

**PKG&QAP A-A-20195E**  
**25 July 2019**  
**W/Change 03 22 June 23 ES23-036 (DSCP-SS-23-00785)**  
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**PKG&QAP A-A-20195D**  
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## **SECTION C**

This document covers snack foods 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-20195E SNACK FOODS**

##### **Types, styles, and flavors.**

Type II - Pretzels

Style C – Sticks

Flavor 1 – Plain, salted

Style E – Nuggets

Flavor 2 – Honey mustard and onion

Style F – Filled pretzels

Flavor 1 – Cheddar cheese

Type V – Baked snack crackers

Flavor 1 – Cheddar cheese

Flavor 2 – Hot and spicy cheese

Type VI – Toasted corn kernels

Flavor 1 – Plain, salted

Flavor 2 – Barbecue

Type VII – Cheese-filled crackers

Flavor 1 – Cheddar cheese

Flavor 2 – Pepperoni pizza

Type IX – Protein puffs, ring shaped

Flavor 1 – Barbecue

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**Packages.**

Package A - Meal, Cold Weather

Package C - Meal, Ready-to-Eat (MRE)

Package J - First Strike Ration® (FSR)

Package L - Food Packet, Modular Operational Ration Enhancement (MORE)

Package M - Close Combat Assault Ration (CCAR)

**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. Net weight.

- (1) Type II, Styles C and E. The net weight of one serving shall be 28 grams.
- (2) Type II, Style F. The net weight of one serving shall be 51 grams.
- (3) Type V. The net weight of one serving shall be 47 grams.
- (4) Type VI. The net weight of one serving shall be 57 grams.
- (5) Type VII. The net weight of one serving shall be 48 grams.
- (6) Type IX. The net weight of one serving shall be 32 grams.

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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.

(1) Moisture, protein, fat, and sodium. For all types, the moisture, protein, fat, and sodium content requirements, procedures and testing shall be in accordance with A-A-20195E.

(2) Oxygen. The oxygen content of the filled and sealed pouch for Type II, Styles C, E and F, Type V, Type VI, Type VII and Type IX, shall not exceed 0.30 percent.

F. Aflatoxin. For Type VI, the aflatoxin content of the corn kernels used to produce the toasted corn kernels shall be negative (15 ppb or less).

## **SECTION D**

### **D-1 PACKAGING**

A. Packaging. The snack foods shall be packaged in a preformed or form-fill-seal barrier pouch as described below. For Type II, Styles C, and E, Type V, Type VI, Type VII, Flavor 1, and Type IX, the pouch shall contain one oxygen scavenger.

(1) Preformed pouch.

a. Pouch material. The preformed pouch shall be fabricated from 0.002 inch thick ionomer or polyethylene film laminated or extrusion coated to 0.00035 inch thick aluminum foil which is then laminated to 0.0005 inch thick polyester. Tolerances for thickness of plastic films shall be plus or minus 20 percent and tolerance for the foil layer shall be plus or minus 10 percent. The material shall show no evidence of delamination, degradation, or foreign odor when heat sealed or fabricated into pouches. The material shall be suitably formulated for food packaging and shall not impart an odor or flavor to the product. The complete exterior surface of the pouch shall be uniformly colored and shall conform to number 20219, 30219, 30227, 30279, 30313, 30324, or 30450 of SAE AMS-STD-595, Colors Used in Government Procurement.

b. Pouch construction. The pouch shall be a flat style preformed pouch having maximum inside dimensions of 5 inches wide by 7-1/4 inches long. The pouch shall be made

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by heat sealing three edges with 3/8 inch (-1/8 inch, +3/16 inch) wide seals. The side and bottom seals 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. Alternatively, 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. A tear nick, notch, or serrations shall be provided to facilitate opening of the filled and sealed pouch. A 1/8 inch wide lip may be incorporated at the open end of the pouch.

