

SECTION C

This document covers thermostabilized spaghetti pizza bake packaged in a polymeric tray for use by the Department of Defense as a component of operational rations.

C-1 ITEM DESCRIPTION

PCR-S-015, SPAGHETTI PIZZA BAKE, PACKAGED IN A POLYMERIC TRAY, SHELF STABLE

C-2 PERFORMANCE REQUIREMENTS

A. Product standard. A sample shall be subjected to first article (FA) or product demonstration model (PDM) inspection as applicable, in accordance with the tests and inspections of Section E of this Performance-based Contract Requirements (PCR) document. The approved sample shall serve as the product standard. Should the contractor at any time plan to, or actually produce the product using different raw material or process methodologies from the approved Product Standard, which result in a product non comparable to the Product Standard, the contractor shall arrange for a new or alternate FA or PDM approval. In any event, all product produced must meet all requirements of this document including Product Standard comparability.

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

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

D. Appearance.

(1) General. The finished product shall be spaghetti pizza bake. The finished product shall be free from foreign materials.

(2) Spaghetti. The product shall be 2 inch pieces of spaghetti pasta in a casserole form.

(3) Sauce with pepperoni. The product shall be Italian seasoned tomato and cheese sauce mixed with diced pepperoni. There shall be no free-flowing sauce in this product.

(4) Pepperoni. The pepperoni shall be diced chunks of pepperoni sausage typically produced from 3/8 inch to 1/2 inch dicer settings. The pepperoni shall be dark reddish brown color, typical of cooked pepperoni.

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E. Odor and flavor. The packaged food shall have an odor and flavor of cooked pepperoni pizza and pasta. The packaged food shall be free from foreign odors and flavors.

F. Texture.

(1) Spaghetti. The spaghetti shall be slightly firm and tender; and shall not be pasty. The cheese, tomato sauce and egg mixture holding the pasta together shall be thick and slightly stringy like pizza cheese.

(2) Sauce. The sauce shall be thick, with specks of Italian spices and may have strands of mozzarella cheese.

(3) Pepperoni. The pepperoni shall be tender and slightly chewy.

G. Net Weight. The average net weight shall be not less than 90 ounces. No individual polymeric tray shall have a net weight of less than 88 ounces.

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

I. Analytical requirements.

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

(2) Salt content. The salt content shall be not less than 0.7 and not greater than 1.7 percent.

(3) Protein content. The protein content shall be not less than 8.0 percent .

C-3 MISCELLANEOUS INFORMATION

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

A. Ingredients/formulation. Ingredients and formulation percentages for the pasta and pepperoni may be as follows:

<u>Ingredients</u>	<u>Percent by weight</u>
Pasta, spaghetti, 2 percent egg white, 2 inch pieces <u>1</u> / ₂	22.00
Pepperoni, diced, 3/8 inch to 1/2 inch pieces	6.06

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1/ A. Zerega's Sons, Inc. spaghetti pasta, 2 percent egg white, 2 inch pieces were used in the development of this product.

B. Ingredients/formulation. Ingredients and formulation percentages for the sauce may be as follows:

<u>Ingredients</u>	<u>Percent by weight</u>
Sauce, tomato basil <u>2/</u>	46.99
Mozzarella, whole milk, shredded	27.52
Water	14.87
Egg, whole, liquid	7.71
Salt <u>3/</u>	1.32
Milk, non-fat dry powder	0.63
Sugar, white, granulated	0.29
Oregano, dried, leaves	0.26
Basil, dried, leaves	0.24
Garlic powder	0.17

2/ Victoria's Tomato Basil Pasta Sauce was used in the development of this product.

3/ The total amount of salt in the sauce formula may be adjusted as necessary to produce a product that complies with the finished product salt requirements.

NOTES: Pasta, pepperoni and sauce percentages are given as part of the whole. Sauce ingredient percentages are given as part of the total of sauce. Weight of pasta is given as blanched weight-divide by two for dry weight.

C. Product preparation. Percentages for product preparation may be as follows:

<u>Ingredients</u>	<u>Percent by weight</u>
Sauce	71.94
Pasta, spaghetti	22.00
Pepperoni	6.06

(1) The pasta should be blanched to a weight of twice its dry weight.

(2) All sauce ingredients should be mixed together.

(3) The sauce is mixed with the blanched, drained pasta.

(4) The cheese and pepperoni should be tossed with the blanched pasta and sauce.

SECTION D

D-1 PACKAGING

A. Preservation. Product shall be filled into polymeric trays and the trays with protective sleeves shall conform to the requirements of section 3 of MIL-PRF-32004, Packaging of Food in Polymeric Trays. Verification testing and inspection of trays, lids and sleeves shall be in accordance with Section 4 of MIL-PRF-32004 and the Quality Assurance Provisions of Section E of this Performance-based Contract Requirements document.

