

ACR-F-002B
30 June 2011
W/Change 09 13 March 17 ES17-027 (DSCP-SS-17-00639)
SUPERSEDING
ACR-F-002A
9 July 2010

SECTION C

The Food Packet, Modular Operational Ration Enhancement (MORE) provides a special purpose enhancement packet for the individual and complements both individual and group rations. This packet of performance enhancing and high carbohydrate foods will help the individual maintain optimal performance levels in extreme operational environments and during high intensity missions.

C-1 ITEM DESCRIPTION

ACR-F-002B, FOOD PACKET, MODULAR OPERATIONAL RATION ENHANCEMENT (MORE), ASSEMBLY REQUIREMENTS

Types

- Type I - High Altitude/Cold Weather
- Type II - Hot Weather

C-2 ASSEMBLY REQUIREMENTS

A. Components. The components are specified in table I.

ACR-F-002B
30 June 2011
W/Change 09 13 March 17 ES17-027 (DSCP-SS-17-00639)
SUPERSEDING
ACR-F-002A
9 July 2010

TABLE I. Components

Component	Reference
Beef and Turkey Snacks, Cured	A-A-20298B A-A-20298C
Beef, Moist-Cured/Kippered, Chopped and Formed	Variety A, Type II, Style a,
Strips, Smoked Meat and Poultry Snacks, Cured	Class 1, Flavor (a) Type IV, Style a,
Beef, Fermented, Chopped and	Class 2, Flavor (b)
Formed, Sticks, Teriyaki	
Beverage Bases (Powdered) Beverage Powder,	A-A-20098E PCR-B-055
Carbohydrate Sweetened with Nutritive Sweetener	Type II,
Fortified Ascorbic Acid and Enhanced Maltodextrin	Formulation e, b
Flat Interlocking Closure Pouch	Design B
Orange	Flavor 4 4
Lemon-Lime	Flavor 4 3
Grape	Flavor 5 2
Tropical Punch	Flavor 4 5
Beverage Powder, Carbohydrate Electrolyte	PCR-B-013A
Flat Interlocking Closure Pouch	Design B
Fruit Punch	Flavor I
Grape	Flavor II
Lemon-Lime	Flavor III
Orange	Flavor IV
Caffeinated Chocolate Pudding	PCR-C-081
Chewing Gum	A-A-20175D
Tablet, Large, with Caffeine, Regular	Type I, Size C, Style (2), Class 1,
Peppermint	Flavor a
Cinnamon	Flavor c
Disk, Regular with Caffeine, Regular	Type VII, Size B, Style (2), Class 1,
Peppermint	Flavor a
Cinnamon	Flavor c
Crackers, Fortified	PCR-C-037A
Plain	Type I
Energy Gel	PCR-E-018
Mixed Berry	Flavor I
Lemon Lime	Flavor II
Orange	Flavor III

ACR-F-002B
30 June 2011
W/Change 09 13 March 17 ES17-027 (DSCP-SS-17-00639)
SUPERSEDING
ACR-F-002A
9 July 2010

TABLE I. Components - Continued

Component	Reference
First Strike Bar	PCR-F-001
Chocolate, Regular	Flavor I, Style A
Mocha, Mini	Flavor V, Style B
Fruits, Infused and Dried	A-A-20299B
Cranberries, Sliced, Plain, Not Fortified, No Sulfur Dioxide	Type VII, Style B, Flavor 1, Fortification a, Class (1)
Fruits, Wet Pack	PCR-F-002C ,
Applesauce, Carbohydrate Enhanced, Sweetened, Regular Style	Type VII
Applesauce, Carbohydrate Enhanced, Sweetened, Regular Style, Cinnamon	Type IX
Nuts, Shelled, Roasted	A-A-20164D
Almonds (Unblanched), Flavored (Smoked)	Type IX, Style C
Nut and Fruit Mix	PCR-N-003
Nuts and Raisins with Pan Coated Chocolate Disks	Type II
Nuts with Raw Sunflower Kernels and Infused Fruit	Type III
Snack Foods	A-A-20195D
Filled Pretzels, Cheddar Cheese	Type II, Style F, Flavor 1
Baked Snack Crackers, Hot and Spicy Cheese	Type V, Flavor 2
Toasted Corn Kernels, Plain, Salted	Type VI, Flavor 1
Spread Soup Mix	PCR-S-023
Cheddar Potato with Artificial Bacon Bits	Type II
Toaster Pastries	A-A-20211B
Regular, Frosted, Brown Sugar Cinnamon, Without Sprinkles, Enriched Wheat Flour, Not Fortified, Rectangular, Single Serving	Type I, Style B, Flavor 3, Frosting Option (B), Grain Composition (1), Fortification b, Shape i, Servings (a)

B. Contents. The contents of each food packet type are specified in table II. Refer to Table I for full citation and document number of components.

