

ACR-E-21
1 April 2021
W/Change 01 20 Oct 21 ES21-049 (DSCP-SS-21-01103)
SUPERSEDING
ACR-E-001B
25 February 2011

SECTION C

The Unitized Group Ration – Express (UGR-E) provides a complete meal to 18 individuals. There are four breakfast and eight lunch/dinner menus. The UGR-E consists of one box. Within the box are a heating module, polymeric trays, beverages, food components, serving utensils, disposable meal trays, and other components.

C-1 ITEM DESCRIPTION

ACR-E-21, UNITIZED GROUP RATION – EXPRESS (UGR-E), ASSEMBLY REQUIREMENTS

C-2 ASSEMBLY REQUIREMENTS

A. Components. The components shall be as specified in table I.

TABLE I. Components

<u>Component</u>	<u>Reference</u>
<u>Entrées</u>	
Beef and Potatoes in Cream Gravy – polymeric tray	PCR-B-052
Beef Fajita Filling – polymeric tray	PCR-B-062
Buffalo Style Chicken Breast Strips in Sauce – polymeric tray	PCR-B-059
Burgundy Beef Stew – polymeric tray	PCR-B-044
Cajun Style Chicken Breast Dices with Andouille Chicken Sausage in Sauce – polymeric tray	PCR-C-089
Chicken Breast in Gravy – polymeric tray	PCR-C-032A
Chili with Beans – polymeric tray	PCR-C-034A
Egg Mix, Reduced Cholesterol, Pasteurized, Uncooked, Dehydrated Small Opening Fitment and Cap	PCR-E-017B
BIB with Center Seal	Class 1
Freeze-dried or Spray-dried	Type I
Hash, Corned Beef – polymeric tray	Style A or B
Hash, Corned Beef – polymeric tray	PCR-H-005
Pork Sausage Links in Brine – polymeric tray	PCR-P-015A
Southwestern Style Chicken Chili – polymeric tray	PCR-S-025
Spaghetti with Meatballs in Sauce – polymeric tray	PCR-S-012A
Turkey Sausage Patties in Brine – polymeric tray	PCR-T-015

ACR-E-21
1 April 2021
W/Change 01 20 Oct 21 ES21-049 (DSCP-SS-21-01103)
SUPERSEDING
ACR-E-001B
25 February 2011

TABLE I. Components - Continued

Component	Reference
<u>Starches</u>	
Granola, Packaged in a Flexible Pouch With Milk and Blueberries	PCR-G-003A Type I
Oatmeal, Apple Cinnamon – polymeric tray	PCR-O-007
Rice – polymeric tray	PCR-R-004B
White Rice	Type I
Brown Rice	Type III
Sweet Potato Casserole – polymeric tray	PCR-S-022
Tortillas, Packaged in a Flexible Pouch Plain	PCR-T-008B Flavor 1
<u>Vegetables</u>	
Vegetables – polymeric tray	PCR-V-007
Carrots, Glazed	Type I
Corn, Mexican Style	Type II
Green Beans, Seasoned	Type III
<u>Desserts and Snacks</u>	
Apple Dessert – polymeric tray	PCR-A-003
Cakes and Brownies – polymeric tray, Cakes	PCR-C-024D, Type I
Breakfast Cake with Maple Flavored Syrup	Flavor 4
Yellow Cake with Chocolate Icing	Flavor 5
Apple Spice Breakfast Cake	Flavor 10
Red Velvet Cake with White Icing	Flavor 12
Golden Harvest Cake with White Icing	Flavor 15
Chocolate Cherry Cake with Cherry Fruit Topping	Flavor 17
Carrot Cake with White Icing	Flavor 20

ACR-E-21
1 April 2021
W/Change 01 20 Oct 21 ES21-049 (DSCP-SS-21-01103)
SUPERSEDING
ACR-E-001B
25 February 2011

