

## **ATTACHMENT 7 – MODIFICATIONS TO PCR-B-055 AND PKG&QAP A-A-20098**

The “SECTION E INSPECTION AND ACCEPTANCE” sections of PCR-B-055, and PKG&QAP A-A-20098 apply in their entirety when performing inspections of beverage bases in accordance with the contractually applicable editions of PCR-B-055, and PKG&QAP A-A-20098. However, the following modifications to the designated beverage base technical documents are to be applied to the technical documents specifically within the scope of the modification as described in this attachment for the purpose of determining compliance with contract requirements by government verification inspection. “

PCR-B-055, BEVERAGE POWDER, CARBOHYDRATE, PACKAGED IN A FLEXIBLE POUCH, SHELF STABLE

1. Paragraph D-1, A., (1), c. Pouch filling and sealing. Read the existing final sentence as, “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.”

2. Paragraph D-1, A., (2), b. Pouch construction. In addition to the content of the paragraph as written, “The side and bottom seal 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,B,(1),a. Alternatively, the pouch shall exhibit no rupture or separation greater than 1/16 inch when tested for internal pressure resistance as specified in E-6,B,(1),c.”

3. Paragraph D-1, A., (2), c. Pouch filling and sealing. Read the paragraph as, “c. Pouch filling and sealing. Product shall be inserted into the pouch and the filled pouch shall be sealed with a not less than 1/8 inch wide heat seal. The closure seal shall be free of foldover wrinkles or entrapped matter that reduces the effective closure seal width to less than 1/8 inch. Seals shall be free of impression or design on the seal surface that would conceal or impair visual detection of seal defects. The integrity of the pouch seals shall be tested by utilizing one of the following three inspection methods. The sealed pouch shall not leak when tested in accordance with E-6,B,(3). Alternatively, 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,B,(1),b. Alternatively, the pouch shall exhibit no rupture or seal separation greater than 1/16 inch when tested for internal pressure resistance as specified in E-6,B,(1),c.”

4. Paragraph E-5, A. Product examination, TABLE I. Use the following defect categories and defect descriptions when performing Table I inspection of hydrated product:

“Hydrated product 4/

Appearance

206 Not a clear to slightly cloudy, sediment-free liquid.

207 Flavor 1 fruit punch beverage not a reddish-orange color.

208 Flavor 2 grape beverage not a purple color.

209 Flavor 3 lemon-lime beverage not a bright pale green color.

210 Flavor 4 orange beverage not a orange color.

211 Flavor 5 tropical punch beverage not a light red color.

212 Flavor 6 lemonade beverage not a pale yellow color.

109 Product does not fully dissolve within two minutes with constant stirring or shaking. Product has discernable lumps.

Odor and flavor

103 Flavor 1 fruit punch beverage not a sweet fruit blend odor or flavor.  
104 Flavor 2 grape beverage not a sweet grape odor or flavor.  
105 Flavor 3 lemon-lime beverage not a sweet, sour, lemon-lime odor or flavor  
106 Flavor 4 orange beverage not a sweet, sour, distinct orange odor or flavor.  
107 Flavor 5 tropical punch beverage not a tropical fruit blend odor or flavor.  
108 Flavor 6 lemonade beverage not a sweet, sour, lemon odor or flavor.”  
5. Paragraph E-5, A. Product examination, TABLE I, footnote 4/. Read as, “4/ Prior to conducting the hydrated product examination, the beverage powder shall be hydrated per label instructions.”

6. Clarification: Paragraph E-6, A., (3) Pouch material certification. Read as, “For design E, compliance with all pouch material, construction and sealing requirements cited in E-6,A,(1) Pouch material certification shall be verified by a CoC.”

7. Paragraph E-6, A., (4) Filled and sealed pouch examination., Table II. Do not apply defect category/description “107..Leakage. 6/”

8. Paragraph E-6, A., (4) Filled and sealed pouch examination., Table II, footnote 6/. Do not apply footnote 6/.

9. Paragraph E-6,B., (3) Leakage test. Read as, “(3) Leakage test. For design E, filled and sealed pouches shall be tested by placing them in a dry desiccator, or similar apparatus, and subjecting them to a vacuum of 26 inches of mercury (atmospheric pressure is 29.9 inches of mercury) for 30 seconds. The lot size shall be expressed in pouches. The sample unit shall be one pouch. The sample size shall be the number of pouches indicated by inspection level S-1. Any pouch that does not swell to form a tightly distended package having at least one distorted edge during the test shall be classified as a leaker. After vacuum testing, the pouches shall be visually inspected for evidence of leakage, delamination and for seal separation. Any leakage, any delamination, or any seal separation of more than 1/16 inch from the product edge of any seal shall be classified as a major defect and shall be cause for rejection of the lot.”

