

SECTION C

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

C-1 ITEM DESCRIPTION

PCR-B-054, BEEF TACO, 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 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. 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 cooked ground beef in a seasoned sauce. The finished product shall be free from foreign materials.

(2) Beef. The ground beef pieces shall be of random size with the largest piece not to exceed 1/4 inch in any dimension. The beef shall have a cooked ground beef color. The packaged product shall be practically free of bone or bone fragments, cartilage, coarse connective tissue, tendons or ligaments, and glandular material.

(3) Sauce. The sauce shall be glossy, moderately thick, and a light to medium brown-orange color. The sauce may contain red flecks of taco seasoning.

E. Odor and flavor. The packaged food shall have an odor and flavor of cooked ground beef in a sauce flavored with taco seasonings. The packaged food shall be free from foreign odors and flavors.

F. Texture.

(1) Beef. The beef shall be moist and tender.

(2) Sauce. The sauce shall be smooth and moderately thick.

G. Net weight. The average net weight shall be not less than 8.0 ounces (227 grams). The net weight of an individual pouch shall be not less than 7.5 ounces (213 grams).

H. Drained weight. The average drained weight of the ground beef shall be not less than 3.3 ounces (93 grams). The drained weight of the ground beef in an individual pouch shall be not less than 3.0 ounces (85 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) Fat. The fat content shall be not greater than 7.5 percent.

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

C-3 MISCELLANEOUS INFORMATION

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

Ingredients: Water, cooked beef (beef, water, salt), modified food starch, tomato paste, salt, chili powder (chili pepper, spices, salt, garlic, not more than 2% silicon dioxide to prevent caking), natural flavor, spices, paprika extract (color).

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.~~ Product shall be filled into pouches and sealed in accordance with MIL-PRF-44073, Packaging of Food in Flexible Pouches, Type I, Style 1.

D-2 LABELING

A. Pouches. Each pouch shall be correctly and legibly labeled. Printing ink shall be

PCR-B-054
26 July 2012
W/Change 01 28 Mar 16 ES16-024 (DSCP-SS-16-00454)

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, filling equipment number and time stamp 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/

- Lot Number
- Filling equipment identification number
- Official establishment number (Optional)
- Retort identification number and Retort cook number (Optional)
- Time stamp (hour and minute of filling/sealing operation)

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 2013 would be coded as 3045). The Julian code shall represent the day the product was packaged into the pouch and processed. Following the four digit Julian code, the other required code information shall be printed in the sequence as listed above.

(3) USDA official inspection legend for the packer's plant 1/

1/ May be placed on the paperboard sleeve if labeled under USDA/FSIS supervision as an identification service.

B. ~~Cartons.~~ Paperboard sleeves.

(1) ~~The cartons shall be clearly printed on one of the largest panels with permanent black ink as follows:~~ The sleeves shall be clearly printed on one of the panels with permanent ink as follows: 1/

- 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/ 2/ 3/~~
- USDA official inspection legend for the packer's plant
- "Nutrition Facts" label in accordance with the Nutrition Labeling and Education Act (NLEA) and all applicable USDA 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.~~

1/ With contracting officer approval, this information may be printed on the pouch in lieu of the paperboard sleeve.

2/ ~~Official establishment number not required in carton code.~~

3/ ~~Cartons shall be time stamped with the hour and minute that the pouch is sealed into the carton. (Cartons are not expected to bear same time stamp as pouch). Alternatively, the Retort identification number and Retort cook number shall be used.~~

(2) Military nutrition information entitled "Military Rations are Good Performance Meals" ~~shall be printed on the entrée carton's 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.~~ shall be printed on the entrée sleeve's panel opposite to the panel printed with the data in D-2,B(1) above, as applicable. The information, provided by the contracting officer, shall be clearly printed with permanent black ink in an area no smaller than 4 inches by 5-1/4 inches.

