIPTION/SPECIFICATION

8970-00-149-1094

MEAL, READY-TO-EAT, INDIVIDUAL, menus no. 1-12 (Case A); menus no. 13-24 (Case B), 12 meals per shipping case, ACR-M-023, 25 October 2001. TPK-2 item.

C-2 CONTRACTOR FURNISHED MATERIAL (CFM)

ENTREES, STARCHES, SOUPS

BEEF IN TERIYAKI SAUCE WITH VEGETABLES, Packaged in a Flexible Pouch, Shelf Stable, PCR-B-0001, September 22, 1997 8940-01-445-9334

BLACK BEAN AND RICE BURRITO, Packaged in a Flexible Pouch, Shelf Stable, PCR-B-0002. December 17, 1997 8940-01-448-5744

BEEF ENCHILADA IN SAUCE, Packaged in a Flexible Pouch, Shelf Stable, PCR-B-010, September 30, 1999 8940-01-479-1722

BEEFSTEAK, GRILLED, WITH MUSHROOM GRAVY, Packaged in a Flexible Pouch, Shelf Stable, PCR-B-030, 15 November 2000 8905-01-486-7121

BEEF PATTY, GRILLED, Packaged in a Flexible Pouch, Shelf Stable, PCR-B-029, 15 November 2000 8905-01-486-7128

BEEF RAVIOLI IN MEAT SAUCE, Packaged in a Flexible Pouch, Shelf Stable, PCR-B-021. 15 November 2000 8940-01-426-0553

BEEF ROAST WITH VEGETABLES, Packaged in a Flexible Pouch, Shelf Stable, PCR-B-035, 24 October 2001, 8940-01-492-4940

BEEF STEW, Packaged in a Flexible Pouch, Shelf Stable, PCR-B-020, 15 November 2000, 8940-00-149-1088

CHICKEN BREAST STRIPS WITH CHUNKY STYLE SALSA, Packaged in a Flexible Pouch, Shelf Stable, PCR-C-0002, September 22,1997 8940-01-445-9335

CHICKEN IN THAI STYLE SAUCE, Packaged in a Flexible Pouch, Shelf Stable, PCR-C-0003, September 22,1997 8940-01-445-9333

CHICKEN TETRAZZINI, Packaged in a Flexible Pouch, Shelf Stable, PCR-C-018, October 1,1998 8940-01-467-2495

COUNTRY CAPTAIN CHICKEN, Packaged in a Flexible Pouch, Shelf Stable, PCR-C-019A, 31 July 2000 8940-01-467-2492

CHEESE TORTELLINI IN TOMATO SAUCE, Packaged in a Flexible Pouch, Shelf Stable, PCR-C-020, October 8,1998 8940-01-397-6661

CHICKEN, NOODLES AND VEGETABLES IN SAUCE, Packaged in a Flexible Pouch, Shelf Stable, PCR-C-021, October 8,1998 8940-01-426-2282

CHICKEN BREAST FILLET, Packaged in a Flexible Pouch, Shelf Stable, PCR-C-022, October 8,1998 8905-01-373-2537

CHICKEN BREAST FILLET, IN TOMATO SAUCE, WITH CAVATELLI, Packaged in a Flexible Pouch, Shelf Stable, PCR-C-023, October 8,1998 8940-01-413-0232

CHILI AND MACARONI, Packaged in a Flexible Pouch, Shelf Stable, PCR-C-027, 15 November 2000 8940-01-375-4375

JAMBALAYA, WITH HAM AND SHRIMP. Packaged in a Flexible Pouch, Shelf Stable, PCR-J-001, September 30, 1999 8940-01-479-1734

MEAT LOAF WITH BROWN ONION CRAW, Packaged in a Flexible Pouch, Shelf Stable, PCR-M-0001, September 22, 1997 8940-01-448-5739

PASTA WITH VEGETABLES IN TOMATO SAUCE, Packaged in a Flexible Pouch, Shelf Stable, PCR-P-009, October 8,1998 8940-01-448-8170

PORK RIB, BONELESS, IMITATION SMOKE FLAVORING ADDED, Packaged in a Flexible Pouch, Shelf Stable, 25 October 2001 PCR-P-028, 8905-01-492-4982

SPAGHETTI WITH MEAT AND SAUCE, Packaged in a Flexible Pouch, Shelf Stable, PCR-S-0002, November 5,1997 8940-01-224-5675

TURKEY BREAST FILLET, CHUNKED AND FORMED, GRILLED, IN GRAVY WITH POTATOES, Packaged in a Flexible Pouch, Shelf Stable, PCR-T-004, 15 November 2000 8940-01-426-3318

VEGETABLE MANICOTTI IN TOMATO SAUCE, Packaged in a Flexible Pouch, Shelf Stable, PCR-V-003, 24 October 2001 8940-01-492-4978

BEANS WESTERN, PCR-B-011, Packaged in a Flexible Pouch, Shelf Stable, October 1,1998 8940-01-454-4915

CLAM CHOWDER, NEW ENGLAND STYLE, Packaged in a Flexible Pouch, Shelf Stable, PCR-C-045, 25 October 2001 8935-01-492-4993

MINISTRONE STEW, Packaged in a Flexible Pouch, Shelf Stable, PCR-M-004, October 2,1998 8940-01-467-2497

NOODLES IN BUTTER FLAVORED SAUCE, Packaged in a Flexible Pouch, Shelf Stable, PCR-N-0001, September 22,1997 8940-01-445-9336

POTATOES, MASHED, Packaged in a Flexible Pouch, Shelf Stable, PCR-P-011, September 30, 1999 8920-01-479-1749

RICE, MEXICAN, Packaged in a Flexible Pouch, Shelf Stable, PCR-R-001, Type II, October 1,1998 8940-01-400-0517

YELLOW AND WILD RICE PILAF, Packaged in a Flexible Pouch, Shelf Stable, PCR-R-001, Type III, October 1,1998 8940-01-467-2507

C-3 DATE OF PACK

For entrée, starch and soup components: Acceptance will be limited to product processed and packed subsequent to date of award.

C-4 MISCELLANEOUS REQUIREMENTS

a. This solicitation incorporates the entrée, starch, and soup component individual performance-based contract requirements (PCRs) to form an integrated technical data package. Individual quality assurance and packaging provisions are contained in each PCR. ALL requirements, including Performance Requirements, Quality Assurance Provisions, and Packaging Requirements for the appropriate PCR apply.

b. A nutritional analysis for each product requiring a Performance-based Contract Requirement (PCR) shall be provided to The U.S. Army Soldier and Biological Chemical Command (SBCCOM) with the award of the military contract and each time there is a major formulation change. The nutritional analysis shall be generated by the Genesis, Product Development and Labeling Software by ESHA, version 6.2 or higher and be sent electronically to SBCCOM (attn: iavlward@natick-emh2.army.mil). For each item, the Genesis food list files shall be provided for 100-gram portion sizes along with the food item files (for unique items entered into the contractors database). The ingredients and the weight of each ingredient shall be included for each formulation. The nutrients included shall be as follows: Weight (g); kilocalories; protein (g); carbohydrates (g); dietary fiber (g); fat-total (g), fat-saturated (g); fat-monounsaturated (g); fat-polyunsaturated (g); cholesterol (mg); water (g); ash (g); vitamin A (retinol equivalents); thiamin-vitamin B1 (mg); riboflavin-vitamin B2 (mg); niacin-vitamin B3 (mg); vitamin B6 (mg); vitamin B12 (mcg); vitamin C (mg); vitamin D (mcg); vitamin E-alpha equivalents (mg); folate (mcg), calcium (mg); copper (mg); iron (mg); magnesium (mg); phosphorus (mg); potassium (mg); sodium (mg); zinc (mg). The nutrients as required under the Nutrient content paragraph and the verification of the nutrients as required under the Methods of Inspection paragraph in each Performance-based contract Requirements document are still mandatory.

- c.** The procedures contained in the ‘Integrated Pest Management (IPM) Program Requirements for Operational Rations’, December 1998, and the “Contractor Sanitation Program - Operational Rations”, December 1998 are required and apply to all assembly and food component operations except as exempted in Section E of this document (see attached IPMP and sanitation programs). In addition, evidence of an insect or rodent infestation, foreign material, or contamination involving any component item, filled and sealed accessory packet, filled and sealed menu bag, or final assembly packed case will be cause for rejection of the involved lot.
- d.** Components shall be utilized in assembly operations on a first-in-first-out basis (or oldest manufacturer’s date of pack when receipted). Contractor shall be solely responsible for the proper care and storage of all components.
- e.** Unless otherwise specified in individual item requirements, the thermoprocessing of (1) meat, poultry, and fish with sauce and gravy, (2) vegetables with sauce, (3) meat and poultry in loaf, slice, or solid form, and (4) fruit shall be in accordance with MIL-PRF-44073F, Packaging of Food in Flexible Packages.
- f.** The packaging, labeling, packing, marking, unitization, inspection and acceptance of (1) meat, poultry, and fish with sauce and gravy, (2) vegetables with sauce, (3) meat and poultry in loaf, slice, or solid form, and (4) fruit shall be in accordance with the applicable Section C, D, or E of the TECHNICAL DATA FOR ENTREES AND STARCHES.
- g.** The provisions contained in Title 21, Chapter 1, Code Of Federal Regulations, Part 110 “Current Good Manufacturing Practice In Manufacturing, Packaging Or Holding Human Food” are applicable.
- h.** All products shall comply with all applicable Federal and State mandatory requirements and regulations relating to the preparation, processing, thermoprocessing, packaging, labeling, packing, storage, and distribution of those products and with all applicable provisions of the Federal Food, Drug, and Cosmetic Act and regulations promulgated thereunder.
- i.** As required by 48 CFR 246.471-1 Subsistence; AR 40-657, Veterinary/Medical Food Inspection and Laboratory Service; DLAR 4155.3, Inspections of Subsistence Supplies and Services; Clause 52.246-9P31, ‘SANITARY CONDITIONS (JAN 1992) DPSC,’ contained in DPSC Master Solicitation 3595; and as clarified by the Armed Forces Food Risk Evaluation Committee, 31 JAN 1996; all Operational Ration food components will originate from sanitarily approved establishments . Acceptable sanitary approval is constituted by listing in the “Directory of Sanitarily Approved Food Establishments for Armed Forces Procurement,” published by the U.S. Army Veterinary Command (VETCOM), or an establishment inspected and approved by the U.S. Department of Agriculture (USDA) or the U.S. Department of Commerce (USDC) and possessing a USDA/USDC establishment number. This requirement applies to all GFM and CFM Operational Ration food components and to all Operational Ration types. Requests for inspection and “Directory” listing by VETCOM will be routed through DPSC-HRS for coordination and action. Situations involving sole sources of supply, proprietary supply sources, and commercial brand name items will be evaluated directly by the Chief, DPSC-HRS, in coordination with the Chief, Approved Sources Division, VETCOM.
- j.** In view of the fact that the ANSI/ASQC Z1 .4-1993 Standard does not contain the definitions for critical, major, and minor defects, the following definitions become contractually binding through their inclusion here:

(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.