ACR-F-002B
30 June 2011
W/Change 09 13 March 17 ES17-027 (DSCP-SS-17-00639)
SUPERSEDING
ACR-F-002A
9 July 2010

TABLE II. Contents

Type I - High Altitude/Cold Weather MORE

<u>Pack 1</u>	<u>Pack 2</u>	<u>Pack 3</u>
Caffeine Chocolate Pudding	First Strike Bar,	Cracker
Nut and Fruit Mix, Type III II	Chocolate	Spread Soup Mix
Toaster Pastry	Nut and Fruit Mix, Type II	Applesauce
Energy Gel, Mixed Berry	Energy Gel, Lemon Lime	Snack, Baked Cracker
Snack, Filled Pretzels,	Snack, Corn Kernels	First Strike Bar,
Cheddar	Beef Snack, Smoked Teriyaki	Mini Mocha
	Caffeinated Gum, Cinnamon	Beverage, Carb Fortified 1/
	Beverage, Carb Fortified 1/	

1/ Flavors shall be procured in equal quantities and assembled in a uniform distribution.

Type II – Hot Weather MORE

<u>Pack 1</u>	<u>Pack 2</u>	<u>Pack 3</u>
Caffeine Chocolate Pudding	First Strike Bar,	Energy Gel, Orange
Dried Cranberries	Chocolate	Snack, Corn Kernels
Energy Gel, Mixed Berry	Nuts, Almonds, Smoked	Applesauce, Cinnamon
Snack, Filled Pretzels,	Energy Gel, Lemon Lime	Nut and Fruit Mix, Type III II
Cheddar	Applesauce	First Strike Bar,
Beverage, Carbo Electro (2) 2/	Caffeinated Gum, Peppermint	Mini Mocha
	Beverage, Carbo Electro (2) 2/	Beverage, Carbo Electro (2) 2/

2/ Flavors shall be procured in equal quantities and assembled in a uniform distribution. When pack contains two beverages, they shall be different flavors.

ACR-F-002B
30 June 2011
W/Change 09 13 March 17 ES17-027 (DSCP-SS-17-00639)
SUPERSEDING
ACR-F-002A
9 July 2010

SECTION D

D-1 PACKAGING

A. Components.

(1) Time-temperature indicator (TTI) label. The TTI label shall be a 3/4 inch square, bull's-eye type, pressure sensitive adhesive label. The TTI label shall have an activation energy (Ea) of 24–30 kcal/mole, be protected from ultraviolet radiation and have a shelf life of 1100 days at 80°F as pivot point.

(2) Assembly package. The assembly package shall be of sufficient thickness and strength to contain the pack components without tearing or spillage of meal contents throughout assembly, packing and distribution. Material will be suitably formulated for use with food packages.

B. Assembly.

(1) Food packet, MORE assembly. Each applicable component for each MORE food packet as described in table II shall be assembled in a food packet. The food packet shall be shrink wrapped or heat-sealed (as applicable) with material suitably formulated for use with food packages. If closed by heat seal, the seal shall be not less than 1/8 inch wide, and vacuum sealing is permitted. The sealed assembly packet shall not show any evidence of foreign odor. The size of the finished assembly packet shall allow for the packing of 24 food packets into the box.

D-2 LABELING

A. Food packet, MORE. Each MORE food packet shall be correctly and legibly labeled on at least one face with permanent ink or other dark contrasting color. The label shall cite (as applicable):

ACR-F-002B
30 June 2011
W/Change 09 13 March 17 ES17-027 (DSCP-SS-17-00639)
SUPERSEDING
ACR-F-002A
9 July 2010

Modular Operational Ration Enhancement (MORE)

(Note: shall be printed in BOLD font)

Type I: High Altitude/Cold Weather (Note: shall be printed in BOLD font)

Pack number (Note: shall be printed in BOLD font)

Specially designed for added nutrition during high altitude operations or at temperatures below 40°F

(May also be consumed at temperatures between 40-70°F) (Note: shall be printed in italicized font)

Contents list

Name and address of assembler

OR

Modular Operational Ration Enhancement (MORE)

(Note: shall be printed in BOLD font)

