

SECTION C

This document covers fat free mayonnaise packaged in a flexible pouch for use by the Department of Defense as a component of operational rations.

C-1 ITEM DESCRIPTION

PACKAGING REQUIREMENTS AND QUALITY ASSURANCE PROVISIONS FOR CID A-A-20140B, MAYONNAISE, SALAD DRESSING AND TARTAR SAUCE

Type and style.

Type I - Mayonnaise

Style C - Fat Free

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 the Packaging Requirements and Quality Assurance Provisions. 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. **Shelf life.** The packaged product shall meet the minimum shelf life requirement of 36 months at 80°F.

C. **General.** The product shall be fat free mayonnaise. There shall be no evidence of excessive heating (materially darkened or scorched mottling, curdling or oiling off). The packaged product shall be free from foreign materials.

D. **Appearance.** The fat free mayonnaise shall be smooth, homogenous, off white to light cream color and have a slight surface sheen.

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E. Odor and Flavor. The fat free mayonnaise shall have a slight vinegar salad dressing odor and flavor and may have egg yolk notes. The packaged product shall be free from foreign odors and flavors.

F. Texture. The fat free mayonnaise shall be smooth, creamy and moderately thick texture.

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

H. Net weight. The net weight of one serving of product shall be 1.0 ounce.

I. Analytical requirements.

(1) Salt content. The salt content shall be not less than 1.65 percent and not greater than ~~2.35~~ 2.70 percent.

(2) pH. The pH shall be not less than 3.1 and not greater than 4.1.

J. Emulsion stability. For all types specified, the emulsion stability requirements and procedures shall be in accordance with A-A-20140B.

C-3 MISCELLANEOUS INFORMATION

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

Ingredients for Type I, Style C (Fat free mayonnaise):

Water, modified food starch, sugar, distilled vinegar, high fructose corn syrup, polydextrose, salt, whey protein concentrate, cellulose gel, cellulose gum, cellulose gel/guar gum blend, egg yolk solids, xanthan gum, lactic acid, titanium dioxide, mustard flour, sodium benzoate and potassium sorbate added as a preservatives, natural flavor, dried egg whites, onion powder, garlic powder, lemon juice concentrate, calcium disodium EDTA added to protect flavor, paprika, beta carotene, yellow No. 5 and yellow No. 6.

SECTION D

D-1 PACKAGING

Comment [p1]: Natick case ES07-131 (DSCP-SS-07-50526) change 02 20 JUL 07. Section C-2, I (1) Salt content. Delete 2.35 and insert 2.70.

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A. Packaging. One ounce of product shall be filled into a preformed barrier pouch as described below.

(1) Preformed pouch.

a. Pouch material. The preformed pouches shall be fabricated from 0.002 inch thick polyolefin film laminated or extrusion coated to 0.00035 inch thick aluminum foil which is then laminated to 0.0005 inch thick polyester. The three plies shall be laminated with the polyester on the exterior of the pouch. The polyolefin layer of bag material shall be suitably formulated for hot fill or post-fill processing. Tolerances for thickness of plastic films shall be plus or minus 20 percent and tolerance for the foil layer shall be plus or minus 10 percent. The material shall show no evidence of delamination, degradation, or foreign odor when heat-sealed or fabricated into pouches. The material shall be suitably formulated for food packaging and shall not impart an odor or flavor to the product. The complete exterior surface of the pouch shall be uniformly colored in the range of 20219 through 30219 or 30279 through 30313 or 30324 through 30450 of FED-STD-595, Colors Used in Government Procurement.

b. Pouch construction. The pouch shall be a flat style preformed pouch having maximum inside dimensions of 2-7/8 inches wide by 5-3/8 inches long. The pouch shall be made by heat sealing three edges with 3/8 inch (-1/8 inch, +3/16 inch) wide seals. The heat seals shall be made in a manner that will assure hermetic seals. The side and bottom seals shall have an average seal strength of not less than 6 pounds per inch of width and no individual specimen shall have a seal strength of less than 5 pounds per inch of width when tested as specified in E-6, A,(4),a. Alternatively, the filled and sealed pouch shall exhibit no rupture or seal separation greater than 1/16 inch or seal separation that reduces the effective closure seal width to less than 1/16 inch when tested for internal pressure resistance as specified in E-6, A,(4),c. A tear nick or tear notch or serrations shall be provided on one outside edge or two opposite outside edges of the pouch to facilitate easy opening of the filled and sealed pouch. A 1/8 inch ($\pm 1/16$ inch) wide lip may be incorporated at the open end of the pouch to facilitate opening and filling of the pouch.

c. Pouch filling and sealing. One ounce of fat free mayonnaise shall be filled into the pouch and the filled pouch shall be sealed. The filled pouch shall be sealed. The closure seal shall be free of foldover wrinkles or entrapped matter that reduces the effective closure seal width to less than 1/16 inch. Seals shall be free of impression or design on the seal surface that would conceal or impair visual detection of seal defects. The average seal strength shall be not less than 6 pounds per inch of width and no individual specimen shall have a seal strength of less than 5 pounds per inch of width when tested as specified in E-6,A,(4),b. Alternatively, the filled and sealed pouch shall exhibit no rupture or seal separation

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greater than 1/16 inch or seal separation that reduces the effective closure seal width to less than 1/16 inch when tested for internal pressure resistance as specified in E-6,A,(4),c.