C-5 ADDITIONS, DELETIONS, AND/OR SUBSTITUTIONS TO DOCUMENTS

ENTREES

**Beef in Teriyaki Sauce with Vegetables, Packaged in a Flexible Pouch,
Shelf Stable, PCR-B-0001, September 22, 1997 8940-01-445-9334**

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March 17,1999

SECTION E INSPECTION AND ACCEPTANCE

E-6 QUALITY ASSURANCE PROVISIONS

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 key 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 material the usability of the unit of product for its intended purpose, or is a departure from established standards having little hearing on the effective use or operation of the unit.

Quality Assurance Provisions.

The following quality assurance criteria, utilizing ANSI/ASQC Z1.4-1993, Sampling Procedures and Tables for Inspection by Attributes, are recommended.

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

(1) First article inspection. The first article shall be inspected in accordance with the provisions of this Performance-based Contract Requirements 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 first article.

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

* 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 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 5-3 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 the drained weight inspection.

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SECTION E CONTINUED

2/ Finished product not equal to or better than the approved first article, when applicable, or other approved model in palatability and overall appearance shall be cause for rejection of the lot.

3/ Machine size requirement for beef slices/strips shall be verified by certificate of conformance.

4/ If the sample average net weight is less than 8.0 ounces, the lot shall be rejected

5/ If the sample average drained weight of beef slices is less than 2.5 ounces, the lot shall be rejected.

6/ If the sample average drained weight of vegetables (combined) is less than 1.5 ounces, the lot shall be rejected.

C. 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 80⁰F. Government verification may include storage for 6 months at 100⁰F or 36 months at 80⁰F. 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) Drained weight. The pouch contents shall be poured into a flat-bottom container. A minimum of three times the volume of the pouch of 180⁰F to 190⁰F 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 slices 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 slices 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 approximately a 45° angle and allowed to drain for 2 minutes before determining the drained weight by subtracting the sieve tare weight from the gross weight. The drained weight shall be reported to the nearest 0.1 ounce.

(4) Nutrient content. The sample to be analyzed shall be a composite of eight filled and sealed pouches which have been selected at random from the lot. The composited sample shall be prepared and analyzed for protein content, fat content, and salt content in accordance with the following methods of the Official Methods of Analysis of AOAC International:

<u>Test</u>	<u>Method Number</u>
Protein	988.05
Fat	960.39, 985.15
Salt	925.47

Make following changes:

(i) In section C-2, para D(2) (Vegetables): Delete “water chestnuts”.

(ii) In section C-3, para A(2) (Product) : Delete formulation and insert:

“Beef slices, cooked	42.27
Sauce	42.27
Mushrooms, cnd, stems & pieces	8.23
Bamboo shoots, cnd, sld	7.23”

In section C-2, para I (Nutrient content): Delete “(1) protein content...” entirely.

In section E-6, para C (4) Nutrient content, lines 3 and 7: delete references to “protein content” and “protein 988.05” accordingly.

In Section D, D-2 Labeling, B Cartons: Delete Footnote 1 entirely and insert:

“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.”

Black Bean and Rice Burrito, Packaged in a Flexible Pouch, Shelf Stable, PCR-B-0002, December 17,1997 8940-01-448-5744

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December 3, 1998

SECTION C

C-1 NSN/ITEM DESCRIPTION

PCR-B-0002 BLACK BEAN AND RICE BURRITO, PACKAGED IN A FLEXIBLE POUCH,
SHELF STABLE

Each component is consumed by combat personnel under worldwide environmental extremes as part of an operational ration, and is a source of nutritional intake. It is essential that this item be produced in accordance with good commercial practice to attain high standards of appearance, odor, flavor, and texture so that high levels of troop acceptance are achieved.

C-2 PERFORMANCE REQUIREMENTS

A. First article. A sample shall be subjected to first article inspection in accordance with the tests and inspections of Section E of this Performance-based Contract Requirements.

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 8C⁰F.

D. Appearance.

* (1) Tortilla. The tortilla shall be a flour tortilla made from enriched wheat flour and shall be a light tan color throughout.

(2) Filling. The filling shall be a uniform mixture of black beans and grains of white rice. The black beans shall be whole. The rice may have a tan to light brown color. There may be evidence of chopped green peppers, chopped onions, and spices in the mixture.

(3) Burrito. The finished burrito shall be a flour tortilla encasing the filling with each end tucked in and sealed. The surface of the finished burrito shall be lightly browned.

E. Odor and flavor.

(1) General. The packaged food shall have an odor and flavor characteristic of a plain flour tortilla, cooked black beans and rice with Mexican style seasoning and spices.

(2) Foreign. The packaged food shall be free from foreign odors and flavors such as, but not limited to, burnt, scorched, rancid, sour, or stale.

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SECTION C CONTINUED

F. Texture.

(1) Tortilla. The cooked tortilla shall be soft, pliable, and slightly chewy.

(2) Filling. The filling shall be moist. The whole black beans shall be slightly soft to slightly firm. The rice shall be slightly soft to slightly firm.

G. Net Weight.

(1) Burrito. The average net weight of the pouched product shall be not less than 4.0 ounces. No individual pouch shall contain less than 3.8 ounces of product.

* (2) Filling. The average weight of the filling in the burrito shall be not less than 1.7 ounces. No individual pouch shall have less than 1.5 ounces of filling.

H. Palatability. The finished product shall be equal to or better than the approved first article when applicable, or other approved model, in palatability and overall appearance.

I. Nutrient content.

(1) Protein content. The protein content shall be not less than 4.5 percent.

(2) Fat content. The fat content shall be not greater than 8.4 percent.

(3) Salt content. The salt content shall be not greater than 1.5 percent.

J. Vegetarian requirements. This product shall not contain ingredients, major or trace, or processing aids derived from the flesh, skin, blood, entrails, or bones of animals. This includes, but is not limited to oils, fats, fatty acids and their esters (palmitic, stearic, oleic, and pelargonic acids), flavorings, gelling agents, coagulants, (rennet derived from calves or pepsin derived from swine which are used in cheese manufacture), binders, emulsifiers (mono/di-glycerides, sodium or magnesium stearate, polysorbate, sorbitans, monostearate, glycerine), fatty alcohol, aldehydes and ketones, lactones, glycerol, amino acids, hydrolyzed proteins, enzymes, and enzyme modified products. Furthermore, these products shall contain no ethyl alcohol or ingredients derived from or containing ethyl alcohol. Milk and eggs, and ingredients derived from them such as yogurt or cheese (produced without animal based rennet or pepsin), are allowed. Conformance with vegetarian requirements shall be verified by a certificate of conformance.

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December 3, 1998

SECTION C CONTINUED

C-3 MISCELLANEOUS INFORMATION

* A. Ingredients. Ingredients may be as follows: Flour tortilla (enriched wheat flour, water, partially hydrogenated soybean and

cottonseed oil with mono and diqlycerides, salt, baking powder, potassium sorbate, sodium stearyl lactylate, calcium sulfate, sodium sulfite) , water, black beans, rice, soybean oil, modified food starch, green peppers, onions, and spices.

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SECTION E CONTINUED

* TABLE I. Product defects 1/ 2/ 3/ 6/

Category		Defect
<u>Major</u>	<u>Minor</u>	
		<u>Appearance</u>
101		The tortilla not as specified
102		Filling not a uniform mixture as specified
103		The finished burrito not as specified
	201	Black beans not whole
		<u>Odor and flavor</u>
104		Odor or flavor not as specified
		<u>Texture</u>
105		Tortilla not soft, pliable, or slightly chewy
	202	Filling not moist
	202	Black beans not slightly soft to slightly firm
	204	Rice not slightly soft to slightly firm
		<u>Weight</u>
	205	Net weight of an individual pouch less than 3.8 ounces <u>4/</u>
	206	The weight of the burrito filling in an individual pouch less than 1.5 ounce <u>5/</u>
*	207	(deleted)

1/ Product not verified by a certificate of conformance as meeting the vegetarian requirements shall be cause for rejection of the lot.

2/ Presence of any foreign odors and flavors such as, but not limited to burnt, scorched, rancid, sour, or stale shall be cause for rejection of the lot.

3/ Finished product not equal to or better than the approved first article, when applicable, or other approved model in palatability and overall appearance shall be cause for rejection of the lot.

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SECTION E CONTINUED

4/ If the sample average net weight is less than 4.0 ounces, the lot shall be rejected.

5/ If the sample average weight of burrito filling is less than 1.7 ounces, the lot shall be rejected.

6/ The enriched wheat flour shall be verified with the statement of ingredients on the label.

C. 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 80⁰F. Government verification may include storage for 6 months at 100⁰F or 36 months at 80⁰F. 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) Filling weight. The tortilla shall be removed from the filling in each burrito sample. The filling from each sample shall be weighed on a suitable scale. Results shall be reported to the nearest 0.1 ounce.

