PCR-C-058A
25 July 2014
W/ Change 01 28 Mar 16 ES16-024 (DSCP-SS-16-00454)
SUPERSEDING
PCR-C-058
11 March 2005

SECTION C

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

C-1 ITEM DESCRIPTION

PCR-C-058A, COBBLER, PACKAGED IN A FLEXIBLE POUCH, SHELF STABLE

Flavor.

Flavor 1 - Cherry blueberry

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 food shall meet the minimum shelf life requirement of 36 months at 80ºF.

D. Appearance.

(1) General. The finished product shall be cooked cherry blueberry cobbler with a baked cookie/crust containing chopped pecans. The product shall show no signs of excessive heating (materially darkened or scorched). The product shall be free from foreign materials.

(2) Fruit. The cooked cherries and blueberries shall be a dark reddish purple color and shall be distinct pieces.

a. Cherries, dark, sweet, pitted, individually quick frozen (IQF). The IQF cherries shall be unsweetened and of the latest season's pack. The packaged IQF cherries shall be free flowing from the package and shall show no evidence of thawing and refreezing.

b. Blueberries, individually quick frozen (IQF). The IQF blueberries shall be unsweetened and of the latest season's pack. The packaged IQF blueberries shall be free flowing from the package and shall show no evidence of thawing and refreezing.

(3) Sauce. The sauce shall be a dark reddish purple color, slightly to moderately thick, and glossy.

(4) Cookie/crust. The baked cookie/crust with chopped pecans shall be intact. The Baked cookie/crust shall be tinted a dark reddish purple color from contact with the sauce.

E. Odor and flavor. The cobbler shall have a cooked cherry blueberry odor and flavor and shall be sweet and slightly tart. The baked cookie/crust shall be sweet and slightly nutty. The packaged food shall be free from foreign odors and flavors.

F. Texture.

(1) Fruit. The cooked cherries and blueberries shall be slightly firm to slightly soft.

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

(3) Cookie/crust. The baked cookie/crust shall be moist with firm and slightly crunchy pecans.

G. Net weight. The average net weight shall be not less than 5.0 ounces (142 Grams). No individual pouch shall have a net weight of less than 4.5 ounces (128 grams).

(1) Fruit and sauce. The average net weight of the fruit and sauce shall be not less 3.25 ounces (92 grams) and not greater than 4 ounces (113 grams). As confirmed by USDA review of formulation.

(2) Cookie/crust. The average net weight of the baked cookie/crust shall be not less than 0.75 ounces and not greater than 1.0 ounce. As confirmed by USDA review of formulation.

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

I. Analytical requirements.

(1) Fat. The fat content shall be not greater than 8.0 percent. The *trans* fat content shall be not greater than 0 grams per serving.

(2) Salt. The salt content shall be not less than 0.1 percent and not greater than 0.8 percent.

SECTION D

D-1 PACKAGING

~~Product shall be filled into pouches and processed in accordance with MIL-PRF-44073, Packaging of Food in Flexible Pouches, Type I, Style 1.~~ 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 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 2015 would be coded as 5045). 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.

B. Paperboard sleeves.

(1)The sleeves shall be clearly printed on one of the panels with permanent black ink as follows: 1/ 2/

Product name (7/32 to 9/32 inch block letters)
Ingredients
Net weight
Name and address of packer
"Nutrition Facts" label in accordance with the Nutrition Labeling and Education Act (NLEA) and all applicable FDA regulations

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

2/ If printed on the sleeve, it shall be configured to fit alongside similar information for an accompanying pouched product. Identity of accompanying pouched product and approval of label design shall be obtained from the contracting officer.

(2) The product shall be formulated and labeled in accordance with all FDA labeling regulations and policies. The sleeves (or pouches, or insert cards, as applicable) shall be labeled with the following product name.

CHERRY BLUEBERRY COBBLER

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.

(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 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 examinations/tests and the 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.

