

SECTION C

This document covers thermostabilized Southwest style beef and black beans with sauce in a flexible pouch for use by the Department of Defense as a component of operational rations.

C-1 ITEM DESCRIPTION

PCR-S-018, SOUTHWEST STYLE BEEF AND BLACK BEANS WITH 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 non comparable to the product standard, the contractor shall arrange for a new or alternate FA or PDM approval. In any event, all product produced must meet all requirements of this document including product standard comparability.

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

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

D. Appearance.

(1) General. The finished product shall be a uniform mixture of whole muscle beef strips, black beans, tomato dices, corn, green and red bell pepper dices, and onion pieces in a seasoned sauce. The finished product shall be free from foreign materials.

(2) Beef strips. The beef strips shall be produced from whole muscle beef cuts in accordance with North American Meat Processors Association (NAMP) Item No. 109B, Beef Rib, Blade Meat, with 1/8 inch maximum thickness of surface fat. Chunking and forming shall not be allowed. The beef strips may be of random length and width and shall be produced by equipment with settings that result in strips 5/8 inch in width and not less than 1 inch in length. The beef shall be free of bone or bone fragments, cartilage, coarse connective tissue, tendons or ligaments, and glandular material. The beef strips shall have a cooked beef color and shall have grill marks.

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(3) Black beans. The black beans shall be practically free of broken, mashed beans or loose skins.

(4) Vegetables.

a. Tomatoes. The tomatoes shall be 3/4 inch dices and shall have a cooked red tomato color.

b. Corn. The corn shall be whole kernel and shall have a cooked yellow corn color.

c. Green and red bell peppers. The green and red bell pepper dices shall have a cooked pepper color.

d. Onion. The onion pieces shall have a translucent appearance of cooked onion.

(5) Sauce. The sauce shall be glossy, a medium brown color and may contain flecks of herbs and spices.

E. Odor and flavor. The packaged food shall have an odor and flavor of cooked, grilled beef, cooked black beans and vegetables in a tomato and beef based sauce flavored with mild Southwestern style seasonings. The product shall elicit a sensation of mild heat. The packaged food shall be free from foreign odors and flavors.

F. Texture.

(1) Beef strips. The beef strips shall be moist and tender but not dry or stringy.

(2) Black beans. The black beans shall be slightly soft to slightly firm.

(3) Vegetables. The corn shall be slightly soft to slightly firm. The tomatoes, green and red bell peppers, and onions shall be tender.

(4) Sauce. The sauce shall be 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 7.5 ounces (213 grams).

H. Drained weight.

(1) Beef strips, black beans, and vegetables. The average drained weight of beef strips, black beans, and vegetables (combined) shall be not less than 4.5 ounces (128 grams).

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The drained weight of beef strips, black beans, and vegetables (combined) in an individual pouch shall be not less than 4.0 ounces (113 grams).

(2) Beef strips. The average drained weight of beef strips shall be not less than 2.5 ounces (71 grams). The drained weight of beef strips in an individual pouch shall be not less than 2.0 ounces (57 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 content. The fat content shall be not greater than 9.0 percent.

(2) Salt content. The salt content shall be not less than 0.5 percent and not greater than 1.4 percent.

C-3 MISCELLANEOUS INFORMATION

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

A. Ingredients. Seasoned beef steak strips (beef, water, fajita seasonings [salt, maltodextrin, dehydrated garlic, corn syrup solids, spices, modified food starch, dehydrated onion, sugar, yeast extract, dehydrated soy sauce, sunflower oil, dehydrated mushrooms, natural flavors, citric acid, dehydrated lemon peel, dehydrated bell peppers, torula yeast, dehydrated wine, dehydrated vinegar, dehydrated parsley, malic acid], whey protein concentrate, modified corn starch, salt, sodium phosphates, butter flavor [maltodextrin, natural butter flavor], sodium phosphates, beef flavor [maltodextrin, salt, beef extract, rendered beef fat, sesame oil], potassium chloride, seasoning [dextrose, caramel color, soy grits, beef stock, sugar, spices, paprika, citric acid, natural butter flavor {maltodextrin, lypolyzed cream, flavor, annatto, turmeric}], caramel color, corn syrup solids, dextrose, spice extractives), tomatoes, water, black beans (black bean), corn, green bell peppers, onions, red bell peppers, seasoning (modified corn starch, salt, dehydrated garlic, spices, onion powder, sugar, chili powder, caramel color, hydrolyzed soy protein, grill flavor [in vegetable oil], corn oil), tomato paste, beef base (roasted beef including juices, autolyzed yeast extract, hydrolyzed soy protein, potato flour, dry whey, caramel color, flavorings, corn oil, paprika), canola oil (high oleic canola oil [ascorbic acid and rosemary added to preserve freshness]), ancho pepper concentrate (red chili pepper puree, ancho powder, salt, corn oil), lime juice concentrate.

