

SECTION C

This document covers cocoa beverage powder 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-20189C COCOA BEVERAGE POWDER

Type, style, flavors, and designs.

Type I - Sugar sweetened

Style B - Without marshmallows

Flavor A - Milk chocolate

Flavor F - Chocolate hazelnut

Design A - Flat pouch (discontinued)

Design B - Flat interlocking closure pouch

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. Powdered product.

(1) Appearance. The product shall have a light to medium brown color. The packaged food shall be free from foreign materials.

(2) Odor. The packaged food shall have a cocoa and sweet milk solids odor. The packaged food shall be free from foreign odors.

(3) Net weight. The net weight of an individual pouch shall be not less than 35 grams.

D. Hydrated product.

(1) General. The hydrated product shall be free from foreign materials.

(2) Appearance. The product shall disperse readily in hot or cold water.

(3) Odor and flavor.

a. Type I, style B, flavor A. The hydrated product shall have a sweet milk chocolate, cream-like odor and flavor.

b. Type I, style B, flavor F. The hydrated product shall have a sweet milk chocolate, hazelnut cream-like odor and flavor.

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

F. Analytical requirement.

(1) Moisture. For the type specified, the moisture content requirement, procedure and testing shall be in accordance with A-A-20189C.

G. Microbiological requirement.

(1) Salmonella. The *Salmonella* test shall be negative for each of six composite samples.

SECTION D

D-1 PACKAGING

A. Packaging. Thirty-five grams of product shall be filled into a pouch. The pouch is to be used as a package and a hydrating pouch for the beverage.

(1) Flat interlocking closure pouch.

a. Pouch material. The 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 bonded to 0.0005 inch thick polyester. Tolerances for thickness of plastic films shall be plus or minus 20 percent and tolerance for 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 material shall be approved for addition of hot water (less than or equal to 212°F). 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 FED-STD-595, Colors Used in Government Procurement.

b. Pouch construction. The pouch shall be a flat design preformed or vertical form-fill-seal pouch with an interlocking closure. The design and dimensions shall be as specified in figure 1. The pouch shall be made by heat sealing the sides and top of the pouch with 3/8 (+1/8, -1/4) inch wide seals. The pouch shall exhibit no rupture or seal separation greater than 1/16 inch when tested for internal pressure resistance. The interlocking closure of the pouch shall not leak more than 15 ml. A tear nick or notch shall be provided on one or two opposite edges of the pouch above the interlocking closure 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. Product shall be inserted into the pouch and the filled pouch shall be sealed with a 1/8 to 1 inch wide heat seal. The closure seal shall be applied not more than 1/2 inch from the open end of the pouch. 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.

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:

- (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

(7) Directions:

Allow water just chemically purified to stand 30 minutes before adding to powder. Tear pouch at notch. Open zipper, add 6 ounces of hot or cold water (1/4 canteen cup) to fill line. Close zipper, shake to mix. Consume promptly (within 1 hour).
Single use only.

Fill line: A fill line (not less than 1/32 inch thick, not less than 2 inches long and centered) shall be placed on the pouch/label for 6 ounce fill at $4\text{-}1/8 \pm 1/4$ inches from the inside edge of the bottom closure seal.

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 2016 would be coded as 6045. The Julian day code shall represent the day the product was packaged into the pouch. Sub-lotting (when used) shall be represented by an alpha character immediately following the four digit Julian code.

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, burst grade 200 or ECT grade 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.

(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

PKG&QAP A-A-20189C
27 May 2015
SUPERSEDING
PKG&QAP A-A-20189C
27 November 2012

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-SEC-F
15 Kansas Street
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.

(3) Conformance inspection. Conformance inspection shall include the product examination/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-20189C 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>Powdered product</u>
		<u>General</u>
101		Product not type or style or flavor as specified.
		<u>Appearance</u>
	201	Product not a well-blended homogenous mixture.
	202	Not free of lumps. <u>4/</u>
	203	Product not a light to medium brown color.
		<u>Odor</u>
102		Product not a cocoa or not a sweet milk solids odor.
		<u>Texture</u>
	204	Not free flowing or not a fine texture.
		<u>Net weight</u>
	205	Net weight of an individual pouch less than 35 grams.
		<u>Hydrated product 5/</u>
		<u>Appearance</u>
103		Product does not disperse readily in hot or cold water.
	206	Product not a light to medium brown color.

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

<u>Category</u>		<u>Defect</u>
<u>Major</u>	<u>Minor</u>	
104		Product not free of floating, agglomerated cocoa particles.
	207	Not a well-blended, uniform consistency.
		<u>Odor and flavor</u>
105		Flavor A not a sweet milk chocolate, cream-like odor or flavor.
106		Flavor F not a sweet milk chocolate, hazelnut cream-like odor or flavor.