TABLE I. Components - Continued

Component	Reference
Candy and Chocolate Confections	A-A-20177F
Pan Coated Candy, Disks	Type IV, Style A
Milk Chocolate, Plain	Flavor 1
Peanut Butter, Plain	Flavor 4
Cookies – polymeric tray	A-A-20295D
Regular	Type I
Chocolate Chip Cookies (Regular, Chunk, or Mini Chips)	Style J
Chocolate-Covered-Crunchy-Peanut-Butter-Candy with	Flavor 11
Chocolate Chips	
White Chocolate Chip Cookies (Regular, Chunk, or Mini	Style Q
Chips) With Cranberries	Flavor 2
Crisp	Bake Type a
Multiple Serving Packages	Class 2
Conventional	Agricultural Practice (A)
Nut and Fruit Mix	PCR-N-003B
Nuts and Raisins	Type I
Nuts, Shelled, Roasted	A-A-20164E
Conventional	Agricultural Practices (1)
Cashews, Halves (Splits), Flavored (Jalapeno)	Type VI, Size 2, Style C
 <u>Beverages</u>	
Beverage Bases (Powdered), Lap or Fin Seal Pouch	A-A-20098F, Design D
Sweetened with Non-nutritive Sweetener, Orange	Type III, Flavor 1
Fortified with Ascorbic Acid and Calcium	Formulation h
Beverage Powder, Carbohydrate, Packaged in a Flexible Pouch,	PCR-B-055
Fortified with Ascorbic Acid and Enhanced with Maltodextrin,	Formulation b
Flat Interlocking Closure Pouch	Design B
Fruit Punch	Flavor 1
Grape	Flavor 2
Lemon-Lime	Flavor 3
Coffee, Soluble, Freeze Dried,	A-A-20184C, Type III
Regular, Lap or Fin Seal Package	Style A, Pack 2
Chocolate Protein Drink Powder	PCR-C-082B
Chocolate	Flavor I

ACR-E-21
1 April 2021
W/Change 01 20 Oct 21 ES21-049 (DSCP-SS-21-01103)
SUPERSEDING
ACR-E-001B
25 February 2011

TABLE I. Components – Continued

Component	Reference
Juice, Fruit, Instant, Flat Interlocking Closure Pouch	PCR-J-002A, Design B
Grape, Sweetened	Type I, Style A
Orange, Unsweetened	Type II, Style B
 <u>Other Food Items</u>	
Cheese Spread, Cheddar, Fortified	PCR-C-039A
With Jalapeno Peppers	Type II
Creamer, Non-Dairy, Dry	A-A-20043D
Regular, Plain/Unflavored	Style I, Flavor A
Hot Sauce	A-A-20097G
Extra Hot 4x, Conventional	Type II, Agricultural Practices A
Natural Butter Flavor Granules, Spray-Dried	A-A-20351A
Regular, Granules/Sprinkles, 57 g.	Type I, Style A, Package 4
Peanut Butter and Grape Jelly Twin Pack	8930-01-396-4009
Peanut Butter and Strawberry Jam Twin Pack	8930-01-436-1912
 <u>Disposables</u>	
Bag, Plastic, Trash	8105-01-521-6616
Cutter, Box, Razor-Based with Housing	8970-01-545-6830
Dining Packet, Food Container, Modified, with Biobased Fork, Knife and Spoon	A-A-3012A, Type IV
Gloves, Disposable, Foodservice, Multipurpose, Large, Ambidextrous, Latex Free, Polyethylene, 1.25 mil thick	8415-01-541-5392
Hand and Body Wipes, Pre-Moistened	A-A-461C
Hand Wipe, Non-Antibacterial	Type I, Style 2
Individually Wrapped, Single Pack	Packaging a
Serving Spoon	8970-01-545-6826
Slotted Serving Spoon	8970-01-545-6828
Spatula	8970-01-545-6831
Tray, Mess, 3 Compartment Tray; Tan or Sand	A-A-52217C, Type II, Class 3
Unitized Group Ration – Express (UGR-E) Heater Module, General Specification for	MIL-DTL-32235B
Unitized Group Ration – Express (UGR-E) Heater Module: Assembled	MIL-DTL-32235B/4
Unitized Group Ration – Express (UGR-E) Heater Module: Boil-In-Bag (BIB) Module	MIL-DTL-32235B/3A

ACR-E-21
1 April 2021
W/Change 01 20 Oct 21 ES21-049 (DSCP-SS-21-01103)
SUPERSEDING
ACR-E-001B
25 February 2011

B. Contents. The contents of each meal shall be as specified in table II. Refer to table I for full citation and document number of components.

