

## SECTION C

This document covers thermostabilized eggs with turkey sausage and potatoes, packaged in a tray pack can for use by the Department of Defense as a component of operational rations.

### C-1 ITEM DESCRIPTION

PCR-E-010, EGGS WITH TURKEY SAUSAGE AND POTATOES, PACKAGED IN A TRAY PACK CAN, SHELF STABLE

### C-2 PERFORMANCE REQUIREMENTS

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

B. Commercial sterility. The packaged food shall be processed until commercially sterile. Thermally processed product shall be free of swelling or microbial activity when tested in accordance with section E-5, B, (1) of this Performance-based Contract Requirements document.

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

D. Appearance.

(1) General. The product shall be eggs with turkey sausage and potato dices uniformly distributed throughout the product. The packaged food shall be free from foreign materials.

(2) Eggs. The color of the finished product shall be a typical yellow cooked egg color or slightly darker. The finished product shall be practically free of starch lumps, air pockets or void areas.

(3) Ground turkey sausage. The ground turkey sausage shall be of the size typically produced by a 1/2-inch plate machine setting. The ground turkey sausage shall be practically free of skin, bone or bone fragments, cartilage, coarse connective tissue, tendons or ligaments, and discolored meat. The sausage shall have a cooked ground turkey sausage color.

(4) Potatoes. The potatoes shall be dice sizes typically produced by a 3/8 by 3/8 by 3/8 or 3/4 inch dicer setting. The potato dices shall have a cooked potato color.

E. Odor and flavor. The packaged food shall have an odor and flavor of cooked eggs with turkey sausage and potatoes. The packaged food shall be free from foreign odors and flavors.

F. Texture.

(1) Egg. The egg product shall be moist, moderately soft, and shall not be rubbery.

(2) Ground turkey sausage. The ground turkey sausage shall be moist and tender.

(3) Potatoes. The potato dices shall be slightly soft to slightly firm.

G. Net weight. The average net weight shall be not less than 102 ounces. No individual tray pack can shall have a net weight of less than 100 ounces.

H. Free liquid weight. Free liquid weight in an individual tray pack can shall be not more than 3.0 ounces.

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

J. Analytical requirements.

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

(2) Fat content. The fat content shall be not greater than  5 percent.

(3) Salt content. The salt content shall be not less than 0.5 and not greater than 1.2 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 eggs and potato may be as follows:

<u>Ingredients</u>	<u>Percent by weight</u>
Liquid or frozen whole eggs	60.046
Water	19.000
Dehydrofrozen diced potatoes, blanched	8.500
Vegetable oil	8.500
Modified waxy maize pre-gelatinized instant starch	3.000
Salt <u>1/</u>	0.750
Ground white pepper	0.150
Citric acid	0.050
Dry or liquid annatto color (15% norbixen)	0.004

B. Ingredients/formulation. Ingredients and formulation percentages for the ground turkey sausage may be as follows:

<u>Ingredient</u>	<u>Percent by Weight</u>
Ground turkey	97.780
Salt <u>1/</u>	1.500
Ground white pepper	0.230
Ground sage	0.140
Ground ginger	0.140
Ground nutmeg	0.070
Ground red pepper	0.070
Ground thyme	0.070

1/ The total amount of salt in the formulas may be adjusted as necessary to produce a product that complies with the finished product salt requirement.

#### NOTES:

##### INGREDIENTS.

Dehydrofrozen diced potatoes measuring 3/8 by 3/8 by 3/4 inches supplied by J.R.Simplot Company, Boise ID were used in this product.

The starch used was instant starch product number 5717 produced by National Starch and Chemical Company, Bridgewater, NJ.

Turkey used was boneless, skinless natural proportion turkey supplied by Hallsmith-Sysco.

Preparation of the diced potatoes:

The diced potatoes should be blanched to a weight of 1.5 times that of the starting weight.

Preparation of the turkey sausage:

Grind turkey meat through 1-inch grinder plate.  
Blend with spices.  
Regrind through 1/2-inch plate.  
Blanch mixture to 85-90 percent yield and cool.

