

SECTION C

This document covers thermostabilized vegetable lasagna in a flexible pouch for use by the Department of Defense as a component of operational rations.

C-1 ITEM DESCRIPTION

PCR-V-008, VEGETABLE LASAGNA, PACKAGED IN A FLEXIBLE POUCH, SHELF STABLE

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 Performance-based Contract Requirements (PCR) 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 non comparable to the Product Standard, the contractor shall arrange for a new or alternate FA or PDM approval. In any event, all product produced must meet all requirements of this document including Product Standard comparability.

B. Commercial sterility. The packaged food shall be processed until commercially sterile.

C. Shelf life. The packaged product shall meet the minimum shelf life requirement of 36 months at 80°F.

D. Appearance.

(1) General. The finished product shall be a uniform mixture of mafalda noodles in a red to reddish brown tomato sauce with pinto beans and zucchini. The packaged food shall be free from foreign materials.

(2) Pasta. The mafalda noodles shall be enriched pasta product. The mafalda noodles shall be broad, flat noodles with ruffled edges. The cooked mafalda noodles shall be approximately 1-1/4 inches in length by 3/4 inch in width and shall have a cooked pasta color.

(3) Sauce. The tomato sauce shall be an opaque red to reddish brown color. The sauce shall contain whole or pieces of pinto beans and pieces of zucchini. The sauce may also contain a small amount of tomato and onion pieces and flecks of herbs and spices.

E. Odor and flavor. The packaged food shall be free from foreign odors and flavors.

(1) Pasta. The mafalda noodles shall have a cooked pasta odor and flavor.

(2) Sauce. The tomato sauce shall have an odor and flavor of cooked tomato with garlic, onion, and cheese. The sauce shall not be bitter or sour.

F. Texture.

(1) Pasta. The mafalda noodles shall be slightly soft to slightly firm and shall not be pasty.

(2) Sauce. The tomato sauce shall be moderately thick.

G. Net weight. The average net weight of the pouched product shall be not less than 8.0 ounces (227 grams). No individual pouch shall have a net weight of less than 7.5 ounces (213 grams).

H. Drained weight. The average drained weight of mafalda noodles, pinto beans, and vegetable(s) shall be not less than 5.3 ounces (150 grams). The drained weight of mafalda noodles, pinto beans, and vegetable(s) in an individual pouch shall be not less than 5.0 ounces (142 grams).

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

J. Analytical requirements.

(1) Protein content. The protein content shall be not less than 4.0 percent.

(2) Fat content. The fat content shall be not greater than 6.0 percent.

(3) Salt content. The salt content shall be not less than 0.5 percent and not greater than 1.2 percent.

K. Vegetarian Requirement. This product shall contain no ingredients, major or trace, and/or processing aids derived from the flesh, skin, blood, entrails, or bones of animals. This includes, but is not limited to oils, fats, fatty acids, and their esters (palmitic, stearic, oleic, and pelargonic acids), flavorings, gelling agents, coagulants, (rennet derived from calves or pepsin derived from swine which are used in cheese manufacture), binders, emulsifiers (mono/di-glycerides, sodium or magnesium stearate, polysorbate, sorbitans, monostearate, glycerin), fatty alcohol, aldehydes, and ketones, lactones, glycerol, amino acids, hydrolyzed

proteins, enzymes, and enzyme modified products. Furthermore, these products shall contain no ethyl alcohol, or ingredients derived from or containing methyl alcohol. Milk and eggs, and ingredients derived from them such as yogurt, or cheese (produced without animal based rennet or pepsin), are allowed.

C-3 MISCELLANEOUS INFORMATION

THE FOLLOWING INGREDIENTS ARE FOR INFORMATION ONLY. THIS IS NOT A MANDATORY REQUIREMENT.

A. Ingredients. Water, mafalda noodles (enriched durum semolina, water, 2 percent egg whites), tomato paste, beans (pinto beans, vegetable shortening, salt, calcium chloride, artificial color, and red 40), zucchini, parmesan cheese (pasteurized part skim milk, cheese cultured, salt, enzymes, powdered, cellulose, potassium sorbate), modified food starch, soybean oil, sugar, salt, garlic powder, onion powder, and spices.

SECTION D

D-1 PACKAGING

Product shall be filled into pouches, processed and each pouch placed into a carton in accordance with MIL-PRF-44073, Packaging of Food in Flexible Pouches, Type I.

