

PP-B-201G
August 31, 1977

SUPERSEDING
Fed. Spec. PP-B-201F
July 2, 1971

FEDERAL SPECIFICATION

BEEF, CORNED, CANNED

This specification was approved by the Commissioner, Federal Supply Service, General Services Administration, for the use of all Federal agencies.

1. SCOPE AND CLASSIFICATION

1.1 Scope. This specification covers canned corned beef for use by all Federal agencies.

1.2 Classification.

1.2.1 Types. The product shall be of the following types, as specified (see 6.1):

- Type I - Standard (commercial product)
- Type II - Special

2. APPLICABLE DOCUMENTS

2.1 The following documents, of the issue in effect on date of invitation for bids or request for proposal, form a part of this specification to the extent specified herein:

Federal Specifications:

- TT-C-495 - Coatings, Exterior, For Tinned Food Cans.
- PPP-B-621 - Boxes, Wood, Nailed and Lock Corner.
- PPP-B-636 - Boxes, Shipping, Fiberboard.
- PPP-C-96 - Cans, Metal 28 Gage and Lighter.
- PPP-F-320 - Fiberboard; Corrugated and Solid, Sheet Stock (Container Grade), and Cut Shapes.

Federal Standard:

- FED-STD-123 - Marking for Shipment (Civil Agencies).

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(Activities outside the Federal Government may obtain copies of Federal Specifications, Standards, and Handbooks as outlined under General Information in the Index of Federal Specifications and Standards and at the prices indicated in the Index. The Index, which includes cumulative monthly supplements as issued, is for sale on a subscription basis by the Superintendent of Documents, U.S. Government Printing Office, Washington, DC 20402.

(Single copies of this specification and other Federal specifications required by activities outside the Federal Government for bidding purposes are available without charge from Business Service Centers, at the General Services Administration Regional Offices in Boston, New York, Washington, DC, Atlanta, Chicago, Kansas City, MO, Ft. Worth, Denver, San Francisco, Los Angeles, and Seattle, WA.

(Federal Government activities may obtain copies of Federal Specifications, Standards, and Handbooks and the Index of Federal Specifications and Standards from established distribution points in their agencies.)

Military Specifications:

- MIL-L-1497 - Labeling of Metal Cans for Subsistence Items.
- MIL-L-35078 - Loads, Unit: Preparation of Nonperishable Subsistence In.

Military Standards:

- MIL-STD-105 - Sampling Procedures and Tables for Inspection by Attributes.
- MIL-STD-129 - Marking for Shipment and Storage.
- MIL-STD-668 - Sanitary Standards for Food Plants.

(Copies of Military Specifications and Standards required by contractors in connection with specific procurement functions should be obtained from the procuring activity or as directed by the contracting officer.)

Laws and Regulations:

U.S. Department of Health, Education and Welfare

Federal Food, Drug and Cosmetic Act and Regulations Promulgated Thereunder

(Application for copies should be addressed to the Superintendent of Documents, U.S. Government Printing Office, Washington, DC 20402.)

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U.S. Department of Agriculture

Meat and Poultry Inspection Regulations

(Application for copies should be addressed to the Superintendent of Documents, U.S. Government Printing Office, Washington, DC 20402.)

Visual Aids for Inspection of Metal Containers

(Application for copies should be addressed to the Superintendent of Documents, U.S. Government Printing Office, Washington, DC 20402.)

2.2 Other publications. The following documents form a part of this specification to the extent specified herein. Unless a specific issue is identified, the issue in effect on date of invitation for bids or request for proposal shall apply:

Association of Official Analytical Chemists

Official Methods of Analysis of the Association of Official Analytical Chemists

(Application for copies should be addressed to the Association of Official Analytical Chemists, P.O. Box 540, Benjamin Franklin Station, Washington, DC 20044.)

Uniform Classification Committee, Agent

Uniform Freight Classification

(Application for copies should be addressed to the Uniform Classification Committee, Room 1106, 222 South Riverside Plaza, Chicago, IL 60606.)

National Motor Freight Traffic Association, Inc., Agent

National Motor Freight Classification

(Application for copies should be addressed to the American Trucking Associations, Inc, Traffic Department, 1616 P Street, N.W., Washington, DC 20036.)

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3. REQUIREMENTS

3.1 First article. When specified (see 6.1), the supplier shall furnish a sample for first article inspection and approval (see 4.3.1.7 and 6.8).