Preparation of the final product:

Frozen eggs should be tempered to a very slight frozen slushy consistency.  
The dry ingredients except the starch should be mixed with a small amount of the water and added to the eggs.  
The starch should be blended into the vegetable oil until smooth and added.  
The blanched potatoes should be added.  
The remaining water should be blended in.  
The turkey sausage should be added and mixed well.  
The product should be allowed to stand until thick enough for uniform filling.  
The finished product should consist of 70 percent egg mixture and 30 percent of ground turkey sausage.

**SECTION D**

**D-1 PACKAGING**

A. Preservation. Product shall be filled into a tray pack can conforming to MIL-C-44340, Can, Tray Pack. The practice of reconditioning tray pack cans by buffing with an abrasive substance shall not be permitted. Verification testing and inspection of tray pack can conformance to the requirements shall be by the testing and inspections of Section 4 of MIL-C-44340 and the Quality Assurance Provisions of Section E of this Performance-based Contract Requirements document.

B. Can condition. The filled, sealed, and processed tray pack can shall conform to the United States Standards for Condition of Food Containers.

C. Can closure. The filled, sealed, and processed tray pack can shall be securely closed.

D. Can vacuum. The filled, sealed, and processed tray pack can shall show evidence of vacuum.

**D-2 LABELING**

A. Tray pack can body. One side of each tray pack can body shall be clearly printed or stamped, in a manner that does not damage the tray pack can, with permanent black ink or any other contrasting color, which is free of carcinogenic elements. Paper labels are not permitted. Each tray pack can shall be labeled with the following:

- (1) Product name. Commonly used abbreviations may be used when authorized by the inspection agency.
- (2) Tray pack can code includes: 1/  
Lot Number  
Filling equipment identification number  
Retort identification number  
Retort cook number

1/ The lot number shall be expressed as a four digit Julian code. The first digit shall indicate the year of production and the next three digits shall indicate the day of the year (Example, 13 February 2002 would be coded as 2044). The Julian code shall represent the day the product was packaged into the tray pack can and processed. Sub-lotting (when used) shall be represented by an alpha character immediately following the four digit Julian code. Following the four digit Julian code and the alpha character (when used), the other required code information shall be printed in the sequence as listed above.

B. Tray pack can lid. The tray pack can lid shall be clearly printed or stamped, in a manner that does not damage the lid, with permanent black ink or any other contrasting color, which is free of carcinogenic elements. As an alternate lid labeling method, a preprinted self-adhering 0.002 inch thick clear polyester label printed with indelible black or other contrasting color ink may be used. Tray pack can labels shall show the following statements:

(1) Lid labeling shall include:

- Product name
- 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 can in water. Bring water to a boil. Simmer gently 40-45 minutes. Avoid overheating (can shows evidence of bulging).

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

YIELD: Serves 18 portions of approximately 2/3 cup each.

#### **D-3 PACKING**

A. Packing for shipment to ration assembler. Four filled, sealed, and processed cans of product, shall be packed in a snug fitting fiberboard box conforming to style RSC-L, type CF, grade 275 of ASTM D 5118, Standard Practice for Fabrication of Fiberboard Shipping Boxes. The cans shall be packed flat, with the first two cans placed with the lids together and the next two cans with the lids together. Fiberboard pads shall be placed between the cans and on the top and bottom of the stacked cans. The pad dimensions shall be not less than 1/8 inch of the full length and width inside dimensions of the box and shall be fabricated of class domestic, grade 175 fiberboard. The box shall be closed in accordance with ASTM D 1974, Standard Practice for Methods of Closing, Sealing, and Reinforcing Fiberboard Shipping Containers.