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

Category		Defect
Major	Minor	
		Appearance
101		Product not cooked cherry blueberry cobbler with a baked cookie/crust containing chopped pecans.
102		Evidence of excessive heating (materially darkened or scorched).
	201	Cooked cherries and blueberries not a dark reddish purple color.
	202	Cooked cherries and blueberries not distinct pieces.
	203	Sauce not a dark reddish purple color or not slightly to moderately thick or not glossy.
	204	Baked cookie/crust with chopped pecans not intact. 6/
	205	Baked cookie/crust not tinted a dark reddish purple color from contact with the sauce.
		Odor and flavor
103		Product not cooked cherry blueberry odor or flavor or not sweet and not slightly tart.
	206	Odor or flavor of baked cookie/crust not sweet or not slightly nutty.
		Texture
	207	Cooked cherries and blueberries not slightly firm to slightly soft.
	208	Sauce not smooth or not slightly to moderately thick.

	209	Baked cookie/crust not moist.
	210	Pecans not firm or not slightly crunchy.

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

Category		Defect
Major	Minor	
		Weight
	211	Net weight of an individual pouch less than 4.5 ounces (128 grams). 7/

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/ The IQF of fruit shall be verified by a Certificate of Conformance (CoC). The CoC shall also establish that IQF fruit is of latest season's pack.

4/ The weight of fruit and sauce, and baked cookie/crust shall be verified with a CoC from the manufacturer based on the formula.

5/ The *trans* fat content shall be verified by the NLEA label. Product not conforming to the *trans* fat content as specified in Section C of this document shall be cause for rejection of the lot.

6/ More than four broken pieces per baked cookie/crust.

7/ Sample average net weight less than 5.0 ounces (142 grams) shall be cause for rejection of the lot.

B. Methods of inspection.

(1) Commercial sterility. Commercial sterility shall be verified in accordance with FDA 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.

(3) 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 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:

Test	Method Number
Fat	991.36
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.

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
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) Sleeve examination 1/. When applicable, the sleeve 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.

1/ Or separate paperboard insert card when used in lieu of the paperboard sleeve.

B. Packing.

(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
Major	Minor	
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.

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W/ Change 01 28 Mar 16 ES16-024 (DSCP-SS-16-00454)
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PCR-C-058
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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

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

D1974/D1974M	Standard Practice for Methods of Closing, Sealing, and Reinforcing Fiberboard Boxes
D5118/D5118M	Standard Practice for Fabrication of Fiberboard Shipping Boxes

AOAC INTERNATIONAL www.aoac.org

Official Methods of Analysis (OMA) of AOAC International

For DLA Troop Support Website Posting

RDNS-SEC-EM 28 March 2016

TO: DLA Troop Support - Subsistence

SUBJECT: ES16-024 (DSCP-SS-16-00454); Document Change Request to Meal, Ready-to-Eat (MRE) Food Product Documents to Allow for Conversion to Paperboard Sleeves in lieu of Cartons and to Change the Language for Directional Tear Testing, in addition to updating MIL-PRF-44073G, Packaging of Food in Flexible Pouches.

1. References:

a. Memo from RDNS-CFF to DSCP-FTRE, dated 27 September 2013, ES13-055 (DSCP-SS-13-01030), Document change request to ACR-M-034, Meal, Ready-to-Eat™ (MRE™), Assembly Requirements and MIL-PRF-44073G, Packaging of Food in Flexible Pouches to allow for replacement of paperboard cartons with paperboard sleeves.

b. Memo from RDNS-CFF to DSCP-FTRE, dated 27 September 2013, ES13-058 (DSCP-SS-13-01082); Document Change Request to Meal, Ready-to-Eat™ (MRE™) Food Product Documents to Allow for Conversion to Paperboard Sleeves in lieu of Cartons.

c. Memo from RDNS-CFF to DSCP-FTRE, dated 24 January 2014, ES14-019 (DSCP-SS-14-00495); Follow up to ES13-058 (DSCP-SS-13-01082); Document Change Request to Meal, Ready-to-Eat™ (MRE™) Food Product Documents; to allow for alternate labeling procedures and the limited use of paperboard insert cards.

