

**PKG&QAP A-A-20081G**  
**24 March 2020**  
**W/Change 01 04 Nov 20 ES20-054 (DSCP-SS-20-00822)**  
**SUPERSEDING**  
**PKG&QAP A-A-20081F**  
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## **SECTION C**

This document covers bacon, precooked, sliced 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-20081G, BACON, PRECOOKED, SLICED, IN FLEXIBLE POUCHES**

Type.

Type II - Institutional Size Pouch – 150 slices

### **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 this Packaging Requirements and Quality Assurance Provisions document. 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 noncomparable to the product standard, the contractor shall submit a replacement FA or PDM for 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. Count. No individual pouch shall contain less than 143 slices of bacon.

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

E. Analytical requirements. The fat content, salt content, and water activity ( $A_w$ ) requirements, procedures, and testing shall be in accordance with A-A-20081G.

## SECTION D

### D-1 PACKAGING

A. Packaging. One hundred and fifty slices of precooked bacon, shingled and placed on sheets of parchment or commercial style food grade paper with ovenable, grease proof, wet strength characteristics shall be packed in an 11 by 16-1/2 inches (approximate) pre-formed or form-fill-seal barrier Institutional Size Pouch (ISP) as described in MIL-PRF-44073, Packaging of Food in Flexible Pouches. As an alternative, the combination of an interior form-fill-seal pouch, exterior pre-formed barrier pouch, and an appropriate quantity of oxygen scavenging sachets, is also acceptable. The filled pouch, or interior form-fill-seal pouch if a combination is used, shall be sealed under a vacuum of not less than 20 inches (50.8 cm) of mercury. The filled and sealed exterior 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. A tear nick, notch or serrations shall be provided to facilitate opening of the filled and sealed barrier pouch. The slices of precooked bacon and parchment paper or commercial style food grade paper, shall be stacked so as to allow the exterior pouch to be folded over to fit into the Unitized Group Ration (UGR) module shipping container cell (12 inches by 11-1/2 inches) without folding the bacon slices. The bacon shall be processed and packaged not more than 90 days prior to shipment.

### D-2 LABELING

A. Pouches. Each exterior 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. As an alternate method, a pre-printed self-adhering 0.002 inch thick clear polyester label printed with indelible contrasting color ink may be used. The label shall contain the following information:

**Note:** The font tested by Natick was Microsoft Helvetica. The font used shall be similarly clear/easy to read as Helvetica. The recommended font sizes are as follows: 22 for the product name, 14 for “yield” and “to heat in water.” If an additional note is required on the label it should also be in font size 14. All other information should be in font size 9.

- (1) Product name
- (2) Ingredients
- (3) Date 1/ 2/
- (4) Quantity: 150 slices

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- (5) Name and address of packer
- (6) Official establishment number
- (7) USDA official inspection legend for the packer's plant
- (8) "Nutrition Facts" label in accordance with the Nutrition Labeling and Education Act (NLEA) and all applicable 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, 14 February 2030 would be coded as 0045. The Julian day code shall represent the day the product was packaged into the pouch.

2/ If the alternative combination package is used, the interior form-fill-seal pouch shall be labeled with 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. The Julian day code shall represent the day the product was packaged into the pouch. The exterior pre-formed barrier pouch shall also be labeled using the Julian day code to represent the day the product was packaged into the exterior pouch.

**YIELD:** Serves 50 portions of approximately 3 slices each

**TO HEAT IN WATER:** Submerge unopened pouch in water. Bring water to a boil. Simmer for 30 minutes. Avoid overheating (pouch shows evidence of bulging).

**TO GRILL OR BAKE:** Invert each layer, bacon side on grill or baking sheet. Peel off paper. Heat until bacon starts to crisp (350°F Grill or 375°F Oven).

**WARNING:** Do not heat pouch in oven.

**CAUTION:** Use care when opening as pressure may have been generated within the pouch.

**TO OPEN:** Open at tear notch or cut with a clean knife.

### **D-3 PACKING**

A. Packing. Not more than 40 pounds of product shall be packed in a fiberboard shipping box constructed in accordance with style RSC-L of ASTM D5118/D5118M, Standard Practice for Fabrication of Fiberboard Shipping Boxes. The fiberboard shall conform to type

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CF, class D, variety SW, minimum burst grade 200 or ECT 32 of ASTM D4727/D4727M, Standard Specification for Corrugated and Solid Fiberboard Sheet Stock (Container Grade) and Cut Shapes. Each box shall be closed in accordance with ASTM D1974/D1974M, Standard Practice for Methods of Closing, Sealing, and Reinforcing Fiberboard Boxes.

#### **D-4 UNIT LOADS**

A. Unit loads. Unit loads shall be as specified in accordance with DLA Troop Support Form 3507, Loads, Unit: Preparation of Semiperishable Subsistence Items.

#### **D-5 MARKING**

A. Shipping containers and unit loads. Shipping containers and unit loads shall be marked in accordance with DLA Troop Support Form 3556, Marking Instructions for Boxes, Sacks, and Unit Loads of Perishable and Semiperishable Subsistence.

