

SECTION C

This document covers breakfast skillet (hash brown potatoes and scrambled eggs mixed with meat or poultry sausage, bell peppers and onions), cooked, dehydrated, packaged in a boil-in-bag (BIB) then overpacked in a barrier pouch or brickpack pouch for use by the Department of Defense as a component of operational rations.

C-1 ITEM DESCRIPTION

PCR-B-053A, BREAKFAST SKILLET (HASH BROWN POTATOES AND SCRAMBLED EGGS MIXED WITH MEAT OR POULTRY SAUSAGE, BELL PEPPERS AND ONIONS), COOKED, DEHYDRATED, SHELF STABLE, PACKAGED IN A BOIL-IN-BAG (BIB) OR BRICKPACK POUCH

Class, type, style, and flavors.

Class.

Class 2 - BIB with large opening fitment and cap
For use in Unitized Group Ration – Heat & Serve (UGR-H&S)

Type.

Type II - BIB without center seal

Style.

Style I - Brickpack pouch
For use in Meal, Cold Weather (MCW)

Flavors.

Flavor 1 - Pork sausage
Flavor 2 - Turkey sausage

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

C. Dehydrated product.

(1) Appearance.

a. General. The finished product shall be a mixture of cooked hash brown potato shreds, cooked egg pieces, cooked meat or poultry sausage pieces appropriate for the specific flavor, cooked green and red bell pepper dices and onion pieces that have been dehydrated. The product shall be fully dehydrated. The finished product shall be free from foreign materials.

b. Hash brown potatoes. The cooked, dehydrated hash brown potatoes shall be shreds and shall be an off-white to light cream exterior and interior color.

c. Eggs. The cooked, dehydrated eggs shall be pieces and shall be a medium yellow color.

d. Vegetables. The cooked, dehydrated green bell pepper shall be dices and shall be a green color. The cooked, dehydrated red bell pepper shall be dices and shall be a red to reddish-orange color. The cooked, dehydrated onion shall be pieces and shall be a white to off-white color.

e. Flavor 1. The cooked, dehydrated pork sausage pieces shall be a light to medium brown color.

f. Flavor 2. The cooked, dehydrated turkey sausage pieces shall be an off-white to light tan color.

(2) Odor. The packaged food shall have a smoked, cooked dehydrated egg odor. The packaged food shall be free from foreign odors.

a. Flavor 1. The breakfast skillet with pork sausage shall have a cooked pork sausage odor.

b. Flavor 2. The breakfast skillet with turkey sausage shall have a cooked turkey sausage odor.

(3) Texture. The product shall not have wet or soft spots indicating incomplete dehydration.

D. Net weight.

(1) Class 2, Type II, BIB. The average net weight shall be not less than 24.7 ounces (700 grams). The net weight of an individual BIB shall be not less than 23.7 ounces (672 grams).

(2) Style I, Brickpack pouch. No individual pouch shall have a net weight of less than 3.2 ounces (90 grams).

E. Rehydrated product.

(1) Appearance.

a. General. The rehydrated product shall be a mixture of cooked hash brown potato shreds, cooked egg pieces, cooked pork or turkey sausage pieces, cooked green and red bell pepper dices and cooked onion pieces typical of a product that has been frozen and reheated. The class 2, type II, flavor 1, and style I, flavor 1, rehydrated product shall be practically free of bone or bone fragments, cartilage, coarse connective tissue, tendons or ligaments, and glandular material. The class 2, type II, flavor 2, rehydrated product shall be practically free of skin, bone or bone fragments, cartilage, coarse connective tissue, tendons or ligaments, glandular material, and discolored meat. The rehydrated product shall be free from foreign materials.

b. Hash brown potatoes. The cooked, rehydrated hash brown potatoes shall be shreds and shall be an off-white to light cream exterior and interior color.

c. Eggs. The cooked, rehydrated eggs shall be pieces and shall be a light to medium yellow color.

d. Vegetables. The cooked, rehydrated green bell pepper shall be dices and shall be a green color. The cooked, rehydrated red bell pepper shall be dices and shall be a red to reddish-orange color. The cooked, rehydrated onion shall be pieces and shall be an off-white color.

e. Flavor 1. The cooked, rehydrated pork sausage pieces shall be 1/4 to 3/4 inch in length. The pork sausage shall be a light to medium brown color.

f. Flavor 2. The cooked, rehydrated turkey sausage pieces shall be 1/8 to 1/4 inch in length. The turkey sausage shall be a light tan color.