B. Polymeric tray closure. The filled, sealed, and processed tray shall be securely closed.

D-2 LABELING

A. Polymeric tray body. The polymeric tray body shall be clearly printed or stamped, in a manner that does not damage the tray, with permanent ink of any contrasting color, which is free of carcinogenic elements. One end of the polymeric tray (see figure 1 of MIL-PRF-32004) shall be marked with the product name and number of portions. If the tray body end markings are not readily legible in low light conditions, a small, easily legible label shall be applied, but not over any existing tray markings. All other markings may be applied along the tray body side. To avoid erroneous marking of trays, the product name, lot number and filling equipment number shall be applied prior to processing. Additional tray marking may be applied before or after processing. 1/

Tray body markings shall include:

(1) Product name. Commonly used abbreviations may be used when authorized by the inspection agency.

(2) Tray code includes: 2/
Lot Number
Filling equipment identification number
Retort identification number
Retort cook number

1/ As an alternate method, tray body markings may be clearly printed or stamped onto the polymeric tray lid prior to processing, in a manner that does not damage the lid, with permanent ink of any contrasting color, which is free of carcinogenic elements, provided that the required markings are applied onto the tray body after processing.

2/ 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,

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25 March 2004 would be coded as 4085). The Julian code shall represent the day the product was packaged into the tray and processed. Sublotting (when used) shall be represented by an alpha character immediately following the four digit Julian code. Following the four digit Julian code and the alpha character (when used), the other required code information shall be printed in the sequence as listed above.

B. Polymeric tray lid. The lid shall be clearly printed or stamped, in a manner that does not cause damage. Permanent ink of any contrasting color, which is free of carcinogenic elements, shall be used. As an alternate labeling method, a pre-printed self-adhering 0.002 inch thick clear polyester label printed with indelible contrasting color ink may be used.

(1) Lid labeling shall include:

Product name [Spaghetti "Pizza Bake" (Spaghetti with Tomato Sauce and Pepperoni)] followed by "For use as Military Rations only"

Ingredients

Net weight

Name and address of packer

Official establishment number (for example, EST 38) or a three letter code identifying the establishment

(2) Lid labeling shall also show the following statements:

TO HEAT IN WATER: Submerge unopened tray in water. Bring water to a boil  immerse gently 40-45 minutes. Avoid overheating (tray shows evidence of bulging).

WARNING: Do not heat tray in oven.

TO TRANSPORT AFTER HEATING: Insert tray back into protective sleeve to protect during transport. If sleeve is unavailable, stack trays lid-to-lid with fiberboard pads in between.

CAUTION: Use care when opening as pressure may have been generated within the tray.

TO OPEN: Using a clean knife, cut the lidding around the inside perimeter of the tray seals.

SUGGESTION: Cut lid along 3 sides and fold over uncut portion. Fold back to keep unused portions protected.

YIELD: Serves 9 portions of spaghetti pizza bake, approximately 1 ¼ cups per serving. Product should be mixed in tray before serving.

D-3 PACKING

A. Packing for shipment to ration assembler. Four filled, sealed, processed and sleeved polymeric trays shall be packed in a snug fitting fiberboard box conforming to style RSC-L, type CF, grade 275 of ASTM D5118/D5118M-95 (2001), Standard Practice for Fabrication of Fiberboard Shipping Boxes. The sleeved trays shall be placed flat with the first two trays placed with the lids together and the next two trays with the lids together. The box shall be closed in accordance with ASTM D1974-98, Standard Practice for Methods of Closing, Sealing, and Reinforcing Fiberboard Boxes.

D-4 UNITIZATION

A. Unit loads. Unit loads shall be as specified in DSCP FORM 3507, Loads, Unit: Preparation of Semiperishable Subsistence Items.

D-5 MARKING

A. Shipping containers and unit loads. Marking of shipping containers and unit loads shall be as specified in DSCP FORM 3556 Marking Instructions for Boxes, Sacks and Unit Loads of Perishable and Semiperishable Subsistence.

SECTION E INSPECTION AND ACCEPTANCE

The following quality assurance criteria, utilizing ANSI/ASQC Z1.4-1993, Sampling Procedures and Tables for Inspection by Attributes, are required. Unless otherwise specified, Single Sampling Plans indicated in ANSI/ASQC Z1.4-1993 will be utilized. When required, the manufacturer shall provide the certificate(s) of conformance to the appropriate inspection activity. Certificate(s) of conformance not provided shall be cause for rejection of the lot.

