

QUALITY ASSURANCE PROVISIONS AND PACKAGING REQUIREMENTS FOR CID A-A-20301,
CEREAL TREATS, MARSHMALLOW

SECTION C

C-1 ITEM DESCRIPTION

Types.

- Type I, Flavor 1 - Toasted Rice Cereal (oven-puffed), Original
- * Type III, Flavor 1 - Corn and Whole Wheat Cereal (expanded/extruded),
Original

Unless otherwise specified, the following applies to all types.

Each component is consumed by combat personnel under worldwide environmental extremes as part of an operational ration, and is a source of nutritional intake. It is essential that this item be produced in accordance with good commercial practice to attain high standards of appearance, odor, flavor, and texture so that high levels of troop acceptance are achieved.

C-2 PERFORMANCE REQUIREMENTS

A. Production standard. A sample shall be subjected to first article or product demonstration model inspection, as applicable in accordance with the tests and inspections of Section E of this Quality Assurance Provisions and Packaging Requirements.

B. Net weight.

(1) Toasted rice cereal treat. The net weight of one serving shall be not less than 37 grams.

* (2) Corn and whole wheat cereal treat. The net weight of one serving shall be not less than 44 grams.

C. Nutrient content. Nutrient content of one serving is as follows:

<u>Cereal treat type</u>	<u>Calorie content</u>
	Not less than
Toasted rice	150 calories
* Corn and whole wheat	180 calories

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SECTION D

D-1 PACKAGING

A. Packaging. The commercially wrapped and labeled package of cereal treat shall be packed in a preformed or form-fill seal barrier pouch as described below.

(1) Preformed pouches.

a. Pouch material. The preformed pouches 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. The three plies shall be laminated with the polyester on the exterior of the pouch. All tolerances for thickness of pouch materials shall be plus or minus 20 percent. The complete exterior surface of the pouch shall be uniformly colored in the range of 20219, 30219, 30227, 30279, 30313, 30324, or 30450 of FED-STD-595, Colors for Government Procurement. 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.

* b. Pouch construction. The pouch shall be a flat style preformed pouch having maximum inside dimensions of 4 inches wide by 7 inches long. The pouch shall be made by heat sealing three edges with 3/8 inch (-1/8 inch, +3/16 inch) wide seals. The heat seals shall be made in a manner that will assure hermetic 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 when tested as specified in E-5,A,(3),a. 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 as specified in E-5,A,(3),c. A tear nick or tear notch shall be provided on one outside edge or two opposite outside edges of the pouch to facilitate easy opening of the filled and sealed pouch. A 1/8 inch (+1/16 inch) wide lip may be incorporated at the open end of the pouch to facilitate opening and filling of the pouch.

c. Pouch filling and sealing. The commercially wrapped and labeled package of cereal treat shall be inserted into the pouch. The filled pouch shall be sealed. 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 when tested as specified in E-5,A,(3),b. 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 as specified in E-5,A,(3),c.

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SECTION D CONTINUED

(2) Horizontal form-fill-seal pouches.

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 D 1238, Flow Rates of Thermoplastics by Extrusion Plastometer and a density range of 0.918 to 0.922 g/cc in accordance with ASTM D 1505, Density of Plastics by 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 foil thickness may be 0.00035 inch. All tolerances for thickness of pouch materials shall be plus or minus 20 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 unit of commercially wrapped and labeled package of cereal treat, as specified in D-1,A, shall be placed into the tray-shaped body of the pouch. 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 when tested as specified in E-5,A,(3),b. 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 as specified in E-5,A,(3),c. The maximum outside dimensions of the sealed pouches shall be 5-1/2 inches wide by 8-5/8 inches long. The closure seal width shall be a minimum of 1/8 inch. A tear nick, a tear notch, or serrations shall be provided on one outside edge or two opposite outside edges of the pouch to facilitate easy opening of the filled and sealed pouch. The sealed pouches shall not show any evidence of material degradation, aluminum stress cracking, delamination or foreign odor. Heat seals shall be free of occluded matter. Seals shall be free of impression or design on the seal surface that would conceal or impair visual detection of seal defects.

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SECTION D CONTINUED

D-2 LABELING

A. Pouches. Each pouch shall be clearly printed or stamped, in a manner that does not damage the pouch, with permanent black ink or other, dark, contrasting color which is free of carcinogenic elements or ingredients. The information shall be located on the body of the pouch not closer than 1/16 inch to any seal. If a non-contact type printer is used, the information may be located anywhere on the pouch (in one complete print), except the closure seal area. The label shall contain the following information:

- (1) Product name (letters not less than 1/8 to 7/16 inch block letters)
- (2) Date 1/
- (3) Net Weight
- (4) Contractor's name and address

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, February 17, 1998 would be coded as 8048. The Julian day code shall represent the day the product was packaged into the pouch.