(5) Nutrient content. The sample to be analyzed shall be a composite of eight filled and sealed pouches which have been selected at random from the lot. The composited sample shall be prepared (see NOTE) and analyzed for protein content, fat content, and salt content in accordance with the following methods of the Official Methods of Analysis of AOAC International:

<u>Test</u>	<u>Method Number</u>
Protein	988.05
Fat	960.39, 985.15
Salt	935.47

Test results shall be reported to the nearest 0.1 percent. Any result not conforming to the requirements specified in Section C of this Performance-based Contract Requirements shall be cause for rejection of the lot.

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

Make following changes:

In Section D, D-2 Labeling, B Cartons: Delete Footnote 1 entirely and insert:
“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.”

Beef Enchilada in Sauce, Packaged in a Flexible Pouch, Shelf Stable, PCR-B-010, September 30, 1999 8940-01-479-1722

Make following changes:

In Section D, D-2 Labeling, B Cartons: Delete Footnote 1 entirely and insert:
“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.”

Beefsteak, Grilled, with Mushroom Gravy, Packaged in a Flexible Pouch, Shelf Stable, PCR-B-030, 15 November 2000 8905-01-486-7121

Make following changes:

In Section D, D-2 Labeling, B Cartons: Delete Footnote 1 entirely and insert:
“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.”

Beef Patty, Grilled, Packaged in a Flexible Pouch, Shelf Stable, PCR-B-029, 15 November 2000 8905-01-486-7128

Make following changes:

In Section D, D-2 Labeling, B Cartons: Delete Footnote 1 entirely and insert:
“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.”

Beef Ravioli in Meat Sauce, Packaged in a Flexible Pouch, Shelf Stable, PCR-B-021, 15 November 2000 8940-01-426-0553

Make following changes:

In Section 0, D-2 Labeling, B Cartons: Delete Footnote 1 entirely and insert:
“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.”

Beef Roast with Vegetables, Packaged in a Flexible Pouch, Shelf Stable, PCR-B-035, 24 October 2001, 8940-01-492-4940

Make following changes:

In Section D, D-2 Labeling, B Cartons: Delete Footnote 1 entirely and insert:

“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.”

Beef Stew, Packaged in a Flexible Pouch, Shelf Stable, PCR-B-020, 15 November 2000, 8940-00-149-1088

Make following changes:

In Section D, D-2 Labeling, B Cartons: Delete Footnote 1 entirely and insert:

“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.”

Chicken Breast Strips with Chunky Style Salsa, Packaged in a Flexible Pouch, Shelf Stable, PCR-C-0002, September 22, 1997 8940-01-445-9335

Substitute new page:

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March 5, 1999

SECTION E INSPECTION AND ACCEPTANCE

E-6 QUALITY ASSURANCE PROVISIONS

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.

Quality Assurance Provisions.

The following quality assurance criteria, utilizing ANSI/ASQC Z1.4-1993, Sampling Procedures and Tables for Inspection by Attributes, are recommended.

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

(1) First article inspection. The first article shall be inspected in accordance with the provisions of this Performance-based Contract Requirements 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 first article.

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

* 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 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 140⁰F to 190⁰F water for 10 minutes prior to the drained weight inspection.

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SECTION E CONTINUED

4/ If the sample average net weight is less than 8.0 ounces, the lot shall be rejected.

5/ If the sample average drained weight of chicken breast strips is less than 2.0 ounces, the lot shall be rejected.

6/ If the sample average drained weight of chunky vegetable pieces is less than 1.7 ounces, the lot shall be rejected.

C. Methods of inspection.

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

* (2) Shelf life. The contractor shall provide a certificate of conformance that the product has a 3 year shelf life when stored at 80⁰F. Government verification may include storage for 6 months at 100⁰F or 36 months at 80⁰F. 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) Drained weight. The contents of the pouch shall be poured into a flat-bottom container. A minimum of three times the volume of the pouch of 180⁰F to 190⁰F 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 remove the sauce. The contents shall then be poured into a US Standard No. 7 sieve in a manner that will distribute the product over the sieve. 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 approximately a 45⁰ angle and allowed to drain for 2 minutes before determining the drained weight by subtracting the sieve tare weight from the gross weight. The drained weight shall be reported to the nearest 0.1 ounce.

(4) Nutrient content. The sample to be analyzed shall be a composite of eight filled and sealed pouches which have been selected at random from the lot, the composted sample shall be prepared and analyzed for protein content, fat content, and salt content in accordance with the following methods of the Official Methods of Analysis of AOAC International:

<u>Test</u>	<u>Method Number</u>
Protein	988.05
Fat	960.39, 985.15
Salt	935.47

Test results shall be reported to the nearest 0.1 percent. Any result not conforming to the requirements specified in Section C of this Performance-based Contract Requirements shall be cause for rejection of the lot.

Make following changes:

In section C-2, para I (Nutrient content) Delete “(1) protein content...” entirely.
In Section E-6, para C (5) Nutrient content, lines 3 and 7: delete references to “protein content” and “protein 988.05” accordingly.

In Section D, D-2 Labeling, B Cartons: Delete Footnote 1 entirely and insert:

“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.”

Chicken in Thai Style Sauce, Packaged in a Flexible Pouch, Shelf Stable, PCR-C-0003, September 22,1997 8940-01-445-9333

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March 18, 1999

SECTION E CONTINUED

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

(1) First article inspection. The first article shall be inspected in accordance with the provisions of this Performance-based Contract Requirements 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 first article.

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

* 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 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 140⁰F to 190⁰F water for 10 minutes prior to the drained weight inspection.

TABLE I. Product defects 1/ 2/3/

Category		Defect
<u>Major</u>	<u>Minor</u>	
		<u>Appearance</u>
101		Bone or bone fragment measuring more than 0.3 inch in any dimension
102		Presence of feathers or feather parts
103		Product not a uniform mixture of chicken pieces And vegetables in sauce
104		Color of chicken pieces not of cooked chicken
	201	Total weight of skin, cartilage, coarse connective tissue, section of tendons or ligaments, and discolored meat is more than 0.20 ounces
	202	Color of sauce not translucent golden brown
	203	Color of vegetables not as specified
	204	Product does not contain the kinds of vegetables as specified

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May 14, 1999

SECTION E CONTINUED**B. Methods of inspection.**

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

* (2) Shelf life. The contractor shall provide a certificate of conformance that the product has a 3 year shelf life when stored at 80⁰F. Government verification may include storage for 6 months at 100⁰F or 36 months at 80⁰F. 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 unit on a suitable scale tared with a representative empty pouch. Results shall be reported to the nearest 0.1 ounce.

(4) Drained weight. The contents of the pouch shall be poured into a flat-bottom container. A minimum of three times the volume of the pouch of 18C⁰ F to 190⁰F 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 remove the sauce. The contents shall then be poured into a U.S. Standard No. 8 sieve •in a manner that will distribute the product over the sieve. 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 approximately a 45⁰ angle and allowed to drain for 2 minutes before determining the drained weight by subtracting the sieve tare weight from the gross weight. The drained weight shall be reported to the nearest 0.1 ounce.

(5) Nutrient content. The sample to be analyzed shall be a composite of eight filled and sealed pouches which have been selected at random from the lot. The composited sample shall be prepared and analyzed for protein content, fat content, and salt content in accordance with the following methods of the Official Methods of Analysis of AOAC International:

<u>Test</u>	<u>Method Number</u>
Protein	988.05
Fat	960.39, 985.15
Salt	935.47

Test results shall be reported to the nearest 0.1 percent. Any result not conforming to the requirements specified in Section C of this Performance-based Contract Requirements shall be cause for rejection of the lot.

Make following changes:

(i) In section C-2, para D(2) (Vegetables) Delete “sliced water chestnuts”.

(ii) In section C-3, para A(Ingredients) : Delete “sliced water chestnuts”.

In section C-2, para I (Nutrient content) : Delete “(1) protein content...” entirely.

In section E-6, para C (5)Nutrient content, lines 3 and 7: delete references to “protein content” and “protein 988.05” accordingly.

In Section D, D-2 Labeling, B Cartons: Delete Footnote 1 entirely and insert:

“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.”

Chicken Tetrazzini, Packaged in a Flexible Pouch, Shelf Stable, PCR-C-018, October 1, 1998 8940-01-467-2495

Substitute new page:

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March 18, 1999

SECTION E INSPECTION AND ACCEPTANCE

Inspection for packaging, labeling and packing, and marking shall be in accordance with the Quality Assurance Provisions and Packaging Requirements for MIL-PRF-44073.

E-6 QUALITY ASSURANCE PROVISIONS (Product)

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.

Quality Assurance Provisions.

The following quality assurance criteria, utilizing ANSI/ASQC Z1.4-1993, Sampling Procedures and Tables for Inspection by Attributes, are required.

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

(1) Production standard inspection. The first article or product demonstration model shall be inspected in accordance with the provisions of this Performance-based Contract Requirements 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.

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

* 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 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 5-3 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 game sampling criteria as above. The pouches shall be immersed in 140⁰F to 190⁰F water for 10 minutes prior to the drained weight inspection.

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SECTION E CONTINUED

3/ Machine setting requirement for chicken pieces shall be verified with a certificate of conformance. The requirement for natural proportions of chicken shall be verified with a certificate of conformance.

4/ Length of the cooked spaghetti shall be verified with a certificate of conformance. The enriched spaghetti shall be verified with the statement of ingredients on the label.

5/ If the sample average net weight is less than 8.0 ounces, the lot shall be rejected.

6/ If the sample average weight of the chicken pieces is less than 2.1 ounces, the lot shall be rejected.

7/ If the average drained weight of the spaghetti and vegetables (combined) is less than 3.5 ounces, the lot shall be rejected.

C. Methods of inspection.

(3) 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 80⁰F.

Government verification may include storage for 6 months at 100⁰F or 36 months at 80SF[?]. 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 180⁰F to 190⁰F 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 chicken or the spaghetti. 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 chicken or the spaghetti. 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 approximately a 45~ angle and allowed to drain for 2 minutes before determining the drained weight by subtracting the sieve tare weight from the gross weight. The drained weight shall be reported to the nearest 0.1 ounce.