D-2 LABELING

A. Pouches. Each pouch shall be correctly and legibly labeled. Printing ink shall be permanent black ink or other, dark, contrasting color which is free of carcinogenic elements. The label shall contain the following information:

- (1) Name and flavor of product (letters not less than 1/8 inch high)
- (2) Ingredients
- (3) Date 1/
- (4) Net Weight
- (5) Contractor's name and address
- (6) "Nutrition Facts" label in accordance with the Nutrition Labeling and Education Act (NLEA) and all applicable FDA/USDA regulations.

1/ Each pouch shall have the date of pack noted by using a four-digit code beginning with the final digit of the current year followed by the three digit Julian day code. For example, 15 October 2004 would be coded as 4289. The Julian day code shall represent the day the product was packaged into the pouch.

D-3 PACKING

A. Packing for shipment to ration assembler. Not more than 40 pounds of pouched product shall be packed flat in layers in a fiberboard shipping container constructed in accordance with style RSC-L, class domestic, variety SW, grade 200 of ASTM D5118/D5118M-95(2001) Standard Practice for Fabrication of Fiberboard Shipping Boxes. Each container shall be securely closed in accordance with ASTM D1974-98 (2003) Standard Practice for Methods of Closing, Sealing, and Reinforcing Fiberboard Boxes.

D-4 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

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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. Six (6) sample units of each item produced shall be randomly selected from that one production lot. The six

(6) sample units shall be shipped to Natick within five working days from the end of the production month and upon completion of all USDA inspection requirements. The sample units will be evaluated for the characteristics of appearance, odor, flavor, texture and overall quality.

(2) Conformance inspection. Conformance inspection shall include the product examination 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 in A-A-20140B and specified in Section C of this Packaging Requirements and Quality Assurance Provisions 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.

TABLE I. Product defects 1/ 2/

Category		Defect
<u>Major</u>	<u>Minor</u>	
		<u>Appearance</u>
101		Product not fat free mayonnaise.
102		Evidence of excessive heating (materially darkened or scorched mottling, curdling or oiling off).
	201	Product not homogenous, or not a off white to light cream color with a slight surface sheen.
		<u>Odor and flavor</u>
103		Product odor or flavor not slight vinegar salad dressing odor and flavor. <u>3/</u>
		<u>Texture</u>
	202	Product not smooth, not creamy or not moderately thick texture.

Weight

203 Net weight of an individual pouch less than 1.0 ounce.

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/ May have egg yolk notes.

B. Methods of inspection.

(1) Shelf life. The contractor shall provide a certificate of conformance that the product has a 36 month 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.

(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) Analytical. 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 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>
Salt	941.13
pH	981.12

Test results shall be reported to the nearest 0.1 percent. The pH shall be reported to the nearest 0.10 value. Verification will be conducted through actual testing by a Government laboratory. Any result not conforming to the analytical requirements shall be cause for rejection of the lot.

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

A. Packaging.

(1) Pouch material certification. Material listed below may be accepted on the basis of a contractor's certification of conformance to the indicated requirements. In addition, compliance to the requirements for inside pouch dimensions and dimensions of manufacturer's seals may be verified by certificate of conformance.

<u>Requirement</u>	<u>Requirement paragraph</u>	<u>Test procedure</u>
Thickness of films for laminated material	D-1,A,(1),a	As specified in ASTM D 2103-03 <u>1/</u>
Aluminum foil thickness	D-1,A,(1),a	As specified in ASTM B 479-00 <u>2/</u>
Laminated material identification and construction	D-1,A,(1),a	Laboratory evaluation
Color of laminated material	D-1,A,(1),a	Visual evaluation by FED-STD-595 <u>3/</u>

1/ ASTM D2103-03 Specification for Polyethylene Film and Sheeting

2/ ASTM B479-00 Standard Specification for Annealed Aluminum and Aluminum-Alloy Foil for Flexible Barrier, Food Contact, and Other Applications

3/ FED-STD-595 Colors Used in Government Procurement

(2) Unfilled preformed pouch certification. A certification of conformance may be accepted as evidence that unfilled pouches conform to the requirements specified in D-1,A,(1) a and b. When deemed necessary by the USDA, testing of the unfilled preformed pouches for seal strength shall be as specified in E-6,A,(4),a.