Type II: Hot Weather (Note: shall be printed in BOLD font)

Pack number (Note: shall be printed in BOLD font)

Specially designed for added nutrition during operations at temperatures above 70°F

(May also be consumed at temperatures between 40-70°F) (Note: shall be printed in italicized font)

Contents list

Name and address of assembler

ACR-F-002B
30 June 2011
W/Change 09 13 March 17 ES17-027 (DSCP-SS-17-00639)
SUPERSEDING
ACR-F-002A
9 July 2010

D-3 PACKING

A. Packing. Twenty four food packets, eight of each pack, shall be packed in a fiberboard box. The fiberboard box shall conform to RSC-L, of ASTM D 5118/D 5118M, Standard Practice for Fabrication of Fiberboard Shipping Boxes, grade V2s of ASTM D 4727/D 4727M, Standard Specification for Corrugated and Solid Fiberboard Sheet Stock (Container Grade) and Cut Shapes, except the requirements for dry burst strength shall be minimum 425 psi, the requirement for wet burst strength shall be minimum 250 psi and the laminated board thickness shall be 0.069 inches. [US Army Research, Development, and Engineering Command, Natick Soldier Research, Development, and Engineering Center has found that solid fiberboard shipping container material consisting of two outer facings of 90# wet strength linerboard and an inner ply of 69# linerboard meets the performance criteria of this specification.] The box liner shall be a full inside width box liner fabricated from grade W5c fiberboard in accordance with ASTM D 5118/D 5118M, except the terminal ends of the liner shall overlap a minimum of 2 inches and no fastening of the overlap is required. The box shall be closed in accordance with closure method 2A1 of ASTM D 1974, Standard Practice for Methods of Closing, Sealing, and Reinforcing Fiberboard Boxes, except the gap between the outer flaps shall be not more the 3/4 inch wide. Each box shall be reinforced with two girthwise nonmetallic straps. The inside dimensions of the box shall be 16-11/16 inches in length, 9-1/8 inches in width and 10-1/4 inches in depth.

D-4 UNITIZATION

A. Unit loads. Forty-eight boxes shall be arranged in unit loads in accordance with type I, class C of DLA Troop Support Form 3507, Loads, Unit: Preparation of Semiperishable Subsistence Items. At least two boxes in each tier shall be oriented to display the TTI label.

D-5 MARKING

A. Shipping containers. Shipping containers shall be marked in accordance with DLA Troop Support Form 3556, Marking Instructions for Boxes, Sacks, and Unit Loads of Perishable and Semiperishable Subsistence and as specified in the contract with the following exceptions:

(1) Identification markings normally placed on an end of the shipping container shall read from top to bottom, left to right, when the shipping container is rotated from its upright position onto its side for palletization. The major flaps of the shipping container closure immediately to the right of the marked end of the shipping container shall bear the following

ACR-F-002B
30 June 2011
W/Change 09 13 March 17 ES17-027 (DSCP-SS-17-00639)
SUPERSEDING
ACR-F-002A
9 July 2010

marking:

Contract data and other required markings

Date of pack

Lot number

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Time Temperature Indicator label shall be centrally positioned on the panel. A minimum distance (quiet zone) of 1/4 inch from the nearest identification marking shall be maintained. One side panel of the shipping container shall be marked “Food Packet, Modular Operational Ration Enhancement (MORE)” in letters not less than 1-1/4 inches high. The marked end panel for Type I shall read “Food Packet, MORE High Altitude/Cold Weather (for temperatures below 40°F)” or for Type II shall read “Food Packet, MORE Hot Weather (for temperatures above 70°F)” in addition to other required markings.

B. Unit loads. Unit loads shall be marked in accordance with DLA Troop Support Form 3556.

SECTION E INSPECTION AND ACCEPTANCE

The following quality assurance criteria, utilizing ANSI/ASQ Z1.4, Sampling Procedures and Tables for Inspection by Attributes, are required. Unless otherwise specified, single sampling plans indicated in ANSI/ASQ Z1.4 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.

ACR-F-002B
30 June 2011
W/Change 09 13 March 17 ES17-027 (DSCP-SS-17-00639)
SUPERSEDING
ACR-F-002A
9 July 2010

(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. Conformance inspection. Conformance inspection shall include the examinations/tests and the methods of inspection cited in this section.

