

SECTION C

This document covers thermostabilized Southwestern style chicken chili in a polymeric tray for use by the Department of Defense as a component of operational rations.

C-1 ITEM DESCRIPTION

PCR-S-025, SOUTHWESTERN STYLE CHICKEN CHILI, PACKAGED IN A POLYMERIC TRAY, 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 whole muscle chicken meat dices, white beans, black beans, and green chili pieces in a seasoned sauce. The finished product shall be free from foreign materials.

(2) Chicken. The chicken shall be whole muscle chicken meat dices typically produced by a 3/4 inch machine setting. The whole muscle chicken meat shall be derived from unground whole muscle chicken meat in natural proportions (void of any ground product). The whole muscle chicken meat dices shall have a cooked chicken color. The packaged food shall be practically free of skin, bone or bone fragments, cartilage, coarse connective tissue, tendons or ligaments, and discolored meat.

(3) Beans. The beans shall be white beans and black beans in an approximate 50/50 percent ratio. The beans shall be practically free of broken beans, mashed beans or loose skins.

a. White beans. The white beans shall be a white to light tan color.

b. Black beans. The black beans shall be a dark brown to black color.

(4) Green chilies. The green chili pieces shall have a cooked appearance and cooked green chili color.

(5) Sauce. The sauce shall be glossy, opaque, moderately thick, and a medium greenish-tan color with visible flecks of herbs and spices.

E. Odor and flavor. The packaged food shall have an odor and flavor of cooked chicken and beans in a mild Southwestern style sauce. The Southwestern style chicken chili may elicit a sensation of mild heat. The packaged food shall be free from foreign odors and flavors.

F. Texture.

(1) Chicken. The whole muscle chicken meat dices shall be moist and tender with a cooked whole muscle chicken meat texture.

(2) Beans. The white and black beans shall be slightly soft to slightly firm.

(3) Sauce. The sauce shall be smooth and moderately thick. The sauce may contain pieces of green chilies and onion.

G. Net weight. The average net weight shall be not less than 94.0 ounces (2665 grams). The net weight of an individual polymeric tray shall be not less than 92.0 ounces (2608 grams).

H. Drained weight.

a. Chicken, chili pieces, and beans. The average drained weight of the cooked whole muscle chicken meat dices, green chili pieces and beans (combined) shall be not less than 47.0 ounces (1333 grams). The drained weight of the cooked whole muscle chicken meat dices, green chili pieces and beans (combined) in an individual polymeric tray shall be not less than 45.0 ounces (1276 grams).

b. Chicken. The percentage of chicken shall be not less than 35% as confirmed by USDA review of formulation.

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

J. Analytical requirements.

(1) Fat. The fat content shall be not greater than 5.0 percent.

(2) Salt. The salt content shall be not less than 0.5 percent and not greater than 1.3 percent.

C-3 MISCELLANEOUS INFORMATION

THE FOLLOWING IS INFORMATION ONLY TO PROVIDE THE BENEFIT OF PAST GOVERNMENT EXPERIENCE. THIS IS NOT A MANDATORY CONTRACT REQUIREMENT.

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

<u>Ingredients</u>	<u>Percent by weight</u>
Chicken, diced, cooked (whole muscle meat in natural proportions)	38.750
Chicken broth <u>1/</u>	30.730
Beans, white and black beans, 50/50 percent ratio (drained/washed)	21.927
Green chilies, chopped (drained)	6.430
Starch (Col Flo)	1.140
Cilantro, dry	.046
Onion	.310
Salt <u>2/</u>	.310
Vegetable oil	.205
Cumin, ground	.072
Red pepper, crushed	.056
Garlic Powder	.024

1/ Chicken broth powder may be used.

2/ The total amount of salt in the formulation may be adjusted as necessary to produce a product that complies with the finished product salt requirement.

SECTION D

D-1 PACKAGING

A. Preservation. Product shall be filled into polymeric trays and the trays with protective sleeves shall conform to the requirements of section 3 of MIL-PRF-32004, Packaging of Food in Polymeric Trays. Government verification testing and inspection of trays, lids and sleeves shall be in accordance with Section 4 of MIL-PRF-32004 and the Quality Assurance Provisions of Section E of this Performance-based Contract Requirements document.

B. Polymeric tray closure. The filled, sealed, and processed tray shall be securely closed.

D-2 LABELING

A. Polymeric tray body. The polymeric tray body shall be clearly printed or stamped, in a manner that does not damage the tray, with permanent ink of any contrasting color, which is free of carcinogenic elements. One end of the polymeric tray (see figure 1 of MIL-PRF-32004) shall be marked with the product name and number of portions. If the tray body end markings are not readily legible in low light conditions, a small, easily legible label shall be applied, but not over any existing tray markings. All other markings may be applied along the tray body side. To avoid erroneous marking of trays, the product name, lot number and filling equipment number shall be applied prior to processing. Additional tray marking may be applied before or after processing. 1/

Tray body markings shall include:

- (1) Product name. Commonly used abbreviations may be used.
- (2) Tray code includes: 2/
 - Lot Number
 - Filling equipment identification number
 - Retort identification number
 - Retort cook number
 - Official establishment number

1/ As an alternate method, tray body markings may be clearly printed or stamped onto the polymeric tray lid prior to processing, in a manner that does not damage the lid, with permanent ink of any contrasting color, which is free of carcinogenic elements, provided that the required markings are applied onto the tray body after processing.