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 and filling equipment number 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/

Company code (Three capital letters representing packer's name)
Lot Number
Filling equipment identification number
Retort identification number
Retort cook number

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 2007 would be coded as 7045). The Julian code shall represent the day the product was packaged into the pouch and processed. Sublotting (when used) shall be represented by an alpha character immediately following the four digit Julian code. Following the four digit Julian code and the alpha character (when used), the other required code information shall be printed in the sequence as listed above.

B. Cartons.

(1) 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/
“Nutrition Facts” label in accordance with the Nutrition Labeling and Education Act (NLEA) and all applicable FDA 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/ Company code not required in carton code.

(2) Military nutrition information entitled “Military Rations Are Good Performance Meals” shall be printed on the entrée cartons 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.

D-3 PACKING

A. Packing for shipment to ration assembler. Seventy-two pouches (of the same product) in cartons shall be packed flat or on edge in a snug-fitting fiberboard shipping container conforming to style RSC, type CF, class domestic, grade 200 of ASTM D 5118/D 5118M, Standard Practice for Fabrication of Fiberboard Shipping Boxes. Each container shall be securely 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:

(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
AMSRD-NSC-CF-F
15 Kansas Street
Natick, MA 01760-5018

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 examinations/tests and 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 specified in Section C of this Performance-based Contract Requirements 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.

TABLE I. Product defects 1/ 2/ 3/ 4/ 5/

Category		Defect
<u>Major</u>	<u>Minor</u>	
		<u>Appearance</u>
101		Product not a uniform mixture of mafalda noodles in a red to reddish brown tomato sauce with pinto beans and zucchini.
	201	Mafalda noodles not broad or not flat or not with ruffled edges.
	202	Mafalda noodles not a cooked pasta color.
	203	Sauce not an opaque red to reddish brown color.
	204	Sauce does not contain pinto beans. <u>6/</u>
	205	Sauce does not contain pieces of zucchini.
		<u>Odor and flavor</u>
102		Mafalda noodles do not have a cooked pasta odor or flavor.
103		Sauce does not have an odor or flavor of tomato with garlic or onion or cheese.
104		Sauce is bitter or sour.
		<u>Texture</u>
	206	Mafalda noodles not slightly soft to slightly firm.
	207	Mafalda noodles pasty.
	208	Sauce not moderately thick.
		<u>Net weight</u>
	209	Net weight of an individual pouch less than 7.5 ounces (213 grams). <u>7/</u>
		<u>Drained weight</u>
	210	Drained weight of mafalda noodles, pinto beans, and vegetable(s) in an individual pouch less than 5.0 ounces (142 grams). <u>8/</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/ Verification of the mafalda noodle as enriched pasta product shall be with the statement of ingredients on the label. Any nonconforming result shall be cause for rejection of the lot.

4/ Size requirement for the mafalda noodle shall be verified by Certificate of Conformance (CoC).

5/ Product not verified by a CoC as meeting the vegetarian requirements shall be cause for rejection of the lot.

6/ Pinto beans may be whole or pieces.

7/ Sample average net weight less than 8.0 ounces (227 grams) shall be cause for rejection of the lot.

8/ Sample average drained weight for mafalda noodles, pinto beans, and vegetable(s) less than 5.3 ounces (150 grams) shall be cause for rejection of the lot.

B. Methods of inspection.

(1) Commercial sterility. Testing for commercial sterility shall be 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 remove the sauce. 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.

(5) Analytical. The sample to be analyzed shall be a composite of eight filled and sealed pouches which have been selected at random from the lot. The composite sample shall be prepared and analyzed in accordance with the following methods of the Official Methods of Analysis (OMA) of AOAC International:

<u>Test</u>	<u>Method Number</u>
Protein	984.13 or 992.15
Fat	985.15
Salt	935.47

Test results shall be reported to the nearest 0.1 percent. Verification will be conducted through actual testing by a Government laboratory. Any nonconforming results shall be cause for rejection of the lot.

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

A. Packaging and labeling.

(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.

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-filled 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.

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>
Sterility	pouches	1 pouch	S-2 <u>2/</u>

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

2/ Select a minimum of one pouch from each retort load. Select pouches from different areas within the retort. For a continuous cooking process, an inspection level of S-3 shall be used to establish sample size.

(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. 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.

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

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

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)

ANSI/ASQ Z1.4-2003 Sampling Procedures and Tables for Inspection by Attributes

ASTM INTERNATIONAL

D 1974-98 (2003) Standard Practice for Methods of Closing, Sealing, and Reinforcing Fiberboard Boxes

D 5118/D 5118M-05ae1 Standard Practice for Fabrication of Fiberboard Shipping Boxes

AOAC INTERNATIONAL

Official Methods of Analysis (OMA) of AOAC International