TABLE II. Contents

STANDARD ITEMS		
Component	Unit of Issue, Servings	Quantity
Coffee	1 pouch, 18 per bag	48 1
Creamer	3 g. packet, 18 per bag	48 1
Hot Sauce	3 fl. oz. bottle	1
Gloves	10 per package	1
Cutter, Box	1 unit	1
Hand Wipe	1 packet, 18 per bag	36 2
Trays, Mess	1 tray, 18 per bag	48 1
Dining Packets	1 packet, 9 per bag	48 2
Trash Bags	4 per package	1
Heater Module	1 module	1

UGR-E BREAKFAST MENU 1

Component	Unit of Issue, Servings	Quantity
Egg Mix, BIB Module	18 per BIB	1
Beef and Potatoes in Cream Gravy	18 per tray	1
Tortillas, Plain	1 (2 count) pouch 2 count pouch, 9 per bag	48 2
Apple Dessert	18 per tray	1
Cake, Breakfast, Apple Spice	18 per tray	1
Peanut Butter and Strawberry Jam	1 Twin pack, 9 per bag	48 2
Juice, Orange	1 pouch, 9 per bag	48 2
Serving Utensils	2 Spoons, 1 Slotted Spoon, 1 Spatula	

ACR-E-21
1 April 2021
W/Change 01 20 Oct 21 ES21-049 (DSCP-SS-21-01103)
SUPERSEDING
ACR-E-001B
25 February 2011

UGR-E BREAKFAST MENU 2

Component	Unit of Issue, Servings	Quantity
Egg Mix, BIB Module	18 per BIB	1
Cajun Style Chicken with Andouille Chicken Sausage	18 per tray	1
Rice, Brown	18 per tray	1
Cake, Breakfast with Maple Flavored Syrup	18 per tray	1
Nuts and Raisins	1 pouch, 9 per bag	182
Juice, Grape	1 pouch, 9 per bag	182
Serving Utensils	2 Spoons, 1 Slotted Spoon, 1 Spatula	

UGR-E BREAKFAST MENU 3

Component	Unit of Issue, Servings	Quantity
Egg Mix, BIB Module	18 per BIB	1
Beef and Potatoes in Cream Gravy	18 per tray	1
Turkey Sausage Patties in Brine	18 per tray	1
Cake, Breakfast with Maple Flavored Syrup	18 per tray	1
Granola, With Milk and Blueberries	1 pouch, 9 per bag	182
Juice, Grape	1 pouch, 9 per bag	182
Serving Utensils	1 Spoon, 2 Slotted Spoons, 1 Spatula	

ACR-E-21
1 April 2021
W/Change 01 20 Oct 21 ES21-049 (DSCP-SS-21-01103)
SUPERSEDING
ACR-E-001B
25 February 2011

UGR-E BREAKFAST MENU 4

Component	Unit of Issue, Servings	Quantity
Egg Mix, BIB Module	18 per BIB	1
Hash, Corned Beef	18 per tray	1
Tortillas, Plain	1 (2 count) pouch 2 count pouch, 9 per bag	18 2
Cake, Golden Harvest with White Icing	18 per tray	1
Oatmeal, Apple Cinnamon	18 per tray	1
Peanut Butter and Grape Jelly	1 1 tw in pack, 9 per bag	18 2
Juice, Orange	1 pouch, 9 per bag	18 2
Serving Utensils	2 Spoons, 1 Slotted Spoon, 1 Spatula	

UGR-E LUNCH/DINNER MENU 1

Component	Unit of Issue, Servings	Quantity
Chili with Beans	18 per tray	1
Green Beans, Seasoned	18 per tray	1
Rice, Brown	18 per tray	1
Butter Granules	57 g. package	1
Candy, Pan Coated Disks, Peanut Butter	1 pouch, 9 per bag	18 2
Cake, Chocolate Cherry with Cherry Fruit Topping	18 per tray	1
Chocolate Protein Drink	1 pouch, 9 per bag	18 2
Beverage Base, Sugar Free Orange	1 pouch, 9 per bag	18 2
Serving Utensils	2 Spoons, 1 Slotted Spoon, 1 Spatula	