(5) Nutrient content. The sample to be analyzed shall be a composite of eight filled and sealed pouches, which have been selected at random from the lot. The composited sample shall be prepared (see Note) and analyzed for protein content, fat content, and salt content in accordance with the following methods of the Official Methods of Analysis of AOAC International:

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SECTION E CONTINUED

<u>Test</u>	<u>Method Number</u>
Protein	988.05, 992.15
Fat	960.39, 985.15
Salt	935.47

Test results shall be reported to the nearest 0.1 percent. Any result not conforming to the requirements specified in Section C of this Performance-based Contract Requirements document shall be cause for rejection of the lot.

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

Make following changes:

In section C-2, para I (Nutrient content): Delete “(1) protein content..” entirely.

In section E-6, para C (5) Nutrient content, lines 3 and 7: delete references to “protein content” and “protein 988.05, 992.15” accordingly.

Country Captain Chicken, Packaged in a Flexible Pouch, Shelf Stable, PCR-C-019A, 31 July 2000 8940-01-467-2492

Make following changes:

In Section D, D-2 Labeling, B Cartons: Delete Footnote 1 entirely and insert:

“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.”

Cheese Tortellini in Tomato Sauce, Packaged in a Flexible Pouch, Shelf Stable, PCR-C-020, October 8, 1998 8940-01-397-6661

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October 18, 1999

SECTION C CONTINUED

G. Weight.

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

(2) Drained weight. The average drained weight shall be not less than 4.0 ounces. The drained weight of tortellini in an individual pouch shall be not less than 3.5 ounces.

H. Palatability. The finished product shall be equal to or better than the approved first article when applicable, or other approved model, in palatability and overall appearance.

* I. Nutrient content.

(1) Fat content. The fat content shall be not greater than 5.0 percent.

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

J. Vegetarian requirements. This product shall contain no ingredients, major or trace, and/or processing aids derived from the flesh, skin, blood, entrails, or bones of animals. This includes, but is not limited to oils, fats, fatty acids and their esters (palmitic, stearic, oleic, and pelargonic acids), flavorings, gelling agents, coagulants, (rennet derived from calves or pepsin derived from swine which are used in cheese manufacture), binders, emulsifiers (mono/di-glycerides, sodium or magnesium stearate, polysorbate, sorbitans, monostearate, glycerin), fatty alcohol, aldehydes and ketones, lactones, glycerol, amino acids, hydrolyzed proteins, enzymes, and enzyme modified products. Furthermore, these products shall contain no

ethyl alcohol or ingredients derived from or containing ethyl alcohol. Milk and eggs, and ingredients derived from them such as yogurt or cheese (produced without animal based rennet or pepsin), are allowed.

C-3 MISCELLANEOUS INFORMATION

THE FOLLOWING LIST OF INGREDIENTS IS PROVIDED FOR INFORMATION ONLY AND IS NOT A MANDATORY CONTRACT REQUIREMENT.

A. Ingredients. Water, tomato puree, cheese tortellini, (enriched durum flour (niacin, ferrous sulfate, thiamin, mononitrate, riboflavin, folic acid), water, part skim ricotta cheese (pasteurized whole milk, whey starter, salt), bleached wheat flour, parmesan cheese (pasteurized milk cultures, salt, enzymes), pasteurized egg whites, salt, yellow corn flour, yeast, sugar, hydrolyzed corn gluten, parsley, granulated garlic, autolyzed yeast extract, vegetable oil (corn or soya) , white pepper, natural colors, partially hydrogenated cottonseed and soybean oils), onions, modified food starch, vegetable oil, parmesan cheese (pasteurized milk cultures, salt enzymes, powdered cellulose, sorbic acid), celery, salt, spices, garlic powder.

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April 13, 1999

SECTION E INSPECTION AND ACCEPTANCE

Inspection for packaging, labeling and packing, and marking shall be in accordance with the Quality Assurance Provisions and Packaging Requirements for MIL-PRF-44073.

E-6 QUALITY ASSURANCE PROVISIONS (PRODUCT)

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.

Quality Assurance Provisions.

The following quality assurance criteria, utilizing ANSI/ASQC Z1.4-1993, Sampling Procedures and Tables for Inspection by Attributes, are required.

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

(1) Production standard inspection. The first article or product demonstration model shall be inspected in accordance with the provisions of this Performance-based Contract Requirements 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.

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

* 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 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 140⁰F to 190⁰F water for 10 minutes prior to the drained weight inspection.

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October 18, 1999

SECTION E CONTINUED

6/ If the sample average drained weight of the tortellini is less than 4.0 ounces, the lot shall be rejected.

C. 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 80⁰F. Government verification may include storage for 6 months at 100⁰F or 36 months at 80⁰F. 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 180⁰F to 190⁰F water shall be added to the container so as to cover the contents. The contents and water shall be gently agitated so to remove the sauce without breaking the tortellini. 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 tortellini. 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 approximately a 45⁰ angle and allowed to drain for 2 minutes before determining the drained weight by subtracting the sieve tare weight from the gross weight. The drained weight shall be reported to the nearest 0.1 ounce.

* (5) Nutrient content. The sample to be analyzed shall be a composite of eight filled and sealed pouches, which have been selected at random from the lot. The composited sample shall be prepared (see Note) and analyzed for fat content and salt content in accordance with the following methods of the Official Methods of Analysis of AOAC International:

<u>Test</u>	<u>Method Number</u>
Fat	960.39, 985.15
Salt	935.47

Test results shall be reported to the nearest 0.1 percent. Any result not conforming to the requirements specified in Section C of this Performance-based Contract Requirements document shall be cause for rejection of the lot.

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

Make following changes:

In section C-2, I. Nutrient content, add the following:

“(1) Protein content. The protein content shall be not less than 4.0 percent.”

In section E-6, C. (5) Nutrient content, under Test and Method Number, add the following:

<u>Test</u>	<u>Method Number</u> ”
Protein	988.05, 992.15

Chicken, Noodles and Vegetables in Sauce, Packaged in a Flexible Pouch, Shelf Stable, PCR-C-021, October 8, 1998 8940-01-426-2282

Substitute new page:

Page 4 of 8
April 13, 1999

SECTION E INSPECTION AND ACCEPTANCE

Inspection for packaging, labeling and packing, and marking shall be in accordance with the Quality Assurance Provisions and Packaging Requirements for MIL-PRF-44073.

E-6 QUALITY ASSURANCE PROVISIONS (PRODUCT)

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.

Quality Assurance Provisions.

The following quality assurance criteria, utilizing ANSI/ASQC Z1.4-1993, Sampling Procedures and Tables for Inspection by Attributes, are required.

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

(1) Production standard inspection. The first article or product demonstration model shall be inspected in accordance with the provisions of this Performance—based Contract Requirements 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.

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

* 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 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 140⁰F to 190⁰F water for 10 minutes prior to the drained weight inspection.”

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May 21, 1999

SECTION E CONTINUED

C. 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 80⁰F . Government verification may include storage for 6 months at 100⁰F or 36 months at 80⁰F. 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 180⁰F to 190⁰F 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 chicken or noodles. 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 chicken or noodles. 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 approximately a 45⁰ angle and allowed to drain for 2 minutes before determining the drained weight by subtracting the sieve tare weight from the gross weight. The drained weight shall be reported to the nearest 0.1 ounce.

(5) Nutrient content. The sample to be analyzed shall be a composite of eight filled and sealed pouches, which have been selected at random from the lot. The composited sample shall be prepared (see Note) and analyzed for protein content, fat content, and salt content in accordance with the following methods of the Official Methods of Analysis of AOAC International:

<u>Test</u>	<u>Method Number</u>
Protein	988.05, 992.15
Fat	922.06
Salt	935.47

Test results shall be reported to the nearest 0.1 percent. Any result not conforming to the requirements specified in Section C of this Performance-based Contract Requirements document shall be cause for rejection of the lot.

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

Make following changes:

In section C-2, para I (Nutrient content): Delete “(1) protein content...” entirely. In section E-6, para C (5)Nutrient content, lines 3 and 7: delete references to “protein content” and “protein 988.05, 992.15” accordingly.

Chicken Breast Fillet, Packaged in a Flexible Pouch, Shelf Stable, PCR-C022, October 8, 1998 8905-01-373-2537

Substitute new page:

Page 4 of 7
April 27, 1999

SECTION E INSPECTION AND ACCEPTANCE

Inspection for packaging, labeling and packing, and marking shall Be in accordance with the Quality Assurance Provisions and Packaging Requirements for MIL-PRF-44073.

E-6 QUALITY ASSURANCE PROVISIONS (PRODUCT)

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.

Quality Assurance Provisions.

The following quality assurance criteria, utilizing ANSI/ASQC Z1.4-1993, Sampling Procedures and Tables for Inspection by Attributes, are required.

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

(1) Production standard inspection. The first article or product demonstration model shall be inspected in accordance with the provisions of this Performance-based Contract Requirements 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.

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

* 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 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 140⁰F to 190⁰F water for 10 minutes prior to the drained weight inspection.

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May 21, 1999

SECTION E CONTINUED

C. 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 8C⁰F. Government verification may include storage for 6 months at 100⁰F or 36 months at 80⁰F. 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) Drained weight. The pouch contents shall be poured into a flat-bottom container. A minimum of three times the pouches volume of 180⁰F to 190⁰F 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 without breaking the chicken breast. The contents shall then be poured into a U.S. Standard 1/4 inch sieve in a manner that will distribute the product over the sieve without breaking the chicken breast. 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 approximately a 45⁰ angle and allowed to drain for 2 minutes before determining the drained weight by subtracting the sieve tare weight from the gross weight. The drained weight shall be reported to the nearest 0.1 ounce.