c. Pouch filling and sealing. The product and one oxygen scavenger (if applicable) shall be inserted into the pouch. The filled pouch shall be sealed. For package M only, the filled pouch shall be sealed under a vacuum of 15 to 20 inches of mercury with a minimum 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 1/16 inch. Seals shall be free of impression or design on the seal surface that would conceal or impair visual detection of seal defects. 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. Alternatively, 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) Horizontal form-fill-seal pouch.

a. Pouch material. The horizontal form-fill-seal pouch shall consist of a formed tray-shaped body with a flat sheet, heat sealable cover or a tray-shaped body with a tray-shaped heat sealable cover. The tray-shaped body and the tray-shaped cover shall be fabricated from a 3-ply flexible laminate barrier material consisting of, from outside to inside, 0.0009 inch thick oriented polypropylene bonded to 0.0007 inch thick aluminum foil with 10 pounds per ream pigmented polyethylene or adhesive and bonding the opposite side of the aluminum foil to 0.003 inch thick ionomer or a blend of not less than 50 percent linear low density polyethylene and polyethylene. The linear low density polyethylene portion of the blend shall be the copolymer of ethylene and octene-1 having a melt index range of 0.8 to 1.2 g/10 minutes in accordance with ASTM D1238, Standard Test Method for Melt Flow Rates of Thermoplastics by Extrusion Plastometer and a density range of 0.918 to 0.922 g/cc in accordance with ASTM D1505, Standard Test Method for Density of Plastics by the Density- Gradient Technique. Alternatively, 0.0005 inch thick polyester may be used in place of the oriented polypropylene as the outer ply of the laminate. The flat sheet cover shall be made of the same 3-ply laminate as specified for the tray-shaped body except the aluminum

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foil thickness may be 0.00035 inch. Tolerances for thickness of plastic films shall be plus or minus 20 percent and tolerance for the foil layer shall be plus or minus 10 percent. The color requirements of the exterior (oriented polypropylene or polyester side) of the laminate shall be as specified in D-1,A(1)a. The material shall show no evidence of delamination, degradation, or foreign odor when heat sealed or fabricated into pouches. The material shall be suitably formulated for food packaging and shall not impart any odor or flavor to the product.

b. Pouch construction. The tray-shaped body and the tray-shaped cover shall be formed by drawing the flexible laminate material into an appropriately shaped cavity. The flat cover shall be in the form of a flat sheet of the barrier material taken from roll stock. The product and one oxygen scavenger (if applicable) shall be placed into the tray-shaped body of the pouch. **For package M only, the product shall be placed into the tray-shaped body of the pouch and sealed under a vacuum of 15 to 20 inches of mercury.** Pouch closure shall be effected by heat sealing together the cover and body along the entire pouch perimeter. The closure seal width shall be a minimum of 1/8 inch. The closure 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. Alternatively, 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. The maximum outside dimensions of the sealed pouches shall be 5-1/2 inches wide by 8-5/8 inches long. A tear nick, notch, or serrations shall be provided to facilitate opening of the filled and sealed pouch. The sealed pouch shall not show any evidence of material degradation, aluminum stress cracking, delamination or foreign odor. Heat seals shall be free of entrapped matter that reduces the effective closure seal width to less than 1/16 inch. Seals shall be free of impression or design on the seal surface that would conceal or impair visual detection of seal defects.

(3) Oxygen scavenger. The oxygen scavenger shall be constructed of materials that are safe for direct food contact. The oxygen scavenger shall be in compliance with all applicable Food and Drug Administration (FDA) regulations.

## **D-2 LABELING**

A. Pouches. Each 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. The label shall contain the following information:

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- (1) Name and flavor of product (letters not less than 1/8 inch high)
- (2) Ingredients
- (3) Date 1/
- (4) Net weight
- (5) Name and address of packer
- (6) "Nutrition Facts" label in accordance with the Nutrition Labeling and Education Act (NLEA) and all applicable FDA 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 2020 would be coded as 0045. The Julian day code shall represent the day the product was packaged into the pouch.