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

**SECTION E INSPECTION AND ACCEPTANCE**

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

A. Definitions.

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

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

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

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

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

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

One lot shall be randomly selected during each calendar month of production. 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 tray pack cans. The sample unit shall be the contents of one can. 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 cans shall be heated in accordance with the heating instructions from the tray pack can 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 eggs with turkey sausage and diced potatoes uniformly distributed throughout the product.
102		Bone or bone fragments measuring more than 0.3 inch in any dimension.
103		Product is not a typical yellow cooked egg color or slightly darker.
	201	Product shows visible lumps of starch.
	202	Presence of two or more air pockets or void areas measuring 1/2 inch or more in each of two separate dimensions.
	203	Presence of three or more air pockets or void areas measuring 1/4 inch or more in each of two separate dimensions.
	204	Sausage not a cooked ground turkey sausage color.
	205	Potato dices do not have a cooked potato color.
	206	Total weight of skin, cartilage, coarse connective tissue, tendons or ligaments, and discolored meat more than 1.0 ounce.
		<u>Odor and flavor</u>
104		The packaged food does not have an odor or flavor of cooked eggs with turkey sausage and potatoes.
		<u>Texture</u>
105		Egg product not moist or not moderately soft.
106		Egg product is rubbery.
	207	Turkey sausage not moist or not tender.
	208	Potato dices not slightly soft to slightly firm.
		<u>Net weight</u>
	209	Net weight of an individual tray pack can less than 100 ounces. <u>4/</u>
		<u>Free liquid weight</u>
	210	Free liquid weight in an individual tray pack can more than 3.0 ounces. <u>5/</u>

1/ Presence of any foreign material 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/ The requirement for the turkey sausage grind size and the potato dice size shall be verified by certificate of conformance.

4/ Sample average net weight less than 102 ounces shall be cause for rejection of the lot.

5/ To test for free liquid weight the can shall be opened and the lid shall be held in place. The can shall be elevated on end, so that any liquid will flow out of the opened corner, and drained for 1 minute, collecting the free liquid. The weight of the free liquid shall be reported to the nearest 0.1 ounce.

B. Methods of inspection.

(1) Commercial sterility. Incubate at  $95^{\circ}\text{F} \pm 5^{\circ}\text{F}$  for 10 days, unless otherwise specified by the inspection agency.

(2) Shelf life. The contractor shall provide a certificate of conformance that the product has a 3 year shelf life when stored at  $80^{\circ}\text{F}$ . Government verification may include storage for 6 months at  $100^{\circ}\text{F}$  or 36 months at  $80^{\circ}\text{F}$ . 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 tray pack can shall be determined by weighing each sample unit on a suitable scale tared with a representative empty tray pack can and lid. Results shall be reported to the nearest 1 ounce.

(4) Starch lumps, air pockets, and void areas. From each sample can of product, remove one 3-inch wide center slice (sliced lengthwise of the can). Place center slice on edge and cut in half lengthwise. Inspect right inside surface for air pockets and void areas and starch lumps.

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

**E-6 QUALITY ASSURANCE PROVISIONS (PACKAGING AND PACKING MATERIALS, TRAY PACK CAN)**

A. Packaging.

(1) Can condition examination. Examination of filled and sealed tray pack cans shall be in accordance with the United States Standards for Condition of Food Containers. In addition, scratches, scuffs or abrasions that occur on the outside coating as a result of the filling, sealing, and processing of the tray pack cans shall not be scored as a defect.

(2) Can closure examination. Can closures shall be examined visually and by teardowns in accordance with the can manufacturer's requirement and 21 CFR, Part 113, Subpart D, or 9 CFR, Part 318, Subpart G, as applicable. Any nonconformance based on observation of can seam teardowns or on record of can seam teardowns shall be classified as a major defect and shall be cause for rejection of any involved product.

(3) Vacuum examination. Cans shall be allowed to cool to 75° + 5°F, held for at least 24 hours after sealing, and then examined for vacuum retention. To examine, lay a straight edge in the center of the lid along the length of the tray pack can. Both ends of the straight edge shall touch the lid at the inside edge of the double seam. There shall be a visible gap between the straight edge and the lid for the entire distance of the label panel. Using a shorter straight edge, the same procedure shall be used across the width, in the center of the tray pack can. One measurement shall be made when examining a ribbed lid; lay the straight edge between the two center ribs along the length of the can. The inspection lot shall include only tray pack cans produced in a single shift on a single sealing machine. The sample size shall be 50 cans. Any nonconformance shall be classified as a major defect and shall be cause for rejection of the lot.

B. Labeling.

(1) Can body labeling examination. The tray pack can body shall be examined for the labeling defects listed in table II below. The lot size shall be expressed in tray pack cans. The sample unit shall be one tray pack can. Utilizing the single sampling plans indicated in ANSI/ASQC Z1.4 - 1993, the inspection level shall be I and the AQL, expressed in terms of defects per hundred units, shall be 0.65 for major defects and 4.0 for minor defects.

