

SECTION C

This document covers thermostabilized creamy spinach fettuccine (egg noodles, spinach and mushrooms in a cream sauce) packaged in a flexible pouch for use by the Department of Defense as a component of operational rations.

C-1 ITEM DESCRIPTION

PCR-C-087, CREAMY SPINACH FETTUCCHINE (EGG NOODLES, SPINACH AND MUSHROOMS IN A CREAM SAUCE), 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 fettuccine type egg noodles and spinach in a cream sauce with sliced mushroom pieces. The finished product shall be free from foreign materials.

(2) Egg noodles. The noodles shall be fettuccine type enriched egg noodle product or other heavy soup, enriched egg noodle product. The cooked egg noodles shall be approximately 2.0 inches in length. The cooked egg noodles shall be distinct strips that readily separate and shall be an off-white to beige color.

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(3) Spinach. The cooked spinach shall be evenly distributed and may have a wilted appearance. The spinach shall be discernible pieces and shall have a cooked dark green spinach color.

(4) Sauce. The sauce shall be a medium cream to beige color with a slight green hue. The sauce shall contain sliced mushroom pieces with a tan to brown color.

E. Odor and flavor. The packaged food shall have an odor and flavor of cooked spinach, mushrooms and egg noodles in a mild garlic and onion seasoned cream sauce. The packaged food shall be free from foreign odors and flavors.

F. Texture.

(1) Egg noodles. The cooked egg noodles shall be slightly soft to slightly firm and shall not be pasty.

(2) Spinach. The cooked spinach shall be soft.

(3) Sauce. The sauce shall be smooth, moderately thick and free flowing. The sauce shall have slightly soft sliced mushroom pieces.

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 egg noodles, spinach and mushroom pieces (combined) shall be not less than 4.8 ounces (136 grams). The drained weight of the egg noodles, spinach and mushroom pieces (combined) in an individual pouch shall be not less than 4.5 ounces (128 grams).

I. Percent by weight of precooked spinach. The formula shall contain not less than 15.0 percent and not greater than 20.0 percent by weight of spinach on a precooked basis weight.

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

K. Analytical requirements.

(1) Fat. The fat content shall be not greater than 4.5 percent.

(2) Salt. The salt content shall be not greater than 1.0 percent.

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L. 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, flavorings, gelling agents, coagulants, binders, emulsifiers, 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.

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.

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

Company code

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 2016 would be coded as 6045). 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.

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B. Paperboard sleeves.

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

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 in lieu of the paperboard sleeve.

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

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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

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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 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/ 3/ 4/ 5/ 6/

| Category | | Defect |
|--------------|--------------|---|
| <u>Major</u> | <u>Minor</u> | <u>Appearance</u> |
| 101 | | Product not a uniform mixture of cooked fettuccine type egg noodles and spinach in a cream sauce with sliced mushroom pieces. |
| | 201 | Cooked egg noodles not distinct strips that readily separate. |
| | 202 | Cooked egg noodles not an off-white to beige color. |
| | 203 | Cooked spinach not evenly distributed. |

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TABLE I. Product defects 1/ 2/ 3/ 4/ 5/ 6/ - Continued

| <u>Category</u> | <u>Defect</u> |
|-----------------|--|
| <u>Major</u> | <u>Minor</u> |
| | 204 Spinach not discernible pieces or not a cooked dark green spinach color. |
| | 205 Sauce not a medium cream to beige color or not with a slight green hue. |
| | 206 Sauce does not contain sliced mushroom pieces with a tan to brown color. |
| | <u>Odor and flavor</u> |
| 102 | Product does not have an odor or flavor of cooked spinach, mushrooms and egg noodles in a mild garlic and onion seasoned cream sauce. |
| | <u>Texture</u> |
| | 207 Cooked egg noodles not slightly soft to slightly firm. |
| | 208 Cooked egg noodles are pasty. |
| | 209 Cooked spinach not soft. |
| | 210 Sauce not smooth or not moderately thick or not free flowing. |
| | 211 Sauce does not have slightly soft sliced mushroom pieces. |
| | <u>Net weight</u> |
| | 212 Net weight of an individual pouch less than 7.5 ounces (213 grams). <u>7/</u> |
| | <u>Drained weight</u> |
| | 213 Drained weight of egg noodles, spinach and mushroom pieces (combined) in an individual pouch less than 4.5 ounces (128 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.

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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 fettuccini or heavy soup noodles as enriched egg noodle product shall be with the statement of ingredients on the label or verified by the producer's Certificate of Conformance (CoC).

4/ Length of the cooked egg noodle product shall be verified by CoC.

5/ Product shall be verified as meeting the vegetarian requirement by CoC.

6/ Percent by weight of precooked spinach in the formula (not less than 15.0 percent and not greater than 20.0 percent) shall be verified by CoC (with review of actual product formulation as needed).

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 less than 4.8 ounces (136 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 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. 7 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~~

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~~agitated so as to remove the sauce without breaking the egg noodles, spinach or mushroom pieces. 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 without breaking the egg noodles, spinach or mushroom pieces. 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 combined 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.~~ Use a U.S. Standard No. 7 sieve for the drained weight examination. Heat all the pouches at the same time for 10 minutes in hot water. 1/ Pour the contents of the pouch into a flat-bottom container and repeatedly add hot water until all of the product has been removed from the pouch. 1/ Additional hot water may be added to the flat-bottom container so as to cover all of the contents. 1/ The mixture shall be gently agitated so as to liquefy rendered fat without breaking the product. 2/ The mixture shall not sit for greater than two minutes. The contents shall then be poured into the sieve in a manner that will distribute the product over the sieve without breaking up the product. 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 an angle from 30 to 45 degrees to ensure complete drainage of liquid from the product. Drain product for two minutes. Place the sieve and its contents onto the scale and tare the scale to zero. Remove the egg noodles, spinach and mushroom pieces (combined) from the sieve by turning the sieve upside down and dumping the product. Place the sieve back on the scale and record the weight as a positive number. This value is the drained weight of the egg noodles, spinach and mushroom pieces (combined). When necessary, rinse the screen before performing the next drained weight exam. The drained weight shall be reported to the nearest 0.1 ounce or to the nearest 1 gram. 3/

1/ Water temperature shall be not less than 140°F and not greater than 165°F.

2/ Additional hot water may be required for completely removing sauce and liquefying rendered fat.

3/ The initial unit of measurement shall be maintained throughout the exam (example: if ounce is used, the unit of measurement shall remain as ounces throughout the exam).

(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:

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| | |
|-------------|----------------------|
| <u>Test</u> | <u>Method Number</u> |
| Fat | 991.36 or 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.

| 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 <u>1/</u> |

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

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(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. 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.

(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 Form

| | |
|-----------|--|
| Form 3556 | Marking Instructions for Boxes, Sacks, and Unit Loads of Perishable and Semiperishable Subsistence |
|-----------|--|

MILITARY SPECIFICATION

| | |
|---------------|---------------------------------------|
| 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 |
|--------------|---|

| | |
|--------------|---|
| D4727/D4727M | Standard Specification for Corrugated and Solid Fiberboard Sheet Stock (Container Grade) and Cut Shapes |
|--------------|---|

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|--------------|--|
| D5118/D5118M | Standard Practice for Fabrication of Fiberboard Shipping Boxes |
|--------------|--|

AOAC INTERNATIONAL www.aoac.org

Official Methods of Analysis (OMA) of the AOAC International