2. In September 2013, Natick requested changes to affected food product documents (as described in detail below) to accommodate the Joint Service approved transition from paperboard cartons to paperboard sleeves in the MRE and the United States Department of Agriculture - Food Safety and Inspection Service (USDA-FSIS) approval of alternate labeling procedures for the retort pouch and paperboard sleeve that will still achieve regulatory compliance. At that time, in lieu of making 31 separate documents changes, a summary of changes was recommended to expedite the transition to Defense Logistics Agency – Troop Support and to meet their MRE 34 solicitation deadlines. Natick promised to follow up with formal document changes to replace the paperboard carton with the paperboard sleeve at a later date.

3. Current changes to the affected documents are for MRE 37 and all future MRE procurements. Due to slight variations in labeling requirements for **USDA entrées and FDA entrées, fruits and sides,** as well as different initial formatting within the affected documents, the requested changes below are grouped by similar documents with similar changes.

4. Natick requests the following changes to the affected **USDA inspected MRE entrée documents:** PCR-A-005, PCR-B-029A, PCR-B-021A, PCR-B-057, PCR-B-020A, PCR-B-054, PCR-B-050, PCR-C-021A, PCR-C-027A, PCR-C-069, PCR-H-012A, PCR- M-015, PCR-M-016, PCR-P-045, PCR-S-018, PCR-S-002 and PKG&QAP A-A-20352B:

(1) Section D-1: Delete paragraph in its entirety and insert “Product shall be filled into pouches and sealed in accordance with MIL-PRF-44073, Packaging of Food in Flexible Pouches, Type I, Style 1.”.

(2) Section D-1: For **PCR-H-012A** delete paragraph in its entirety and insert “Product shall be filled into pouches and sealed in accordance with MIL-PRF-44073, Packaging of Food in Flexible Pouches, Type I, Style 1.”.

(3) Section D-1: For **PKG&QAP A-A- 20352B** delete paragraph in its entirety and insert “Product shall be filled into pouches and sealed in accordance with MIL-PRF-44073, Packaging of Food in Flexible Pouches, Type I, Style 1. Type VI may be packaged in commercial gusseted pouches.”.

(4) Section D-2, A, (2): After “Filling equipment identification number” delete “Official establishment number” or “Official inspection legend” depending on the document and insert “Official establishment number (Optional)”.

(5) Section D-2, A, (2): For **PCR-P-045** and **PCR-B-050** After “Official establishment number (Optional)” insert “Retort identification number and Retort cook number (Optional)”.

(6) Section D-2, A, (2): For **PCR-C-069** and **PCR-M-015** After “Retort identification number and Retort cook number” insert “(Optional)”. After “Retort identification number and Retort cook number (Optional)” insert “Time stamp (hour and minute of filling/sealing operation)”.

(7) Section D-2, A: After “Time stamp…or Retort cook number (if applicable) and footnote 1/” insert a new subsection (3) with footnote 1/ “(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.”

(8) Section D-2, B: Delete “Cartons” and insert “Paperboard sleeves”.

(9) Section D-2, B, (1): Delete “The cartons shall be clearly printed on one of the largest panels with permanent black ink as follows:” and insert “The sleeves shall be clearly printed on one of the panels with permanent black ink as follows: 1/”.

(10) Section D-2, B, (1): For **PCR-B-050** delete “BRISKET ENTRÉE GRAVY WITH SEASONED BEEF BRISKET SLICES” and insert “Product name (7/32 to 9/32 inch block letters)”.

(11) Section D-2, B, (1): For **PCR-P-045** delete “PORK SAUSAGE PATTY, MAPLE FLAVORED” and insert “Product name (7/32 to 9/32 inch block letters)”.

(12) Section D-2, B, (1): Delete “Code (same as pouch code, see pouches) 1/ 2/ 3/” and “USDA official inspection legend for the packer’s plant”.