3.2 Materials. All ingredients and materials shall be free from foreign material, foreign odor and foreign color.

3.2.1 Beef. Beef shall be fresh or frozen, bone-in or boneless loins, rounds, ribs, squarecut chucks, or a combination of these cuts. Tenderloins may be retained by the supplier. Beef shall be in excellent condition (see 6.2.2). When frozen beef is used, it shall have been stored at 0°F. (-18°C.) or lower for not more than 180 days prior to use. Verification records shall be available. The beef shall be boned and trimmed to remove and exclude bone, hanging tender, backstrap, kidney, sacrosciatic ligament, carotid arteries and jugular veins from the neck area, exposed serous membranes, silver strip, gracillis membrane, blood clots and bruises over one inch (25 mm), exposed surfaces of dark or discolored tissue, bloody meat, cartilage, exposed ligament, tendinous ends to show 75 percent lean in the clods-knuckles-heels-neck-rounds and prescapular, popliteal, prefemoral, iliac, thymus and other exposed glands.

3.2.2 Salt. The salt (sodium chloride) shall be white, refined, with or without anticaking agents. Iodized salt shall not be used.

3.2.3 Cure ingredients. Substances and their quantities, (e.g., nitrates, nitrites, and flavoring agents) shall be any of those permitted by the Regulations Governing the Meat Inspection of the U.S. Department of Agriculture.

3.3 Types.

3.3.1 Type I - standard. Type I product is a conventional commercial product prepared without inspection of manufacture by the purchaser. It shall conform to the finished product (3.5), USDA (3.6), and Food and Drug (3.7), requirements, and those parts of section 5 relating to commercial packaging, labeling, packing, and marking.

3.3.2 Type II - special. Type II product is subject to inspection for all the requirements of this specification.

3.4 Processing (applicable to type II product only). The beef shall be cut into approximately 1/2 inch (13 mm) pieces or ground through a 1/2 inch (13 mm) plate, cured, and cooked. After curing and cooking the corned beef shall be filled into cans (see 5.1); and the cans sealed and commercially sterilized.

3.5 Finished product. Both types I and II finished product shall comply with the requirements of table I.

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TABLE I. Finished product requirements

Item No.	Requirement
1.	Any area where product adheres to the interior of the can shall not exceed 1 square inch (6.5 cm ²).
2.	The weight of meat after draining liquid and scraping off gelatin and rendered fat with the fingers shall be not less than five pounds eight ounces (2.5 kg).

The following requirements shall be applied to three of the six cross-sectional surfaces formed when the loaf is quartered:

3. The cut surfaces shall have a uniform cure color (reddish hue).
4. The cut surface shall be free from pockets of air, fat, or gelatin that have an area greater than 3/8 square inch (2.4 cm²) (e.g., 1/2 inch x 3/4 inch) (13 mm x 19 mm).
5. When chilled to 40°F. (4°C.), the meat shall not fall apart when removed from the can.
6. The loaf shall yield intact 1/4 inch (6 mm) thick slices (slight crumbling at edges acceptable). Two slices from each of the three cut surfaces not used for the above surface requirements shall be used to determine sliceability.

The following requirements apply to the entire contents of the can:

7. There shall be no foreign odor or flavor, such as, but not limited to burnt, scorched, stale, sour, rancid, musty, or moldy odor or flavor.
8. There shall be no foreign color, such as, but not limited to black, purple, blue, green, yellow, or white. 1/
9. There shall be no foreign material (see 6.2.8). See items 15, 17, and 18 of this table and defects 104, 202, and 203 of table VII for exception to foreign material.
10. There shall be no bone greater than 1/4 inch (6 mm) in any dimension.
11. There shall be no connective tissue, cartilage, ligament, or tendon greater than 2 inches (51 mm) in any dimension.

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TABLE I. Finished product requirements (con.)

Item No.	Requirement
12.	The fat content shall be not more than 18 percent (see 4.4.2).
13.	Shall comply with the moisture-protein ratio (MPR) of the USDA (see 4.4.2).
14.	The salt content shall be not less than 1.5 nor more than 3.0 percent (see 4.4.2).
15.	There shall be no solder pellet greater than 1/8 inch (3 mm) in any dimension or more than two solder pellets of any dimension adhering to the product (see 6.2.5).
16.	There shall be no discoloration of the product adjacent to the key weld or side seam which exceed four individual spots each greater than 1/4 inch (6 mm) in any dimension or any single spot greater than 3/4 inch (19 mm) in any dimension (see 6.2.3).
17.	There shall be not more than 15 minute (pepper size) particles adhering to the product (see 6.2.6).
18.	No single spot of organic coating material on the product shall be greater than 1/8 inch (3 mm) in any dimension nor shall there be more than four or more particles of any size (see 6.2.4).

