

C-1 ITEM DESCRIPTION

PACKAGING REQUIREMENTS AND QUALITY ASSURANCE PROVISIONS FOR MIL-PRF-32176A, BAG, HOT BEVERAGE

SECTION D

D-1 PACKAGING

Referenced in applicable Assembly Contract Requirements (ACR) documents.

D-2 LABELING

Referenced in MIL-PRF-32176A Bag, Hot Beverage.

D-3 PACKING

A. Packing for shipment to ration assembler. 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, minimum burst grade 200 or ECT 32 of ASTM D4727/D4727M, Standard Specification for Corrugated and Solid Fiberboard Sheet Stock (Container Grade) and Cut Shapes. Each box shall be securely 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/ASQC Z1.4, Sampling Procedures and Tables for Inspection by Attributes, are required. Unless otherwise specified, single sampling plans indicated in ANSI/ASQC Z1.4 will be utilized. When required, the

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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-6 QUALITY ASSURANCE PROVISIONS (PACKAGING AND PACKING MATERIALS)

A. Packaging.

(1) Bag testing. The bag and material shall be tested for the requirements listed in table I of MIL-PRF-32176A. The lot size, sample unit, and inspection level criteria for each test are listed below. Any test failure shall be classified as a major defect and shall be cause for rejection of the lot.

Requirement	Lot size expressed in	Sample unit	Inspection level
Color	Bags	1 bag	S-2
Bag integrity	Bags	1 bag	S-2
Heat seals	Bags	1 bag	S-2
Interlocking closure integrity	Bags	1 bag	S-2
Interlocking closure operation	Bags	1 bag	S-2
Interface (bag & interlocking closure)	Bags	1 bag	S-2
Environmental	Bags	1 bag	S-2

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(2) Bag examination. The bags shall be examined for the defects listed in table II of MIL-PRF-32176A. The lot size shall be expressed in bags. The sample unit shall be one bag. 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.

B. Packing.

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

TABLE I. Shipping container and marking defects

Category		Defect
<u>Major</u>	<u>Minor</u>	
101		Marking missing or incorrect or illegible or improper size or improper location sequence or improper method of application.
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.

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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

DEPARTMENT OF DEFENSE SPECIFICATION

MIL-PRF-32176A Bag, Hot Beverage

(Copies of these documents are available from <http://quicksearch.dla.mil/qsSearch.aspx> or from the Standardization Document Order Desk, 700 Robbins Ave, Building 4D, Philadelphia, PA 19111-5094.)

NON-GOVERNMENTAL STANDARDS

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

ANSI/ASQCZ1.4 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

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