(13) Section D-2, B, (1): Delete footnote 1/ in its entirety and insert “1/ With contracting

officer approval, this information may be printed on the pouch in lieu of the paperboard sleeve.".

(14) Section D-2, B, (1): Delete footnote 2/ in its entirety.

(15) Section D-2, B, (1): When present in the document, delete footnote 3/ in its entirety.

(16) Section D-2, B, (2): Delete "…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." and insert "…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.".

(17) Section D-2, B, (3): When subsection (3) is present in the document, delete second sentence "The cartons shall be labeled with the following product name." and insert "The sleeves (or pouches, as applicable) shall be labeled with the following product name.".

(18) Section D-2, B, (3): For **PCR-B-029A** delete second sentence "The cartons shall be labeled with the following product name." and insert "The sleeves (or pouches, as applicable) shall be labeled with the following product names, as applicable.".

(19) Section D-2, B, (3): For **PCR-B-050** insert a new subsection (3) "(3) The product shall be formulated and labeled in accordance with all USDA labeling regulations and policies. The sleeves (or pouches, as applicable) shall be labeled with the following product name.

BRISKET ENTRÉE (GRAVY WITH SEASONED BEEF BRISKET SLICES)"

(20) Section D-2, B, (3): For **PCR-C-069** insert a new subsection (3) "(3) The product shall be formulated and labeled in accordance with all USDA labeling regulations and policies. The sleeves (or pouches, as applicable) shall be labeled with the following product name.

CHICKEN PESTO PASTA"

(21) Section D-2, B, (3): For **PCR-P-045** insert a new subsection (3) "(3) The product shall be formulated and labeled in accordance with all USDA labeling regulations and policies. The sleeves (or pouches, as applicable) shall be labeled with the following product name.

PORK SAUSAGE PATTY, MAPLE FLAVORED"

(22) Section D-2, B, (3): For **PCR-M-015** insert a new subsection (3) "(3) The product shall be formulated and labeled in accordance with all USDA labeling regulations and policies. The sleeves (or pouches, as applicable) shall be labeled with the following product name.

MEATBALLS IN MARINARA SAUCE"

(23) Section E-6, A (2): For **PCR-M-015** insert a new subsection (2) with table and footnote 1/ "(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/

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

(24) Section E-6, A (2) Pouch examination. For **PCR-M-015** renumber as E-6, A (3).

(25) Section E-6, A (3): For **PCR-M-015** renumber as E-6, A (4). Delete "Examination of pouch and carton assembly. paragraph in its entirety and insert a new paragraph "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.".

(26) Section E-6, A, (4): Delete "Examination of pouch and carton assembly. paragraph in its entirety and insert a new paragraph "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.".

5. Natick requests the following changes to the affected **FDA inspected MRE entrée documents:** PCR-C-020A and PCR-V-010:

(1) Section D-1: Delete paragraph in its entirety and insert "Product shall be filled into pouches and sealed in accordance with MIL-PRF-44073, Packaging of Food in Flexible Pouches, Type I, Style 1.".

(2) Section D-2, B: Delete "Cartons" and insert "Paperboard sleeves".

(3) Section D-2, B, (1): Delete "The cartons shall be clearly printed on one of the largest panels with permanent black ink as follows:" and insert "The sleeves shall be clearly printed on one of the panels with permanent black ink as follows: 1/".

(4) Section D-2, B, (1): Delete "Code (same as pouch code, see pouches) 1/ 2/ 3/".

(5) Section D-2, B, (1): Delete footnote 1/ in its entirety and insert "1/ With contracting officer approval, this information may be printed on the pouch in lieu of the paperboard sleeve.".

(6) Section D-2, B, (1): Delete footnote 2/ in its entirety.

(7) Section D-2, B, (1): Delete footnote 3/ in its entirety.

(8) Section D-2, B, (2): Delete "…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." and insert "…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.".