(4) Nutrient content. The sample to be analyzed shall be a composite of eight filled and sealed pouches, which have been selected at random from the lot. The composited sample shall be prepared (see Note) and analyzed for protein content, fat content, and salt content in accordance with the following methods of the Official Methods of Analysis of AOAC International:

<u>Test</u>	<u>Method Number</u>
Protein	988.05, 992.15
Fat	960.39, 985.15
Salt	935.47

Test results shall be reported to the nearest 0.1 percent. Any result not conforming to the requirements specified in Section C of this Performance-based Contract Requirements document shall be cause for rejection of the lot.

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

Make following changes:

In section C-2, pare I (Nutrient content) : Delete “(1) protein content...” entirely.

In section E-6, pare C (4)Nutrient content, lines 3 and. 7: delete references to “protein content...” “protein 988.05, 992.15” accordingly.

Chicken Breast Fillet, in Tomato Sauce, with Cavatelli, Packaged in a Flexible Pouch, Shelf Stable, PCR-C-023, October 8, 1998 8940-01-413-0232

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SECTION E INSPECTION AND ACCEPTANCE

Inspection for packaging, labeling and packing, and marking shall be in accordance with the Quality Assurance Provisions and Packaging Requirements for MIL-PRF-44073.

E-6 QUALITY ASSURANCE PROVISIONS (PRODUCT)

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.

Quality Assurance Provisions.

The following quality assurance criteria, utilizing ANSI/ASQC Z1.4-1993, Sampling Procedures and Tables for Inspection by Attributes, are required.

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

(1) Production standard inspection. The first article or product demonstration model shall be inspected in accordance with the provisions of this Performance-based Contract Requirements 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.

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

* 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 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 5-3 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~P to 190%' water for 10 minutes prior to the drained weight inspection.

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SECTION F CONTINUED

1/ Presence of any foreign material such as, but not limited to dirt, insect parts, hair, wood, glass, metal), or foreign odors and 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 first article, when applicable, or other approved model in palatability and overall appearance shall be cause for rejection of the lot.

3/ Verification of the enriched macaroni product shall be with the statement of ingredients on the label.

4/ If the sample average net weight is less than 8.0 ounces, the lot shall be rejected.

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 80⁰F. Government verification may include storage for 6 months at 100⁰F or 36 months at 80⁰F. 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 on a suitable scale tared with a representative empty pouch. Results shall be reported to the nearest 0.1 ounce.

(3) Drained weight. The pouch contents shall be poured into a flat-bottom container. A minimum of three times the volume of the pouch of 180⁰F to 190⁰F 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 chicken breast fillet or cavatelli. 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 chicken breast fillet or cavatelli. 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 approximately a 45⁰ angle and allowed to drain for 2 minutes before determining the drained weight by subtracting the sieve tare weight from the gross weight. The drained weight shall be reported to the nearest 0.1 ounce.

(4) Nutrient content. The sample to be analyzed shall be a composite of eight filled and sealed pouches, which have been selected at random from the lot. The composited sample shall be prepared (see Note) and analyzed for protein content, fat content, and salt content in accordance with the following methods of the Official Methods of Analysis of AOAC International:

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SECTION E CONTINUED

<u>Test</u>	<u>Method Number</u>
Protein	988.05, 992.15
Fat	922.06
Salt	935.47

Test results shall be reported to the nearest 0.1 percent. Any result not conforming to the requirements specified in Section C of this Performance-based Contract Requirements document shall be cause for rejection of the lot.

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

Make **following changes**:

In section C-2, para I (Nutrient content) Delete “(1) protein content...” entirely.

In section E-6, pars C (5) Nutrient content, lines 3 and 7: delete references to “protein content” and “protein 988.05, 992.15” accordingly.

**Chili and Macaroni, Packaged in a Flexible Pouch, Shelf Stable, PCR-C-027,
15 November 2000 8940-01-375-4375**

Make following changes:

In Section D, D-2 Labeling, B Cartons: Delete Footnote 1 entirely and insert:

“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.”

Jambalaya, with Ham and Shrimp, Packaged in a Flexible Pouch, Shelf Stable, PCR-J-001, September 30, 1999 8940-01-479-1734

Make following changes:

Page 2, Sec C-2, subpara I., make the following changes:

Delete “Nutrient Content.”, insert “Analytical Requirements.”

Delete entirely, “(1) Protein content. The protein content... 6.0 percent.”

Renumber “(2) and (3)” to “(1) and (2)”

Page 2, Sec C-3, A., make the following changes:

Line 5, Rice, blanched, delete “18.00”, insert “14.00”

Line 7, Chicken broth, delete “15.57”, insert “9.57”

Line 8, Ham, diced, delete “15.00”, insert “25.00”

Page 8, Sec E, C. (5), make the following changes:

Delete “Nutrient Content.”, insert “Analytical.”

Line 4, delete “protein content,”

Under Test, delete “Protein”

Under Method Number, delete “988.05, 992.15”

In Section D, D-2 Labeling, B Cartons: Delete Footnote 1 entirely and insert:

“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.”

Meat Loaf with Brown Onion Gravy, Packaged in a Flexible Pouch, Shelf Stable, PCR-M-0001, September 22, 1997 8940-01-448-5739

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SECTION C CONTINUED

(2) Gravy. The gravy shall be moderately thick. The gravy shall be smooth except for the minced onions. The minced onions shall be soft.

G. Weight.

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

(2) Drained weight. The average drained weight of the intact portion of meatloaf shall be not less than 3.5 ounces. The drained weight of the intact portion of meatloaf in an individual pouch shall be not less than 3.2 ounces.

H. Palatability. The finished product shall be equal to or better than the approved first article when applicable, or other approved model, in palatability and overall appearance.

I. Nutrient content.

(1) Protein content. The protein content shall be not less than 6.7 percent.

* (2) Fat content. The fat content shall be not greater than 8.0 percent.

(3) Salt content. The salt content shall be not greater than 1.3 percent.

C-3 MISCELLANEOUS INFORMATION

A. Ingredients.

(1) Ingredients for meatloaf may be as follows: beef, water, wheat flour, textured vegetable protein, onions, tomato paste, onion powder, salt, spices, sugar, autolyzed yeast extract, garlic powder, and dehydrated green peppers.

(2) Ingredients for gravy may be as follows: water, onions, beef extract, margarine, modified food starch, burgundy wine, onion powder, wheat flour, salt, sugar, and spices.

SECTION D

D-1 PACKAGING

A. Product shall be filled into pouches and the pouches shall be filled into cartons. Both shall meet the requirements of Section 3 and Figures 1 and 2 of MIL-PRF-44073. Verification testing and inspection of pouch and carton conformance to the requirements shall be by the testing and inspections of Section 4 of MIL-PRF-44073 and the Quality Assurance Provisions of Section E of this Performance-based Contract Requirements.

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SECTION E CONTINUED

(1) First article inspection. The first article shall be inspected in accordance with the provisions of this Performance-based Contract Requirements 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 first article.

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

* 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 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 140⁰F to 190⁰F water for 10 minutes prior to the drained weight inspection.

TABLE I. Product defects 1/ 2/

Category		Defect
Major	Minor	
		<u>Appearance</u>
101		Bone or bone fragment measuring more than 0.3 inch in Any dimension
102		Meatloaf not produced from ground beef
	201	Color not typical of cooked, ground beef
	202	Gravy not a medium brown color or not smooth, glossy, and semi-opaque
	203	Gravy does not contain pieces of minced, cooked onions
		<u>Odor and flavor</u>
103		Meatloaf odor or flavor not characteristic of cooked ground beef, seasoned with herbs and spices
104		Gravy odor or flavor not of mildly seasoned beef gravy with minced onions

Texture

- 204 Meatloaf not firm
- 205 Meatloaf not medium coarse texture or not moist
- 206 Minced onions not soft

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SECTION E CONTINUED

TABLE I. Product defects 1/ 2/(cont'd)

Category		Defect
<u>Major</u>	<u>Minor</u>	
	207	Gravy not smooth except for minced onions
	208	Gravy not moderately thick
		<u>Weight</u>
	209	Net weight of an individual pouch less than 7.5 ounces <u>3/</u>
	210	Drained weight of intact portion of meatloaf in an individual pouch less than 3.2 ounces <u>4/</u>

1/ Presence of any foreign odors and 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 first article, when applicable, or other approved model in palatability and overall appearance shall be cause for rejection of the lot.

3/ If the sample average net weight is less than 8.0 ounces, the lot shall be rejected.

4/ If the sample average drained weight of the intact portion of meatloaf is less than 3.5 ounces, the lot shall be rejected.

C. 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 80⁰F. Government verification may include storage for 6 months at 100⁰F for 36 months at 80⁰F. 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 pouch's volume of 180⁰F to 190⁰F water shall be added to the container so as to cover the contents. The contents and water shall be gently agitated without breaking the meatloaf. The contents shall then be poured into a 1/4 inch sieve. The sieve shall be tilted at approximately a 45⁰ angle and allowed to drain for 2 minutes before determining the drained weight by subtracting the sieve tare weight from the gross weight. The drained weight shall be reported to the nearest 0.1 ounce.

Make following changes:

In section C-2, para I (Nutrient content) : Delete (1) protein content." entirely.

In section E-6, para C (5)Nutrient content, lines 3 and 7: delete references to "protein content" and "protein 988.05" accordingly.

In Section D, D-2 Labeling, B Cartons: Delete Footnote 1 entirely and insert: "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."

Pasta with Vegetables in Tomato Sauce, Packaged in a Flexible Pouch, Shelf Stable, PCR-P-009, October 8,1998 8940-01-448-8170

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Page 2 of 8
October 18, 1999

SECTION C CONTINUED

F. Texture.

(1) Pasta. The cooked pasta shall be slightly soft to slightly firm.

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

(3) Sauce. The sauce shall be moderately thick with pieces of tomato.

G. Weight.

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

(2) Drained weight. The drained weight of pasta and vegetables (combined) in an individual pouch shall be not less than 4.5 ounces.

H. Palatability. The finished product shall be equal to or better than the approved first article when applicable, or other approved model, in palatability and overall appearance.

* I. Nutrient content.