(3) Filled and sealed pouch examination. The filled and sealed pouches shall be examined for the defects listed in table II. The lot size shall be expressed in pouches. The

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sample unit shall be one pouch. 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 2.5 for minor defects.

TABLE II. Filled and sealed pouch defects 1/

Category		Defect
<u>Major</u>	<u>Minor</u>	
101		Tear, hole, or open seal.
102		Seal width less than 1/16 inch. <u>2/</u>
103		Presence of delamination. <u>3/</u>
104		Unclean pouch. <u>4/</u>
105		Pouch has foreign odor.
106		Any impression or design on the heat seal surfaces which conceals or impairs visual detection of seal defects. <u>5/</u>
107		Not packaged as specified.
	201	Label missing, incorrect, or illegible.
	202	Tear notch or serrations missing or does not facilitate opening.
	203	Seal width less than 1/8 inch but greater than 1/16 inch.
	204	Presence of delamination. <u>3/</u>

1/ Any evidence of rodent or insect infestation shall be cause for rejection of the lot.

2/ The effective closure seal is defined as any uncontaminated, fusion bonded, continuous path, minimum 1/16 inch wide, from side seal to side seal that produces a hermetically sealed pouch.

3/ Delamination defect classification:

Major - Delamination of the outer ply in the pouch seal area that can be propagated to expose aluminum foil at the food product edge of the pouch after manual flexing of the delaminated area. To flex, the delaminated area shall be held between the thumb and

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forefinger of each hand with both thumbs and forefingers touching each other. The delaminated area shall then be rapidly flexed 10 times by rotating both hands in alternating clockwise- counterclockwise directions. Care shall be exercised when flexing delaminated areas near the tear notches to avoid tearing the pouch material. After flexing, the separated outer ply shall be grasped between thumb and forefinger and gently lifted toward the food product edge of the seal or if the separated area is too small to be held between thumb and forefinger, a number two stylus shall be inserted into the delaminated area and a gentle lifting force applied against the outer ply. If separation of the outer ply can be made to extend to the product edge of the seal with no discernible resistance to the gentle lifting, the delamination shall be classified as a major defect. Additionally, spot delamination of the outer ply in the body of the pouch that is able to be propagated beyond its initial borders is also a major defect. To determine if the laminated area is a defect, use the following procedure: Mark the outside edges of the delaminated area using a bold permanent marking pen. Open the pouch and remove the contents. Cut the pouch transversely not closer than 1/4 inch ($\pm 1/16$ inch) from the delaminated area. The pouch shall be flexed in the area in question using the procedure described above. Any propagation of the delaminated area, as evidenced by the delaminated area exceeding the limits of the outlined borders, shall be classified as a major defect.

Minor - Minor delamination of the outer ply in the pouch seal area is acceptable and shall not be classified as a minor defect unless it extends to within 1/16 inch of the food product edge of the seal. All other minor outer ply delamination in the pouch seal area or isolated spots of delamination in the body of the pouch that do not propagate when flexed as described above shall be classified as minor defects.

4/ Outer packaging shall be free from foreign matter which is unwholesome, has the potential to cause pouch damage (for example, glass, metal filings) or generally detracts from the clean appearance of the pouch. The following examples shall not be classified as defects for unclean:

a. Foreign matter which presents no health hazard or potential pouch damage and which can be readily removed by gently shaking the package or by gently brushing the pouch with a clean dry cloth.

b. Dried product which affects less than 1/8 of the total surface area of one pouch face(localized and aggregate).

c. Water spots.

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5/ If doubt exists as to whether or not the sealing equipment leaves an impression or design on the closure seal surface that could conceal or impair visual detection of seal defects, samples shall be furnished to the contracting officer for a determination as to acceptability.

(4) Seal testing. The pouch seals shall be tested for seal strength as required in a, b, or c, as applicable.

a. Unfilled preformed pouch seal testing. The seals of the unfilled preformed pouch shall be tested for seal strength in accordance with ASTM F88-00 Standard Test Method for Seal Strength of Flexible Barrier Materials. The lot size shall be expressed in pouches. The sample size shall be the number of pouches indicated by inspection level S-1. Three adjacent specimens shall be cut from each of the three sealed sides of each pouch in the sample. The average seal strength of any side shall be calculated by averaging the three specimens cut from that side. Any average seal strength of less than 6 pounds per inch of width or any test specimen with a seal strength of less than 5 pounds per inch of width shall be cause for rejection of the lot.