(9) Section D-2, B, (3): When paragraph is present in the document, delete second sentence "The cartons shall be labeled with the following product name." and insert "The sleeves (or pouches, as applicable) shall be labeled with the following product name.".

(10) Section E-6, A, (4): Delete "Examination of pouch and carton assembly. paragraph in its entirety and insert a new paragraph "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.".

6. Natick requests the following change to the affected **FDA inspected MRE entrée document:** PKG&QAP A-A-20155D:

(1) Section D-1: Delete paragraph in its entirety and insert "Product shall be filled into pouches and sealed in accordance with MIL-PRF-44073, Packaging of Food in Flexible Pouches, Type I, Style 1.".

7. Natick requests the following changes to affected **FDA inspected MRE sides documents:** PCR-B-056, PCR-P-011A, PCR-P-048 and PCR-S-019:

(1) Section D-1: Delete paragraph in its entirety and insert "Product shall be filled into pouches and sealed in accordance with MIL-PRF-44073, Packaging of Food in Flexible Pouches, Type I, Style 1.".

(2) Section D-2, B: Delete "Cartons" and insert "Paperboard sleeves".

(3) Section D-2, B, (1): Delete "The cartons shall be clearly printed on one of the largest panels with permanent black ink as follows:" and insert "The sleeves shall be clearly printed on one of the panels with permanent black ink as follows: 1/ 2/".

(4) Section D-2, B, (1): Delete "Code (same as pouch code, see pouches) 1/ 2/ 3/".

(5) Section D-2, B, (1): Delete footnote 1/ in its entirety and insert "1/ With contracting officer approval, this information may be printed on the pouch or on a separate paperboard insert card in lieu of the paperboard sleeve.".

(6) Section D-2, B, (1): Delete footnote 2/ in its entirety and insert "2/ If printed on the sleeve, it shall be configured to fit alongside similar information for an accompanying pouched

product. Identity of accompanying pouched product and approval of label design shall be obtained from the contracting officer.".

(7) Section D-2, B, (1): When present in the document, delete footnote 3/ in its entirety.

(8) Section D-2, B, (2): Delete paragraph in its entirety.

(9) Section D-2, B, (3): Renumber as D-2, B, (2). Second sentence, delete "…cartons…" and insert "…sleeves (or pouches, or insert cards, as applicable)" shall be labeled ...

(10) Section E-6, A, (4): Delete "Examination of pouch and carton assembly. paragraph in its entirety and insert a new paragraph and footnote 1/ "Sleeve examination 1/. 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 the AQL, expressed in terms of defects per hundred units, shall be 0.65 for major defects and 2.5 for minor defects.

1/ Or separate paperboard insert card when used in lieu of the paperboard sleeve."

8. Natick requests the following changes to affected **FDA inspected MRE fruits document:** PCR-A-001B:

(1) Section D-1: Delete paragraph in its entirety and insert "Product shall be filled into pouches and sealed in accordance with MIL-PRF-44073, Packaging of Food in Flexible Pouches, Type I, Style 1.".

(2) Section D-2, B: Delete "Cartons" and insert "Paperboard sleeves".

(3) Section D-2, B, (1): Delete "The cartons shall be clearly printed on one of the largest panels with permanent black ink as follows:" and insert "The sleeves shall be clearly printed on one of the panels with permanent black ink as follows: 1/ 2/".

(4) Section D-2, B, (1): Delete "Code (same as pouch code, see pouches) 1/ 2/ 3".

(5) Section D-2, B, (1): Delete footnote 1/ in its entirety and insert "1/ With contracting officer approval, this information may be printed on the pouch or on a separate paperboard insert card in lieu of the paperboard sleeve.".

(6) Section D-2, B, (1): Delete footnote 2/ in its entirety and insert "2/ If printed on the sleeve, it shall be configured to fit alongside similar information for an accompanying pouched product. Identity of accompanying pouched product and approval of label design shall be obtained from the contracting officer.".