### **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 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-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.

## **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.

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(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. 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-SCC-EMR  
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. Three (3) sample units shall be randomly selected from that one production lot. The three (3) 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.

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(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-20195E and Section C of this 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 1.5 for major defects and 4.0 for minor defects. Defects and defect classifications are listed in table I.

TABLE I. Product defects 1/ 2/ 3/

Category		Defect
<u>Major</u>	<u>Minor</u>	
		<u>General</u>
101		Product not type or not style or not flavor as specified.
102		Pouch does not contain one intact oxygen scavenger. <u>4/</u>
	201	Types II, V, VII and IX shall not contain more than 30 percent by weight of broken pieces per serving. <u>5/</u>
		<u>Type II - Pretzels - Style C - Sticks (flavor 1) 4/ 5/</u>
103		Pretzels do not have a hard surface or do not have a dry center or do not have a crunchy texture.
104		Pretzels do not have a baked wheat flour odor or flavor.
105		Pretzels do not have a golden-brown exterior color or do not have a creamy-white interior color.
		<u>Type II - Pretzels - Style E - Nuggets (flavor 2) 4/ 5/</u>
106		Pretzel nuggets do not have a hard surface or do not have a dry center or do not have a crunchy texture.



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TABLE I. Product defects 1/ 2/ 3/ - Continued

Category		Defect
<u>Major</u>	<u>Minor</u>	
107		Pretzel nuggets do not have a baked wheat flour or not slightly sweet or not a mustard and onion odor or flavor.
108		Pretzel nuggets do not have a golden-brown exterior color or do not have a creamy-white interior color or do not have a dusting of visible yellow spices. <u>Type II - Pretzels - Style F - Filled pretzels (flavor 1) 5/ 6/ 7/</u>
109		Cheese filled pretzel does not consist of a puffed or extruded cylindrical pretzel shell surrounding a cheese filling.
110		Percent filling less than 32 percent by weight of the filled pretzel.
111		Pretzel shell does not have a crunchy texture.
	202	Cheese filled pretzel filling not soft or not slightly chalky.
112		Pretzel shell does not have a baked wheat flour odor or flavor.
	203	Pretzel shell does not have a golden-brown exterior color with a hard glossy surface.
	204	Cheese filled pretzel filling not an orange-brown color.
113		Flavor 1, cheddar cheese filled pretzel filling does not have a slightly tangy cheddar cheese flavor. <u>Type V - Baked snack cracker (flavors 1 and 2) 4/ 5/</u>
114		Finished baked snack crackers do not have a symmetrical, 3/4 to 1-1/4 inch (1.9 - 3.2 cm) size.
115		Snack crackers do not have a firm, crispy texture.
	205	Snack crackers do not have a raised “air baked” appearance.

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TABLE I. Product defects 1/ 2/ 3/ - Continued

Category		Defect
<u>Major</u>	<u>Minor</u>	
	206	Snack crackers do not have perforated edges around the wafer.
116		Snack crackers do not have a baked wheat cracker flavor or odor.
117		Flavor 1, cheddar cheese snack crackers do not have a fresh or not tangy or not dehydrated cheddar cheese odor or flavor.
118		Flavor 2, hot and spicy cheese snack crackers do not have a spicy jalapeno or not dehydrated cheese odor or flavor.
	207	Flavor 1, cheddar cheese snack crackers do not have a light to medium orange color.
	208	Flavor 2, hot and spicy cheese snack crackers do not have a dark orange color.
<u>Type VI - Toasted corn kernels (flavors 1 and 2) 4/ 8/ 9/ 10/ 11/</u>		
119		Toasted corn kernel texture not crispy or not lightly crunchy or kernels are hard.
120		Flavor 1, toasted corn kernels do not have a toasted corn or not salty or not slight oil flavor or a toasted corn odor.
121		Flavor 2, toasted corn kernels do not have a mild spicy or not barbecue odor or flavor.
122		Flavor 1, toasted corn kernels do not have a bright to moderate golden-yellow color with fine grain salt on the surface.
123		Flavor 2, toasted corn kernels do not have a light to medium red color with fine grain salt and spice particles on the surface.