1/ Presence of any foreign materials such as, but not limited to dirt, insect parts, hair, glass, wood, or metal, or any foreign odors or flavors such as, but not limited to burnt, scorched, rancid, sour, stale, musty or moldy shall be cause for rejection of the lot. Foreign flavors not applicable to powdered product.

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. Palatability not applicable to powdered product.

3/ The producer shall provide a USDA Grading Certificate indicating that the whey and nonfat dry milk ingredients met all the requirements for U.S. Extra Grade. USDA Grading Certificate not provided shall be cause for rejection of the lot.

4/ Lumps that do not fall apart under light pressure shall be scored as a defect.

5/ Prior to conducting the hydrated product examination, the cocoa beverage powder shall be hydrated per label instructions. Product that does not fully dissolve within 2 minutes with constant stirring or shaking shall be cause for rejection of the lot.

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

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. 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. Results shall be reported to the nearest 1 gram.

(3) Microbiological testing. The finished product shall be tested for *Salmonella*. Sixty filled and sealed pouches shall be randomly selected from the lot regardless of lot size and six composite samples shall each be prepared by combining the contents of ten of these pouches. Each composite sample shall be individually tested for *Salmonella* in accordance with the Official Methods of Analysis (OMA) of the AOAC International, method 967.25, 967.26, 967.28, 986.35, 991.13, 996.08, 2003.09, 2004.03, 2009.03, 2011.03, and 2011.17 or the Food and Drug Administration (FDA) Bacteriological Analytical Manual (BAM). Any result not conforming to the microbiological requirement shall be cause for rejection of the lot.

NOTE: The following conditions apply for *Salmonella* testing:

- (a) For prepackaged product received from a supplier and is not further processed, the contractor will furnish a Certificate of Analysis (CoA) that the product represented is *Salmonella* negative.
- (b) For bulk product received, the contractor is responsible for providing a CoA stating that the bulk product is *Salmonella* negative. USDA *Salmonella* testing is required for each end item lot and shall be the basis for lot acceptance with respect to *Salmonella*.

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. Compliance to 21 CFR substances in contact with hot water (less than or equal to 212°F) may be verified by CoC.

<u>Characteristic</u>	<u>Requirement paragraph</u>	<u>Test procedure</u>
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Thickness of films for laminated material	D-1,A(1)a	ASTM D2103 <u>1/</u>
Aluminum foil thickness	D-1,A(1)a	ASTM B479 <u>2/</u>
Laminated material identification and construction	D-1,A(1)a	Laboratory evaluation
Color of laminated material	D-1,A(1)a	FED-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 necessary by the USDA, testing of the unfilled preformed pouches for seal strength shall be as specified in E-6,B(1)a or b.

(3) 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	Fill line missing or does not measure within $\pm 1/4$ inch of 4-1/8 inches from the inside edge of the bottom closure seal.
108	Not packaged as specified.
	201 Label missing or incorrect or illegible.
	202 Tear nick or notch 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>
	205 Pouch does not meet design or dimensions cited in Figure 1.
	206 Fill line on pouch not required thickness or length.
	207 Pouch closure seal more than 1/2 inch from the open end of the pouch.

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.

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.

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 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 specimens shall be cut from the closure seal of each pouch in the sample. For vertical 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 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. 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 sides and end of the pouch. When testing the closure seal, the top and interlocking closure 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 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.

(2) Interlocking closure test. The interlocking closure of the pouch shall be tested. 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-2. Open a filled and sealed interlocking pouch and prepare beverage in accordance with instructions using 70°F ($\pm 5^\circ\text{F}$) water. Close pouch. Invert pouch and suspend pouch for 15 seconds. Collect and measure any liquid that drips. Pouches that leak more than 15 ml 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

PKG&QAP A-A-20189C
27 May 2015
SUPERSEDING
PKG&QAP A-A-20189C
27 November 2012

Category		Defect
<u>Major</u>	<u>Minor</u>	
101		Marking missing or incorrect or illegible.
102		Inadequate workmanship. <u>1/</u>
	201	More than 40 pounds of product.

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.