(2) Odor and flavor. The rehydrated product shall have a smoked odor and flavor and an odor and flavor characteristic of frozen and reheated cooked hash brown potatoes, cooked eggs, with green and red bell peppers and onions. The packaged food shall be free from foreign odors and flavors.

a. Flavor 1. The breakfast skillet with pork sausage shall have a cooked pork sausage odor and flavor.

b. Flavor 2. The breakfast skillet with turkey sausage shall have a cooked turkey sausage odor and flavor.

(3) Texture.

a. General. The Class 2, Type II, BIB product shall rehydrate in accordance with label instructions and shall show complete water penetration within five minutes. The Style I, Brickpack pouch product shall fully rehydrate within ten minutes.

b. Hash brown potatoes. The hash brown potato shreds shall be moist and tender.

c. Eggs. The egg pieces shall be moist and tender and may be slightly spongy.

d. Vegetables. The green and red bell pepper dices and onion pieces shall be soft and tender.

e. Flavors 1 and 2. The pork sausage and turkey sausage pieces shall be moist and tender.

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

G. Analytical requirements.

(1) Protein.

a. For flavor 1, the protein content shall be not less than 12.0 percent.

b. For flavor 2, the protein content shall be not less than 20.0 percent.

(2) Fat. For flavors 1 and 2, the fat content shall be not greater than 35.0 percent.

(3) Sodium.

a. For flavor 1, the sodium content shall be not greater than 1540 mg per 100 grams.

b. For flavor 2, the sodium content shall be not greater than 1600 mg per 100 grams.

(4) Moisture. The moisture content of the dehydrated product shall be not greater than 2.0 percent.

H. Microbiological requirements.

(1) Aerobic plate count. The aerobic plate count shall be not greater than 75,000 Colony Forming Units (CFU) per gram in four of five samples and not greater than 150,000 CFU per gram in any individual sample.

(2) Escherichia coli (E. coli) count. *E. coli* shall have less than 10 CFU per gram or less than 3 Most Probable Number (MPN) per gram, where findings indicate zero colonies CFU per plate or zero tubes producing gas for MPN.

(3) Salmonella. The *Salmonella* test shall be negative for each of five pouches or BIBs tested per production lot.

I. BIB filling and sealing.

(1) Class 2, Type II, BIB. The combined dehydrated product shall be inserted into the BIB and then into the barrier pouch within 96 hours from combining individual components. If the product cannot be packaged within 96 hours, then the remaining product shall be adequately protected from moisture by either holding under a nitrogen atmosphere with 2.0 percent or less oxygen, or under a vacuum of at least 27 inches of mercury (27 Hg). If a vacuum is used, it shall be broken with nitrogen. Product may be held for a period not to exceed 30 days prior to packaging into BIBs.

SECTION D

D-1 PACKAGING

A. Packaging.

a. Class 2, Type II, BIB. A net weight of 24.7 ounces (700 grams) of dehydrated product shall be filled and sealed in a preformed BIB in accordance with the PACKAGING REQUIREMENTS AND QUALITY ASSURANCE PROVISIONS FOR PRODUCT PACKAGED IN A BOIL-IN-BAG (BIB).

(1) Barrier pouch. One Class 2, Type II BIB and oxygen scavenger (in accordance with the applicable assembly document) shall be placed in a barrier pouch having maximum outside dimensions of 18 by 18 inches. The pouch shall be made from a heat sealable barrier material. Note that material conforming to MIL-PRF-131 has been used. All four edges of the pouch shall be heat-sealed with seals not less than 1/8 inch wide. The BIB and oxygen scavenger shall not be entrapped in the heat seals. The side, bottom and closure seals shall have an average seal strength of not less than 6 pounds per inch of width and no individual specimen shall have a seal strength of less than 5 pounds per inch of width. Alternatively, the filled and sealed pouch shall exhibit no rupture or seal separation greater than 1/16 inch or seal separation that reduces the effective closure seal width to less than 1/16 inch when tested for internal pressure resistance. A tear nick, notch or serrations shall be provided to facilitate opening of the filled and sealed pouch.