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TABLE I. Product defects 1/ 2/ 3/ - Continued

Category		Defect
<u>Major</u>	<u>Minor</u>	
		<u>Type VII - Cheese filled crackers (flavors 1 4/ and 2) 5/ 6/ 7/</u>
124		Cheese filled cracker does not consist of a cylindrical cracker shell surrounding a cheese filling.
125		Percent filling less than 32 percent by weight of the filled pretzel.
126		Cheese filled cracker shell does not have a crunchy or not a dry texture.
	209	Cheese filled cracker filling not soft or not slightly chalky.
127		Cheese filled cracker shell does not have a baked wheat cracker odor or flavor.
128		Flavor 1, cheddar cheese filled cracker filling does not have a mild or not a tangy cheddar cheese flavor.
129		Flavor 2, pepperoni pizza cheese filled cracker filling does not have a mild tomato or pepperoni and cheese flavor.
	210	Cheese filled cracker shell does not have a golden-brown color with salt crystals that adhere to the surface.
	211	Cheese filled cracker filling does not have an orange-brown color.
		<u>Type IX – Protein puffs, ring shaped (flavor 1) 4/ 5/</u>
	212	Flavor 1, ring shaped protein puffs are not approximately 1/2 – 3/4 inch in diameter.
	213	Flavor 1, ring shaped protein puffs are not crispy or not crunchy or do not have a dry center.
	214	Flavor 1, ring shaped protein puffs do not have a reddish-orange exterior color or do not have an off-white interior color.

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TABLE I. Product defects 1/ 2/ 3/ - Continued

Category		Defect
<u>Major</u>	<u>Minor</u>	
130		Flavor 1, ring shaped protein puffs do not have a moderate smoky barbecue, or not a paprika odor or flavor.
	215	Flavor 1, ring shaped protein puffs do not have a slight to moderate heat.
		<u>Net weight</u>
	216	For Type II, Styles C and E, net weight of an individual pouch less than 28 grams.
	217	For Type II, Style F, net weight of an individual pouch less than 51grams.
	218	For Type V, net weight of an individual pouch less than 47 grams.
	219	For Type VI, net weight of an individual pouch less than 57 grams.
	220	For Type VII, net weight of an individual pouch less than 48 grams.
	221	For Type IX, net weight of an individual pouch less than 32 grams.

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/ Sodium and fat content shall be verified by the product supplier's Certificate of Analysis (CoA). If government verification testing is performed for sodium and fat contents on a filled and sealed lot, product shall be tested in accordance with A-A-20195E.

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4/ Applicable to Type II, Styles C, and E, Type V, Type VI, Type VII, Flavor 1, and Type IX. Construction of the oxygen scavenger and compliance with FDA regulations shall be verified by a Certificate of Conformance (CoC).

5/ Verification that at least 30 percent broken pieces by weight of the pretzels, crackers, and protein puffs in the finished product shall be verified by USDA on the first production lot of a contract cycle or in the case a new snack supplier is obtained. A CoC for intact product shall be provided on all future lots produced using the same snack supplier.

6/ Pouches which contain an amount of discolored, burnt, crushed or very small pieces which materially distract from the overall good quality, appearance, and palatability of the product shall be classified as a major defect.

7/ For Type II, Style F and Type VII, the percent filling requirement shall be verified by a CoC.

8/ Corn kernel size and the requirement that toasted corn kernels be prepared from whole hybrid corn kernels that have been steam baked/toasted shall be verified by a CoC.

9/ The contractor shall provide a CoA from the USDA, AMS, Science and Technology Programs (S&TP) laboratory stating that the aflatoxin content of the corn kernels used to produce the toasted corn kernels is 15 ppb or less. Failure to meet the 15 ppb aflatoxin limit or loss of traceability shall be cause for rejection of the toasted corn kernel lot(s).

