

PKG & QAP
MIL-DTL-32235A
15 September 2010
SUPERSEDING
MIL-DTL-32235
2 February 2007

PACKAGING REQUIREMENTS AND QUALITY ASSURANCE PROVISIONS FOR MIL-DTL-32235A; HEATER MODULE, GENERAL SPECIFICATION FOR, AND APPLICABLE SPECIFICATION SHEETS

SECTION D

D-1 PACKAGING

A. Material safety data sheets. When required, a material safety data sheet (MSDS) shall be prepared in accordance with the requirements of FED-STD-313.

D-2 LABELING

A. MSDS. The MSDS, when required, shall be attached to the unit loads.

D-3 PACKING

A. Packing. One complete or partially assembled Type I or Type II heater module or one or more complete or partially assembled BIB module(s) in a fiberboard box shall require no additional packing. When packing components, 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-4 UNITIZATION

A. Unit loads. Boxes shall be arranged in unit loads in accordance with Type I, Class A of DSCP FORM 3507, Loads, Unit: Preparation of Semiperishable Items.

D-5 MARKING

A. Shipping containers and unit loads. Shipping containers and unit loads 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.

E-5 QUALITY ASSURANCE PROVISIONS (PRODUCT)

A. Product examination. The finished product shall be examined for compliance with the requirements specified in MIL-DTL-32235A, the applicable specification sheets and as specified in this Packaging Requirements and Quality Assurance Provisions (PKG & QAP) document.

(1) Heater module testing. The heater module shall be tested for the requirements listed in table I of MIL-DTL-32235A. The lot size, sample unit, and inspection level criteria for each test are listed below.

Requirement	Lot size expressed in	Sample unit	Inspection level
Heater module use	Modules	1 module	S-2
Heating performance	Modules	1 module	S-2

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(2) Conformance inspection. The following heater module requirements listed in table I of MIL-DTL-32235A and in this document shall be verified with a Certificate of Conformance (CoC):

- Polymeric food tray
- Institutional Size Pouch (ISP)
- Boil-In-Bag (BIB)
- Activated heater module
- Shelf life
- Temperature range of operation
- Food safety
- Health hazard assessment
- Material Safety Data Sheet (MSDS)

(3) Heater module examination. The heater module shall be examined for the defects listed in table II of MIL-DTL-32235A. The lot size shall be expressed in modules. The sample unit shall be one module. The inspection level shall be S-3 and the acceptable quality level (AQL), expressed in terms of defects per hundred units, shall be 1.0 for major defects and 4.0 for minor defects. Five heater modules shall be examined for critical defects. The finding of any critical defect shall be cause for the rejection of the lot.

(4) Type I, Type II and BIB heater module examination. In addition to the heater module examination cited in E-5,A(3), the Type I, II and BIB heater module, as applicable, shall be examined for the defects listed in table I in the applicable specification sheets. The lot size shall be expressed in modules. The sample unit shall be one module. The inspection level shall be S-3 and the AQL, expressed in terms of defects per hundred units, shall be 1.0 for major defects and 4.0 for minor defects.

(5) Type I and Type II single heater capacity test. The single heater shall be tested for the requirements specified in MIL-DTL-32235A/1 and MIL-DTL-32235A/2, utilizing the double sampling plans indicated in ANSI/ASQ Z1.4. The lot size shall be expressed in heaters. The sample unit shall be one heater. The inspection level shall be S-3 and the AQL, expressed in terms of defects per hundred units, shall be 2.5.

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

A. Packing.

(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
<u>Major</u>	<u>Minor</u>	
101		Marking missing or incorrect or illegible.
102		Inadequate workmanship. <u>1/</u>
	201	Contents more or less than specified.
103		MSDS, when required, missing or incorrect or illegible.

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.

(2) Unit load examination. The unit load shall be examined in accordance with the requirements of DSCP FORM 3507. Any nonconformance shall be a major defect.

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SECTION J REFERENCE DOCUMENTS

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

DLA Troop Support – Subsistence FORMS

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

FEDERAL STANDARD

FED-STD-313	Material Safety Data, Transportation Data and Disposal Data for Hazardous Materials Furnished To Government Activities
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MILITARY SPECIFICATIONS

MIL-DTL-32235A	Heater Module, General Specification for
MIL-DTL-32235A/1	Heater Module, Type I: Heater, Assembly Required
MIL-DTL-32235A/2	Heater Module, Type II: Heater, Assembled
MIL-DTL-32235A/3	Heater Module, Boil-In-Bag (BIB) Module

NON-GOVERNMENTAL STANDARDS

AMERICAN SOCIETY FOR QUALITY (ASQ) www.asq.org

ANSI/ASQ Z1.4	Sampling Procedures and Tables for Inspection by Attributes
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ASTM INTERNATIONAL www.astm.org

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| 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 |