(2) Oxygen scavenger. The oxygen scavenger shall be constructed of materials that are safe for direct food contact. The oxygen scavenger shall be in compliance with all applicable Food and Drug Administration (FDA) regulations.

(3) Oxygen content. The oxygen content of the headspace gas in the barrier pouch shall not exceed 2.0 percent.

(4) Box. One barrier pouch with one Class 2, Type II BIB and oxygen scavenger shall be packed in a box in accordance with the applicable assembly document. The box shall be style RSC, or telescoping design. If paperboard is used, it shall be minimum 0.028 inch thick and shall have a minimum basis weight of 100 pounds per square foot. The material may be coated. The material may be bleached. Corrugated materials of E, B, or C flute may also be used. The use of materials composed of the highest percentage of recovered materials practicable is encouraged. The outside dimensions of the carton shall not exceed 12-1/2 by 11-1/2 by 4-1/2 inches.

b. Style I, Brickpack pouch. A net weight of 3.2 ounces (90 grams) of dehydrated product shall be filled and sealed into pouches in accordance with the PACKAGING REQUIREMENTS AND QUALITY ASSURANCE PROVISIONS FOR PRODUCT PACKAGED IN A BRICKPACK POUCH.

D-2 LABELING

A. Labeling.

(1) Class 2, Type II, BIB. Each BIB shall be correctly and legibly labeled. Printing ink shall be permanent black ink or other dark contrasting color, which is free of carcinogenic elements. A carcinogenic-free pre-printed self-adhering clear polyester label printed with indelible contrasting ink may also be used. The label shall contain the following information:

- (1) Name of product (letters not less than 1/4 inch high)
- (2) Ingredients
- (3) Date 1/
- (4) Net weight
- (5) Contractor's name and address
- (6) USDA plant number
- (7) "Nutrition Facts" label in accordance with the Nutrition Labeling and Education Act (NLEA) and all applicable USDA regulations

NOTE: There shall be a black line, minimum 1/16 inch thick, indicating the fill level.

1/ Each BIB shall have the date of pack noted by using a four digit code beginning with the final digit of the current year followed by the three digit Julian day code. For example, 14 February 2030 would be coded as 0045. The Julian day code shall represent the day the product was packaged into the BIB.

The following instructions shall be printed on the Class 2, Type II, BIB:

YIELD: Serves 10 portions of approximately 1 cup each.

PREPARATION:

1. Shake BIB to settle contents. Open cap.
2. Support BIB on flat surface.
3. Add about 56 ounces (7 cups) of potable water to fill line. Replace cap.
4. Shake BIB until contents are rehydrated. Knead if necessary.

WARNING: Do not heat BIB in oven.

Rehydrated breakfast skillet should be used within one hour unless refrigerated for use within 24 hours.

COOKING

IN WATER: Place rehydrated closed BIB in boiling water. Simmer gently 35 minutes or until breakfast skillet is hot. Avoid overcooking (BIB may show evidence of bulging).

TO TRANSPORT AFTER HEATING: Insert BIB into an insulated food container or empty cooked breakfast skillet into an insulated food container to protect during transport.

CAUTION: Use care when opening as pressure may have been generated within the BIB.

TO OPEN: Cut bottom of BIB with clean knife.

Note: The font tested by Natick was Microsoft Helvetica. The font used shall be similarly clear/easy to read as Helvetica. The recommended font sizes are as follows: 22 for the

product name, 14 for “yield” and “cooking/heating.” If an additional note is required on the label it should also be in font size 14. All other information should be in font size 9.

(2) Style I, Brickpack pouch. Each pouch shall be labeled in accordance with the PACKAGING REQUIREMENTS AND QUALITY ASSURANCE PROVISIONS FOR PRODUCT IN A BRICKPACK POUCH.