10/ The contractor shall provide a CoC identifying all toasted corn kernel lot numbers and their respective lot weights that are traceable to the accompanying USDA Aflatoxin CoA.

11/ If more than 30 days have elapsed between the date of the USDA Aflatoxin CoA for the corn kernel ingredient and the date the toasted corn kernels are packaged for the final product, the contractor shall provide a CoC certifying that all toasted corn kernel lots have been stored at less than 80°F and less than 75 percent relative humidity.

**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 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

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palatability and must receive an overall score of 5 or higher based on a 9 point quality scale to be considered acceptable.

(2) Net weight.

a. Commercially wrapped product in pouch. The net weight shall be verified with the label on the commercial package. Product not conforming to the net weight requirement, as specified, shall be cause for rejection of the lot.

b. Non-commercially wrapped product in pouch. The net weight of the filled and sealed pouches shall be determined by weighing each sample unit on a suitable scale tared with a representative empty pouch and oxygen scavenger, as applicable. Results shall be reported to the nearest gram. Product not conforming to the net weight requirement, as specified, shall be cause for rejection of the lot.

(3) Oxygen testing. Eight filled and sealed pouches shall be randomly selected from one production lot and individually tested for oxygen content. Testing shall be accomplished after the filled and sealed pouches have been allowed to equilibrate at room temperature for not less than 48 hours from the time of sealing. Test results shall be reported to the nearest 0.01 percent. Government verification will be conducted through actual testing by a Government laboratory. Any individual result not conforming to the oxygen content requirement shall be cause for rejection of the lot.

(4) Aflatoxin testing. The sample to be analyzed shall be a composite of eight filled and sealed pouches which have been selected at random from the lot. The composited sample shall be prepared and analyzed in accordance with the OMA of AOAC International method 991.31 with preparation of the sample performed according to AOAC method 977.16. Test results shall be reported to the nearest whole number. Government verification will be conducted through actual testing by a Government laboratory. Any result not conforming to the requirement shall be cause for rejection of the lot.

NOTE: The following conditions apply for aflatoxin testing:

a. For prepackaged toasted corn kernels product received from a supplier which are not further processed, the contractor will furnish a CoA that the aflatoxin in the corn kernels represented is not greater than 15 ppb. No additional testing is required. Results shall be reported to the nearest whole number.

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b. For corn kernels received in bulk (to be used in toasted corn kernels end item), the contractor can accept a USDA certificate that the aflatoxin in the bulk lot is below 15 ppb. If a USDA certificate does not accompany the bulk lot, the following alternate method of inspection may be used. The contractor shall have the bulk shipment sampled and tested by USDA. (Sampling shall take place at the contractor location where the finished product will be placed into the pouch.)

(i) Three sets of representative, independently-drawn samples shall be submitted to the laboratory for testing – the number of sampling points and quantity of corn kernels per sampling point to be determined using USDA procedures. Each of the three sets of samples shall be composited and respectively designated as test sample 1, test sample 2, and test sample 3.

(ii) Lots will be reported as negative for aflatoxin if test sample 1 has an aflatoxin level at or below 5 ppb. If test sample 1 is at or above 25 ppb the lot fails.

(iii) If the aflatoxin level for test sample 1 is above 5 ppb and less than 25 ppb, test sample 2 may be analyzed. Test results for test sample 1 and 2 will be averaged. If the average aflatoxin level for test samples 1 and 2 is 10 ppb or less the lot will be reported as negative for aflatoxin, but fails if the aflatoxin level is at or above 20 ppb.

(iv) If the average value for test samples 1 and 2 is above 10 ppb but less than 20 ppb, test sample 3 may be analyzed. The results of test samples 1, 2 and 3 will be averaged. If the average aflatoxin level for test samples 1, 2, and 3 is 15 ppb or less the lot will be reported as negative for aflatoxin. If the average aflatoxin level for test samples 1, 2, and 3 is above 15 ppb the lot fails.