D-3 PACKING

A. Packing for shipment to ration assembler. Not more than 40 pounds of pouched product shall be packed flat in layers in a fiberboard shipping container constructed in accordance with style RSC-L, class domestic, variety SW, grade 200 of ASTM D 5118, Standard Practice for Fabrication of Fiberboard Shipping Boxes. Each container shall be securely closed in accordance with ASTM D 1974, Standard Practice for Methods of Closing, Sealing, and Reinforcing Fiberboard Shipping Containers.

D-4 MARKING

A. Shipping containers. Shipping containers shall be marked in accordance with DPSC Form 3556, Marking Instructions for Shipping cases, Sacks and Palletized/containerized Loads of Perishable and Semiperishable Subsistence.

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SECTION E INSPECTION AND ACCEPTANCE

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.

E-5 PACKAGING AND PACKING MATERIALS

Quality Assurance Provisions.

The following quality assurance criteria, utilizing ANSI/ASQC Z1.4-1993, Sampling Procedures and Tables for Inspection by Attributes, are required.

A. Packaging.

(1) Pouch material certification. Material listed below may be accepted on the basis of a contractor's certification of conformance to the indicated requirements. In addition, compliance to the requirements for inside pouch dimensions and dimensions of manufacturer's seals may be verified by certificate of conformance.

<u>Requirement</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	As specified in L-P-378 1/ except that a machinists' micrometer may be used provided that its graduations and accuracy conform to the requirements of L-P-378
Aluminum foil thickness	D-1,A, (1), a and D-1,A, (2), a	As specified in ASTM B 479 2/
Laminated material identification	D-1,A, (1), a and D-1,A, (2), a	Laboratory evaluation

and construction

Color of laminated material D-1,A,(1),a and
D-1,A,(2),a

Visual evaluation

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1/ FED L-P-378 Plastic Sheet and Strip, Thin Gauge, Polyolefin

2/ ASTM B 479 Specification for Annealed Aluminum Foil For Flexible
Barrier Application

(2) Filled and sealed pouch examination. The filled and sealed pouches shall be examined for the defects listed in table I. The lot size shall be expressed in pouches. The sample unit shall be one pouch. The inspection level shall be I and the acceptable quality level (AQL), expressed in terms of defects per hundred units, shall be 0.65 for major defects and 4.0 for minor defects.

TABLE I. Filled and sealed pouch defects 1/

Category		Defect
<u>Major</u>	<u>Minor</u>	
101		Tear, 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 packed as specified
108		Presence of stress cracks in the aluminum foil <u>6/</u> <u>7/</u>
	201	Label smudges, is missing, incorrect, or illegible
	202	Tear nick, notch, or serrations missing or does not facilitate easy opening
	203	Seal width less than 1/8 inch but greater than 1/16 inch
	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.

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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 (+ 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/ 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).

c. Water spots.

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.

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7/ 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 2mm 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) 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 F 88 - Seal Strength of Flexible Barrier Materials. The lot size shall be expressed in pouches. 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 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 F 88. The lot size shall be expressed in pouches. The sample size shall be the number of pouches indicated by inspection level S-1. For the closure seal on preformed bags, 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 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 bottom seals of the pouch. 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 equal to the thickness of the product +1/16 inch.

Pressure shall be applied at the approximate uniform rate of 1 pound 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 I, footnote 2/) shall be considered a test failure. Any test failure shall be cause for rejection of the lot.

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SECTION E CONTINUED

B. Packing.

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

Major: National stock number, item description, contract number,
 name and address of producer, or date of pack missing,
 incorrect or illegible
 Container not properly closed
 Components missing, damaged, or not as specified

Minor: Other required markings missing, incorrect, or illegible
 More than 40 pounds of product

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SECTION E CONTINUED

E-6 QUALITY ASSURANCE PROVISIONS (PRODUCT)

A. Classification of inspections. The inspection requirements specified herein are classified as follows:

(1) Production standard. The first article or product demonstration model shall be inspected in accordance with the provisions of this Quality Assurance Provisions and Packaging Requirements and evaluated for overall appearance and palatability. Any failure to conform to the performance requirements or any appearance or palatability failure shall be cause for rejection.

(2) Conformance inspection. Conformance inspection shall include the product examination and the methods of inspection cited in this section.

B. Product examination. The finished product shall be examined for compliance with the performance requirements specified in Section C of the Quality Assurance Provisions and Packaging requirements utilizing the single sampling plans indicated in ANSI/ASQC Z1.4 - 1993. The lot size shall be expressed in pouches. The sample unit shall be the contents of one pouch. The inspection level shall be S-2 and the AQL, expressed in terms of defects per hundred units, shall be 1.5 for major defects and 6.5 for minor defects. Defects and defect classifications are listed in Table II.

