

SECTION CC-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 80°F.

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.

SECTION C CONTINUEDF. 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.

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 diglycerides, salt, baking powder, potassium sorbate, sodium stearoyl lactylate, calcium sulfate, sodium sulfite), water, black beans, rice, soybean oil, modified food starch, green peppers, onions, and spices.

SECTION DD-1 PACKAGING

A. Product shall be filled into pouches and the pouches shall be placed 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, March 19, 1995 would be coded as 5078). 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.

SECTION D CONTINUEDB. 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 (class 1, 2, and 3 - mandatory; class 4 - not applicable).
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 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 panel except the largest panels of the carton.

2/ Official establishment number not required in carton code.

(2) Military nutrition information entitled "Military Rations Are Good Performance Meals" shall be printed on the large carton panel opposite to the panel printed with the data in D-2,B.(1). The information, provided by the contracting officer, shall be clearly printed with permanent black ink in an area not smaller than 4-1/4 inches by 6-3/4 inches.

D-3 PACKING

A. Packing for shipment to ration assembler. Seventy-two pouches (of the same product) in cartons shall be packed flat or on edge in a snug-fitting fiberboard shipping container conforming to style RSC, type CF, class domestic, grade 200 of ASTM D 5118, Standard Practice for Fabrication of Fiberboard Shipping Boxes. Each container shall be securely closed in accordance with ASTM D 1974, Standard Practice for Methods of Closing, Sealing, and Reinforcing Fiberboard Shipping Containers.

D-4 MARKING

A. Shipping containers. Shipping containers shall be marked in accordance with DPSC Form 3556, Marking Instructions for Shipping Cases, Sacks and Palletized/Containerized Loads of Perishable and Semiperishable Subsistence.

SECTION E INSPECTION AND ACCEPTANCEE-6 QUALITY ASSURANCE PROVISIONSDefinitions.

(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 140°F to 190°F water for 10 minutes prior to the drained weight inspection.

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* 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
	203	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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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 80°F. Government verification may include storage for 6 months at 100°F or 36 months at 80°F. Upon completion of either storage period, the product will be subjected to a sensory evaluation panel for appearance and palatability and must receive an overall score of 5 or higher based on a 9 point hedonic scale to be considered acceptable.

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

(4) 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.

SECTION J REFERENCE DOCUMENTS

DPSC FORM

DPSC FORM 3556 Marking Instructions for Shipping Cases, Sacks and Palletized/Containerized Loads of Perishable and Semiperishable Subsistence, May 96

FEDERAL STANDARD

FED-STD-595 - Colors Used in Government Procurement

MILITARY SPECIFICATION

MIL-PRF-44073 - Packaging of Food in Flexible Pouches

NON-GOVERNMENTAL STANDARDS

AMERICAN SOCIETY FOR QUALITY CONTROL (ASQC)

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

AMERICAN SOCIETY FOR TESTING AND MATERIALS (ASTM)

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

D 3985 - Oxygen Gas Transmission Rate Through Plastic Film and Sheeting Using a Coulometric Sensor

D 5118 - Standard Practice for Fabrication of Fiberboard Shipping Boxes

F 372 - Standard Test Method for Water Vapor Transmission of Flexible Barrier Materials Using an Infrared Detection Technique

AOAC INTERNATIONAL

Official Methods of Analysis of the AOAC International

AMSSB-RCF-FN (Valvano/4259)

8 April 2002

TO: DSCP-HRAA (LeCollier/3625)

Subject: (ES02-105) Technical Inquiry; Various MRE Documents (listing below); Clarify Carton labeling information

Ref: Quality Summit Mar 13, 2002, Industry One on One Sessions.

1. Based on discussions at referenced meeting, the U.S. Army Soldier and Biological Chemical Command, Soldier Systems Center (SBCCOM) has decided to clarify the carton labeling information since the requirement as written has been misinterpreted.

2. SBCCOM requests that DSCP implement the following change to the listed subject documents for all current, pending and future procurements until the documents are formally amended or revised:

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."

3. The affected MRE entrée related documents are as follows:

Clam Chowder, New England style, Pouch	PCR-C-045	25 Oct 01
Pork Rib, Boneless, Imitation, Pouch	PCR-P-028	25 Oct 01
Fruits, Wet Pack, Pouch	PCR-F-002A	24 Oct 01
Vegetable Manicotti, Pouch	PCR-V-002	24 Oct 01
Beef Roast w/Vegetables, Pouch	PCR-B-035	24 Oct 01
Chili and Macaroni, Pouch	PCR-C-027	15 Nov 00
Beef Stew, Pouch	PCR-B-020	15 Nov 00
Beef Ravioli in Meat Sauce, Pouch	PCR-B-021	15 Nov 00
Beef w/Mushrooms in Sauce, Pouch	PCR-B-022	15 Nov 00
Beef Patty, Grilled, Pouch	PCR-B-029	15 Nov 00
Beefsteak, Grilled w/Mushroom Gravy, Pouch	PCR-B-030	15 Nov 00
Pork Chop, Jamaican, Pouch	PCR-P-012	15 Nov 00
Seafood Tortellini, Pouch	PCR-S-011	15 Nov 00
Turkey Breast, in Gravy w/Potatoes, Pouch	PCR-T-004	15 Nov 00
Country Captain Chicken, Pouch	PCR-C-019A	31 Jul 00
Jambalaya w/Ham & shrimp, Pouch	PCR-J-001	30 Sep 99
Beef Enchilada in Sauce, Pouch	PCR-B-010(1)	30 Sep 99
Potatoes, Mashed, Pouch	PCR-P-011	30 Sep 99
Black Bean and Rice Burrito, Pouch	PCR-B-0002	17 Dec 97
Spaghetti w/Meat Sauce, Pouch	PCR-S-0002	5 Nov 97
Pork Chow Mein, Pouch	PCR-P-0002	5 Nov 97
Chicken and Rice, Pouch	PCR-C-0005	5 Nov 97
Chicken Stew, Pouch	PCR-C-0006	5 Nov 97
Beef Frankfurters, Pouch	PCR-B-0003	5 Nov 97
Pasta w/Vegetables in Cheese Sauce, Pouch	PCR-P-0001	22 Sep 97
Noodles, Buttered, Pouch	PCR-N-0001	22 Sep 97
Meatloaf w/Gravy, Pouch	PCR-M-0001	22 Sep 97
Chicken Breast w/Salsa, Pouch	PCR-C-0002	22 Sep 97
Chicken Breast in Thai Sauce, Pouch	PCR-C-0003	22 Sep 97

Beef in Teriyaki Sauce w/Vegetables, Pouch PCR-B-0001 22 Sep 97
Apple Slices in Spice Sauce, Pouch PCR-A-0001 4 Apr 97

4. Several MRE related component documents, i.e. breads, cakes, cookies, do not require a carton.

5. Several MRE entrée related documents from the Oct 1998 time frame did not contain the specific labeling of pouches and cartons inclusively. They referenced MIL-PRF-44073 in the Section D requirements.

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6. Therefore, SBCCOM requests that DSCP implement the following change to the Quality Assurance Provisions and Packaging Requirements for MIL-PRF-44073E Packaging of Foods in Flexible Pouches for all current and pending procurements until the document is formally amended or revised:

In III, A, 1 Labeling and marking, 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."

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