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B. Ingredients and formulation. Ingredients and formulation may be as follows:

<u>Sauce</u>	<u>Percent by weight</u>
Water	32.69
Tomatoes, 3/4 inch diced with juice	29.32
Green bell peppers, fresh, 1/2 inch diced	10.00
Onions, fresh, 1/2 inch diced	8.00
Red bell peppers, fresh, 1/2 inch diced	6.00
Southwest seasoning	5.81
Tomato paste	3.75
Beef base	2.05
Canola oil	1.36
Ancho base	0.82
Lime juice concentrate 6X	0.20

C. Product preparation. Percentages for product preparation may be as follows:

<u>Ingredient</u>	<u>Percent by weight</u>
Sauce	50.00
Beef, fajita strips	35.00
Black beans, individually quick frozen (IQF)	7.50
Corn, IQF	7.50

NOTE: The product used for the development of this PCR was produced by Missa Bay LLC, Elburn, IL.

SECTION D

D-1 PACKAGING

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 and filling equipment number shall be applied. All other marking may be applied before or after thermal processing.

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(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 or 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 2010 would be coded as 0045). 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. 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 USDA 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 USDA labeling regulations and policies. The sleeves (or pouches, as applicable) shall be labeled with the following product name.

SOUTHWEST STYLE BEEF AND BLACK BEANS WITH SAUCE

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 D 5118/D5118M, Standard Practice for Fabrication of Fiberboard Shipping Boxes. The fiberboard shall conform to type CF, class D, variety SW, grade 200 of ASTM D 4727/D 4727M, Standard Specification for Corrugated and Solid Fiberboard Sheet Stock (Container Grade) and Cut Shapes. Each box shall be closed in accordance with ASTM D 1974, Standard Practice for Methods of Closing, Sealing, and Reinforcing Fiberboard Boxes.

D-5 MARKING

A. Shipping containers. Shipping containers shall be marked in accordance with DSCP FORM 3556, Marking Instructions for Boxes, Sacks, and Unit Loads of Perishable and Semiperishable Subsistence.

SECTION E INSPECTION AND ACCEPTANCE

The following quality assurance criteria, utilizing ANSI/ASQ Z1.4, Sampling Procedures and Tables for Inspection by Attributes, are required. Unless otherwise specified, single sampling plans indicated in ANSI/ASQ Z1.4 will be utilized. When required, the manufacturer shall provide the Certificate(s) of Conformance to the appropriate inspection activity. Certificate(s) of Conformance not provided shall be cause for rejection of the lot.

A. Definitions.

(1) Critical defect. A critical defect is a defect that judgment and experience indicate would result in hazardous or unsafe conditions for individuals using, maintaining, or depending on the item; or a defect that judgment and experience indicate is likely to prevent the performance of the major end item, i.e. the consumption of the ration.

(2) Major defect. A major defect is a defect, other than critical, that is likely to result in failure, or to reduce materially the usability of the unit of product for its intended purpose.

(3) Minor defect. A minor defect is a defect that is not likely to reduce materially the usability of the unit of product for its intended purpose, or is a departure from established standards having little bearing on the effective use or operation of the unit.

B. Classification of inspections. The inspection requirements specified herein are classified as follows:

(1) Product standard inspection. The first article or product demonstration model shall

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be inspected in accordance with the provisions of this document and evaluated for overall appearance and palatability. Any failure to conform to the performance requirements or any appearance or palatability failure shall be cause for rejection of the lot. The approved first article or product demonstration model shall be used as the product standard for periodic review evaluations. All food components that are inspected by the USDA shall be subject to periodic review sampling and evaluation. The USDA shall select sample units during production of contracts and submit them to the following address for evaluation:

US Army Research, Development and Engineering Command
Natick Soldier Research, Development and Engineering Center
RDNS-CFF
15 Kansas Street
Natick, MA 01760-5018

One lot shall be randomly selected during each calendar month of production. Six (6) sample units of each item produced shall be randomly selected from that one production lot. The six (6) sample units shall be shipped to Natick within five working days from the end of the production month and upon completion of all USDA inspection requirements. The sample units will be evaluated for the characteristics of appearance, odor, flavor, texture, and overall quality.

(2) Conformance inspection. Conformance inspection shall include the examinations/tests and methods of inspection cited in this section and in section 4 of MIL-PRF-44073.

E-5 QUALITY ASSURANCE PROVISIONS (PRODUCT)

A. Product examination. The finished product shall be examined for compliance with the performance requirements specified in Section C of this Performance-based Contract Requirements document utilizing the double sampling plans indicated in ANSI/ASQ Z1.4. The lot size shall be expressed in pouches. The sample unit shall be the contents of one pouch. The inspection level shall be S-3 and the acceptable quality level (AQL), expressed in terms of defects per hundred units, shall be 1.5 for major defects and 4.0 for minor defects. Defects and defect classifications are listed in table I. For drained weight inspection, a separate set of pouches shall be selected from the lot using the same sampling criteria as above. The pouches shall be immersed in not less than 140°F water for 10 minutes prior to conducting the product examination and the drained weight inspection.