TABLE II. Product defects 1/ 2/

<u>Category</u>		<u>Defect</u>
<u>Major</u>	<u>Minor</u>	
		<u>Appearance</u>
101		Toasted rice cereal treat does not contain pieces of ready-to-eat, oven puffed rice in a glossy, pale colored marshmallow matrix (type I only)
*102		Corn and whole wheat cereal treat does not contain golden brown pieces of ready-to-eat corn and wheat cereal in a glossy, pale colored marshmallow matrix (type III only)
103		Evidence of excessive heating (materially darkened or scorched)
104		Crushed cereal treat <u>3/</u>

- 201 Broken cereal treat 4/
- 202 Cereal treat does not exhibit a rough texture

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SECTION E CONTINUED

TABLE II. Product defects 1/ 2/ (cont'd)

<u>Category</u>		<u>Defect</u>
<u>Major</u>	<u>Minor</u>	
<u>Odor and flavor</u>		
105		Odor or flavor of type I cereal treat not of a toasted, grainy, nutty rice cereal with sweet and sugary marshmallow
*106		Odor or flavor of type III cereal treat not of a corn and wheat ready-to-eat cereal with sweet and sugary marshmallow
<u>Texture</u>		
*107		Not crispy or cohesive (cereal pieces); or not soft, pliable or chewy (marshmallow matrix)

1/ The presence of foreign material for example, dirt, insect parts, hair, wood, glass, or metal, or foreign odors and flavors such as, but not limited to burnt, scorched, rancid, moldy, or stale shall be cause for rejection of the lot.

2/ Finished product not equal to or better than the approved first article, when applicable, or other approved model in palatability and overall appearance shall be cause for rejection of the lot.

3/ More than one quarter of the cereal treat is crushed.

4/ Cereal treat broken into more than three pieces.

C. Methods of inspection.

* (1) Net weight. The net weight shall be verified with the label on the commercial package. Product not conforming to the net weight requirement in Section C of this supplement shall be cause for rejection of the lot.

(2) Nutrient content.

<u>Test</u>	<u>Method Number</u>
Calories	<u>1</u> /

1/ The calorie content shall be verified by the NLEA "Nutrition Facts" label. Product not conforming to the calorie content as specified in Section C of this supplement shall be cause for rejection of the lot.

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SECTION J REFERENCE DOCUMENTS

DPSC FORM

DPSC FORM 3556 Marking Instructions for Shipping Cases, Sacks and
Palletized/Containerized Loads of Perishable and Semiperishable
Subsistence, May 96

FEDERAL SPECIFICATION

L-P-378 - Plastic Sheet and Strip, Thin Gauge, Polyolefin

FEDERAL STANDARD

FED-STD-595 - Colors Used in Government Procurement

NON-GOVERNMENTAL STANDARDS

AMERICAN SOCIETY FOR QUALITY CONTROL (ASQC)

ANSI/ASQCZ1.4-1993 - Sampling Procedures and Tables for Inspection by
Attributes

AMERICAN SOCIETY FOR TESTING AND MATERIALS (ASTM)

B 479 - Specification for Annealed Aluminum Foil For Flexible Barrier
Application

D 1238 - Flow Rates of Thermoplastics by Extrusion Plastometer

D 1505 - Density of Plastics by Density Gradient Technique

D 1974 - Standard Practice for Methods of Closing, Sealing, and
Reinforcing Fiberboard Shipping Containers

D 5118 - Standard Practice for Fabrication of Fiberboard Shipping
Boxes

F 88 - Seal Strength of Flexible Barrier Materials

AOAC INTERNATIONAL

Official Methods of Analysis of the AOAC International

AMSSB-RCF-F(N) (Richards/5037)

10 May 2000

TO: DSCP-HROAC (Lowry/7773)

SUBJECT: (ES00-088); Request for document Change, A-A-20295, Cookies, and A-A-20301, Cereal Treats; DSCP Case No. 1-R-016-00.

1. Date received: 22 April 2000
Date due: 8 May 2000
Date replied: 10 May 2000

2. Natick concurs in subject request. Accordingly, the following changes are provided to the Quality Assurance Provisions and Packaging Requirements for subject CID's for use in all current, pending and future procurements until the document(s) are formally amended or revised:

In A-A-20295:

- para D-2, A., (3), after "Net weight" insert "2/"

In A-A-20301:

- para D-2, A., (3), after "Net weight" insert "2/"
- para D-2, A., add new subpara as follows "(5) "Nutrition Facts" label in accordance with the Nutrition Labeling and Education Act (NLEA) and all applicable FDA/USDA regulations "2/"
- para D-2, A., insert new footnote as follows "2/ Shall appear on the commercial package or the barrier pouch as applicable."

3. POC for this action is Mr. Allen Richards, X5037.

DONALD A. HAMLIN
Team Leader
DoD Food Engineering
Services Team

Document changes.

CF: (ARichards)
Beward
Hamlin
Hill
Hoffman
Malason
Richards
Richardson
Sherman

Salerno
Valvano
Wagner