### **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.

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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 appearance, odor, flavor, and texture. Any failure to conform to the performance requirements or any appearance or palatability failure shall be cause for rejection of the lot.

(2) Periodic review evaluation. 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:

DEPARTMENT OF THE ARMY  
FCDD-SCD-SCR  
COMBAT CAPABILITIES DEVELOPMENT COMMAND-SOLDIER CENTER  
10 GENERAL GREENE AVENUE  
NATICK, MA 01760-5056

One lot shall be randomly selected during each calendar month of production or as otherwise specified in the contract. Two (2) sample units shall be randomly selected from that one production lot. The two (2) sample units shall be shipped to Natick within five (5) working days from the end of the production month from which they are randomly selected and upon completion of all USDA inspection requirements. The sample units will be evaluated for overall quality against the current first article or product demonstration model.

(3) Conformance inspection. Conformance inspection shall include the examinations/tests and 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 specified in A-A-20081G and Section C of the Packaging Requirements and Quality Assurance Provisions document utilizing the double sampling plans indicated in ANSI/ASQ Z1.4. 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 4.0 for major

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defects and 6.5 for minor defects. Defects and defect classifications are listed in table I. The pouches shall be heated in water in accordance with pouch label instructions prior to conducting any portion of the product examination.

TABLE I. Product defects 1/ 2/

Category		Defect
<u>Major</u>	<u>Minor</u>	
		<u>Appearance</u>
101		Pouch contains less than 143 slices of bacon.
102		Product not as specified.
103		Precooked, sliced bacon not 5.0 inches (12.7 cm) to 8.0 inches (20.3 cm) in length or not more than 1-1/2 inches (3.8 cm) in width.
104		Bone or bone fragment measuring 0.3 inch (7.6 mm) or more in any dimension.
	201	Precooked, sliced bacon does not have a reddish brown lean portion or does not have an off-white to yellow tan fat portion.
	202	Bacon contains cartilage or skin or bruise measuring 0.3 inch (7.6 mm) or more in any dimension.
	203	Bacon contains glandular tissue measuring 0.5 inch (12.7 mm) or more in any dimension.
	204	Bacon slice cut or torn more than one-half the width of the slice. <u>3/</u>
	205	Bacon slices have burnt edges or burnt areas measuring 0.3 inch (7.6 mm) by 0.2 (5.1 mm) or more in any dimension (a burnt edge is one in which the black color of carbonation is evident to the eye). <u>4/</u>
	206	Bacon slices break or crack when the ends are brought together. <u>5/</u>
	207	Individual bacon slice separates more than one half the length of the slice. <u>6/</u>

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TABLE I. Product defects 1/ 2/ - Continued

Category	Defect	
<u>Major</u>	<u>Minor</u>	
	208	Precooked bacon slices not placed layout style with edges abutting on sheets. <u>7/</u>
	209	Precooked, sliced bacon not placed on sheets of parchment or commercial style food grade paper, as specified.
		<u>Odor and flavor</u>
105		Product does not have a smoky or not a salty or not a cured or not a cooked bacon odor or flavor.

1/ Presence of any foreign materials such as, but not limited to dirt, insect parts, hair, glass, wood, or metal, or any foreign odors or flavors such as, but not limited to burnt, scorched, rancid, sour, stale, musty or moldy 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/ More than 8 slices (5 percent) of the bacon slices cut or torn more than one-half of the width of the slice.

4/ More than 5 slices (3 percent) of the slices exhibit burnt areas per pouch.

5/ More than 30 slices (20 percent) of the bacon slices break or crack when the ends are brought together.

6/ More than 8 slices (5 percent) of the individual bacon slice separates more than one half the length of the slice.

7/ More than 15 slices (10 percent) of the slices with two or more slices overlapping on another slice.

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

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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 quality scale to be considered acceptable.

(2) Analytical tests. The following conditions apply for analytical testing:

a. For prepackaged product received from a supplier that is not further processed, USDA shall perform analytical testing on the first production lot and each subsequent replenishment PDM during a contract cycle. For all lots in between, the contractor will furnish a Certificate of Analysis (CoA) providing test results showing that the product meets all analytical requirements. The CoA shall cover no greater than a 24 hour production time frame.

b. For bulk product received that is to be repackaged, the contractor will furnish a CoA providing test results showing that the bulk product received meets all analytical and microbiological requirements. For fat, salt, and water activity testing, if the bulk and end item lot identities have been preserved, then skip lot testing may be implemented once an acceptable quality history, as determined by the contracting officer, has been established.

c. If the precooked bacon slices are received in bulk and the conditions in (b) above are not met, each end item lot must be sampled and tested by the USDA and skip lot is not applicable.

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

### **A. Packaging.**

(1) Pouch material testing. The exterior pouch material shall be examined for the characteristics listed in table I of MIL-PRF-44073, Packaging of Food in Flexible Pouches for Type II. Any test failure shall be classified as a major defect and shall be cause for rejection of the lot.