1/ Surface discoloration due to normal thermal processing shall not apply (see 6.2.3).

3.6 Plant qualification. The product shall originate, be processed, marked and handled in plants which are operated under the Meat and Poultry Inspection Regulations of the U.S. Department of Agriculture. Finished product refrigeration facilities (freezer, storage and shipping) not operating under these regulations shall meet the requirements of MIL-STD-668.

3.7 Federal Food, Drug and Cosmetic Act. All deliveries shall conform in every respect to the provisions of the Federal Food, Drug and Cosmetic Act and Regulations Promulgated Thereunder.

4. QUALITY ASSURANCE PROVISIONS

4.1 Responsibility for inspection. Unless otherwise specified in the contract or purchase order, the contractor is responsible for the performance of all inspection requirements as specified herein. Except as otherwise specified in the contract or order, the contractor may use his own or any other facilities suitable for the performance of the inspection requirements specified herein, unless disapproved by the Government. The Government reserves the right to perform any of the inspections set forth in the specification where such inspections are deemed necessary to assure supplies and services conform to the prescribed requirements.

4.2 Plant qualification conditions. The product furnished under this document shall be unacceptable if not produced and stored in plants which currently meet the qualification conditions of 3.6.

4.3 Inspection. Sampling for inspection shall be performed in accordance with MIL-STD-105 and a final inspection shall be performed for small quantities at the point of destination (see 6.1).

4.3.1 Component and material inspection. In accordance with 4.1 components and materials shall be inspected in accordance with all the requirements of referenced specifications, drawings and standards unless otherwise excluded, amended, modified or qualified in this specification or applicable purchase document.

4.3.1.1 Examination of beef. Beef cuts shall be examined prior to and during processing to determine compliance with the requirements for prohibited material, type of cuts, time and temperature, and condition as specified in 3.2 and 3.2.1. Records of time and temperatures shall be maintained by the supplier. Nonconformance to one or more of the above referenced requirements, reflected by actual examination or by records shall be cause for rejection of the lot or portion thereof or resultant end item, made therefrom, as applicable.

4.3.1.2 Examination of salt (type II only). Examination of salt shall be made to determine compliance with the requirements of 3.2.2 as concerns identity. Determination of compliance with the identity requirements shall be made by examination of labels, invoices, etc. In addition, the salt shall be examined for the condition requirements of 3.2. The sample for the examination for condition requirements shall be an approximate one-pound (0.45 kg) composite derived from five primary containers or all the containers if less than five form a lot. Nonconformance to one or more of the above referenced requirements reflected either by records or by actual examination shall be cause for rejection of the component lot or the finished product made therefrom, as applicable.

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4.3.1.3 Testing of components. Testing of components described in this specification shall be as shown in table II. Results shall apply to the lot average. Nonconformance to one or more test requirements shall be cause for rejection of the lot.

TABLE II. Testing of components (see 4.3.1)

Component	Sample size	Lot size expressed in	Inspection level	Characteristics	Results reported	Test ref. and rqmt. paragraph
Cans and lids <u>1/</u> (when applicable)	One can and lid	Number of cans	S-2	Tin plate	Nearest 0.01 lb/ base box	4.4.3 5.1.1

1/ Exterior can coating (when required) and can labels should be tested in accordance with the applicable subsidiary specifications, except that the tests shall be performed on the same cans submitted for tin plate testing.

4.3.1.4 Process examination (type II product only). Unless otherwise specified (see 6.1) examination shall be made during processing to determine compliance with the processing requirements of 3.4 as concerns cutting, grinding and procedures. Nonconformance to one or more of the above referenced requirements shall be cause for rejection of the lot or the finished product made therefrom, as applicable.

4.3.1.5 Examination of end item (type I and II product). Classification of defects found during examination shall be in accordance with tables IV through VII and 4.3.1.5.1 through 4.3.1.5.5. The inspection levels, sample units, expression of lot sizes and the acceptable quality levels (AQLs) for the above tables shall be as shown below in table III. AQLs shall be expressed in defects per hundred units (DHU) for tables IV, VI and VII.