(7) Section D-2, B, (1): When present in the document, delete footnote 3/ in its entirety.

(8) Section D-2, B, (2): Delete paragraph in its entirety.

(9) Section D-2, B, (3): Renumber as D-2, B, (2). Second sentence, delete "cartons" and insert "sleeves (or pouches, or insert cards, as applicable)" shall be labeled ...

(10) Section E-6, A, (4): Delete "Examination of pouch and carton assembly. paragraph in its entirety and insert a new paragraph and footnote 1/ "Sleeve examination 1/. 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.

1/ Or separate paperboard insert card when used in lieu of the paperboard sleeve."

9. Natick requests the following changes to affected **FDA inspected MRE fruits document:** PCR-F-002C:

(1) Section D-1: Delete paragraph in its entirety and insert "Product shall be filled into pouches and sealed in accordance with MIL-PRF-44073, Packaging of Food in Flexible Pouches, Type I, Style 1. Applesauce shall be packaged in a side or center spout pouch.".

(2) Section D-2, C: Delete "Cartons" and insert "Paperboard sleeves".

(3) Section D-2, C, (1): Delete "The cartons shall be clearly printed on one of the largest panels with permanent black ink as follows:" and insert "The sleeves shall be clearly printed on one of the panels with permanent black ink as follows: 1/ 2/".

(4) Section D-2, C, (1): Delete "Code (same as pouch code, see pouches) 1/ 2/ 3".

(5) Section D-2, C, (1): Delete footnote 1/ in its entirety and insert "1/ With contracting officer approval, this information may be printed on the pouch or on a separate paperboard insert card in lieu of the paperboard sleeve.".

(6) Section D-2, C, (1): Delete footnote 2/ in its entirety and insert "2/ If printed on the sleeve, it shall be configured to fit alongside similar information for an accompanying pouched product. Identity of accompanying pouched product and approval of label design shall be obtained from the contracting officer.".

(7) Section D-2, C, (1): Delete footnote 3/ in its entirety.

(8) Section D-2, C, (2): Delete paragraph in its entirety.

(9) Section D-2, C, (3): Renumber as D-2, C, (2). Second sentence, delete "…cartons or pouches" and insert "sleeves (or pouches, or insert cards, as applicable)".

(10) Section D-3, A: First sentence, delete "pouches in cartons" and insert "product".

(11) Section E-6, A, (2), After E-6, A, (2) insert a new paragraph "(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."

(12) Section E-6, A, (3): Renumber as E-6, A, (4). Delete "Examination of pouch and carton assembly. paragraph in its entirety and insert a new paragraph and footnote 1/ "Sleeve examination 1/. 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.

1/ Or separate paperboard insert card when used in lieu of the paperboard sleeve."

10. Natick requests the following changes to affected **FDA inspected MRE fruits document:** PCR-C-058A:

(1) Section D-1: Delete paragraph in its entirety and insert "Product shall be filled into pouches and sealed in accordance with MIL-PRF-44073, Packaging of Food in Flexible Pouches, Type I, Style 1.".

(2) Section D-2, B, (2): Second sentence, after "pouches" insert "or insert cards,".

(3) Section E-6, A, (4): First sentence, after "MIL-PRF-44073" insert "for Type I".

(4) Section E-6, A, (4): Footnote 1/, after "the" insert "paperboard".

11. In addition, Natick requests changes to affected food product documents (as described in detail below) to accommodate the changes in directional tear testing that were developed and validated by the Combat Ration Network Program, Short Term Project #3013, which was conducted in coordination with MRE suppliers and Rutgers University.

12. Changes to the affected documents are for MRE 37 and all future MRE procurements. Due to slight variations in the formatting within the affected documents, the requested changes below are grouped by similar documents with similar changes.