ACR-E-21
1 April 2021
W/Change 01 20 Oct 21 ES21-049 (DSCP-SS-21-01103)
SUPERSEDING
ACR-E-001B
25 February 2011

~~UGR-E LUNCH/DINNER MENU 2~~

Component	Unit of Issue, Servings	Quantity
Cajun Style Chicken with Andouille Chicken Sausage	18 per tray	1
Corn, Mexican Style	18 per tray	1
Rice, White	18 per tray	1
Cake, Yellow with Chocolate Icing	18 per tray	1
Butter Granules	57 g. package	1
Candy, Pan Coated Disks, Milk Chocolate	1 pouch	18
Beverage, Carbohydrate Fortified, Fruit Punch	1 pouch	18
Serving Utensils	2 Spoons, 1 Slotted Spoon, 1 Spatula	

UGR-E LUNCH/DINNER MENU 2

Component	Unit of Issue, Servings	Quantity
Spaghetti with Meatballs	9 per tray	2
Green Beans, Seasoned	18 per tray	1
Cake, Red Velvet with White Icing	18 per tray	1
Candy, Pan Coated Disks, Milk Chocolate	1 pouch, 9 per bag	2
Butter Granules	57 g. package	1
Beverage, Carbohydrate Fortified, Lemon-Lime	1 pouch, 9 per bag	2
Serving Utensils	1 Spoon, 1 Slotted Spoon, 1 Spatula	

ACR-E-21
1 April 2021
W/Change 01 20 Oct 21 ES21-049 (DSCP-SS-21-01103)
SUPERSEDING
ACR-E-001B
25 February 2011

UGR-E LUNCH/DINNER MENU 3

Component	Unit of Issue, Servings	Quantity
Burgundy Beef Stew	18 per tray	1
Rice, Brown	18 per tray	1
Green Beans, Seasoned	18 per tray	1
Cookies, White Chocolate Chip with Cranberries	18 per tray	1
Nuts and Raisins	1 pouch, 9 per bag	18 2
Chocolate Protein Drink	1 pouch, 9 per bag	18 2
Beverage Base, Sugar Free Orange	1 pouch, 9 per bag	18 2
Butter Granules	57 g. package	1
Serving Utensils	2 Spoons, 1 Slotted Spoon	

UGR-E LUNCH/DINNER MENU 4

Component	Unit of Issue, Servings	Quantity
Buffalo Style Chicken	18 per tray	1
Carrots, Glazed	18 per tray	1
Rice, White	18 per tray	1
Cookies, Chocolate Chip, Chocolate-Covered-Crunchy-Peanut-Butter Candy with Chocolate Chips	18 per tray	1
Candy, Pan Coated Peanut Butter Disks	1 pouch, 9 per bag	18 2
Butter Granules	57 g. package	1
Beverage, Carbohydrate Fortified, Grape	1 pouch, 9 per bag	18 2
Serving Utensils	2 Spoons, 1 Slotted Spoon	

ACR-E-21
1 April 2021
W/Change 01 20 Oct 21 ES21-049 (DSCP-SS-21-01103)
SUPERSEDING
ACR-E-001B
25 February 2011

UGR-E LUNCH/DINNER MENU 5

Component	Unit of Issue, Servings	Quantity
Spaghetti with Meatballs	18 per tray	1
Green Beans, Seasoned	18 per tray	1
Cake, Red Velvet with White Icing	18 per tray	1
Candy, Pan Coated Disks, Milk Chocolate	1 pouch	18
Butter Granules	57 g. package	1
Beverage, Carbohydrate Fortified, Lemon-Lime	1 pouch	18
Serving Utensils	— 1 Spoon, 1 Slotted Spoon, 1 Spatula	

UGR-E LUNCH/DINNER MENU 5

Component	Unit of Issue, Servings	Quantity
Cajun Style Chicken with Andouille Chicken Sausage	18 per tray	1
Corn, Mexican Style	18 per tray	1
Rice, White	18 per tray	1
Cake, Yellow with Chocolate Icing	18 per tray	1
Candy, Pan Coated Disks, Milk Chocolate	1 pouch, 9 per bag	2
Butter Granules	57 g. package	1
Beverage, Carbohydrate Fortified, Fruit Punch	1 pouch, 9 per bag	2
Serving Utensils	2 Spoons, 1 Slotted Spoon, 1 Spatula	