#### PACKAGING REQUIREMENTS AND QUALITY ASSURANCE PROVISIONS FOR CID A-A-20098 BEVERAGE BASES (POWDERED)

1. Paragraph E-5, A. Product examination., TABLE I. Use the following defect categories and defect descriptions when performing Table I inspection of hydrated product: “Hydrated product 5/ Appearance 102 Color not of the applicable flavor specified. 206 Product does not fully dissolve within two minutes with constant stirring or shaking. Product has discernable lumps. 207 Product not clear to slightly cloudy. 208 Product not a sediment-free liquid. Odor and flavor 104 Odor or flavor not of the applicable flavor specified.”

2. Paragraph E-5, A. Product examination., TABLE I, footnote 5/. Read as, “5/ Prior to conducting the hydrated product examination, the beverage base shall be hydrated per label instructions.”

3. Paragraph E-6, A.,(1) Pouch material certification. Read each instance of “D-1,A(2)a” as “D-1,A,(2)”.

4. Paragraph E-6, A., (2) Unfilled preformed pouch certification. Read as, “(2) Unfilled preformed pouch certification. A CoC may be accepted as evidence that unfilled pouches conform to the requirements specified in D-1, A., (2).” There is no seal test requirement for Design D pouches.

5. Clarification: Paragraph E-6, A., (3) Pouch material certification. For design D, compliance with all pouch material, construction and sealing requirements cited in D-1, A., (2) and E-6, A., (1) Pouch material certification, shall be verified by a CoC.

6. Paragraph E-6, A., (4) Filled and sealed pouch examination. When performing this examination, “Until such time as it is revoked by the contracting officer, for the purpose of both contractor and government compliance inspection, the contracting officer authorizes the use of inspection level S-4.”

7. Paragraph E-6, A., (4) Filled and sealed pouch examination.,TABLE II. Use the following table when implementing inspection level S-4 as authorized by the contracting officer. Maintain the footnotes located in the PKG&QAP as applicable.

“TABLE II. Filled and sealed pouch defects 1/

102 Seal width less than 1/16 inch. 2/ 8/

103 Presence of delamination. 3/ 8/

104 Unclean pouch. 4/

105 Pouch has foreign odor.

106 Any impression or design on the heat seal surfaces which conceals or impairs visual detection of seal defects. 5/ 8/

107 Leakage. 6/ 7/

109 Not packaged as specified.

201 Label missing or incorrect or illegible.

202 Tear nick or notch or serrations missing or does not facilitate opening. 8/ 9/

203 Seal width less than 1/8 inch but greater than or equal to 1/16 inch. 2/ 8/

204 Presence of delamination. 3/ 8/”

8. Paragraph E-6, A., (4) Filled and sealed pouch examination.,TABLE II, footnotes. Use the following footnote: “7/ Any pouch that does not swell to form a tightly distended package having at least one distorted edge during the leakage test shall be recorded as a leaker.”

9. Paragraph E-6, A., (4) Filled and sealed pouch examination.,TABLE II, footnotes. Use the following footnote when implementing inspection level S-4 as authorized by the contracting officer: “8/ The contractor may offer a Certificate of Conformance (CoC) for these requirements. The government quality assurance representative (GQAR) may verify these requirements by the contractor’s CoC. The GQAR may examine a reduced number of samples for these requirements, that number being at the discretion of the GQAR. If the GQAR notes a defect, the GQAR shall expand the number of samples examined to be the full sample size.”

10. Paragraph E-6, A., (4) Filled and sealed pouch examination.,TABLE II, footnotes. Use the following footnote when implementing inspection level S-4 as authorized by the contracting officer: “9/ Pouch material which in and of its own nature facilitates opening without loss of product serviceability is authorized by the contracting officer.”

11. Paragraph E-6, B., (3) Leakage test.. The last sentence, “Any leakage, any delamination, or any seal separation of more than 1/16 inch from the product edge of any seal shall be recorded as a major defect.”, does not apply. For defect classification of leakage test findings, refer to Table II defect descriptions and their corresponding defect category to record findings of any leakers 7/, delamination, or inadequate seal width.”