(3) The product shall be formulated and labeled in accordance with all USDA labeling regulations and policies. The BIBs and pouches shall be labeled with the following product names, as applicable:

<u>Flavors</u>	<u>Product Names</u>
1	BREAKFAST SKILLET WITH PORK SAUSAGE, COOKED, DEHYDRATED
2	BREAKFAST SKILLET WITH TURKEY SAUSAGE, COOKED, DEHYDRATED

B. Barrier pouch (Class 2, Type II, BIB). Each barrier pouch shall be correctly and legibly labeled. Printing ink shall be permanent black ink or other dark contrasting color, which is free of carcinogenic elements. The label shall contain the following information:

- (1) Name of product (letters not less than 1/4 inch high)
- (2) Contents
- (3) Date 1/
- (4) Contractor's name and address

1/ Each barrier pouch shall have the date of pack noted by using a four digit code beginning with the final digit of the current year followed by the three digit Julian day code. For example, 14 February 2030 would be coded as 0045. The Julian day code shall represent the day the product was packaged into the BIB.

C. Box (Class 2, Type II, BIB). Each box shall be correctly and legibly labeled. Printing ink shall be permanent black ink or other, dark, contrasting color. The label shall contain the following information:

- (1) Name of product (letters not less than 1/4 inch high)
- (2) Contents
- (3) Date 1/
- (4) Contractor's name and address

1/ Each box shall have the date of pack noted by using a four digit code beginning with the final digit of the current year followed by the three digit Julian day code. For example, 14 February 2030 would be coded as 0045. The Julian day code shall represent the day the product was packaged into the BIB.

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, minimum burst grade 200 or ECT 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-4 UNITIZATION

A. Unit loads.

(1) Class 2, Type II, BIB. Unit loads shall be as specified in DLA Troop Support Form 3507, Loads, Unit: Preparation of Semiperishable Subsistence Items.

D-5 MARKING

A. Shipping containers and unit loads. Shipping containers and unit loads 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:

DEPARTMENT OF THE ARMY
FCDD-SCC-EMR
COMBAT CAPABILITIES DEVELOPMENT COMMAND-SOLDIER CENTER
10 GENERAL GREENE AVENUE
NATICK, MA 01760-5056

a. Class 2, Type II, BIB. One lot shall be randomly selected during each calendar month of production or as otherwise specified in the contract. The sample unit shall be one paperboard carton or barrier pouch containing one BIB of breakfast skillet. Two (2) sample units shall be randomly selected from that one production lot. The two (2) 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.

b. Style I, Brickpack pouch. 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.

a. Class 2, Type II, BIB. Conformance inspection shall include the examinations/tests and the methods of inspection cited in this section and in PACKAGING REQUIREMENTS AND QUALITY ASSURANCE PROVISIONS FOR PRODUCT PACKAGED IN A BOIL-IN-BAG (BIB).

b. Style I, Brickpack pouch. Conformance inspection shall include the examinations/tests and the methods of inspection cited in this section and in PACKAGING REQUIREMENTS AND QUALITY ASSURANCE PROVISIONS FOR PRODUCT PACKAGED IN A BRICKPACK POUCH.

E-5 QUALITY ASSURANCE PROVISIONS (PRODUCT)

A. Product examination.

(1) Class 2, Type II, BIB. 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 BIBs. The sample unit shall be the contents of one BIB. The inspection level shall be S-2 and the acceptable quality level (AQL), expressed in terms of defects per hundred units, shall be 1.5 for major defects and 6.5 for minor defects. Defects and defect classifications are listed in table I.

(2) Style I, Brickpack pouch. 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/

Category		Defect
<u>Major</u>	<u>Minor</u>	
		<u>Dehydrated product</u>
		<u>Appearance</u>
101		Product not a mixture of cooked hash brown potato shreds or not cooked egg pieces or not cooked meat or not cooked poultry sausage pieces appropriate to the flavor or not cooked green or not red bell pepper dices or not onion pieces that have been dehydrated.
102		Product not fully dehydrated. <u>3/</u>
103		Product not style or type as specified.
	201	Cooked, dehydrated hash brown potatoes not shreds or do not have an off-white to light cream exterior or interior color.
	202	Cooked, dehydrated eggs not pieces or not a medium yellow color.
	203	Cooked, dehydrated green bell pepper not dices or not a green color.
	204	Cooked, dehydrated red bell pepper not dices or not a red to reddish-orange color.
	205	Cooked, dehydrated onion not pieces or not a white to an off-white color.
	206	Flavor 1 cooked, dehydrated pork sausage pieces not a light to medium brown color.
	207	Flavor 2 cooked, dehydrated turkey sausage pieces not an off-white to light tan color.
		<u>Odor</u>
104		Product does not have a smoked or not a cooked dehydrated egg odor.

