

**DEPARTMENT OF THE ARMY**  
**HEADQUARTERS, UNITED STATES ARMY VETERINARY COMMAND**  
**OPERATIONAL RATIONS INSPECTION PROCEDURE (OPRATS IP14)**  
**Revision 7, 3 March 2011**

**Unitized Group Ration - A, Procurement/Origin/In-Plant Verification Inspection**

1.0 **PURPOSE**: To establish standardized procedures for the food safety and quality assurance of Unitized Group Ration – A (UGR-A) at origin.

2.0 **SCOPE**: This procedure applies to all Army Veterinary Inspectors (AVI) performing in-plant UGR-A food safety and quality assurance functions at a contractor assembly plant prior to OCONUS shipment. “OCONUS” also refers to Alaska and Hawaii deliveries for the purpose of this Inspection Procedure (IP).

**NOTE**: With regards to UGR-A’s assembled by Wornick, Ameriquel, and/or Labatt and shipped to Hawaii or Alaska, no origin in-plant inspections generally are required. However, DLA-Troop Support may request inspections of these shipments in which case the AVI will perform and document the origin in-plant inspection results.

3.0 **DEFINITIONS**: See applicable UGR-A Contract

4.0 **REFERENCES**:

- 4.1 Individual Assembler (Contractor) UGR-A Contracts
- 4.2 Solicitation Number SPO300-99-R-7001
- 4.3 ANSI/ASQ Z1.4-2003
- 4.4 United States Standards for Condition of Food Containers
- 4.5 DSCP Manual 4155.20
- 4.6 AR 25-400-2, The Army Records Information Management Systems (ARIMS)
- 4.7 AR 40-657, Veterinary/Medical Food Safety, Quality Assurance, and Laboratory Services
- 4.8 DSCP website, <https://www.dscp.dla.mil/subs/rations/programs/ugr/uaabt.asp#menu>
- 4.9 Worldwide Directory of Sanitarily Approved Food Establishments for Armed Forces Procurement

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**5.0 PROCEDURES:**

5.1 The contractor will provide the AVI with a production schedule detailing the quantity and menu numbers to be produced NLT 72 hours prior to the scheduled production run. The contractor's representative must be present in the plant at all times in order for the AVI to conduct these inspections. In the event that the contractor representative is not present, the AVI will notify DSCP Operational Rations Quality Assurance Representative or Contracting Officer for guidance at (215) 737-7802.

5.2 The AVI will develop a moving-lot sampling plan in accordance with Table I, Inspection Level **S-2** and Table II-A (Single Sampling Plans for Normal Inspection - Master Table) ANSI/ASQ Z1.4-2003. The AVI will use the same sampling plan when inspecting the perishable and semi-perishable modules unless the quantity of the perishable modules being produced differs from the number of semi-perishable modules being produced. If the perishable and semi-perishable lot sizes **do not** coincide, separate **sample plans will be developed for each. The AVI will establish for each different lot size of separate NSNs (i.e. Breakfast menus and Lunch/Dinner menus) a separate sample plan.** The Lotus Notes, UGR-A9 Origin database calculates the sample size automatically. The AVI will apply strict random sampling in all instances.

**NOTE:** When a moving-lot sampling plan cannot be accomplished then a stationary-lot sampling plan will be accomplished. Stationary-lot sampling plan will be in accordance with Table I, Inspection Level **S-3** and Table II-A (Single Sampling Plans for Normal Inspection - Master Table) ANSI/ASQ Z1.4-2003. Samples should be representative of the entire lot and strict random sampling used.

**NOTE:** Grand-lotting of multiple like/same menus may be accomplished when necessary. (Example of this would be when assembly facility assembles five B5 menus for five separate orders at the same time. Rather than five separate sample sizes the five orders may be combined and one larger sample size created to represent all five orders of B5 menu). The intent is to save time and resources while representing multiple lots with one inspection.

5.2.1 The AVI will pull module sample cases off the assembly line for inspection (or from completed pallets if stationary lot inspection). The AVI will not interrupt the contractor's assembly line operation unless a food safety issue is identified. The AVI will immediately report non-conformances other than food safety issues to the contractor's representative for resolution.

5.2.2 When changes to the contractors production schedule plan alters the quantity of modules being produced, the AVI will determine if a new sampling plan will be calculated to reflect the new lot size being produced.

5.3 The AVI's in-plant verification inspections are limited to the following sections of the contract:

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5.3.1 Substitution of Menu Items or Brand Labels. The AVI will compare both the menu sheet in “Box 1” of the semi-perishable module and the menu sheet in Attachment 1 of the contract to the contents of the UGR-A modules. Written authorization for substitutions, as stated in the contract, also applies to email notification received by the contractor from DSCP and the contractor will provide the in-plant AVI DSCP’s written authorization or notification.

