

**PKG & QAP  
A-A-20361  
3 March 2010  
W/Change 02 21 November 2012**

## **SECTION C**

This document covers seasoned chicken breast fillets packaged in flexible pouches, shelf stable 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-20361 CHICKEN BREAST FILLETS, SEASONED, IN FLEXIBLE POUCHES**

##### Types.

Type I – Garlic and herb seasonings  
Type II – Barbecue sauce

##### Packages.

Package C – Meal, Ready-to-Eat™ (MRE™)  
Package J – First Strike Ration® (FSR®)

### **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 the Packaging Requirements and Quality Assurance Provisions. 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 non comparable to the product standard, the contractor shall submit a new or 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. The average net weight shall be not less than 4.0 ounces (113 grams). The net weight of an individual pouch shall be not less than 3.7 ounces (105 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. The fat and sodium requirements, procedures and testing shall be in accordance with A-A-20361.

**SECTION D**

**D-1 PACKAGING**

The specified product shall be filled into pouches and each pouch ~~without the carton~~ shall be packed in accordance with MIL-PRF-44073, Packaging of Food in Flexible Pouches, Type I.

**Comment [Mn1]:** ES13-006(DSCP-SS-13-11352)change 02,21-NOV-12 Delete "without the carton".

**Note:** Package C may be packaged with or without the carton, package J shall be packaged without the carton.

**Comment [Mn2]:** ES13-006(DSCP-SS-13-11352)change 02 21-NOV-12 Insert "Note: Package C may be packaged with or without the carton, package J shall be packaged without the carton."

**D-2 LABELING**

A. Pouches. Each pouch shall be correctly and legibly labeled. Printing ink shall be permanent black ink or any other contrasting color, which is free of carcinogenic elements. Prior to thermal processing of the pouches, the product name, lot number, filling equipment number and time stamp shall be applied. All other marking may be applied before or after thermal processing.

- (1) Product name (not less than 1/8 inch high). Commonly used abbreviations may be used.
- (2) Pouch code includes: 1/
  - Lot number
  - Filling equipment identification number
  - Official inspection legend
  - Retort identification number and Retort cook number (Optional)
  - Time stamp (hour and minute of filling/sealing operation)

1/ The lot number shall be expressed as a four digit Julian code. The first digit shall indicate the year of production and the next three digits shall indicate the day of the year (Example, 14 February 2011 would be coded as 1045). The Julian code shall represent the day the product was packaged into the pouch and processed. Following the four digit Julian code, the other required code information shall be printed in the sequence as listed above.

NOTE: Commercial pouch graphics (colors, design and labeling) shall be submitted to the

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Contracting Officer for review and approval and to the US Army Natick Soldier Research, Development and Engineering Center (RDNS-CFF) for review.

**B. Cartons.**

(1) When used for package C, the cartons shall be clearly printed on one of the largest panels with permanent black ink as follows:

- Product name (7/32 to 9/32 inch block letters)
- Ingredients
- Net weight
- Name and address of packer
- Code (same as pouch code, see pouches) 1/ 2/ 3/
- USDA official inspection legend for the packer's plant
- "Nutrition Facts" label in accordance with the Nutrition Labeling and Education Act (NLEA) and all applicable USDA regulations

1/ Code may be ink printed on any outside carton panel. Code may be embossed on any outside carton panel except the largest panels of the carton.

2/ Official establishment number not required in carton code.

3/ Cartons shall be time stamped with the hour and minute that the pouch is sealed into the carton. (Cartons are not expected to bear same time stamp as pouch). Alternatively, the Retort identification number and Retort cook number shall be used.

(2) Military nutrition information entitled "Military Rations Are Good Performance Meals" shall be printed on the entrée carton's large panel opposite to the panel printed with the data in D-2,B (1) above. The information, provided by the contracting officer, shall be clearly printed with permanent black ink in an area no smaller than 4-1/4 inches by 6-3/4 inches.

(3) The cartons shall be labeled with the following product name.

**CHICKEN BREAST FILLET, SEASONED, GARLIC AND HERB SEASONING**

**Comment [Mn3]:** ES13-006 (DSCP-SS-13-11352) change 02 21-NOV-12 Insert "B. Cartons.

(1) When used for package C, the cartons shall be clearly printed on one of the largest panels with permanent black ink as follows:

Product name (7/32 to 9/32 inch block letters)

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**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 D 5118/D 5118M, Standard Practice for Fabrication of Fiberboard Shipping Boxes. The fiberboard shall conform to type CF, class D, variety SW, grade 200 of ASTM D 4727/D 4727M, Standard Specification for Corrugated and Solid Fiberboard Sheet Stock (Container Grade) and Cut Shapes. Each box shall be closed in accordance with ASTM D 1974, 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 DSCP 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.