(1) Fat content. The fat content shall be not greater than 2.0 percent.

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

J. Vegetarian requirements. This product shall contain no ingredients, major or trace, and/or processing aids derived from the flesh, skin, blood, entrails, or bones of animals. This includes, but is not limited to oils, fats, fatty acids and their esters (palmitic, stearic, oleic, and pelirgonic acids), flavorings, gellin⁹ agents, coagulants, (rennet derived from calves or pepsin derived from swine which are used in cheese manufacture), binders, emulsifiers (mono/di-glycerides, sodium or magnesium stearate, polysorbate, sorbitans, monostearate, glycerine), fatty alcohol, aldehydes and ketones, lactones, glycerol, amino acids, hydrolyzed proteins, enzymes, and enzyme modified products. Furthermore, these products shall contain no ethyl alcohol or ingredients derived from or containing ethyl alcohol. Milk and eggs, and ingredients derived from them such as yogurt or cheese (produced without animal based rennet or pepsin), are allowed.

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SECTION E INSPECTION AND ACCEPTANCE

Inspection for packaging, labeling and packing, and marking shall be in accordance with the Quality Assurance Provisions and Packaging Requirements for MIL-PRF-44073.

E-6 QUALITY ASSURANCE PROVISIONS (PRODUCT)

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.

Quality Assurance Provisions.

The following quality assurance criteria, utilizing ANSI/ASQC Z1.4-1993, Sampling Procedures and Tables for Inspection by Attributes, are required.

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

(1) Production standard inspection. The first article or product demonstration model shall be inspected in accordance with the provisions of this Performance-based Contract Requirements 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.

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

* 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 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 5-3 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 140⁰F to 190⁰F water for 10 minutes prior to the drained weight inspection.

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SECTION E CONTINUED

3/ Product not verified by a certificate of conformance as meeting the vegetarian requirements shall be cause for rejection of the lot.

4/ Verification of the enriched macaroni product shall be with the statement of ingredients on the label.

5/ If the sample average net weight is less than 8.0 ounces, the lot shall be rejected.

C. Methods of inspection.

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

(2) Shelf life. Compliance with shelf life shall be determined by incubation for 1 month at 120⁰ F or 6 months at 100⁰F or 36 months at 80⁰F. Contractor shall provide a certificate of conformance.

(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 180⁰F to 190⁰F 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 pasta 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 pasta 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 approximately a 45⁰ angle and allowed to drain for 2 minutes before determining the drained weight by subtracting the sieve tare weight from the gross weight. The drained weight shall be reported to the nearest 0.1 ounce.

* (5) Nutrient content. The sample to be analyzed shall be a composite of eight filled and sealed pouches, which have been selected at random from the lot. The composited sample shall be prepared (see Note) and analyzed for fat content, and salt content in accordance with the following methods of the Official Methods of Analysis of AOAC International:

<u>Test</u>	<u>Method Number</u>
Fat	960.39, 985.15
Salt	935.47

Test results shall be reported to the nearest 0.1 percent. Any result not conforming to the requirements specified in Section C of this Performance-based Contract Requirements document shall be cause for rejection of the lot.

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

Pork Rib, Boneless, Imitation Smoke Flavoring Added, Packaged in a Flexible Pouch, Shelf Stable, 25 October 2001 PCR-P-028, 8905-01-492-4982

Make following changes:

In Section D, D-2 Labeling, B Cartons: Delete Footnote 1 entirely and insert:

“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.”

Spaghetti with Meat and Sauce, Packaged in a Flexible Pouch, Shelf Stable, PCR-S-0002, November 5, 1997 8940-01-224-5675

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SECTION F INSPECTION AND ACCEPTANCE

E-6 QUALITY ASSURANCE PROVISIONS

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.

Quality Assurance Provisions.

The following quality assurance criteria, utilizing ANSI/ASQC Z1.4-1993, Sampling Procedures and Tables for Inspection by Attributes, are recommended.

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

(1) First article inspection. The first article shall be inspected in accordance with the provisions of this Performance-based Contract Requirements 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 first article.

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

* 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 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 140⁰F to 190⁰F water for 10 minutes prior to the drained weight inspection.

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May 21, 1999

SECTION E CONTINUED

4/ Type and size requirements for cooked spaghetti shall be verified by certificate of conformance.

5/ If the sample average net weight is less than 8.0 ounces, the lot shall be rejected.

6/ If the sample average drained weight of the beef and spaghetti is less than 5.1 ounces, the lot shall be rejected.

B. Methods of inspection.

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

* (2) Shelf life. The contractor shall provide a certificate of conformance that the product has a 3 year shelf life when stored at 80⁰F. Government verification may include storage for 6 months at 100⁰F or 36 months at 80⁰F. 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 pouch's volume of 180⁰F to 190⁰F 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 the spaghetti. The contents shall then be poured into a U.S. Standard No. 20 sieve in a manner that will distribute the product over the sieve without breaking the beef or the spaghetti. 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 approximately a 45⁰ angle and allowed to drain for 2 minutes before determining the drained weight by subtracting the sieve tare weight from the gross weight. The drained weight shall be reported to the nearest 0.1 ounce.

(5) Nutrient content. The sample to be analyzed shall be a composite of eight filled and sealed pouches which have been selected at random from the lot. The composited sample shall be prepared (see NOTE) and analyzed for protein content, fat content, and salt content in accordance with the following methods of the Official Methods of Analysis of AOAC International:

<u>Test</u>	<u>Method Number</u>
Protein	984.13
Fat	960.39, 985.15
Salt	935.47

Test results shall be reported to the nearest 0.1 percent. Any result not conforming to the requirements specified in Section C of this

Performance-based Contract Requirements shall be cause for rejection of the lot.

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

Make following changes:

In section C-2, para I(Nutrient content): Delete “(1) protein content...” entirely.

In section E-6, pars C (5)Nutrient content, lines 3 and 7: delete references to “protein content” and “protein 984.13” accordingly.

In Section D, D-2 Labeling, B Cartons: Delete Footnote 1 entirely and insert:

“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.”

Turkey Breast Fillet, Chunked and Formed, Grilled, in Gravy with Potatoes, Packaged in a Flexible Pouch, Shelf Stable, PCR-T-004, 15 November 2000 8940-01-426-3318

Make following changes:

In Footnote Section D, D-2 Labeling, B Cartons: Delete 1 entirely and insert:

“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.”

Vegetable Manicotti in Tomato Sauce, Packaged in a Flexible Pouch, Shelf Stable, PCR-V-003, 24 October 2001 8940-01-492-4978

Make following changes:

In Section D, D-2 Labeling, B Cartons: Delete Footnote 1 entirely and insert:

“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.”

STARCHES AND SOUPS

Beans Western, PCR-B-01 1, Packaged in a Flexible Pouch, Shelf Stable, October 1,1998 8940-01-454-4915

Substitute new page:

Page 2 of 8

October 18, 1999

SECTION C CONTINUED

F. Texture.

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

(2) Pinto beans. The pinto beans shall be slightly soft to slightly firm.

(3) Lentils. The lentils shall be slightly soft to slightly firm.

(4) Sauce. The sauce shall be moderately thick with pieces of tomato and onions.

G. Weight.

(1) Net weight. The average net weight shall be not less than 5.0 ounces. No individual pouch shall contain less than 4.5 ounces.

(2) Drained weight. The average drained weight of western beans shall be not less than 3.6 ounces. The drained weight of western beans in an individual pouch shall be not less than 3.4 ounces. The drained weight of the kidney and pinto beans combined in an individual pouch shall be not less than 1.5 ounces.

H. Palatability. The finished product shall be equal to or better than the approved first article when applicable, or other approved model, in palatability and overall appearance.

* I. Nutrient content.

(1) Fat content. The fat content shall be not greater than 2.0 percent.

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

J. Vegetarian requirements. This product shall contain no ingredients, major or trace, and/or processing aids derived from the flesh, skin, blood, entrails, or bones of animals. This includes, but is not limited to oils, fats, fatty acids and their esters (palmitic, stearic, oleic, and palarqonic acids), flavorings, galling agents, coagulants, (rennet derived from calves or pepsin derived from swine which are used in cheese manufacture), binders, emulsifiers (mono/di-glycerides, sodium or magnesium stearate, polysorbate, sorbitans, monostearate, glycerine), fatty alcohol, aldehydes and ketones, lactones, glycerol, amino acids, hydrolyzed proteins, enzymes, and enzyme modified products. Furthermore, these products shall contain no ethyl alcohol or ingredients derived from or containing ethyl alcohol. Milk and eggs, and ingredients derived from them such as yogurt or cheese (produced without animal based rennet or pepsin) , are allowed.

Substitute new page:

Page 5 of 8

March 16, 1999

SECTION E INSPECTION AND ACCEPTANCE

Inspection for packaging, labeling and packing, and marking shall be in accordance with the Quality Assurance Provisions and Packaging Requirements for MIL-PRE-44073.

E-6 QUALITY ASSURANCE PROVISIONS (PRODUCT)

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.

Quality Assurance Provisions.

The following quality assurance criteria, utilizing ANSI/ASQC Z1.4-1993, Sampling Procedures and Tables for Inspection by Attributes, are required.

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

(1) Production standard inspection. The first article or product demonstration model shall be inspected in accordance with the provisions of this Performance-based Contract Requirements 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.

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

* 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 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 140⁰F to 190⁰F water for 10 minutes prior to the drained weight inspection.

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SECTION E CONTINUED

6/ If the sample average net weight is less than 5.0 ounces, the lot shall be rejected.

7/ If the sample average drained weight of the product is less than 3.6 ounces, the lot shall be rejected.

C. 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 80⁰F. Government verification may include storage for 6 months at 100⁰F or 36 months at 80⁰F. 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 pouch's volume of 180⁰F to 190⁰F water shall be added to the container so as to cover the contents. The contents and water shall be gently agitated without breaking the beans. 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 beans. 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 approximately a 45⁰ angle and allowed to drain for 2 minutes before determining the drained weight by subtracting the sieve tare weight from the gross weight. The drained weight shall be reported to the nearest 0.1 ounce.