A. Definitions.

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

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

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

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

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

US Army Research, Development and Engineering Command
Natick Soldier Center
AMSRD-NSC-CF-F
15 Kansas Street
Natick, MA 01760-5018

One lot shall be randomly selected during each calendar month of production. Two (2) sample units of each item produced shall be randomly selected from that one production lot. The two (2) sample units shall be shipped to Natick within five working days from the end of the production month and upon completion of all USDA inspection requirements. The sample units will be evaluated for the characteristics of appearance, odor, flavor, texture and overall quality.

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

E-5 QUALITY ASSURANCE PROVISIONS (PRODUCT)

A. Product examination. The finished product shall be examined for compliance with the performance requirements specified in Section C of 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 trays. The sample unit shall be the contents of one tray. The inspection level shall be S-3 and the acceptable quality level (AQL), expressed in terms of defects per hundred units, shall be 4.0 for major defects and 6.5 for minor defects. Defects and defect classifications are listed in table I below. The trays shall be heated in accordance with the heating instructions from the tray label prior to conducting any portion of the product examination.

TABLE I. Product defects 1/ 2/ 3/

Category	Defect
<u>Major</u>	<u>Minor</u>
	<u>Appearance</u>
101	Product not spaghetti pizza bake.
	201 Sauce not Italian seasoned tomato and cheese sauce mixed with pepperoni.
	202 Excess free-flowing sauce in product.
	203 Pepperoni sausage not diced chunks <u>3/</u> .
	204 Pepperoni sausage not dark reddish brown color.
	<u>Odor and flavor</u>
102	The packaged food does not have an odor or flavor of cooked pepperoni pizza and pasta.
	<u>Texture</u>
	205 Spaghetti not slightly firm or not tender.
	206 Spaghetti is pasty.
	207 Sauce not thick with specks of Italian spices.
	208 Sauce mixture (cheese, tomato and egg) not holding the pasta together.
	209 Sauce mixture (cheese, tomato and egg) not slightly thick or not slightly stringy.
	210 Pepperoni not tender or not slightly chewy.
	<u>Net weight</u>
	211 Net weight of an individual polymeric tray is less than 88 ounces. <u>4/</u>

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1/ Presence of any foreign materials such as, but not limited to dirt, insect parts, hair, wood, glass, metal, or mold, or any foreign odors or flavors such as, but not limited to burnt, scorched, rancid, sour, or stale shall be cause for rejection of the lot.

2/ Finished product not equal to or better than the approved product standard in palatability and overall appearance shall be cause for rejection of the lot.

3/ Size requirements for spaghetti and pepperoni dices shall be verified by certificate of conformance.

4/ Sample average net weight less than 90 ounces shall be cause for rejection of the lot.

B. Methods of inspection.

(1) Commercial sterility. Commercial sterility shall be verified in accordance with USDA/FSIS regulations.

(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 polymeric tray shall be determined by weighing each sample unit on a suitable scale tared with a representative empty tray and lid. Results shall be reported to the nearest 1 ounce.

(4) Analytical. The sample to be analyzed shall be a one-pound composite of three filled and sealed polymeric trays that have been selected at random from one production lot. The composite sample shall be prepared and analyzed in accordance with the following Official Methods of Analysis of AOAC International (OMA).

<u>Test</u>	<u>Method Number</u>
Fat	985.15 or 925.12
Salt	935.47
Protein	984.13 or 922.15

Test results shall be reported to the nearest 0.1 percent. Verification will be conducted through actual testing by a Government laboratory. Any result not conforming to the analytical requirements shall be cause for rejection of the lot.

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

A. Packaging and labeling.

(1) Polymeric tray testing. For purposes of clarification, the polymeric tray without the lid will be referred to as the “tray” and the polymeric tray with the lid shall be referred to as the “container”. The polymeric tray with protective sleeve and polymeric tray material shall be examined for the characteristics listed in table I of MIL-PRF-32004, Packaging of Food in Polymeric Trays. The lot size, sample unit, and inspection level criteria are provided in table II below for each of the test characteristics. Any test failure shall be classified as a major defect and shall be cause for rejection of the lot. For rough handling survivability at frozen temperature, polymeric tray survival rate shall be at least 85 percent.