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

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(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 overall appearance and palatability. Any failure to conform to the performance requirements or any appearance or palatability failure shall be cause for rejection of the lot. 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:

US Army Research, Development and Engineering Command  
Natick Soldier Research, Development and Engineering Center  
RDNS-CFF  
15 Kansas Street  
Natick, MA 01760-5056

One lot shall be randomly selected during each calendar month of production. Six (6) sample units of each item produced shall be randomly selected from that one production lot. The six (6) sample units shall be shipped to Natick within five working days from the end of the production month and upon completion of all USDA inspection requirements. The sample units will be evaluated for the characteristics of appearance, odor, flavor, texture and overall quality.

(2) Conformance inspection. Conformance inspection shall include the product examination and the methods of inspection cited in this section and in section 4 of MIL-PRF-44073.

**E-5 QUALITY ASSURANCE PROVISIONS (PRODUCT)**

A. Product examination. The finished product shall be examined for compliance with the performance requirements in A-A-20361 and specified in 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 1.5 for major defects and 4.0 for minor defects. Defects and defect classifications are listed in table I. For drained weight inspection, a separate set of pouches shall be selected from the lot using the same sampling criteria as above. The pouches shall be immersed in not less than 140°F water for 10 minutes prior to conducting the product examination and the drained weight inspection.

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TABLE I. Product defects 1/ 2/ 3/

Category	Defect
<u>Major</u>	<u>Minor</u>
101	Product not type as specified.
	<u>Appearance</u>
102	Bone or bone fragment measuring more than 0.3 inch in any dimension.
201	Seasoned chicken breast fillets not fully cooked, boneless, skinless fillets or not with a natural chicken breast shape or not intact.
202	Seasoned chicken breast fillets do not have prominent grill marks on the surface.
203	Total weight of skin, cartilage, coarse connective tissue, tendons or ligaments, and discolored meat more than 0.20 ounce.
204	Type I garlic and herb seasoned chicken breast fillets do not have a light golden interior or exterior color or not with herb pieces evenly spread over the surface.
205	Type I broth does not have a golden translucent appearance.
206	Type II barbecue sauce seasoned chicken breast fillets do not have a brown exterior or tan interior from the absorbed sauce.
207	Type II barbecue sauce not reddish brown in color or not with spice flecks.
208	Type II barbecue sauce not moderately thick or not glossy.
	<u>Odor and flavor</u>
103	Type I garlic and herb seasoned chicken breast fillets do not have a garlic and herb, cooked chicken odor or flavor.
104	Type II barbecue sauce seasoned chicken breast fillets do not have a cooked chicken in a sweet tangy barbecue sauce odor or flavor.

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

<u>Category</u>		<u>Defect</u>
<u>Major</u>	<u>Minor</u>	
		<u>Texture</u>
	209	Seasoned chicken breast fillets not moist or not tender.
	210	Seasoned chicken breast fillets are dry or fibrous or rubbery.
		<u>Net weight</u>
	211	Net weight of individual pouch less than 3.7 ounces (105 grams). <u>4/</u>
		<u>Drained weight</u>
	212	Drained weight of chicken breast fillets in individual pouch less than 2.4 ounces (70 grams). <u>5/</u>

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/ Requirements for seasoned chicken breast fillets produced from whole muscle chicken breasts and chicken breast fillet derived from fresh chilled broilers, fryers, or roasters that were slaughtered not more than 7 days prior to production of the chicken breasts shall be verified by Certificate of Conformance.

4/ Sample average net weight less than 4.0 ounces (113 grams) shall be cause for rejection of the lot.

5/ Sample average drained weight of chicken less than 2.6 ounces (75 grams) shall be cause for rejection of the lot.

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**B. Methods of inspection.**

(1) Commercial sterility. Commercial sterility shall be verified in accordance with USDA/FSIS regulations.

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

(3) Net weight. The net weight of the filled and sealed pouches shall be determined by weighing each sample on a suitable scale tared with a representative empty pouch. Results shall be reported to the nearest 0.1 ounce or to the nearest 1 gram.

(4) Drained weight. The pouch contents shall be poured into a flat-bottom container. A minimum of three times the volume of the pouch of not less than 140°F water shall be added to the container so as to cover the contents. The contents and water shall be gently agitated so as to liquify rendered fat. The contents shall then be poured into a U.S. Standard No. 7 sieve in a manner that will distribute the product over the sieve. The sieve area shall be such that the distributed product does not completely cover all the openings of the sieve. The sieve shall be tilted at such an angle to assure complete drainage of liquid from the product. Drain product for two minutes before determining the drained weight by subtracting the sieve tare weight from the gross weight. The drained weight shall be reported to the nearest 0.1 ounce or to the nearest 1 gram.