(v) Bulk lots determined to be conforming for aflatoxin as evidenced by a USDA certificate, in accordance with the above procedures will be considered acceptable for use as ingredients. Results shall be reported to the nearest whole number. No additional finished product aflatoxin testing is required if the end item lots are manufactured using that bulk product and both the bulk and end item lots' identities have been preserved. Bulk corn kernels with aflatoxin greater than 15 ppb shall not be used as ingredients.

c. If corn kernels are received in bulk (to be used in toasted corn kernels end item), and the conditions in (b) above are not met, each end-item lot of toasted corn kernels must be sampled and tested by USDA. End item lots determined to have not

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greater than 15 ppb in aflatoxin in the toasted corn kernels ingredient as evidenced by a USDA Certificate will be considered acceptable.

NOTE: A USDA CoA on corn kernels which have been kept in storage (at less than 80°F and less than 75 percent relative humidity) is acceptable. Contractor must attest to these storage conditions. If storage conditions for the corn kernels are not established, a USDA CoA for aflatoxin on the corn kernels will be considered current if not more than 30 days have elapsed since the date of the analysis.

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

A. Packaging.

(1) Pouch material certification. The pouch material shall be tested for these characteristics. A Certificate of Conformance (CoC) may be accepted as evidence that the characteristics conform to the specified requirements.

<u>Characteristic</u>	<u>Requirement paragraph</u>	<u>Test procedure</u>
Thickness of films for laminated material	D-1,A(1)a and D-1,A(2)a	ASTM D2103 <u>1/</u>
Aluminum foil thickness	D-1,A(1)a and D-1,A(2)a	ASTM B479 <u>2/</u>
Laminated material identification and construction	D-1,A(1)a and D-1,A(2)a	Laboratory evaluation
Color of laminated material	D-1,A(1)a and D-1,A(2)a	SAE AMS-STD-595 <u>3/</u>

1/ Standard Specification for Polyethylene Film and Sheeting

2/ Standard Specification for Annealed Aluminum and Aluminum-Alloy Foil for Flexible Barrier, Food Contact, and Other Applications

3/ Colors Used in Government Procurement

(2) Unfilled preformed pouch certification. A CoC may be accepted as evidence that unfilled pouches conform to the requirements specified in D-1,A(1)a and b. When deemed



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necessary by the USDA, testing of the unfilled preformed pouches for seal strength shall be as specified in E-6,B(1)a.

(3) Pouch vacuum examination (Package M). The filled and sealed pouches shall be visually examined for conformance to the vacuum requirement not less than 96 hours after filling and sealing. The sealed pouch 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 major defect. 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.

(34) Filled and sealed pouch examination. The filled and sealed 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 I and the AQL, expressed in terms of defects per hundred units, shall be 0.65 for major defects and 2.5 for minor defects.

TABLE II. Filled and sealed pouch defects 1/

Category		Defect
<u>Major</u>	<u>Minor</u>	
101		Tear or hole or open seal.
102		Seal width less than 1/16 inch. <u>2/</u>
103		Presence of delamination. <u>3/</u>
104		Unclean pouch. <u>4/</u>
105		Pouch has foreign odor.
106		Any impression or design on the heat seal surfaces which conceals or impairs visual detection of seal defects. <u>5/</u>
107		Not packaged as specified.
108		Presence of stress cracks in the aluminum foil. <u>6/ 7/</u>

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| 201 | Label missing or incorrect or illegible.  |
| 202 | Tear nick or notch or serrations missing or does not facilitate opening.        |
| 203 | Seal width less than 1/8 inch but greater than or equal to 1/16 inch. <u>2/</u> |
| 204 | Presence of delamination. <u>3/</u>   |
- 

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

2/ 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/ 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 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.

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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/ 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/ 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/ Applicable to form-fill-seal pouches only.

7/ 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 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.