2/ 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 tray and processed. Sublotting (when used) shall be represented by an alpha character immediately following the four digit Julian code. Following the four digit Julian code and the alpha character (when used), the other required code information shall be printed in the sequence as listed above.

B. Polymeric tray lid. The lid shall be clearly printed or stamped in a manner that does not cause damage. Permanent ink of any contrasting color, which is free of carcinogenic elements, shall be used. As an alternate labeling method, a pre-printed self-adhering 0.002 inch thick clear polyester label printed with indelible contrasting color ink may be used.

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 “to heat in water.” If an additional note is required on the label, such as “fluff before serving,” it should also be in font size 14. All other information should be in font size 9.

(1) Lid labeling shall include:

- Product name
- Ingredients
- Net weight
- Name and address of packer
- Official inspection legend
- “Nutrition Facts” label in accordance with the Nutrition Labeling and Education Act (NLEA) and all applicable USDA regulations

(2) Lid labeling shall also show the following statements:

YIELD: Serves 18 portions of approximately 2/3 cups each of Southwestern Style Chicken Chili

TO HEAT IN WATER: Submerge unopened tray in water. Bring water to a boil. Simmer gently 35-40 minutes. Avoid overheating (tray shows evidence of bulging).

WARNING: Do not heat tray in oven.

TO TRANSPORT AFTER HEATING: Insert tray back into protective sleeve to protect during transport. If sleeve is unavailable, stack trays lid-to-lid with fiberboard pads in between.

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

TO OPEN: Using a clean knife, cut the lidding around the inside perimeter of the tray seals.

SUGGESTION: Cut lid along 3 sides and fold over uncut portion. Fold back to keep unused portions protected.

(3) The product shall be formulated and labeled in accordance with all USDA labeling regulations and policies. The lid shall be labeled with the following product name:

SOUTHWESTERN STYLE CHICKEN CHILI

D-3 PACKING

A. Packing. Four filled, sealed, processed and sleeved polymeric trays shall be packed in a fiberboard shipping box constructed in accordance with style RSC-L 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. The sleeved trays shall be placed flat with the first two trays placed with the lids together and the next two trays with the lids together. 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. Boxes shall be arranged in unit loads in accordance with 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:

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 and the methods of inspection cited in this section.

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 trays. The sample unit shall be the contents of one tray. The inspection level shall be S-3 and the acceptable quality level (AQL), expressed in terms of defects per hundred units, shall be 4.0 for major defects and 6.5 for minor defects. Defects and defect classifications are listed in table I. The trays shall be heated in accordance with the heating instructions from the tray label prior to conducting any portion of the product examination. The samples for drained weight inspection shall be selected using the same sampling criteria as above.

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

Category		Defect
<u>Major</u>	<u>Minor</u>	
		<u>Appearance</u>
101		Product not a uniform mixture of cooked whole muscle chicken meat dices, white beans, black beans, and green chili pieces in a seasoned sauce.
102		Bone or bone fragment measuring more than 0.3 inch in any dimension.
	201	Total weight of skin, cartilage, coarse connective tissue, tendons or ligaments, and discolored meat more than 1.0 ounce (28 grams).
	202	Chicken not whole muscle chicken meat dices.
	203	Whole muscle chicken meat dices not a cooked chicken color.
	204	Beans not practically free of broken beans, mashed beans, or loose skins.
	205	White beans not a white to light tan color.
	206	Black beans not a dark brown to black color.
	207	Green chili pieces do not have a cooked appearance or cooked green chili color.
	208	Sauce not glossy or not opaque or not moderately thick or not a medium greenish-tan color, or does not have visible flecks of herbs and spices.
		<u>Odor and flavor</u>
103		Product does not have an odor or flavor of cooked chicken and beans in a mild Southwestern style sauce.

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

Category		Defect
<u>Major</u>	<u>Minor</u>	
		<u>Texture</u>
	209	Whole muscle chicken meat dices not moist or not tender or does not have a cooked whole muscle chicken meat texture.
	210	White beans or black beans not slightly soft to slightly firm.
	211	Sauce not smooth or not moderately thick.
		<u>Net weight</u>
	212	Net weight of an individual polymeric tray less than 92.0 ounces (2608 grams). <u>6/</u>
		<u>Drained weight</u>
	213	Drained weight of cooked whole muscle chicken meat dices, green chili pieces and beans (combined) in an individual polymeric tray less than 45.0 ounces (1276 grams). <u>7/</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/ Machine setting and requirement for whole muscle chicken meat to be derived from unground whole muscle chicken meat in natural proportions (void of any ground product) shall be verified by a Certificate of Conformance (CoC).

4/ Requirement for beans to be white beans and black beans in an approximate 50/50 percent ratio shall be verified by USDA review of the producer's formulation.