* (5) Nutrient content. The sample to be analyzed shall be a composite of eight filled and sealed pouches, which have been selected at random from the lot. The composited sample shall be prepared (see Note) and analyzed for fat and salt content in accordance with the following methods of the Official Methods of Analysis of AOAC International:

<u>Test</u>	<u>Method Number</u>
Fat	960.39, 985.15
Salt	935.47

Test results shall be reported to the nearest 0.1 percent. Any result not conforming to the requirements specified in Section C of this Performance-based Contract Requirements document shall be cause for rejection of the lot.

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

Clam Chowder, New England Style, Packaged in a Flexible Pouch, Shelf Stable, PCR-C-045, 25 October 2001 8935-01-492-4993

Make following changes:

In Section D, D-2 Labeling, B Cartons: Delete Footnote 1 entirely and insert:

“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.”

Minestrone Stew, Packaged in a Flexible Pouch, Shelf Stable, PCR-M-004, October 2,1998 8940-01-467-2497

Substitute new page:

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SECTION C CONTINUED

F. Texture.

(1) Pasta. The cooked pasta shall be slightly soft to slightly firm.

(2) vegetables. The vegetables shall be slightly soft to slightly thin.

(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 contain less than 7.5 ounces.

(2) Drained weight. The average drained weight of the pasta and vegetables (combined) shall be not less than 5.3 ounces. The drained weight of pasta and vegetables (combined) in an individual pouch shall be not less than 5.0 ounces.

H. Palatability. The finished product shall be equal to or better Than the approved first article when applicable, or other approved model, in palatability and overall appearance.

* I. Nutrient content.

(1) Fat content. The fat content shall be not greater than 1.0 percent.

(2) Salt content. The salt content shall be not greater than 1.0 percent.

J. Vegetarian requirements. This product shall contain no ingredients, major or trace, and/or processing aids derived from the flesh, skin, blood, entrails, or bones of animals. This includes, but

is not limited to oils, fats, fatty acids and their esters (palmitic, stearic, oleic, and pelargonic acids), flavorings, gelling agents, coagulants, (rennet derived from calves or pepsin derived from swine which are used in cheese manufacture) , binders, emulsifiers (mono/di-glycerides, sodium or magnesium stearate, polysorbate, sorbitans, monostearate, glycerine), fatty alcohol, aldehydes and ketones, lactones, glycerol, amino acids, hydrolyzed proteins, enzymes, and enzyme modified products. Furthermore, these products shall contain no ethyl alcohol or ingredients derived from or containing ethyl alcohol. Milk and eggs, and ingredients derrved from them such as yogurt or cheese (produced without animal based rennet or pepsin), are allowed.

C-3 MISCELLANEOUS INFORMATION

THE FOLLOWING LIST OF INGREDIENTS IS PROVIDED FOR INFORMATION ONLY AND IS NOT A MANDATORY CONTRACT REQUIREMENT.

A. **Ingredients.** Water, tomatoes, enriched macaroni, (semolina, water, egg white, niacin, ferrous sulfate, thiamin mononitrate, riboflavin, folate) peas, kidney beans, green beans, carrots, celery, onion, tomato paste, loon starch-modified with erythorbic acid added, salt, spices, parsley flakes and garlic powder.

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SECTION E INSPECTION AND ACCEPTANCE

Inspection for packaging, labeling and packing, and marking shall be in accordance with the Quality Assurance Provisions and Packaging Requirements for MIL-PRF-44073.

E-6 QUALITY ASSURANCE PROVISIONS (PRODUCT)

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.

Quality Assurance Provisions.

The following quality assurance criteria, utilizing ANSI/ASQC Z1.4-1993, Sampling Procedures and Tables for Inspection by Attributes, are required.

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

(1) Production standard inspection. The first article or product demonstration model shall be inspected in accordance with the provisions of this Performance-based Contract Requirements 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.

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

* 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 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 140⁰F to 190⁰F water for 10 minutes prior to the drained weight inspection.

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4/ Verification of the enriched macaroni product shall be with the statement of ingredients on the label.

5/ If the sample average net weight is less than 8.0 ounces, the lot shall be rejected.

6/ If the sample average drained weight of the pasta and vegetables (combined) is less than 5.3 ounces, the lot shall be rejected.

C. Methods of inspection.

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

(2) Shelf life. Compliance with shelf life shall be determined by incubation for 1 month at 120SF or 6 months at 100⁰F or 36 months at 80⁰F. Contractor shall provide a certificate of conformance.

(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 pouch's volume 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 without breaking the pasta and 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 pasta 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 approximately a 45° angle and allowed to drain for 2 minutes before determining the drained weight by subtracting the sieve tare weight from the gross weight. The drained weight shall be reported to the nearest 0.1 ounce.

* (5) Nutrient content. The sample to be analyzed shall be a composite of eight filled and sealed pouches, which have been selected at random from the lot. The composited sample shall be prepared (see Note) and analyzed for fat content and salt content in accordance with the following methods of the Official Methods of Analysis of AOAC International:

<u>Test</u>	<u>Method Number</u>
Fat	960.39, 985.15
Salt	935.47

Test results shall be reported to the nearest 0.1 percent. Any result not conforming to the requirements specified in Section C of this Performance-based Contract Requirements document shall be cause for rejection of the lot.

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

Noodles in Butter Flavored Sauce, Packaged in a Flexible Pouch, Shelf Stable, PCR-N-0001, September 22, 1997 8940-01-445-9336

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SECTION C

C-1 NSN/ITEM DESCRIPTION

PCR-N-0001 NOODLES IN BUTTER FLAVORED SAUCE, PACKAGED IN A FLEXIBLE POUCH, SHELF STABLE

Each component is consumed by combat personnel under worldwide environmental extremes as part of an operational ration, which is the sole source of nutritional intake. It is essential that this item be produced in accordance with good commercial practice to attain high

standards of appearance, odor, flavor, and texture so that high levels of troop acceptance are achieved.

C-2 PERFORMANCE REQUIREMENTS

A. First article. A sample shall be subjected to first article inspection in accordance with the tests and inspections of Section E of this Performance-based Contract Requirements.

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 80⁰F.

D. Appearance.

* (1) Noodles. The cooked noodles shall be enriched, fettuccini type egg noodles and shall be approximately 4.0 inches in length. The cooked noodles shall be distinct strips that readily separate. The cooked noodles shall be off white to pale yellow in color.

(2) Sauce. The sauce shall be glossy and semi transparent and shall be pale yellow in color.

(3) General. There shall be some unabsorbed free sauce.

E. Odor and flavor.

(1) General. The packaged food shall have an odor and flavor characteristic of processed noodles in butter flavored sauce.

(2) Foreign. The packaged food shall be free from foreign odors and flavors such as, but not limited to, burnt, scorched, rancid, sour, or stale.

F. Texture.

(1) Noodles. The cooked noodles shall be tender and shall not be soft, mushy or pasty.

(2) Sauce. The sauce shall be smooth and moderately thick.

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SECTION C CONTINUED

G. Weight.

(1) Net weight. The average net weight shall be not less than 5.0 ounces. No individual pouch shall contain less than 4.5 ounces.

(2) Drained weight. The average drained weight of the noodles shall be not less than 3.5 ounces. The drained weight of the noodles in an individual pouch shall be not less than 3.0 ounce

H. Palatability. The finished product shall be equal to or better than the approved first article, when applicable, or other approved model in palatability and overall appearance.

* I. Nutrient content.

(1) Fat content. The fat content shall be not greater than 8.5 percent.

(2) Salt content. The salt content shall be not greater than 1.4 percent.

C-3 MISCELLANEOUS INFORMATION

A. Ingredients and formulation. Ingredients and formulation percentages may be as follows:

(1) <u>Sauce</u>	<u>Ingredients</u>	<u>Percent by weight</u>
	Water	83.728
	Margarine	12.000
	Starch, waxy maize, modified	2.500
	Salt	1.550
	Pepper, white, ground	0.120
	Garlic powder	0.100
	Color, annatto <u>1/</u>	0.002

1/ The total color shall be (as % norbixin) shall be 15 percent.

(2) <u>Product</u>	<u>Ingredients</u>	<u>Percent by weight</u>
	Sauce	68.00
	Noodles, blanched <u>1/</u>	32.00

1/ The percent by weight of the blanched noodles was based on the weight of the noodles after blanching to 2 times the dry weight, rinsing and cooling.

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SECTION D

D-1 PACKAGING

A. Product shall be filled into pouches and the pouches shall be filled into cartons. Both shall meet the requirements of Section 3 and Figures 1 and 2 of MIL-PRF-44073. Verification testing and inspection of pouch and carton conformance to the requirements shall be by the testing and inspections of Section 4 of MIL-PRF-44073 and the Quality Assurance Provisions of Section E of this Performance-based Contract Requirements.

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 or ingredients. To avoid erroneous marking of pouches, the product name, lot number and filling equipment number shall be applied prior to thermal processing. All other marking may be applied before or after thermal processing.

(1) Product name (1/8 to 7/16 inch block letters) . 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)
(applicable to class 1 and 3 only)
Retort identification number
Retort cook number

1/ Shall be code marked as follows: 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, July 1, 1997 would be coded as 7182) . 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. For food products that do not require an establishment number, the Julian code shall be preceded by three capital letters, which represent the packer's name.

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/

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SECTION D CONTINUED

* USDA approval stamp for the packers plant (applicable to meat and poultry items only) . '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 or embossed on the outside of any other panel except the largest panels of the carton.

2/ Official establishment number not required in carton code.

* (2) Military nutrition information entitled "Nutrition: A FORCE MULTIPLIER" shall be printed on the large carton panel opposite to the panel with the data in 0-2,5(1). 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 CE, 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 0 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

E-6 QUALITY ASSURANCE PROVISIONS

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.

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SECTION E CONTINUED

Quality Assurance Provisions.