5.3.2 Date-of-Pack/Shelf Life/Freshness Requirements. The AVI will base computation on the shortest shelf life component contained in the ration module. To determine the shelf life remaining/Inspection Test Date (ITD), use Attachment 1 of the contract . For ITD determination of condiment components, the AVI will utilize the inspection requirements listed in the contract.

5.3.3 Packaging, Packing, Marking and Labeling of the UGR-A Modules. The AVI will use the inspection requirements listed in the contract. Inspection will include the sanitary condition, serviceability, and possible infestation of all pallets prior to unit load configuration.

5.3.4 Delivery, Shipping, and Storage Requirements. The AVI will place emphasis on the condition, wholesomeness, and temperature requirements associated with the perishable components. For initial product temperature, the AVI will place the thermometer between two primary units inside the case. If the initial temperature results indicate a temperature nonconformance, the AVI will take the actual internal product temperature by inserting the thermometer directly into the frozen product IAW DSCP Manual 4155.20. The AVI will use the inspection requirements listed in the contract.

5.3.5 Missing Components. The AVI will count all items to ensure that the required components in accordance with Table 1 of the contract have been included in the ration modules. Table 1 is found in the DSCP website at:

<https://www.dscp.dla.mil/subs/rations/programs/ugr/uaabt.asp#menu>

5.3.6 Product Sanitarily Approved Source Requirements. All UGR-A subsistence components must originate from establishments listed in the Worldwide Directory of Sanitarily Approved Food Establishments for Armed Forces Procurement or be exempt from listing in accordance with the Directory and AR 40-657.

5.3.7 Inspection of UGR-A Components. UGR-A food components are expected to meet the requirements in Table II of the procurement contract. Table II is found in the DSCP website at:

<https://www.dscp.dla.mil/subs/rations/programs/ugr/uaabt.asp#menu>

5.3.7.1 Inspectors should compare the description in Table II with the labeling on the case/product.

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5.3.7.2 Common deficiencies at origin and how to address them are:

5.3.7.2.1 Deficiencies that can be addressed with a non-destructive inspection. This may include opening a box of items that are bagged but not sealed. For example, the pork chops are loosely bagged. They can be removed, examined, weighed and/or measured as appropriate. The inspector would take appropriate measures to ensure that he does not contaminate the product. Then the inspector would return the item to the container and tape it shut. He would annotate or make a stamp impression on the case that indicates the item was vet inspected and the date of inspection.

5.3.7.2.2 Deficiencies that can best be checked at the point of manufacture (not at the assembly plant), such as breaching on chicken breast.

5.3.7.2.3 Deficiencies that can be detected at origin (assembly plant) or destination, but would require Destructive Open Package Inspection (DOPI). For these types of inspections, the inspector should be directed to perform a DOPI or request the authority to perform a DOPI because of some indication that there is a problem. This indication could come from the label or condition of the case or some other reason. If the item is canned, vacuum-packed or sealed in a plastic bag, DOPI would be required to perform the inspection.

5.3.7.2.4 Deficiencies that can only be checked at the lab, such as % fat.

5.3.7.2.5 Origin inspection will be non-destructive unless authorized by DSCP. Inspectors will not perform grade verification, unless trained and certified by VETCOM; alternatively the AVI may request support/supervision of a VETCOM Destination Auditor. In the event destructive sampling is required to perform the above verification inspection, written authorization will be provided by DSCP.

5.3.8 OCONUS Shipment Requirements: The requirements in the contract are the responsibility of the contractor.

5.3.9 Additional Inspection Guidelines. The following guidance is provided to supplement the current contractual inspection requirements for the UGR-A In-procurement inspection:

5.3.9.1 The AVI will classify can defects IAW the U.S. Standards for Condition of Food Containers/ The USDA Visual inspection Gauge (Metal Containers). The AVI will not report "insignificant" defects.

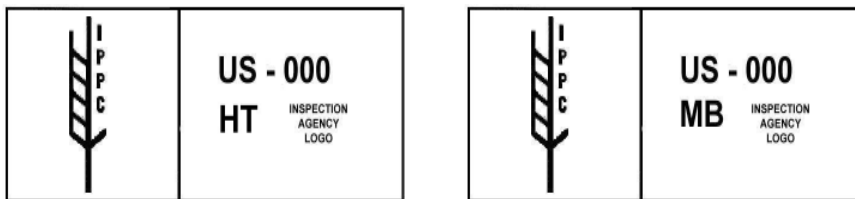
5.3.9.2 The AVI will not physically stress the integrity of the UGR-A component packaging in an attempt to verify suspected damage or leakage.

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5.4 At Time of Shipment.

5.4.1 The AVI will check unit load configuration for conformance just prior to shipment of the palletized end item IAW Contract. Sample size for unit loads will be in accordance with Table I, Inspection Level **S-1** and Table II-A (Single Sampling Plans for Normal Inspection - Master Table) ANSI/ASQ Z1.4-2003.