5/ Percentage of whole muscle chicken meat dices of not less than 35 percent of the formulation shall be confirmed by USDA review of the producer's formulation.

6/ Sample average net weight less than 94.0 ounces (2665 grams) shall be cause for rejection of the lot.

7/ Sample average drained weight of cooked whole muscle chicken meat dices, green chili pieces and beans less than 47.0 ounces (1333 grams) shall be cause for rejection of the lot.

B. Methods of inspection.

(1) Commercial sterility. Commercial sterility shall be verified in accordance with USDA/FSIS regulations.

(2) Shelf life. The contractor shall provide a Certificate of Conformance that the product has a 36 month shelf life when stored at 80°F. Government verification may include storage for 6 months at 100°F or 36 months at 80°F. Upon completion of either storage period, the product will be subjected to a sensory evaluation panel for appearance and palatability and must receive an overall score of 5 or higher based on a 9 point quality scale to be considered acceptable.

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

(4) Drained weight. To determine drained weight, the contents shall be poured into a flat-bottom container. A minimum of three times the polymeric tray's volume 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 agitated so as to liquefy rendered fat and to remove sauce without breaking the chicken or beans. The contents shall then be poured into a U.S. Standard No. 8 sieve in a manner that will distribute the product over the sieve without breaking the chicken or beans. 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 0.5 ounce or to the nearest 1 gram.

(5) Analytical. The sample to be analyzed shall be a one-pound composite of three filled and sealed polymeric trays that have been selected at random from one production 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	922.06, 991.36, 2007.04, 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, POLYMERIC TRAY)

A. Packaging and labeling.

(1) Polymeric tray testing. For purposes of clarification, the polymeric tray without the lid will be referred to as the “tray” and the polymeric tray with the lid shall be referred to as the “container”. The polymeric tray with protective sleeve and polymeric tray material shall be examined for the characteristics listed in table I of MIL-PRF-32004, Packaging of Food in Polymeric Trays. The lot size, sample unit, and inspection level criteria are provided in table II for each of the test characteristics. Any test failure shall be classified as a major defect and shall be cause for rejection of the lot. For rough handling survivability at frozen temperature, polymeric tray survival rate shall be at least 85 percent.

TABLE II. Polymeric tray quality assurance criteria
Prior to processing

Characteristic	Lot size expressed in	Sample unit	Inspection level
Tray configurations and dimensions	Trays	1 tray	S-1
Oxygen gas transmission rate of tray	Trays	1 tray	S-1
Oxygen gas transmission rate of lid	Yards	1/2 yard	S-1
Water vapor transmission rate of tray	Trays	1 tray	S-1
Water vapor transmission rate of lid	Yards	1/2 yard	S-1
Camouflage	Containers	1 container	S-1

<u>After processing</u>			
Characteristic	Lot size expressed in	Sample unit	Inspection level
Processing	Trays	1 tray	S-2
Rough handling survivability	Test containers	1 container	S-2
Protective sleeve	Containers	1 container	S-1
Residual gas	Containers	1 container	S-1
Closure seal	Containers	1 container	S-1
Internal pressure	Containers	1 container	S-1
Lid opening	Containers	1 container	S-1

(2) Examination of container. The container with protective sleeve removed shall be examined for the defects listed in table II of MIL-PRF-32004 and the labeling defects listed in table III. The lot size shall be expressed in containers. The sample unit shall be one processed and labeled container. 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.

TABLE III. Container labeling defects

Category		Defect
<u>Major A</u>	<u>Minor</u>	
101		Polymeric tray lid or body labeling missing or incorrect or illegible.
	201	When a pre-printed self adhering label is used, the label not adhering to tray lid (for example, label raised or peeled back from edge to corner) or presence of any areas of gaps along the perimeter of the label where the label is not properly adhered.

(3) Label adhesive examination. When self-adhering labels are used, the adhesive shall be tested in accordance with ASTM D3330/D3330M, Standard Test Method for Peel Adhesion of Pressure-Sensitive Tape. In lieu of testing, a CoC shall be provided.

B. Packing.

(1) Shipping container and marking examination. The filled and sealed shipping containers shall be examined for the defects listed in table IV. 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 IV. 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	Arrangement or number of polymeric trays not as specified.

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.

C. Unitization.

(1) Unit load examination. The unit load shall be examined in accordance with DLA Troop Support Form 3507, Loads, Unit: Preparation of Semiperishable Subsistence Items. Any nonconformance shall be classified as a major defect.

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

MILITARY SPECIFICATIONS

MIL-PRF-32004	Packaging of Food in Polymeric Trays
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GOVERNMENT PUBLICATIONS

Federal Food, Drug, and Cosmetic Act and regulations promulgated thereunder
(21 CFR Parts 1-199) and (9 CFR Parts 1-391)

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

D3330/D3330M Standard Test Method for Peel Adhesion of Pressure-
Sensitive Tape

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

D5118/D5118M Standard Practice for Fabrication of Fiberboard
Shipping Boxes

AOAC INTERNATIONAL www.aoac.org

Official Methods of Analysis (OMA) of AOAC International