ACR-E-21
1 April 2021
W/Change 01 20 Oct 21 ES21-049 (DSCP-SS-21-01103)
SUPERSEDING
ACR-E-001B
25 February 2011

UGR-E LUNCH/DINNER MENU 6

Component	Unit of Issue, Servings	Quantity
Southwest Chicken Chili	18 per tray	1
Rice, White	18 per tray	1
Carrots, Glazed	18 per tray	1
Cookies, White Chocolate Chip with Cranberries	18 per tray	1
Cashews, Jalapeno	1 pouch, 18 per bag	181
Cheese Spread, Jalapeno	1 pouch, 18 per bag	181
Beverage, Carbohydrate Fortified, Fruit Punch	1 pouch, 9 per bag	182
Butter Granules	57 g. package	1
Serving Utensils	2 Spoons, 1 Slotted Spoon	

UGR-E LUNCH/DINNER MENU 7

Component	Unit of Issue, Servings	Quantity
Beef Fajita Filling	15 per tray	2
Tortillas, Plain	1 (2 count) pouch 2 count pouch, 9 per bag	182
Corn, Mexican Style	18 per tray	1
Cake, Carrot with White Icing	18 per tray	1
Butter Granules	57 g. package	1
Chocolate Protein Drink	1 pouch, 9 per bag	182
Beverage Base, Sugar Free Orange	1 pouch, 9 per bag	182
Serving Utensils	2 Slotted Spoons, 1 Spatula	

ACR-E-21
1 April 2021
W/Change 01 20 Oct 21 ES21-049 (DSCP-SS-21-01103)
SUPERSEDING
ACR-E-001B
25 February 2011

UGR-E LUNCH/DINNER MENU 8

Component	Unit of Issue, Servings	Quantity
Chicken Breast in Gravy	18 per tray	1
Sweet Potato Casserole	18 per tray	1
Green Beans, Seasoned	18 per tray	1
Cookies, Chocolate Chip, Chocolate-Covered-Crunchy-Peanut-Butter Candy with Chocolate Chips	18 per tray	1
Nuts and Raisins	1 pouch, 9 per bag	482
Butter Granules	57 g. package	1
Beverage, Carbohydrate Fortified, Grape	1 pouch, 9 per bag	482
Serving Utensils	2 Spoons, 1 Slotted Spoon	

SECTION D

D-1 PACKAGING

A. Menu and heater module assembly. The components of each menu specified in table II shall be packaged. The heater module shall be completely assembled, as described in the appropriate MIL-DTL-32235 specification sheet. Components may be prepackaged or sub-assembled.

B. Loading sequence. The heater module shall first be loaded in the box, then the other components shall be loaded into the box.

C. Unit packaging. Components shall be packaged in accordance with the documents referenced in table I.

D. Intermediate packaging. Components may be intermediate packaged.

D-2 LABELING

A. Components. Components shall be labeled in accordance with the documents referenced in table I.

ACR-E-21
1 April 2021
W/Change 01 20 Oct 21 ES21-049 (DSCP-SS-21-01103)
SUPERSEDING
ACR-E-001B
25 February 2011

D-3 PACKING

A. Packing. Each complete menu shall be assembled into a box. Each box shall be constructed in accordance with style RSC of ASTM D5118/D5118M, Standard Practice for Fabrication of Fiberboard Shipping Boxes. The fiberboard shall conform to type CF, class D, variety SW, grade V3c of ASTM D4727/D4727M, Standard Specification for Corrugated and Solid Fiberboard Sheet Stock (Container Grade) and Cut Shapes, or equivalent. The maximum outside dimensions of the box shall be 20 by 16 by 10-1/4 inches. Boxes shall be free from evidence of rodent or insect infestation. Boxes shall be assembled by gluing or taping. Each container shall be closed and then sealed (H-taped) in accordance with methods B or C of ASTM D1974/D1974M, Standard Practice for Methods of Closing, Sealing, and Reinforcing Fiberboard Boxes.

D-4 UNITIZATION

A. Unit loads. Boxes shall be arranged in unit loads in accordance with Type I, Class A of DLA Troop Support Form 3507, Loads, Unit: Preparation of Semiperishable Subsistence Items.