TABLE I. Product defects 1/ 2/ - Continued

Category		Defect
<u>Major</u>	<u>Minor</u>	
105		Flavor 1 breakfast skillet with pork sausage not a cooked pork sausage odor.
106		Flavor 2 breakfast skillet with turkey sausage not a cooked turkey sausage odor.
		<u>Texture</u>
107		Product has wet or soft spots indicating incomplete dehydration.
		<u>Net weight</u>
		<u>Class 2, Type II, BIB</u>
	209	Net weight of an individual BIB less than 23.7 ounces (672 grams). <u>4/</u>
		<u>Style I, Brickpack pouch</u>
	210	Net weight of an individual pouch less than 3.2 ounces (90 grams).
		<u>Rehydrated product 5/</u>
		<u>Appearance</u>
108		Product not a mixture of cooked hash brown potato shreds or not cooked egg pieces or not cooked pork or not turkey sausage pieces or not cooked green or not red bell pepper dices or not cooked onion pieces or not typical of a product that has been frozen and reheated.
109		Bone or bone fragment measuring more than 0.3 inch in any dimension.
	211	Class 2, Type II, flavor 1, total weight of cartilage, coarse connective tissue, tendons or ligaments, and glandular material more than 2.0 ounces (57 grams).
	212	Class 2, Type II, flavor 2, total weight of skin, cartilage, coarse connective tissue, tendons or ligaments, and discolored meat more than 1.0 ounce (28 grams).

TABLE I. Product defects 1/ 2/ - Continued

Category	Defect
<u>Major</u>	<u>Minor</u>
	213
	214
	215
	216
	217
	218
	219
	220
	<u>Odor and flavor</u>
110	
111	
112	

TABLE I. Product defects 1/ 2/ - Continued

Category		Defect
<u>Major</u>	<u>Minor</u>	<u>Texture</u>
	221	Rehydrated hash brown potato shreds not moist or not tender.
	222	Rehydrated egg pieces not moist or not tender.
	223	Rehydrated green and red bell pepper dices and onion pieces not soft or not tender.
	224	Flavors 1 and 2 pork sausage or turkey sausage pieces not moist or not tender.

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. Foreign flavor is not applicable to dehydrated product.

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. Palatability not applicable to dehydrated product.

3/ Presence of dark colored cores or a glazed surface area more than 0.25 inch in any dimension.

4/ Sample average net weight less than 24.7 ounces (700 grams) shall be cause for rejection of the lot.

5/ Prior to conducting the rehydrated product examination, the breakfast skillet shall be rehydrated per BIB or Brickpack pouch instructions. Product that does not rehydrate within five or ten minutes respectively, shall be cause for rejection of the lot.

B. Methods of inspection.

(1) 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.

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

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

<u>Test</u>	<u>Method Number</u>
Protein	988.05, 992.15
Fat	925.32, 991.36, 2007.04 or 2008.06
Sodium	985.35, 984.27

Test results for the protein and fat shall be reported to the nearest 0.1 percent. Test results for sodium shall be reported to the nearest 1 milligram per 100 grams. 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.

(4) Moisture testing.

a. Class 2, Type II, BIB. The sample to be analyzed shall be a one pound composite from three filled and sealed BIBs which have been selected at random from one lot. The composite sample shall be prepared by blending to uniformity using a blender or a food processor. The blending must be rapid and conducted in such a way that minimum heat is transferred to the product and that the product has minimum exposure to atmospheric moisture. The prepared sample shall be analyzed in accordance with OMA of AOAC International methods 927.05 1/, 985.14, or 2008.06.

b. Style I, Brickpack pouch. Eight filled and sealed pouches shall be selected at random from the lot regardless of lot size. The contents of each pouch shall be blended to uniformity using a blender or a food processor. The blending must be rapid and conducted in such a way that minimum heat is transferred to the product and that the product has minimum

exposure to atmospheric moisture. Each sample shall be tested for moisture content in accordance with OMA of AOAC International method 925.45A 1/.

Test results shall be reported to the nearest 0.1 percent. Any result not conforming to the requirements specified in Section C of this Performance-based Contract Requirements document shall be cause for rejection of the lot.