C. Packaging examination.

(1) Assembled food packets examination. The filled and sealed food packets shall be inspected for the defects listed in table III. The lot size shall be expressed in packets. The sample unit shall be one packet. The inspection level shall be S-4 and the acceptable quality level (AQL), expressed in terms of defects per hundred units, shall be 2.5 for major defects and 4.0 for minor defects. A minimum of 50 samples shall be examined for critical defects. The finding of any critical defect shall be cause for rejection of the lot. The inspection sample shall contain a proportionate amount of packets.

TABLE III. Assembled food packet defects

Category		Defect
<u>Critical</u>	<u>Major</u> <u>Minor</u>	
1		Tear or hole or open seal in spread soup mix or energy gel or pudding or applesauce.
2		Swollen spread soup mix or energy gel or pudding or applesauce.
	101	Food packet not type or not pack as specified.
	102	Component missing or incorrect pack for packet.
	103	Packet not clean or outer packaging of contents not clean. <u>1/</u>
	104	Foreign odor.
	105	Label missing or incorrect or illegible.
	106	Tear or hole or open seal in component packages.

ACR-F-002B
30 June 2011
W/Change 09 13 March 17 ES17-027 (DSCP-SS-17-00639)
SUPERSEDING
ACR-F-002A
9 July 2010

107 Crushed or broken component. 2/

201 Tear or hole or open seal in packet. 3/

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

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

b. Localized dried product which affects less than 1/8 of the total surface area of one pouch face, or an aggregate of scattered dried product which affects less than 1/4 of the total surface area of one pouch face.

2/ For definition of crushed or broken, refer to applicable ration component document.

3/ The holes provided in shrink wrap to allow venting of air to facilitate effective application of shrink wrap are permitted and shall not be scored as defects.

D. Packing.

(1) Shipping container and marking examination. The filled and sealed shipping containers shall be examined for the defects listed in table IV. 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.

ACR-F-002B
30 June 2011
W/Change 09 13 March 17 ES17-027 (DSCP-SS-17-00639)
SUPERSEDING
ACR-F-002A
9 July 2010

TABLE IV. Shipping container and marking defects

Category		Defect
<u>Major</u>	<u>Minor</u>	
101		Marking missing or incorrect or illegible.
102		Outer flaps do not completely meet, leaving an opening greater than 3/4 inch between flap ends.
103		Inadequate workmanship. <u>1/</u>
104		Missing food packet. <u>2/</u>
105		Not eight of each pack specified.
106		Not correct type food packet.
	201	Twenty four food packets do not fit in box.
	202	Time-temperature indicator missing or not centrally located on panel.
	203	Time-temperature indicator 1/4-inch quiet zone not maintained.

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.

2/ Each missing food packet is a defect.

(2) Flap closure testing. The lot size shall be expressed in shipping containers. The sample unit shall be one shipping container. The inspection level shall be S-2 and the AQL, expressed in terms of defects per hundred units, shall be 4.0. The closure of the four outer flaps of the container shall be tested separately. A 90 degree angular bar with each leg approximately 5 inches long by 3 inches wide by 1/8 inch thick shall be used to test the flap closures. Insert one leg of the angular bar full length under the center of one outer flap. Insertion shall be made through the open slot between the outer flaps. Lift the container

ACR-F-002B
30 June 2011
W/Change 09 13 March 17 ES17-027 (DSCP-SS-17-00639)
SUPERSEDING
ACR-F-002A
9 July 2010

vertically by the other leg of the bar until the container is suspended. The complete upper surface of the inserted leg shall be in contact with the inner surface of the flap during the lifting and suspension of the container. Complete separation of the adhesive bond of one or more of the outer flaps, showing no evidence of fiber tear, shall be scored a major defect.

F. Unit load examination. The unit load shall be examined in accordance with the requirements of DLA Troop Support Form 3507. Any nonconformance shall be classified as a major defect.

SECTION J REFERENCE DOCUMENTS

Unless otherwise specified, the issues of these documents are those active on the date of the solicitation or contract.

DLA Troop Support Forms

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

NON-GOVERNMENTAL STANDARDS

AMERICAN SOCIETY FOR QUALITY (ASQ) www.asq.org

ANSI/ASQ Z1.4 Sampling Procedures and Tables for Inspection by Attributes

ASTM INTERNATIONAL www.astm.org

D 1974	Standard Practice for Methods of Closing, Sealing, and Reinforcing Fiberboard Boxes
D 4727/D 4727M	Standard Specification for Corrugated and Solid Fiberboard Sheet Stock (Container Grade) and Cut Shapes
D 5118/D 5118M	Standard Practice for Fabrication of Fiberboard Shipping Boxes