(3) The product shall be formulated and labeled in accordance with all USDA labeling regulations and policies. ~~The cartons shall be labeled with the following product name.~~ The sleeves (or pouches, as applicable) shall be labeled with the following product name.

BEEF TACO

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. 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. 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
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 USDA 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/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 and not greater than 190°F water for 10 minutes prior to conducting the product examination and the drained weight inspection

TABLE I. Product defects 1/ 2/

Category	Defect
<u>Major</u>	<u>Minor</u>
	<u>Appearance</u>
101	Product not a uniform mixture of cooked ground beef in a seasoned sauce.
102	Bone or bone fragment measuring more than 0.3 inch in any dimension.
201	Total weight of cartilage, coarse connective tissue, tendons or ligaments, and glandular material more than 0.35 ounce (9.9 grams).
202	Beef pieces not of random size or the largest piece exceeds 1/4 inch in any dimension.
203	Beef not a cooked ground beef color.
204	Sauce not glossy or not moderately thick.
205	Sauce not a light to medium brown-orange color.

PCR-B-054
26 July 2012
W/Change 01 28 Mar 16 ES16-024 (DSCP-SS-16-00454)

Odor and flavor

103 Product does not have an odor or flavor of cooked ground beef in a sauce flavored with taco seasonings.

Texture

- 206 Beef not moist or not tender.
- 207 Sauce not smooth or not moderately thick.

Net weight

208 Net weight of an individual pouch less than 7.5 ounces (213 grams). 3/

Drained weight

209 Drained weight of ground beef in an individual pouch less than 3.0 ounces (85 grams). 4/

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

4/ Sample average drained weight of ground beef less than 3.3 ounces (93 grams) shall be cause for rejection of the lot.

B. Methods of inspection.

(1) Commercial sterility. Commercial sterility shall be verified 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 quality scale to be considered acceptable.

PCR-B-054
26 July 2012
W/Change 01 28 Mar 16 ES16-024 (DSCP-SS-16-00454)

(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. Weigh a U.S. Standard No. 12 sieve to obtain the sieve tare 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 and not greater than 190°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 liquefy rendered fat and to remove the sauce without breaking the beef. The contents shall then be poured into a U.S. Standard No. 12 sieve in a manner that will distribute the product over the sieve without breaking the beef. 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 weights 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>
Fat	985.15, 991.36, 2007.04, 2008.06
Salt	935.47

Test results shall be reported to the nearest 0.1 percent. Government verification will be conducted through actual testing by a Government laboratory. Any result not conforming to the analytical requirement shall be cause for rejection of the lot.

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

A. Packaging.

(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 and shall be cause for rejection of the lot.

<u>Characteristic</u>	<u>Lot size expressed in</u>	<u>Sample unit</u>	<u>Inspection level</u>
Oxygen transmission rate	yards	1/2 yard	S-1

PCR-B-054
26 July 2012
W/Change 01 28 Mar 16 ES16-024 (DSCP-SS-16-00454)

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
Directional tear	pouches	1 pouch	S-3

(2) Filled and sealed pouch testing. The filled and sealed thermoprocessed or hot-fill 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 and shall be cause for rejection of the lot.

Characteristic	Lot size expressed in	Sample unit	Inspection level
Residual gas volume	pouches	1 pouch	S-2
Internal pressure	pouches	1 pouch	S-2 ^{1/}
Directional tear	pouches	1 pouch	S-2

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

(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.~~ Sleeve examination. The sleeves 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 sleeves. The sample unit shall be one sleeve. 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.

B. Packing.

PCR-B-054
26 July 2012
W/Change 01 28 Mar 16 ES16-024 (DSCP-SS-16-00454)

(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	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 Forms

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) www.asq.org

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

ASTM INTERNATIONAL www.astm.org

PCR-B-054
26 July 2012
W/Change 01 28 Mar 16 ES16-024 (DSCP-SS-16-00454)

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

AOAC INTERNATIONAL www.aoac.org

Official Methods of Analysis (OMA) of AOAC International