1/ The temperature-time cycle for moisture analysis shall be modified by using a temperature of 70°C for 16 hours at a pressure of not more than 100 mm of mercury.

(5) Oxygen testing. Eight filled and sealed pouches shall be randomly selected from one production lot and individually tested for oxygen content. Testing shall be accomplished after the filled and sealed pouches have been allowed to equilibrate at room temperature for not less than 48 hours from the time of sealing. Test results shall be reported to the nearest 0.01 percent. Government verification will be conducted through actual testing by a Government laboratory. Any individual result not conforming to the oxygen content requirement shall be classified as a major defect and shall be cause for rejection of the lot.

(6) Microbiological testing. Five filled and sealed BIBs or pouches shall be selected at random from the lot regardless of lot size. The product shall be individually tested for microbiological levels in accordance with the OMA of AOAC International or the Food and Drug Administration (FDA) Bacteriological Analytical Manual (BAM). Any result not conforming to the microbiological requirements shall be cause for rejection of the lot.

<u>Test</u>	<u>Method Number</u>
Aerobic plate count	966.23, 966.24, 989.10 or 990.12
<i>E. coli</i>	966.24, 991.14, 992.30 or BAM Ch. 4 sections C & F
<i>Salmonella</i>	967.26, 967.28, 986.35, 991.13, 994.04, 121501, 2000.06 (b), 2003.09, or 2004.03

NOTE: The following condition applies for *Salmonella* and microbiological testing:

USDA *Salmonella* and additional microbiological testing is required for each end item lot and shall be the basis for lot acceptance with respect to *Salmonella* and other microbiological testing requirements.

PCR-B-053A
19 August 2020
SUPERSEDING
PCR-B-053
19 September 2012

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

(1) Class 2, Type II, BIB. Inspection for packaging, labeling, packing, and marking shall be in accordance with the PACKAGING REQUIREMENTS AND QUALITY ASSURANCE PROVISIONS FOR PRODUCT PACKAGED IN A BOIL-IN-BAG (BIB).

(2) Style I, Brickpack pouch. Inspection for packaging, labeling, packing, and marking shall be in accordance with the PACKAGING REQUIREMENTS AND QUALITY ASSURANCE PROVISIONS FOR PRODUCT PACKAGED IN A BRICKPACK POUCH.

SECTION J REFERENCE DOCUMENTS

Unless otherwise specified, the applicable version of these documents is that which is active on the date of the solicitation or contract.

DLA Troop Support Forms

Form 3507	Loads, Unit: Preparation of Semiperishable Subsistence Items
Form 3556	Marking Instructions for Boxes, Sacks, and Unit Loads of Perishable and Semiperishable Subsistence

DEPARTMENT OF DEFENSE SPECIFICATION

MIL-PRF-131	Barrier Materials, Watervaporproof, Greaseproof, Flexible, Heat-Sealable
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(Copies of these documents are available from <http://quicksearch.dla.mil/qsSearch.aspx> or from the Standardization Document Order Desk, 700 Robbins Ave, Building 4D, Philadelphia, PA 19111-5094.)

SPECIFICATIONS

PACKAGING REQUIREMENTS AND QUALITY ASSURANCE PROVISIONS FOR PRODUCT PACKAGED IN A BOIL-IN-BAG (BIB)

PACKAGING REQUIREMENTS AND QUALITY ASSURANCE PROVISIONS FOR PRODUCT PACKAGED IN A BRICKPACK POUCH

GOVERNMENT PUBLICATIONS

FOOD AND DRUG ADMINISTRATION Bacteriological Analytical Manual (BAM)
<http://www.fda.gov/food/foodscienceresearch/laboratorymethods/ucm2006949.htm>

Federal Meat Inspection Act (FMIA) and regulations promulgated thereunder (9 Code of Federal Regulations (CFR) Parts 1-391)

Poultry Products Inspection Act (PPIA) and regulations promulgated thereunder (9 Code of Federal Regulations (CFR) Parts 1-391)

Food Standards and Labeling Policy Book

NON-GOVERNMENTAL STANDARDS

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

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

AOAC INTERNATIONAL www.aoac.org

Official Methods of Analysis (OMA) of AOAC International

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

D5118/D5118M Standard Practice for Fabrication of Fiberboard Shipping Boxes