

**PACKAGING REQUIREMENTS AND QUALITY ASSURANCE PROVISIONS FOR  
MIL-PRF-32176, BAG, HOT BEVERAGE**

**SECTION D**

**D-1 PACKAGING**

Covered in applicable Assembly Contract Requirements (ACR) documents.

**D-2 LABELING**

Covered in MIL-PRF-32176 Bag, Hot Beverage.

**D-3 PACKING**

A. Packing for shipment to ration assembler. Not more than 40 pounds of bags shall be packed 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 UNITIZATION**

Not Applicable.

**D-5 MARKING**

A. Shipping containers. Shipping containers shall be marked in accordance with DSCP FORM 3556, Marking Instructions for Boxes, Sacks and Unit Loads of Perishable and Semiperishable Subsistence.

**SECTION E INSPECTION AND ACCEPTANCE**

**E-5 PACKAGING AND PACKING MATERIALS**

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.

A. Packaging.

(1) Bag testing. The bag and material shall be tested for the requirements listed in table I of MIL-PRF-32176. The lot size, sample unit, and inspection level criteria for each test are listed below. Any test failure shall be classified as a major defect and shall be cause for rejection of the lot.

Requirement	Lot size expressed in	Sample unit	Inspection level
Color	Bags	1 bag	S-2
Bag integrity	Bags	1 bag	S-2
Heat seals	Bags	1 bag	S-2
Interlocking closure integrity	Bags	1 bag	S-2
Interlocking closure operation	Bags	1 bag	S-2
Interface (bag & interlocking closure)	Bags	1 bag	S-2
Environmental	Bags	1 bag	S-2

(2) Bag examination. The bags shall be examined for the defects listed in table II of MIL-PRF-32176. The lot size shall be expressed in bags. The sample unit shall be one bag. 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.

B. Packing.

(1) Shipping container and marking examination. The filled and sealed shipping containers shall be examined for the defects listed in table I 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 I. 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	Contents more or less than 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.

**SECTION J REFERENCE DOCUMENTS**

DSCP FORMS

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

MILITARY SPECIFICATIONS

MIL-PRF-32176      Bag, Hot Beverage

NON-GOVERNMENTAL STANDARDS

AMERICAN SOCIETY FOR QUALITY (ASQ)

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

ASTM INTERNATIONAL

D1974-98 (2003)      Standard Practice for Methods of Closing, Sealing, and Reinforcing Fiberboard Boxes

D5118/D5118M-95 (2001)      Standard Practice for Fabrication of Fiberboard Shipping Boxes