TABLE II. Can body labeling defects

Category		Defect
<u>Major</u>	<u>Minor</u>	
101		Tray pack can code or product name missing, incorrect, or illegible.
102		Not printed or stamped as specified.
103		Printing or stamping causes can body damage.
	201	Labeling ink not a contrasting color.

(2) Can lid labeling examination. The tray pack can shall be examined for the defects listed in table III below. The lot size shall be expressed in tray pack cans. The sample unit shall be one tray pack can. Utilizing the single sampling plans indicated in ANSI/ASQC Z1.4 - 1993, the inspection level shall be I and the AQL, expressed in terms of defects per hundred units, shall be 0.65 for major defects and 4.0 for minor defects.

TABLE III. Can lid labeling defects

Category		Defect
<u>Major</u>	<u>Minor</u>	
101		Label torn or scratched so as to obliterate any of the markings.
102		Labeling missing, incorrect or illegible.
	201	Air bubbles under label.
	202	Label not properly adhered to can (label raised or peeled back from edges or corners).

(3) Label adhesive examination. When self-adhering labels are used, the adhesive shall be tested in accordance with ASTM D 3330. In lieu of testing, a certificate of conformance (COC) shall be provided.

C. 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. Utilizing the single sampling plans indicated in ANSI/ASQC Z1.4 - 1993, 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 tray pack cans 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.

D. 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 and shall be cause for rejection of the lot.

**SECTION J REFERENCE DOCUMENTS**

DSCP FORMS

DSCP FORM 3507 Loads, Unit: Preparation of Semiperishable Subsistence Items  
DPSC FORM 3556 Marking Instructions for Shipping Cases, Sacks and Palletized/Containerized Loads of Perishable and Semiperishable Subsistence

MILITARY SPECIFICATIONS

MIL-C-44340 Can, Tray Pack

GOVERNMENT PUBLICATIONS

Federal Food, Drug, and Cosmetic Act and regulations promulgated thereunder (21 CFR Parts 1-199) and (9 CFR Parts 1-391)  
U.S. Standards for Condition of Food Containers

NON-GOVERNMENTAL STANDARDS

AMERICAN SOCIETY FOR QUALITY (ASQ)

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

AMERICAN SOCIETY FOR TESTING AND MATERIALS (ASTM)

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

Fiberboard Shipping Containers  
D 3330 Peel Adhesion of Pressure-Sensitive Tape  
D 5118 Standard Practice for Fabrication of Fiberboard Shipping Boxes

AOAC INTERNATIONAL

Official Methods of Analysis of the AOAC International (OMA)

AMSSB-RCF-F(N)(Friel/4261)

24 October 2002

TO: DSCP-HRUT (Charya/73832)

SUBJECT: (ES03-004) Request for Document Changes, Protein and Fat requirement for Eggs with Turkey Sausage, Polymeric Tray, PCR-E-011; Eggs with Turkey Sausage, Tray Pack Can, PCR-E-010; SPO300-00-D-Z207; Stenger;  
DSCP-SS-03-00335

1. Date received: 18 October 2002  
Date due: 25 October 2002  
Date replied: 24 October 2002

2. Natick Soldier Center (NSC) concurs with the Contractor's request to reduce the protein requirement and to increase the fat requirement in the subject document.

NSC discussed the issue of protein with the turkey sausage producer and was told that there would be a substantial cost savings if the product was produced with turkey thigh meat versus product made using turkey breast meat.

There will be no adverse nutritional effect on the menu.

Samples of eggs with turkey sausage produced with turkey thigh meat were submitted to Natick and evaluated as a technical review and also as a first article. This product was found to be very acceptable.

3. Natick submits the attached documents with electronic highlighted changes. Request DSCP implement changes to the subject documents for the UGR procurement until the documents are formally amended or revised.

C-2, J. (1), line 1, delete "11.0", insert "8.5"

C-2, J. (2), line 1, delete "11.0", insert "13.5"

DONALD A. HAMLIN  
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MFriel

CF: NSC:	CF: DSCP & SVCs:
Acheson	Beward
Friel	Brown
Hamlin	Byrd
Harrington	Charette
Hill	Dyduck
Konrady A.	Ferrante
Richards	Henry
Swantak	Hoffman
Trottier	Malason
Valvano	Salerno