b. Pouch closure seal testing. The closure seals of the pouches shall be tested for seal strength in accordance with ASTM F 88-00. The lot size shall be expressed in pouches. The sample size shall be the number of pouches indicated by inspection level S-1. For the closure seal on preformed pouches, three adjacent specimens shall be cut from the closure seal of each pouch in the sample. The average seal strength of any side, end or closure shall be calculated by averaging the three specimens cut from that side, end or closure. Any average seal strength of less than 6 pounds per inch of width or any test specimen with a seal strength of less than 5 pounds per inch of width shall be cause for rejection of the lot.

c. Internal pressure test. The internal pressure resistance shall be determined by pressurizing the pouches while they are restrained between two rigid plates. The sample size shall be the number of pouches indicated by inspection level S-1. If a three seal tester (one that pressurizes the pouch through an open end) is used, the closure seal shall be cut off for testing the side and bottom seals of the pouch. For testing the closure seal, the bottom seal shall be cut off. The pouches shall be emptied prior to testing. If a four-seal tester (designed to pressurize filled pouches by use of a hypodermic needle through the pouch wall) is used, all four seals can be tested simultaneously. The distance between rigid restraining plates on the four-seal tester shall be equal to the thickness of the product +1/16 inch. Pressure shall be applied at the approximate uniform rate of 1 pound per square inch gage (psig) per second until 14 psig pressure is reached. The 14 psig pressure shall be held constant for 30 seconds and then released. The pouches shall then be examined for separation or yield of the heat seals. Any rupture of the pouch or evidence of seal separation greater than 1/16 inch in the pouch manufacturer's seal shall be considered a test failure. Any seal separation that reduces

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the effective closure seal width to less than 1/16 inch (see table II, footnote 2/) shall be considered a test failure. Any test failure shall be cause for rejection of the lot.

B. Packing.

(1) Shipping container and marking examination. The filled and sealed shipping containers shall be examined for the defects listed in table III 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 III. 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. 1/
	201	More than 40 pounds of product.

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

SECTION J REFERENCE DOCUMENTS

DSCP FORMS

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

FEDERAL STANDARD

FED-STD-595 Colors Used in Government Procurement

NON-GOVERNMENTAL STANDARDS

AMERICAN SOCIETY FOR QUALITY (ASQ)

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

Attributes

ASTM INTERNATIONAL

B479-00	Standard Specification for Annealed Aluminum and Aluminum-Alloy Foil for Flexible Barrier, Food Contact, and Other Applications
D1238-04	Standard Test Method for Melt Flow Rates of Thermoplastics by Extrusion Plastometer
D1974-98 (2003)	Standard Practice for Methods of Closing, Sealing, and Reinforcing Fiberboard Boxes
D2103-03	Standard Specification for Polyethylene Film and Sheeting
D5118/D5118M-95 (2001)	Standard Practice for Fabrication of Fiberboard Shipping Boxes
F88-00	Standard Test Method for Seal Strength of Flexible Barrier Materials

AOAC INTERNATIONAL

Official Methods of Analysis of the Association of Official Analytical Chemists International

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For DSCP Website Posting

AMSRD-NSC-CF-F

TO: DSCP-FTRAA

SUBJECT: ES07-131; DSCP- SS-07-50526, Request for specification change, PKG&QAP A-A-20140B Mayonnaise, Salad Dressing and Tartar Sauce, increase to Salt content range.

REFERENCE:

ES07-082; DSCP- SS-07-37510, Request for waiver; Salt A-A-20140B Mayonnaise, Salad Dressing and Tartar Sauce. Replied 25 April 07

1. Natick received a request for specification change to PKG&QAP A-A-20140B Mayonnaise, Salad Dressing and Tartar Sauce to increase the range of percent salt content.
2. It is requested that the salt content in the QAP for the Fat Free Mayonnaise be increased from 1.65 to 2.35 percent to 1.65 to 2.7 percent. The Fat Free Mayonnaise is included in Menu #10 along with the Tuna. They developed this product which was tested and approved for the MRE. However, the PKG&QAP was prepared using product that was produced on a small scale. When the scale-up production began in 2006, it was difficult for the Company to meet the upper salt requirement, so two requests for waivers have been approved since 2006.
3. Since this problem continues and the minor increase in the salt content does not negatively impact the nutritional content of the MRE or First Strike Ration, Natick concurs with the change to increase the salt requirement from 1.65 to 2.35 percent to 1.65 to 2.7 percent in PKG&QAP A-A-20140B. In the above referenced ES Case ES07-082, SS-07-37510, the samples were evaluated and found to be acceptable for organoleptical qualities.
4. Natick submits the following change to PKG&QAP A-A-20140B Mayonnaise, Salad Dressing and Tartar Sauce for all current, pending and future procurements until the document is formally amended or revised:
 - a. Section C-2, I (1) Salt content. Delete 2.35 and insert 2.70.
5. The Military Service representatives were contacted regarding this specification change and they concur with this specification change request