

SECTION C

This document covers toilet tissue packet 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-59594A, TOILET TISSUE, INSTITUTIONAL

Style, type, class, and sheet size.

Style II – Folded
Type A – One ply
Class 1 – Perforated
Sheet size b – 114.3 mm x 114.3 mm (4.5” x 4.5”)

Packages.

Package A – Meal, Cold Weather (MCW)
Package B – Food Packet, Long Range Patrol (LRP)
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 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 materials 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. Overall appearance. The finished product shall be equal to or better than the approved product standard in overall appearance.

SECTION D

D-1 PACKAGING

A. Packet assembly. Twenty-four sheets shall be assembled in a packet. The sheets shall either be continuous with perforations at approximately 4-1/2 inch intervals or 24 individual sheets. The tissue shall be folded and then wrapped in a sleeve of unbleached kraft paper. The sleeve shall cover the entire length of the wrapped tissues. The sleeve shall be closed with an effective seal (i.e., gluing, taping, heat sealing). The sleeve shall be closed so as to ensure that the tissue does not adhere to the sleeve. The packet shall not have an objectionable odor. Maximum dimensions of the packet shall be 2-3/4 x 1-3/8 x 5/8 inches.

D-2 LABELING

A. Packets. Each packet shall be clearly printed or stamped, in a manner that does not damage the packet, with permanent black ink or other dark contrasting color that is free of carcinogenic elements. Ink shall not bleed through onto the toilet tissue. The information may be located anywhere on the packet. The label shall contain the following information:

Contractor's name and address

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 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. 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, which 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 and odor. Any failure to conform to the performance requirements or any appearance or odor 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. The Defense Contract Management Area Office (DCMAO) 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 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 DCMAO inspection requirements. The sample units will be evaluated for overall quality against the current first article or product demonstration model.

(2) Conformance inspection. Conformance inspection shall include the examinations and methods 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 Section C of the Packaging Requirements and Quality

Assurance Provisions document and A-A-59594A utilizing the double sampling plans indicated in ANSI/ASQ Z1.4. The lot size shall be expressed in packets. The sample unit shall be the contents of one packet. 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/}

Category		Defect
<u>Major</u>	<u>Minor</u>	
101		Not style, type, class, sheet size as specified.
		<u>Appearance</u>
	201	Toilet tissue not unglazed.
	202	Tissue edges not clean or not smooth.
102		Unclean. ^{3/}
	203	Holes or tears or wrinkles in tissue.
	204	Presence of foreign material or undigested paper or unbleached waste.
	205	Not white or not dull beige.
		<u>Odor</u>
103		Disagreeable odor when dry or wet.

^{1/} Finished product not equal to or better than the approved product standard in overall appearance shall be cause for rejection of the lot.

^{2/} Recycled content shall be verified by a Certificate of Conformance.

^{3/} Product shall be free of foreign matter that is unwholesome, has the potential to cause damage (for example, glass, metal filings), or generally detracts from the clean appearance of the product.

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

A. Packaging.

(1) Packet examination. The packets shall be examined for the defects listed in table II. The lot size shall be expressed in packets. The sample unit shall be one packet. 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. Packet defects ^{1/}

Category		Defect
<u>Major</u>	<u>Minor</u>	
101		Unclean. ^{2/}
102		Sleeve missing, damaged or not securely closed.
103		Packet has an objectionable odor.
	201	Label missing, incorrect, or illegible.
	202	Packet exceeds dimensions.
	203	Ink bleeds onto tissue.
	204	Sleeve and tissue adhered to each other.
	205	Not 24 sheets of tissue.

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

^{2/} Packaging shall be free from foreign matter that is unwholesome, has the potential to cause packet damage (for example, glass, metal filings) or detracts from the clean appearance of the packet.

B. 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.

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

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

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

D5118/D5118M Standard Practice for Fabrication of Fiberboard Shipping Boxes