5.4.2 For all OCONUS shipments, the AVI will check the outside stringer of all wood pallets for the stencil/brand/stamp indicating the pallet is Heat Treated (HT) or treated with Methyl Bromide (MB) to meet quarantine requirements. The following are examples of the markings required for each pallet:



5.4.3 The contractor will load all frozen components onto a conveyance with an ambient temperature at or below 0 degrees Fahrenheit. The conveyance will be pre-cooled (prior to loading) to 0 degrees Fahrenheit. It is the contractor's responsibility to ensure that the conveyances are properly cooled, cleaned, and inspected for infestation. The plant personnel will check and record ambient temperature of the conveyance to ensure temperature compliance.

5.4.4 To the maximum extent possible, the AVI will be present during the loading of the conveyances for shipment to OCONUS destination. The temperature determination requirements are IAW the contract. The AVI will inspect the conveyance for cleanliness and infestation prior to loading IAW Contract.

5.4.5 When the shipment is designated as "acceptance at origin," the AVI will sign the DD Form 250, Material Inspection and Receiving Report (MIRR) or the contractor's invoice as final government acceptance. For Alaska and Hawaii deliveries, the requirement for acceptance is at destination.

5.5 Procurement Inspection Reporting. In-plant AVI's will use the Lotus Notes, UGR-A9 Origin Database for documenting all sampling and inspection results.

5.6 Nonconformance Reporting.

5.6.1 The UGR-A contract has no AQLs or accept/reject criteria. The AVI will report all non-conformances to the contractor's representative and to the DLA-Troop Support Operational Rations Quality Assurance Representative or Contracting Officer for guidance/immediate correction at (215) 737-7802.

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**NOTE:** The reason to report to DLA-Troop Support is that the AVI have no authority to accept/reject, rather only to make the recommendation to accept/reject and report this recommendation to accountable officer and DSCP.

5.6.2 The AVI will explain all non-conformances in detail in the Lotus Notes, UGR-A9 Origin Database.

5.7 UGR-A9 Origin Database.

5.7.1 Ensure to explain on each inspection whether the inspection was a moving-lot or stationary-lot inspection. Also, whether grand-lotting was performed. This will help the contracting officer when they review inspection results.

5.7.2 The sample sizes that automatically calculate on the inspection form in the UGR-A9 Inspection database may not exactly match the actual sample size based on whether the inspection was a moving-lot, stationary lot, and/or grand-lot. The sample sizes automatically calculate for a stationary-lot inspection. This is okay, and why you must ensure to explain on the form the requirement in paragraph 5.7.1.

**6.0 RECORDS, REPORTS, AND FORMS:**

6.1 Lotus Notes, UGR-A9 Origin Database.

6.2 If a computer is not available, the AVI can use a hard copy of DD Form 1714.

6.3 DD Form 1714 Filling Procedures (Enclosure 1).

6.4 DD Form 1714(Enclosure 2, parts 1 & 2).

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**Procedures for Completing a DD Form 1714:**

- Block 1: Contract number (SPO300-99-D-1111)
- Block 2: Lot Number (enter See Block #25)
- Block 3: Date of Verification (24 Nov 00)
- Block 4: Prime Contractor (Johnson Co. San Antonio, TX)
- Block 5: Lot Size (enter both quantities, 50 Perish/75 Semi-Perish)
- Block 6: Verification Of (check Contractor)
- Block 7: Plant Location (Dallas, TX)
- Block 8: Drawn From (check either Original Lot or Other (In-Line))
- Block 9: Defects Based On (check DHU)
- Block 10: Item Description (D10 – Perish & Semi-Perish)
- Block 11: Type of Verification (Contractor's QAS)
- Block 12: (N/A)
- Block 13: Specification Number and Date (Contract/Solicitation/Origin Insp. Handbook)
- Block 14: Number of Lots Verified to Date (N/A)
- Block 15: Disposition (Check either block depending on outcome of inspection)
- Block 16: Examination (Table II)
- Block 17: Insp. Level (S-3)
- Block 18 & 19: (N/A)
- Block 20: (check Contr.)
  - 20A: Sample Size (enter whatever the Table II identifies)
  - 20B: No of Def. (enter number of total defects from both Perish & Semi-Perish inspection)
- Block 21 & 22 & 23 & 24: (N/A)
- Block 25: Results
  - 25A: Examination (Enter Box1 & Box2)
  - 25B: Defects (Enter DOP & ITD, and list all defects)
  - 25C: Tally (Change Major & Minor to read BX1 & BX2)
- Block 26: Typed Name & Signature of Asst. QCR
- Block 27: Typed Name of Senior QCR or SQCR & Office Symbol
  - 27A: Signature of person in Block 27
- Block 28: Remarks (Develop sample plan, to include lot size, sample size, list of random numbers used to get samples for inspection, direction and number slots used to get sample numbers, and diagram of pallet to identify how pallet was counted to get samples identified using table of random numbers)

**Special Instructions:** Block 25 should be used to record all defects to include any notes, phone calls made along with date and person spoken to. Under the Tally section tally all defects under the BX1 or BX2 columns based on whether the defects were taken from BX1 or BX2 of the modules. Recommend that two back/Reverse pages be used for each module, one for Semi-Perish and one for Perish. This gives you more room to report notes in Block 25. The same sample plan in Block 28 should be used for both back pages unless the quantities for Perish & Semi-Perish are different.