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

**A. Packaging.**

(1) Pouch material testing. The pouch material shall be examined for the characteristics listed in table I of MIL-PRF-44073 for Type I. The lot size, sample unit, and inspection level criteria for each of the test characteristics are listed below. Any test failure shall be classified as a major defect and shall be cause for rejection of the lot.



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Characteristic	Lot size expressed in	Sample unit	Inspection level
Oxygen transmission rate	yards	1/2 yard	S-1
Water vapor transmission rate	yards	1/2 yard	S-1
Camouflage	yards	1/2 yard	S-1
Thermal processing	pouches	1 pouch	S-2
Low temperature	pouches	1 pouch	S-2
High temperature	pouches	1 pouch	S-2

(2) Filled and sealed pouch testing. The filled and sealed thermoprocessed or hot-fill processed pouches shall be examined for the characteristics listed in table I of MIL-PRF-44073 for Type I. The lot size, sample unit, and inspection level criteria for each of the test characteristics are listed below. Any test failure shall be classified as a major defect and shall be cause for rejection of the lot.

Characteristic	Lot size expressed in	Sample unit	Inspection level
Residual gas volume	Pouches	1 pouch	S-2
Internal pressure	Pouches	1 pouch	S-2 <u>1/</u>
Directional tear	Pouches	1 pouch	S-2

1/ When a three-seal tester is used, a separate set of samples is required for testing of the closure seal.

(3) Pouch examination. The pouches shall be examined for the defects listed in table II of MIL-PRF-44073 for Type I. The lot size shall be expressed in pouches. The sample unit shall be one thermal processed pouch. The inspection level shall be I and the AQL, expressed in terms of defects per hundred units, shall be 0.65 for major A defects, 2.5 for major B defects, and 4.0 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.

(4) Examination of pouch and carton assembly. When used for package C, the completed pouch and carton assemblies shall be examined for the defects listed in table III of MIL-PRF-44073 for Type I. The lot size shall be expressed in units of completed assemblies. The sample unit shall be one pouch and carton assembly. The inspection level shall be S-3 and the AQL, expressed in terms of defects per hundred units, shall be 0.65 for major defects and 2.5 for minor defects. Fifty sample pouch and carton assemblies shall be examined for critical defects. The finding of any critical defect shall be cause for rejection of the lot.

**Comment [Mn4]:** ES13-006(DSCP-SS-13-11352) change 02 21-NOV-12 Insert "4) Examination of pouch and carton assembly. When used for package C, the completed pouch and carton assemblies shall be examined for the defects listed in table III of MIL-PRF-44073 for Type I. The lot size shall be expressed in units of completed assemblies. The sample unit shall be one pouch and carton assembly. The inspection level shall be S-3 and the AQL, expressed in terms of defects per hundred units, shall be 0.65 for major defects and 2.5 for minor defects. Fifty sample pouch and carton assemblies shall be examined for critical defects. The finding of any critical defect shall be cause for rejection of the lot."

**B. Packing.**

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

Category		Defect
Major	Minor	
101		Marking missing or incorrect or illegible.
102		Inadequate workmanship. <u>1/</u>
	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.

**SECTION J REFERENCE DOCUMENTS**

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

**DSCP FORMS**

DSCP FORM 3556      Marking Instructions for Boxes, Sacks, and Unit Loads of Perishable and Semiperishable Subsistence

**MILITARY SPECIFICATIONS**

MIL-PRF-44073      Packaging of Food in Flexible Pouches

**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

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Attributes

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

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

AOAC INTERNATIONAL [www.aoac.org](http://www.aoac.org)

Official Methods of Analysis (OMA) of AOAC International

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## For DLA Troop Support Website Posting

RDNS-CFF

21 November 2012

SUBJECT: ES13-006 (DSCP-SS-13-11352); Request substitution of Chicken Breast Fillet, Seasoned, Type I, Garlic and Herb Seasonings (CID and PKG & QAP A-A-20361) for Tuna, Flavor 1 - Lemon Pepper (CID and PKG&QAP A-A-20155D), Menu 21 in Meal Ready-to-Eat™ (MRE™) 33 Assembly due to supply issues associated with tuna