D-5 MARKING

A. Shipping boxes and unit loads. Marking of shipping boxes and unit loads shall be as specified in DLA Troop Support Form 3556, Marking Instructions for Boxes, Sacks, and Unit Loads of Perishable and Semiperishable Subsistence. Item name, in letters not less than 1 inch and in permanent contrasting color, shall be as follows:

UGR – Express L/D (Lunch/Dinner) MENU NUMBER __

or

UGR – Express B (Breakfast) MENU NUMBER __

or

UGR – Express Holiday Menu

The shipping container shall also be marked with special marking:

ACR-E-21
1 April 2021
W/Change 01 20 Oct 21 ES21-049 (DSCP-SS-21-01103)
SUPERSEDING
ACR-E-001B
25 February 2011

FOR OUTDOOR USE ONLY

DO NOT ROUGH HANDLE WHEN FROZEN (0°F or below)

NOTE: This case contains WATER-ACTIVATED Flameless Heaters

NOTE: In addition, any hazard markings required by MIL-DLT-32235B, MIL-DTL-32235B/3A, and MIL-DTL-32235B/4, as required for Occupational Safety and Health Administration (OSHA), U.S. Environmental Protection Agency (USEPA) and U.S. Department of Transportation (USDOT) compliance are to be marked as applicable.

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.

(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.

ACR-E-21
1 April 2021
W/Change 01 20 Oct 21 ES21-049 (DSCP-SS-21-01103)
SUPERSEDING
ACR-E-001B
25 February 2011

(1) UGR-E assembled menus examination. The assembled menus shall be examined for the defects specified in table III. The lot size shall be expressed in assembled menus. The sample unit shall be one fully assembled menu. The inspection level shall be S-2 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. Five assembled menus shall be randomly selected from the lot and examined for critical defects. The finding of a critical defect shall be cause for rejection of the lot.

TABLE III. UGR-E assembled menus defects 1/

Category	Defect	
<u>Critical</u>	<u>Major</u>	<u>Minor</u>
1		Any canned food product (including trays) leaking or damaged so as to expose contents.
	101	Bottled product leaking or damaged.
	102	Boxed product leaking or damaged.
	103	Pouched product leaking or damaged.
	104	Component not clean. <u>2/</u>
	105	Box not as specified.
	106	Marking missing or incorrect or illegible.
	107	Box not closed as specified.
	108	Item missing.
	109	Heater module damaged.
	201	More than 5 percent of the quantity of any disposable (except heater module) is crushed or damaged so as to be unusable.
	202	Intermediate bag has tear or open seam.

ACR-E-21
1 April 2021
W/Change 01 20 Oct 21 ES21-049 (DSCP-SS-21-01103)
SUPERSEDING
ACR-E-001B
25 February 2011

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

2/ 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 components 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 cloth.

b. Water spots.

c. Very thin grease, oil, or product residue that is discernible by touch, but is not readily discernible by visual examination.

(2) 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 applicable version of these documents is that which is active on the date of the solicitation or contract.

DLA Troop Support Forms

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

DEPARTMENT OF DEFENSE SPECIFICATIONS

MIL-DTL-32235B	Unitized Group Ration – Express (UGR-E) Heater Module, General Specification for
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ACR-E-21
1 April 2021
W/Change 01 20 Oct 21 ES21-049 (DSCP-SS-21-01103)
SUPERSEDING
ACR-E-001B
25 February 2011

MIL-DTL-32235B/4 Unitized Group Ration – Express (UGR-E)
Heater Module: Assembled

MIL-DTL-32235B/3A Unitized Group Ration – Express (UGR-E)
Heater Module: Boil-In-Bag (BIB) Module

(Copies of these documents are available from <http://quicksearch.dla.mil/qsSearch.aspx> or from the Standardization Document Order Desk, 700 Robbins Ave, Building 4D, Philadelphia, PA 19111-5094.)

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

D1974/1974M Standard Practice for Methods of Closing, Sealing, and
Reinforcing Fiberboard Boxes

D4727/D4727M Standard Specification for Corrugated and Solid
Fiberboard Sheet Stock (Container Grade) and Cut
Shapes

D5118/D5118M Standard Practice for Fabrication of Fiberboard
Shipping Boxes