**Enclosure 1**

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PRODUCT VERIFICATION RECORD						1. CONTRACT NUMBER SP0300-99-D-2200					
2. LOT NUMBER See block #25		3. DATE OF VERIFICATION 24 NOV 00		4. PRIME CONTRACTOR (Name, City, and State) Johnson Food Co. San Antonio, TX							
5. LOT SIZE 24 Perish / 48 Semi		6. VERIFICATION OF <input checked="" type="checkbox"/> CONTRACTOR <input type="checkbox"/> QCR		7. PLANT LOCATION (City and State) Dallas, TX							
8. DRAWN FROM <input checked="" type="checkbox"/> ORIGINAL LOT <input type="checkbox"/> RESUBMITTED LOT <input checked="" type="checkbox"/> OTHER (Specify) OR IN-LINE						9. DEFECTS BASED ON <input checked="" type="checkbox"/> DHU <input type="checkbox"/> % DEFECTIVE					
10. ITEM DESCRIPTION D10 - Semi-Perish ; Perish				11. TYPE OF VERIFICATION Contractor's QAS		12. RESULT OF VERIFICATION <input type="checkbox"/> COMPARABLE <input checked="" type="checkbox"/> N/A <input type="checkbox"/> NON-COMPARABLE					
13. SPECIFICATION NUMBER AND DATE Contract/Solicitation/Origin INSP. HDBK				14. NUMBER OF LOTS VERIFIED TO DATE N/A		15. DISPOSITION <input checked="" type="checkbox"/> ACCEPTED <input type="checkbox"/> REJECTED					
SAMPLING PLANS											
16. EXAMINATION	17. INSP. LEVEL	18. AQL	19. CLASS OF DEFECT	20. <input checked="" type="checkbox"/> CONTR. <input type="checkbox"/> QCR		21. ACCEPTANCE NUMBER	22. REJECTION NUMBER	23. VERIFICATION SAMPLE		24. ACTION NUMBER	
				A. SAMPLE SIZE	B. NO. OF DEF.			A. SAMPLE SIZE	B. NO. OF DEF.		
Table II	S-3	N/A	N/A	2	6	N/A	N/A				
25. RESULTS (Continue on reverse side)											
A. EXAMINATION		B. DEFECTS					C. TALLY				
		<b>EXAMPLE</b>					MAJOR: BX 1		MINOR: BX 2		
							MAJOR: BX 1		MINOR: BX 2		
26. TYPED NAME AND SIGNATURE OF ASST. QCR (When applicable)				27. TYPED NAME OF SENIOR QCR OR SQCR AND OFFICE SYMBOL				27A. SIGNATURE			
John Doe, SPC				Jane Doe, SSG				<i>John Doe</i>			

DD Form 1714, JUN 69

USAPPC V1.00

**Enclosure 2, part 1**



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25. RESULTS (Continued)			
A. EXAMINATION	B. DEFECTS	C. TALLY	
		MAJOR BX 1	MINOR BX 2
BX1	DOP 0193	ITD 0335	
BX2	0208	1034	
	ITD on BX1 incorrectly computed based on Parkay Margarine with 30 Nov 00 date. Should be 1151 based on Coffee with MFG date 05-31-00. Also, Parkay Margarine should not be used to determine ITD of BX1.		11
	Green Bean in BX2 not correct brand. Should be Libby's or Blue Sky IAW ATTACHMENT 2, actually Tri-Valley Brand.		1111

*Line Mistakes*  
*out and place initials*  
*waived per Ms. Henry 20 Nov 00*

**EXAMPLE**

These are your tally marks to record defects. Add these up to place in block 20 b.

28. REMARKS

hot size = 24 Perish  
 SS = 2 → 17, 22 ←  
 X00XX

89103  
 8(17)31  
 74445  
 14143  
 6(22)03

These numbers come from table of random number. The circle numbers are your sample to pull.

Draw picture of pallet and label how you counted the pallet to get your two samples.

DD Form 1714 Reverse, JUN 69

USAPPC V1.00

Perish → Have two reverse pages label one as Perish & one as semi-perish. This allows more room to record information.

Enclosure 2, part 2