The following quality assurance criteria, utilizing ANSI/ASQC Z1.4-1993, Sampling Procedures and Tables for Inspection by Attributes, are recommended.

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

(1) First article inspection. The first article shall be inspected in accordance with the provisions of this Performance-based Contract Requirements 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 first article.

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

* 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 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 1. 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^oF to 190^oF water for 10 minutes prior to the drained weight inspection.

TABLE I. Product defects 1/ 2/3/

Category		Defect
<u>Major</u>	<u>Minor</u>	
		<u>Appearance</u>
101		Cooked noodles not distinct strips that readily separate
102		Color of cooked noodles not off white to pale yellow
	201	Color of sauce not glossy semi transparent or not Pale yellow
	202	Lack of unabsorbed free sauce
		<u>Odor and flavor</u>
103		Odor or flavor not characteristic of processed noodles in butter flavored sauce
		<u>Texture</u>

203	Noodles not tender or are soft, mushy or pasty
204	Sauce not smooth or not moderately thick

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SECTION E CONTINUED

TABLE I. Product defects 1/ 2/3/ (cont'd)

Category		Defect
<u>Major</u>	<u>Minor</u>	<u>Weight</u>
	205	Net weight of an individual pouch less than 4.5 ounces <u>4/</u>
	206	Drained weight of noodles in an individual pouch less than 3.0 ounces <u>5/</u>

1/ Presence of any foreign odors and 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 first article, when applicable, or other approved model in palatability and overall appearance shall be cause for rejection of the lot.

3/ Type and size requirements for cooked noodles shall be verified by certificate of conformance.

4/ If the sample average net weight is less than 5.0 ounces, the lot shall be rejected.

5/ If the sample average drained weight of noodles is less than 3.5 ounces, the lot shall be rejected.

C. Methods of inspection.

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

* (2) Shelf life. The contractor shall provide a certificate of conformance that the product has a 3 year shelf life when stored at 80⁰F. Government verification may include storage for 6 months at 100⁰F or 36 months at 80⁰F. 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 unit on a suitable scale tared with a representative empty pouch. Results shall be reported to the nearest 0.1 ounce.

(4) Drained weight. The contents of the pouch shall be poured into a flat-bottom container. A minimum of three times the volume of the pouch of 180⁰F to 190⁰F 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 noodles. 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 noodles. 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 approximately a 45⁰ angle and allowed to drain for 2 minutes before

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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) Nutrient content. The sample to be analyzed shall be a composite of eight filled and sealed pouches which have been selected at random from the lot. The composited sample shall be prepared and analyzed for fat content and salt content in accordance with the following methods of the Official Methods of Analysis of AOAC International:

<u>Test</u>	<u>Method Number</u>
Fat	960.39, 985.15
Salt	935.47

Make following changes:

In Section D, D-2 Labeling, B Cartons: Delete Footnote 1 entirely and insert:

“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.”

Potatoes, Mashed, Packaged in a Flexible Pouch, Shelf Stable, PCR-P-011, September 30,1999 8920-01-479-1749

Make following changes:

Section C-2, I., make the following changes:

Subpara (1), lines 2-3, delete entirely;

Renumber subparas “(2), (3) and (4)” to “(1), (2) and (3)”

Section E-6, C., (3), make the following changes:

line 4, delete “protein content”;

line 9, under Test, delete “Protein”; under Method Number, delete “988.05, 992.15”

In Section D, D-2 Labeling, B Cartons: Delete Footnote 1 entirely and insert:

“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.”

Rice, Mexican, Type II, 8940-01-400-0517; Rice, Yellow and Wild Rice Pilaf, Type III, Packaged in a Flexible Pouch, Shelf Stable, 8940-01 -467-2507; PCR-R-001, October 1,1998

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SECTION C CONTINUED

*TABLE I. Nutrient content 1/

	Moisture		Fat	Salt
	NGT	NLT	NGT	NGT
Type I	70.0%	60.0%	8.5%	1.5%
Type II	68.0%	62.0%	3.5%	1.5%
Type III	76.0%	70.0%	4.0%	1.5%

1/ NGT not greater than NLT = not less than

C-3 MISCELLANEOUS INFORMATION

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

A. Ingredients and formulation. Ingredients and formulation percentages may be as follows:

(1) Type I- white rice Percent by weight

Ingredients

Rice, enriched, parboiled, long grain,	52.8
Blanched	35.2
Water	10.5
Margarine	1.2
Salt	0.3
Lecithin	

(2) Type II - Mexican rice

Ingredients Percent by weight

Rice, enriched, parboiled, long grain,	
Blanched	67.85
Broth/stock, chicken, canned, frozen or dehydrated (16 percent solids)	11.86
Water	7.91
Corn	4.50
Oil, vegetable	2.55
Chili powder	1.20

Olives, ripe, pitted, sliced, canned	0.90
Onions, chopped, dehydrated	0.90
Peppers, red, sweet, dehydrated	0.90
Salt	0.80
Lecithin	0.25
Parsley	0.15
Pepper, white, ground	0.07
Garlic powder	0.07
Pepper, jalapeno, powder	0.05
Pepper, red, ground	0.04

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(3) Type III-yellow and wild rice pilaf

Ingredients - rice (enriched, parboiled, long grain) water, wild rice, carrots, seasoning mix (shall contain turmeric), peas, mushrooms pieces, and corn oil.

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SECTION E CONTINUED

2/ Finished product not equal to or better than the approved first article, when applicable, or other approved model in palatability and overall appearance shall be cause for rejection of the lot.

3/ Enriched, parboiled, long grain rice shall be verified with the statement of ingredients on the label.

4/ For type II product, the combined weight of the corn, olives, and red peppers of not greater than 0.5 ounce in an individual pouch shall be verified with a certificate of conformance based on the producer's formulation.

5/ For type III product, wild rice of not less than 1.0 ounce in an individual pouch shall be verified with a certificate of conformance based on the producer's formulation.

6/ For type III product, the combined weight of the carrots, peas, and mushrooms of not greater than 0.5 ounce in an individual pouch shall be verified with a certificate of conformance, based on the producer's formulation.

7/ If the sample average net weight is less than 5.0 ounces, the lot shall be rejected.

C. Methods of inspection.

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

* (2) Shelf life. The contractor shall provide a certificate of conformance that the product has a 3 year shelf life when stored at

80⁰F. Government verification may include storage for 6 months at 100⁰F or 36 months at 80⁰F 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) Nutrient content. The sample to be analyzed shall be a composite of eight filled and sealed pouches which have been selected at random from the lot. The composited sample shall be prepared (see NOTE) and analyzed for moisture content, protein content, fat content, and salt content in accordance with the following methods of the Official Methods of Analysis of AOAC International:

<u>Test</u>	<u>Method Number</u>
Moisture	925.459
Protein	988.05, 992.15
Fat	960.39, 985.15
Salt	935.47

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SECTION E CONTINUED

Test results shall be reported to the nearest 0.1 percent. Any result not conforming to the requirements specified in Section C of this Performance-based Contract Requirements document shall be cause for rejection of the lot.

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

D-1 PACKAGING

As provided in applicable PCR:

A. Product shall be filled into pouches and the pouches shall be filled into cartons. Both shall meet the requirements of Section 3 and Figures 1 and 2 of MIL-PRF-44073F. Verification testing and inspection of pouch and carton conformance to the requirements shall be by the testing and inspections of Section 4 of MIL-PRF-44073F and the Quality Assurance Provisions of Section E of applicable Performance-based Contract Requirements (PCRs).

D-2 LABELING

As provided in applicable PCR:

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 or ingredients. To avoid erroneous marking of pouches, the product

name, lot number and filling equipment number shall be applied prior to thermal processing. All other marking may be applied before or after thermal processing.

(1) Product name (1/8 to 7/16 inch block letters). 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) (applicable to class 1 and 3 only)
Retort identification number
Retort cook number 2/

1/ Shall be code marked as follows: 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, July 1, 1997 would be coded as 7182). 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. For food products that do not require an establishment number, the Julian code shall be preceded by three capital letters, which represent the packer's name.

2/ Required only when product is retorted.

In addition, the manufacturer (processor of packaged item) shall certify that the thermostabilized pouches have been printed, or stamped, with permanent ink which is free of carcinogenic elements or ingredients by furnishing a Certificate of Conformance (CoC) worded as follows:

"I hereby certify that (Contractor's name) has labeled all thermostabilized pouches produced under contract number DLA _____, with permanent ink that has been declared free of carcinogenic elements or ingredients."

Date of execution:

Signature:

Title:

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 approval stamp for the packers plant (applicable to meat and poultry items only).

'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 or embossed on the outside of any other panel except the largest panels of the carton.

2/ Official establishment number not required in carton code.

(2) Military nutrition information shall be printed on the large carton panel opposite to the panel printed with the data in 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 as follows:

- (a) On entree cartons - Information entitled 'Military Rations Are Good Performance Meals', etc.
- (b) On non-entree cartons - Information entitled Nutrition: A FORCE MULTIPLIER', etc.

NOTE: Cartons containing samples to be submitted to US Army Natick Research, Development and Engineering Center for First Article/Product Demonstration Model evaluation may carry all required carton labeling information on white, self adhesive labels.

D-3 PACKING

As provided in applicable PCR:

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

As provided in applicable PCR:

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 PROVISIONS

SECTION E INSPECTION AND ACCEPTANCE PROVISIONS CONTAINED IN THIS TECHNICAL DATA PACKAGE APPLY TO BOTH ENTREE AND COMPONENT ITEMS.

SEE ALSO INDIVIDUAL COMPONENT QUALITY ASSURANCE PROVISIONS AND APPLICABLE TABLE OF PRODUCT DEFECTS CONTAINED IN PCR FOR EACH ITEM. ALL PCR SECTION E INSPECTION AND ACCEPTANCE PROVISIONS APPLY.

SECTION J REFERENCE DOCUMENTS

SEE SECTION J DOCUMENTS LISTED FOR ASSEMBLED MRE AND CFM COMPLEMENTARY ITEMS.