13. Natick requests the following changes to the affected MRE food product documents: PCR-A-005, PCR-B-029A, PCR-B-021A, PCR-B-057, PCR-B-020A, PCR-B-054, PCR-C-020A, PCR-C-021A, PCR-C-027A, PCR-M-016, PCR-S-018, PCR-S-002, PCR-H-012A, PCR-V-010, PCR-B-056, PCR-P-011A, PCR-P-048, PCR-S-019, PCR-A-001B and PCR-C-058A:

(1) Section E-6, A (1): After "High temperature" entry, insert Directional tear table entry as follows: "Directional tear; pouches; 1 pouch; S-3".

(2) Section E-6, A, (2): After "Internal Pressure" entry, delete entire "Directional tear" table entry.

14. Natick requests the following changes to the affected MRE food product documents: PCR-F-002C, PKG&QAP A-A-20155D and PKG&QAP A-A-20352B:

(1) Section E-6, A (1): After “High temperature” entry, insert Directional tear table entry as follows: “Directional tear, when applicable; pouches; 1 pouch; S-3”.

(2) Section E-6, A, (2): After “Internal Pressure” entry, delete entire “Directional tear” table entry.

15. Natick requests the following changes to the affected MRE food product document: PCR-M-015:

(1) Section E-6, A (1): After “Thermal processing” entry, delete “Environmental conditions” entry and insert the following three entries as follows: “Low temperature; pouches; 1 pouch; S-2”; “High temperature; pouches; 1 pouch; S-2”; and “Directional tear; pouches; 1 pouch; S-3”.

16. Natick requests the following changes to affected MRE food product document: PCR-C-069:

(1) Section E-6, A (1): After “High temperature” entry, insert Directional tear table entry as follows: “Directional tear; pouches; 1 pouch; S-3”.

(2) Section E-6, A, (2): After “Internal Pressure” entry, delete the following entry: “Sterility; pouches; 1 pouch; S-2 2/”.

17. Natick requests the following changes to affected MRE food product documents: PCR-B-050 and PCR-P-045:

(1) Section E-6, A (1): After “High temperature” entry, insert Directional tear table entry as follows: “Directional tear; pouches; 1 pouch; S-3”.

(2) Section E-6, A, (2): After “Internal Pressure” entry, delete the following two entries: “Sterility; pouches; 1 pouch; S-2 2/” and “Directional tear; pouches; 1 pouch; S-2”.

(3) Section E-6, A, (2): Delete entire footnote “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.”

18. Natick also requests the following changes to MIL-PRF-44073G, Packaging of Food in Flexible Pouches:

(1) Section 4.2 Performance characteristics testing., Table I, Footnote 1/. After “pouch configurations and dimensions,” add “directional tear,”.

(2) Section 4.4 Examination of pouch and sleeve (or insert card), Table III. Pouch and sleeve (or insert card) defects, Major defect 102, after “clean.” delete footnote “ 1/”.

(3) Section 4.5.4 Directional tear test. Delete paragraph in its entirety and insert "Pouches that have been designed to be opened lengthwise shall be tested for directional tear performance. Samples shall be randomly drawn from each production lot and tested for minimum width remaining after tearing. The samples shall be divided into two groups of equal numbers. For each group, the directional tear test shall be initiated from the opposing pouch end. The test may be performed on empty pouches that have not been retorted. If the path of the resultant pouch tear line reduces the short side width of the remaining opened pouch to less than 3-1/2 inches when measured from the outer edge of the pouch at any point along the tear line, it shall be considered a test failure and shall be cause for rejection of the lot."

(4) Section 6.6 Directional tear tester. After Section 6.5.1 Type II Sleeve design and material. insert a new paragraph "Section 6.6 Directional tear tester. It has been found that a Directional Tear Tester developed under the Defense Logistics Agency Combat Ration Network Program, Short Term Project #3013, meets the performance criteria of this specification. With this apparatus, the pouch lays on a horizontal surface and is oriented with one short side of the pouch against a backstop. The tear notch is positioned between the two grippers. The test stand has a linear air slide that rotates the gripper that grips the pouch above the tear notch, initiates the tear, and then pulls the gripper straight across in a parallel line to the opposite short side seal, while maintaining the pouch position on the supported surface by the second gripper."