1. Tuna continues to be unavailable due to sourcing issues with no timeline available for resolution. Currently, MRE™ 32 contains a substitution of Chicken Breast Fillet, Seasoned, Type I, Garlic and Herb Seasonings (CID and PKG & QAP A-A-20361) for Tuna, Lemon Pepper (CID and PKG & QAP A-A-20155D) contained in Menu 21.
2. Natick recommends continuing with the substitution of the entrée Chicken Breast Fillet, Seasoned, Type I Garlic and Herb Seasonings (CID and PKG & QAP A-A-20361) for Tuna, Lemon Pepper (CID and PKG & QAP A-A-20155D) contained in Menu 21 for MRE™ 33 assembly due to supply issues associated with tuna.
3. To prevent delivery delays, the PKG&QAP A-A-20361 will allow for packaging the Chicken Breast Fillet entrée with or without an outer carton. This allowance will apply only to the MRE™ assembly.
4. Natick will continue to monitor the availability of tuna for future use in MRE™ menus. If Tuna, Lemon Pepper becomes available during the production of MRE™ 33, the assemblers may continue to assemble Menu 21 with Chicken Breast Fillets, Seasoned until inventory is depleted.
5. A change to PKG&QAP for CID A-A-20361 Chicken Breast Fillets, Seasoned, in Flexible Pouches is required to reflect the option for packaging in a carton for the MRE™.
6. This substitution will not be a permanent change to the MRE™ 33 Assembly; therefore there will be no change to ACR-M-033.
7. Natick submits the following changes to PKG&QAP for CID A-A-20361 for all current, pending, and future contracts until the document is formally amended or revised:
  - a. Section D-1, Packaging, page 2, line 1, after “pouch” delete “without the carton”.

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SUBJECT: ES13-006 (DSCP-SS-13-11352); Request substitution of Chicken Breast Fillet, Seasoned, Type I, Garlic and Herb Seasonings (CID and PKG & QAP A-A-20361) for Tuna, Flavor 1 - Lemon Pepper (CID and PKG&QAP A-A-20155D), Menu 21 in Meal Ready-to-Eat™ (MRE™) 33 Assembly due to supply issues associated with tuna

b. Section D-1, Packaging, page 2, After “Type I.” insert “Note: Package C may be packaged with or without the carton, package J shall be packaged without the carton.”

c. Section D-2, Labeling, bottom of page 2, After the NOTE, insert “B. Cartons.

(1) When used for package C, the cartons shall be clearly printed on one of the largest panels with permanent black ink as follows:

Product name (7/32 to 9/32 inch block letters)

Ingredients

Net weight

Name and address of packer

Code (same as pouch code, see pouches) 1/ 2/ 3/

USDA official inspection legend for the packer’s plant

“Nutrition Facts” label in accordance with the Nutrition Labeling and Education Act (NLEA) and all applicable USDA regulations

1/ Code may be ink printed on any outside carton panel. Code may be embossed on any outside carton panel except the largest panels of the carton.

2/ Official establishment number not required in carton code.

3/ Cartons shall be time stamped with the hour and minute that the pouch is sealed into the carton. (Cartons are not expected to bear same time stamp as pouch). Alternatively, the Retort identification number and Retort cook number shall be used.

(2) Military nutrition information entitled “Military Rations Are Good Performance Meals” shall be printed on the entrée carton’s large panel opposite to the panel printed with the data in D-2,B (1) above. The information, provided by the contracting officer, shall be clearly printed with permanent black ink in an area no smaller than 4-1/4 inches by 6-3/4 inches.

(3) The cartons shall be labeled with the following product name.

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SUBJECT: ES13-006 (DSCP-SS-13-11352); Request substitution of Chicken Breast Fillet, Seasoned, Type I, Garlic and Herb Seasonings (CID and PKG & QAP A-A-20361) for Tuna, Flavor 1 - Lemon Pepper (CID and PKG&QAP A-A-20155D), Menu 21 in Meal Ready-to-Eat™ (MRE™) 33 Assembly due to supply issues associated with tuna

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d. Section E-6, Quality Assurance Provisions (Packaging and Packing Materials), page 8, After “(3) Pouch examination. The pouches shall be examined for the defects.....rejection of the lot” Insert “(4) Examination of pouch and carton assembly. When used for package C, the completed pouch and carton assemblies shall be examined for the defects listed in table III of MIL-PRF-44073 for Type I. The lot size shall be expressed in units of completed assemblies. The sample unit shall be one pouch and carton assembly. The inspection level shall be S-3 and the AQL, expressed in terms of defects per hundred units, shall be 0.65 for major defects and 2.5 for minor defects. Fifty sample pouch and carton assemblies shall be examined for critical defects. The finding of any critical defect shall be cause for rejection of the lot.”

8. Attached is Change 02, PKG&QAP for CID A-A-20361 Chicken Breast Fillets, Seasoned in Flexible Pouches, dated 21 November 2012, with changes highlighted.