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**B. Methods of inspection.**

(1) Seal testing. The pouch seals shall be tested for seal strength as required in a, b, or c, as applicable.

a. Unfilled preformed pouch seal testing. The seals of the unfilled preformed pouch shall be tested for seal strength in accordance with ASTM F88/F88M, Standard Test Method for Seal Strength of Flexible Barrier Materials. The lot size shall be expressed in pouches. The sample unit shall be one unfilled pouch. The sample size shall be the number of pouches indicated by inspection level S-1. Three adjacent specimens shall be cut from each of the three sealed sides of each pouch in the sample. The average seal strength of any side shall be calculated by averaging the three specimens cut from that side. Any average seal strength of less than 6 pounds per inch of width or any test specimen with a seal strength of less than 5 pounds per inch of width shall be classified as a major defect and shall be cause for rejection of the lot.

b. Pouch closure seal testing. The closure seals of the pouches shall be tested for seal strength in accordance with ASTM F88/F88M. 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. For the closure seal on preformed pouches, three adjacent specimens shall be cut from the closure seal of each pouch in the sample. For the form-fill-seal pouches, three adjacent specimens shall be cut from each side and each end of each pouch in the sample. The average seal strength of any side, end or closure shall be calculated by averaging the three specimens cut from that side, end or closure. Any average seal strength of less than 6 pounds per inch of width or any test specimen with a seal strength of less than 5 pounds per inch of width shall be classified as a major defect and shall be cause for rejection of the lot.

c. Internal pressure test. The internal pressure resistance shall be determined by pressurizing the pouches while they are restrained between two rigid plates. The sample size shall be the number of pouches indicated by inspection level S-1. If a three-seal tester (one that pressurizes the pouch through an open end) is used, the closure seal shall be cut off for testing the side and end of the pouch and the distance between restraining plates shall be 1/2 inch. For testing the closure seal, the bottom seal shall be cut off. The pouches shall be emptied prior to testing. If a four-seal tester (designed to pressurize filled pouches by use of a hypodermic needle through the pouch wall) is used, all four seals can be tested simultaneously. The distance between rigid restraining plates on the four-seal tester shall be as close to 1/2 inch as possible while accommodating the thickness of the product, the

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product may be manipulated to fit within the confines of the restraining apparatus. Pressure shall be applied at the rate of 1-2 pounds per square inch gage (psig) per second until 14 psig pressure is reached. The 14 psig pressure shall be held constant for 30 seconds and then released. The pouches shall then be examined for separation or yield of the heat seals. Any rupture of the pouch or evidence of seal separation greater than 1/16 inch in the pouch manufacturer's seal shall be considered a test failure. Any seal separation that reduces the effective closure seal width to less than 1/16 inch (see table II, footnote 2/) shall be considered a test failure. Any test failure shall be classified as a major defect and shall be cause for rejection of the lot.

C. 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. 1/
	201	More than 40 pounds of product.

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.

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## **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 Form

Form 3556	Marking Instructions for Boxes, Sacks, and Unit Loads of Perishable and Semiperishable Subsistence
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### 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
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AOAC INTERNATIONAL [www.aoac.org](http://www.aoac.org)

Official Methods of Analysis (OMA) of AOAC International

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

B479	Standard Specification for Annealed Aluminum and Aluminum-Alloy Foil for Flexible Barrier, Food Contact, and Other Applications
D1238	Standard Test Method for Melt Flow Rates of Thermoplastics by Extrusion Plastometer
D1505	Standard Test Method for Density of Plastics by the Density-Gradient Technique
D1974/D1974M	Standard Practice for Methods of Closing, Sealing, and Reinforcing Fiberboard Boxes
D2103	Standard Specification for Polyethylene Film and Sheeting

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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
F88/F88M	Standard Test Method for Seal Strength of Flexible Barrier Materials

SAE INTERNATIONAL [www.sae.org](http://www.sae.org)

SAE AMS-STD-595 Colors Used in Government Procurement