(5) Section 6.6 Subject term (key word) listing. Renumber as Section 6.7.

(6) Section 6.7 Changes from previous issue. Renumber as Section 6.8.

19. The following documents with Changes highlighted and dated 28 March 2016 are attached: **USDA inspected MRE entrée documents:** Change 01, PCR-A-005, Asian Style Beef Strips with Vegetables, Packaged in a Flexible Pouch, Shelf Stable; Change 01 PCR-B-029A, Beef Patty, Grilled, Packaged in a Flexible Pouch, Shelf Stable; Change 01, PCR-B-021A, Beef Ravioli in Meat Sauce, Packaged in a Flexible Pouch, Shelf Stable; Change 01, PCR-B-057, Beef Shredded, in Barbecue Sauce, Packaged in a Flexible Pouch, Shelf Stable; Change 01, PCR-B-020A, Beef Stew, Packaged in a Flexible Pouch, Shelf Stable; Change 01, PCR-B-054 Beef Taco, Packaged in a Flexible Pouch, Shelf Stable; Change 01, PCR-C-069, Chicken Pesto Pasta, Packaged in a Flexible Pouch, Shelf Stable; Change 01, PCR-P-021A, Chicken, Egg Noodles, and Vegetables, in Sauce, Packaged in a Flexible Pouch, Shelf Stable; Change 01, PCR-C-027A, Chili and Macaroni, Packaged in a Flexible Pouch, Shelf Stable; Change 01, PCR-M-015 Meatballs in Marinara Sauce, Packaged in a Flexible Pouch, Shelf Stable; Change 01, PCR-M-016, Mexican Style Chicken Stew, Packaged in a Flexible Pouch, Shelf Stable; Change 01, PCR-P-045, Pork Sausage Patty, Maple Flavored, Packaged in a Flexible Pouch, Shelf Stable; Change 01, PCR-S-018, Southwest Style Beef and Black Beans with Sauce, Packaged in a Flexible Pouch, Shelf Stable; Change 01, PCR-S-002, Spaghetti with Beef and Sauce, Packaged in a Flexible Pouch, Shelf Stable; Change 03, PCR-B-050, Brisket Entrée (Gravy with Seasoned Beef Brisket Slices), Packaged in a Flexible Pouch, Shelf Stable; Change 03, PKG&QAP A-A-20352B Chicken Chunks, White Cooked, Canned or in Flexible Pouches; Change 01, Hash Brown Potatoes with Bacon, Peppers and Onions, Packaged in a Flexible Pouch, Shelf Stable; **FDA inspected MRE entrée documents:** Change 01, PCR-P-020A,

Cheese Tortellini in Tomato Sauce, Packaged in a Flexible Pouch, Shelf Stable; Change 01, PKG&QAP A-A-20155D Tuna; Change 01, PCR-V-010, Vegetable Crumbles with Pasta in Taco Style Sauce, Packaged in a Flexible Pouch, Shelf Stable; **FDA inspected MRE sides documents:** Change 01, PCR-B-056, Black Beans in a Seasoned Sauce, Packaged in a Flexible Pouch, Shelf Stable; Change 01, PCR-P-048, Potatoes Au Gratin; Change 01, PCR-P-011A Potatoes, Mashed; Change 01, PCR-S-019 Santa Fe Style Rice and Beans, Packaged in a Flexible Pouch, Shelf Stable; **FDA inspected MRE fruits documents:** Change 01, PCR-A-001B, Apple Pieces in Spiced Sauce, Packaged in a Flexible Pouch, Shelf Stable; Change 01, PCR-C-058A, Cobbler, Packaged in a Flexible Pouch, Shelf Stable; Change 02, PCR-F-002C Fruits, Wet Pack, Packaged in a Flexible Pouch, Shelf Stable and Change 06, MIL-PRF-44073G, Packaging of Food in Flexible Pouches.