(2) Filled and sealed pouch testing. The filled and sealed processed exterior pouches shall be examined for the defects listed in table II. The lot size shall be expressed in pouches. The sample unit shall be one pouch. The inspection level shall be II and the AQL, expressed



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in terms of defects per hundred units, shall be 0.65 for major defects and 2.5 for minor defects. Two hundred sample units shall be examined for critical defects. The finding of any critical defect shall be cause for rejection of the lot.

TABLE II. Filled and sealed pouch defects 1/

Category		Defect
<u>Critical</u>	<u>Major</u>	<u>Minor</u>
1		Tear or hole or open seal. <u>2/</u>
2		Seal width less than 1/16 inch. <u>2/ 3/</u>
	101	Presence of delamination. <del>3/</del> <u>4/</u>
	102	Unclean pouch. <del>4/</del> <u>5/</u>
	103	Pouch has foreign odor.
	104	Any impression or design on the heat seal surfaces which conceals or impairs visual detection of seal defects. <del>5/</del> <u>6/</u>
	105	Not packaged as specified.
	106	Presence of stress cracks in the aluminum foil. <del>6/ 7/</del> <u>8/</u>
	107	If alternative combination packaging is used, oxygen scavenging sachets missing between interior and exterior pouches.
	<u>108</u>	Filled and sealed exterior pouch exhibits rupture or seal separation greater than 1/16 inch or seal separation that reduces the effective closure seal less than 1/16 inch when tested for internal pressure resistance.
	201	Exterior barrier ISP pouch label missing or incorrect or illegible.

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TABLE II. Filled and sealed pouch defects 1/ - Continued

Category	Defect
<u>Critical</u>	
<u>Major</u>	
<u>Minor</u>	
	<del>202</del> If alternative combination packaging is used, interior form-fill seal pouch label missing or incorrect or illegible.
	203 <sup>2</sup> Tear nick or notch or serrations missing or does not facilitate opening. <sup>2/</sup>
	204 <sup>3</sup> Seal width less than 1/8 inch but greater than or equal to 1/16 inch. <sup>2/ 3/</sup>
	205 <sup>4</sup> Presence of delamination. <del>3/</del> <sup>2/ 4/</sup>

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

2/ Shall apply to both the interior and exterior barrier pouch.

~~2/~~ <sup>3/</sup> 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/~~ <sup>4/</sup> 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 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

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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/~~ **5/** 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).

~~5/~~ **6/** 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.

~~6/~~ **7/** Applicable to form-fill-seal pouches only.

~~7/~~ **8/** The initial examination shall be a visual examination of the closed package. Any suspected visual evidence of stress cracks in the aluminum foil (streaks, breaks, or other disruptions in the laminated film) shall be verified by the following physical examination. To examine for stress cracks, the inside surface of both tray-shaped bodies shall be placed over a light source and the outside surface observed for the passage of light. Observation of light

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through the pouch material in the form of a curved or straight line greater than 2 mm in length shall be evidence of the presence of stress cracks. Observation of light through the pouch material in the form of a curved or straight line 2 mm in length or smaller or of a single pinpoint shall be considered a pinhole. Observation of ten or more pinholes per pouch shall be evidence of material degradation.

(3) Pouch vacuum examination. The filled and sealed exterior pouches (to include when a combination package with oxygen scavenging sachets are used) shall be visually examined for conformance to the vacuum requirement not less than 96 hours after filling and sealing. The sealed exterior pouch (non-combination pouch only) shall continue to exhibit tight adherence to the surface contours of the contents when a pulling force is applied at the center of each side seal. This force shall be applied by holding each side seal between thumb and forefinger of each hand, while simultaneously exerting a slight pull with both hands. Any evidence of loss of vacuum shall be classified as a critical defect and shall be cause for rejection of the lot. If evidence of vacuum cannot be readily determined when using a combination package, the exterior barrier ISP may be opened and the form-fill-seal interior pouch examined as described above. The lot size shall be expressed in pouches. The sample unit shall be one filled and sealed pouch. The inspection level shall be I and the AQL, expressed in terms of defects per hundred units, shall be 0.65.

B. Packing.

(1) Shipping container and marking examination. The filled and sealed shipping containers shall be examined for the defects listed in table III. 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 missing or incorrect or illegible.
102		Inadequate workmanship. <u>1/</u>
	201	More than 40 pounds of product.

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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**

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

### GOVERNMENT PUBLICATION

Federal Meat Inspection Act (FMIA) and regulations promulgated thereunder (9 Code of Federal Regulations (CFR) Parts 1-391)

### DEPARTMENT OF DEFENSE SPECIFICATION

MIL-PRF-44073 Packaging of Food in Flexible Pouches

(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](http://www.asq.org)

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

ASTM INTERNATIONAL [www.astm.org](http://www.astm.org)

D1974/D1974M Standard Practice for Methods of Closing, Sealing, and Reinforcing Fiberboard Boxes

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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