TABLE II. Polymeric tray quality assurance criteria

Characteristic	<u>Prior to processing</u>		
	Lot size expressed in	Sample unit	Inspection level
Tray configurations and dimensions	Trays	1 tray	S-1
Oxygen gas transmission rate of tray	Trays	1 tray	S-1
Oxygen gas transmission rate of lid	Yards	1/2 yard	S-1
Water vapor transmission rate of tray	Trays	1 tray	S-1
Water vapor transmission rate of lid	Yards	1/2 yard	S-1
Camouflage	Containers	1 container	S-1

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Characteristic	<u>After processing</u>		
	Lot size expressed in	Sample unit	Inspection level
Processing	Trays	1 tray	S-2
Rough handling survivability	Test containers	1 container	S-2
Protective sleeve	Containers	1 container	S-1
Residual gas	Containers	1 container	S-1
Closure seal	Containers	1 container	S-1
Internal pressure	Containers	1 container	S-1
Lid opening	Containers	1 container	S-1

(2) Examination of container. The container with protective sleeve removed shall be examined for the defects listed in table II of MIL-PRF-32004 and the labeling defects listed in table III below. The lot size shall be expressed in containers. The sample unit shall be one processed and labeled container. The inspection level shall be I and the AQL, expressed in terms of defects per hundred units, shall be 0.65 for major A defects, 2.5 for major B defects and 4.0 for minor defects. Two hundred sample units shall be examined for critical defects. The finding of any critical defect shall be cause for rejection of the lot.

TABLE III. Container labeling defects

Category		Defect
<u>Major A</u>	<u>Minor</u>	
101		Polymeric tray lid or body labeling missing, incorrect or illegible.
	201	When a pre-printed self adhering label is used, the label not adhering to tray lid (for example, label raised or peeled back from edge to corner) or presence of any areas of gaps along the perimeter of the label where the label is not properly adhered.

(3) Label adhesive examination. When self-adhering labels are used, the adhesive shall be tested in accordance with ASTM D3330/D3330M-00. In lieu of testing, a certificate of conformance (COC) shall be provided.

B. Packing.

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

TABLE IV. Shipping container and marking defects

Category		Defect
<u>Major</u>	<u>Minor</u>	
101		Marking omitted, incorrect, illegible, or improper size, location sequence or method of application.
102		Inadequate workmanship. <u>1/</u>
	201	Arrangement or number of polymeric trays not as specified.

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

C. Unitization.

(1) Unit load examination. The unit load shall be examined in accordance with the requirements of DSCP FORM 3507, Loads, Unit: Preparation of Semiperishable Subsistence Items. Any nonconformance shall be classified as a major defect.

SECTION J REFERENCE DOCUMENTS

DSCP FORMS

DSCP FORM 3507	Loads, Unit: Preparation of Semiperishable Subsistence Items
DSCP FORM 3556	Marking Instructions for Boxes, Sacks and Unit Loads of Perishable and Semiperishable Subsistence

MILITARY SPECIFICATIONS

MIL-PRF-32004	Packaging of Food in Polymeric Trays
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GOVERNMENT PUBLICATIONS

Federal Food, Drug, and Cosmetic Act and regulations promulgated thereunder
(21 CFR Parts 1 - 199) and (9 CFR Parts 1 - 391)
NON-GOVERNMENTAL STANDARDS

AMERICAN SOCIETY FOR QUALITY (ASQ)

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

ASTM INTERNATIONAL

D1974-98 Standard Practice for Methods of Closing,
Sealing, and Reinforcing Fiberboard Boxes
D3330/D3330M-00 Standard Test Method for Peel Adhesion of
Pressure-Sensitive Tape
D5118/D5118M-95 (2001) Standard Practice for Fabrication of Fiberboard
Shipping Boxes

AOAC INTERNATIONAL

Official Methods of Analysis of the AOAC International (OMA)

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TO: DSCP-HRUT (Charya/3832)

SUBJECT: ES04-100; Document Change; PCR-S-015 Spaghetti Pizza Bake, Packaged in a Polymeric Tray; The Wornick Company; USDA approved a new product name and a qualifier on label

Date received: 25 August 2004

Date due: ASAP

Date replied: 1 September 2004

1. The Wornick Company contacted Natick and requested a name change to the subject item since USDA would not approve the current name or spaghetti casserole as presented. Their First Articles were approved and needed a new label in order to go into production.

2. The following change is highlighted in the attached file.

Sec D-2, B (1): After "Product name" insert "[Spaghetti "Pizza Bake" (Spaghetti with Tomato Sauce and Pepperoni)] followed by "For use as Military Rations only"

3. Natick recommends that DSCP implement the change with a contract modification for the current, pending and future procurements until the subject document is formally amended or revised.

4. The POC for this action is Jennifer Toschik.

1 Encl

DONALD A. HAMLIN
Team Leader
DoD Food Engineering
Services Team
R Valvano

CF: NSC:
B Trottier
S Harrington
J Toschik

CF: DSCP & SVCs:
G Miller C Henry
S Tucker M Malason
F Bankoff R Byrd

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M Friel	L Dyduck
D Hamlin	E Haldeman
<u>C Norton</u>	<u>L Salerno</u>
M Acheson	B Spencer
R Valvano	
A Richards	