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

<u>Category</u>		<u>Defect</u>
<u>Major</u>	<u>Minor</u>	
		<u>Appearance</u>
101		Product not a uniform mixture of whole muscle beef strips, black beans, tomato dices, corn, green and red bell pepper dices, and onion pieces 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 ounces.
	202	Beef strips not a cooked beef color.
	203	Beef strips do not have grill marks. <u>5/</u>
	204	Black beans not practically free of broken or mashed beans or loose skins.
	205	Tomato dices not a cooked red tomato color.
	206	Corn not whole kernel or not a cooked yellow corn color.
	207	Green and red bell pepper dices do not have a cooked pepper color.
	208	Onion pieces do not have a translucent appearance of cooked onion.
	209	Sauce not glossy or not a medium brown color.
		<u>Odor and flavor</u>
103		Product does not have an odor or flavor of cooked, grilled beef, cooked black beans or vegetables in a tomato and beef based sauce flavored with mild Southwestern style seasonings, or does not elicit a sensation of mild heat.
		<u>Texture</u>
	210	Beef strips not moist or not tender but are dry or stringy.

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

<u>Category</u>		<u>Defect</u>
<u>Major</u>	<u>Minor</u>	
	211	Black beans not slightly soft to slightly firm.
	212	Corn not slightly soft to slightly firm.
	213	Tomatoes or green or red bell peppers or onions not tender.
	214	Sauce not moderately thick.
		<u>Net weight</u>
	215	Net weight of an individual pouch less than 7.5 ounces (213 grams). <u>6/</u>
		<u>Drained weight</u>
	216	Combined drained weight of beef strips, black beans, and vegetables in an individual pouch less than 4.0 ounces (113 grams). <u>7/</u>
	217	Drained weight of beef strips in an individual pouch less than 2.0 ounces (57 grams). <u>8/</u>

1/ Presence of any foreign materials such as, but not limited to dirt, insect parts, hair, glass, wood, or metal, or any foreign odors or flavors such as, but not limited to burnt, scorched, rancid, sour, stale, musty or moldy shall be cause for rejection of the lot.

2/ Finished product not equal to or better than the approved product standard in palatability and overall appearance shall be cause for rejection of the lot.

3/ Equipment settings and the requirement that beef strips be produced from whole muscle cuts in accordance with NAMP Item No. 109B shall be verified by a Certificate of Conformance (CoC).

4/ Tomato dice size requirement shall be verified by a CoC.

5/ Grill marks are not present on at least one beef strip.

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

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7/ Sample average drained weight of beef strips, black beans, and vegetables (combined) less than 4.5 ounces (128 grams) shall be cause for rejection of the lot.

8/ Sample average drained weight of beef strips less than 2.5 ounces (71 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 hedonic scale to be considered acceptable.

(3) Net weight. The net weight of the filled and sealed pouches shall be determined by weighing each sample on a suitable scale tared with a representative empty pouch. Results shall be reported to the nearest 0.1 ounce or to the nearest 1 gram.

(4) Drained weight. ~~The pouch contents shall be poured into a flat-bottom container. A minimum of three times the volume of the pouch of not less than 140°F water shall be added to the container so as to cover the contents. The contents and water shall be gently agitated so as to liquefy rendered fat and to remove the sauce without breaking the beef or vegetables. 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. 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. Remove beef strips from the sieve and record weight of sieve plus its contents. Subtract the weight of the sieve plus its contents from the combined drained weight to determine the weight of the beef. The drained weight shall be reported to the nearest 0.1 ounce or to the nearest 1 gram.~~ Use a U.S. Standard No. 12 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 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

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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 beef strips from the sieve. Place the sieve back on the scale and record the weight as a positive number. This value is the drained weight of the beef strips. Empty the remaining contents of the sieve by turning the sieve upside down and dumping the remaining product. Place the sieve back on the scale and record the weight as a positive number. This value is the combined drained weight. 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:

<u>Test</u>	<u>Method Number</u>
Fat	985.15
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 nonconforming results 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.

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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.

(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 below. The lot size shall be expressed in shipping containers. The sample unit shall be one shipping container fully packed. The inspection level shall be S-3 and the AQL, expressed in terms of defects per hundred units, shall be 4.0 for major defects and 10.0 for total defects.

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TABLE II. Shipping container and marking defects

<u>Category</u>		<u>Defect</u>
<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 issues of these documents are those active on the date of the solicitation or contract.

DSCP FORMS

DSCP FORM 3556 Marking Instructions for Boxes, Sacks, and Unit Loads of Perishable and Semiperishable Subsistence

MILITARY SPECIFICATIONS

MIL-PRF-44073 Packaging of Food in Flexible Pouches

NON-GOVERNMENTAL STANDARDS

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

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

ASTM INTERNATIONAL www.astm.org

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

D 4727/D 4727M Standard Specification for Corrugated and Solid Fiberboard Sheet Stock (Container Grade) and Cut Shapes

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

AOAC INTERNATIONAL www.aoac.org

Official Methods of Analysis (OMA) of AOAC International

NORTH AMERICAN MEAT PROCESSORS ASSOCIATION (NAMP) www.namp.com

The Meat Buyers Guide