PKG&QAP A-A-20189C
27 May 2015
SUPERSEDING
PKG&QAP A-A-20189C
27 November 2012

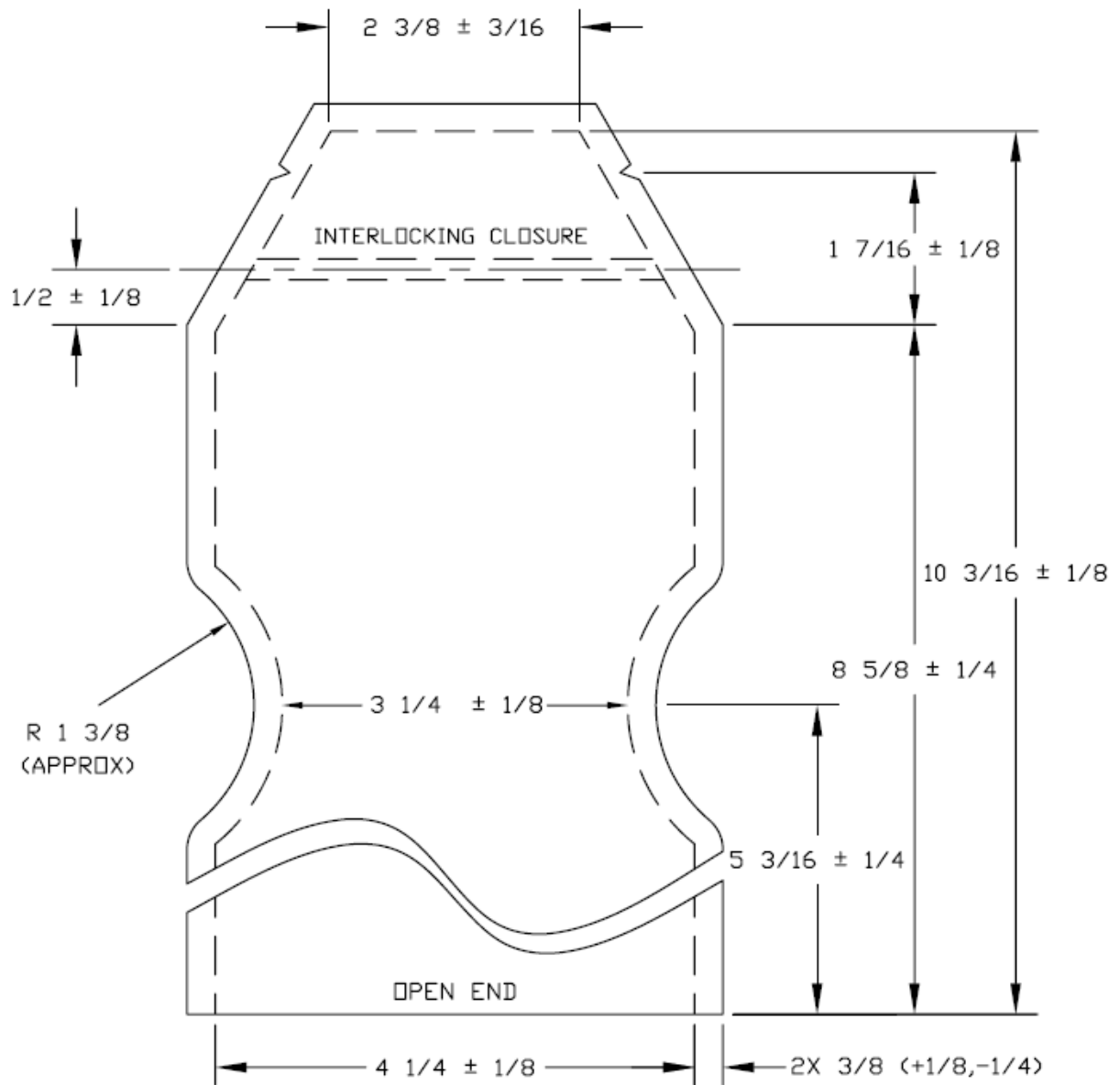


FIGURE 1. Design B, Flat Interlocking Closure Pouch
(Not actual size)

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

GOVERNMENT PUBLICATIONS

FOOD AND DRUG
ADMINISTRATION

Bacteriological Analytical Manual (BAM)
[http://www.fda.gov/Food/FoodScienceResearch/
LaboratoryMethods/ucm2006949.htm](http://www.fda.gov/Food/FoodScienceResearch/LaboratoryMethods/ucm2006949.htm)

FEDERAL STANDARD

FED-STD-595 Colors Used in Government Procurement

NON-GOVERNMENTAL STANDARDS

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

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

ASTM INTERNATIONAL www.astm.org

B479 Standard Specification for Annealed Aluminum and
Aluminum-Alloy Foil for Flexible Barrier, Food
Contact, and Other Applications

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

D2103 Standard Specification for Polyethylene Film and
Sheeting

PKG&QAP A-A-20189C
27 May 2015
SUPERSEDING
PKG&QAP A-A-20189C
27 November 2012

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

AOAC INTERNATIONAL www.aoac.org

Official Methods of Analysis (OMA) of AOAC International