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TABLE III. End item examination criteria.

Table	Inspection Level	Sample unit	Lot size expressed in	AQLs		
				Major A	Major B	Minor
IV	I	One can	Number of cans	0.25	1.5	4.0
V	S-3	One can	Number of cans	-	1.5	2.5
VI	S-3	One can	Number of cans	-	1.0	10.0
VII	S-3	Contents of one can	Number of cans	<u>1/</u>	1.0	6.5

1/ The finding of any major A defect shall be cause for rejection of the lot.

TABLE IV. External examination of primary container 1/

Category			Defect
Major A	Major B	Minor	
101			Leaker.
102			Springer, flipper or sweller.
103			False seam or improper seam.
104			Improperly closed.
	151		Not type, style or size specified.
	152		Severe dent.
	153		Dent causing sharp ridge.
	154		Severe panelling, buckling or collapsed cans.
	155		Cable cut.
	156		Pitted rust. <u>2/</u>
	157		Key missing.
		201	Not reasonably clean. <u>3/</u>
		202	Moderate dent.

1/ Use Visual Aids for Inspection of Metal Containers as a guide for classifying can defects.

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- 2/ Rust that can be removed by wiping with a soft cloth will not be considered as pitted rust.
- 3/ Cans showing a very thin film of grease which is discernible to the touch but not readily discernible visually are considered to be clean.

TABLE V. Net and drained weight and can vacuum examination

Category		Defect
<u>Major B</u> <u>Minor</u>		
151		Distance from the straight edge to the can side not greater at the middle of the can than it is near the beads (end seam) or no definite reading indicated on vacuum gauge (see 4.4.1).
152		Drained weight less than five pounds-eight ounces (2.5 kg) (per item 2, table I). <u>1/</u> <u>2/</u>
	201	Net weight. <u>1/</u> <u>2/</u> Net weight more than 2 ounces (57 g) under specified net weight (see 5.1.1).

- 1/ The lot shall be rejected if the sample data indicates the lot average net weight is less than specified.
- 2/ Weigh to a tolerance of 1/4 ounce or 7 grams.

TABLE VI. Examination of interior can coating

Category		Defect
<u>Major B</u> <u>Minor</u>		
151		Missing.
152		Blistered or softened areas which can be peeled by fingertip abrasion.
	201	Blistered or softened areas which cannot be peeled by fingertip abrasion.
	202	Scratches through enamel. <u>1/</u>
	203	Denuded areas other than scratches.

- 1/ Scratches or the absence of enamel resulting from normal fabrication and handling or opening the sealed can for inspection shall not be considered defects.

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TABLE VII. Examination of product characteristics

Category			Defect
Major A	1/	Major B	Minor

151 Product adheres to the interior of the can in excess of 1 square inch (6.5 cm²). 2/

The following defects shall be applied to three of the six cross-sectional surfaces formed when the loaf is quartered:

152 Uncured area greater than one-half inch (13 mm) in any dimension.

153 Pockets of air, fat or gelatin on the applicable cut surfaces exceed an area of 3/8 square inch (2.4 cm²) (e.g., 1/2 inch x 3/4 inch) (13 mm x 19 mm). 3/

154 Loaf does not slice as specified (see item 6, table I).

The following defects apply to the entire contents of the can:

101 Presence of foreign odor or flavor, e.g., burnt, scorched, stale, sour, rancid, musty or moldy. 1/

102 Presence of foreign color, e.g., black, purple, blue, green, yellow or white. 1/

103 Presence of foreign material (see 6.2.8). 1/
(Do not tally defects 104, 202, and 203 as foreign material when these defects are found.)

201 Presence of bone greater than 1/4 inch (6 mm) or cartilage greater than 1/2 inch (13 mm) in any dimension. 2/ 3/

202 Presence of connective tissue, ligament, or tendon that exceeds two inches (51 mm) in any dimension. 3/

155 When chilled to 40°F. (4°C.), the meat falls apart when removed from the can.

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TABLE VII. Examination of product characteristics (con.)

Category			Defect
Major A	1/	Major B	Minor
104			Presence of one solder pellet greater than 1/8 inch (3 mm) in any dimension or presence of more than two solder pellets of any dimension adhering to the product. <u>3/</u>
		203	Single spot of organic coating material on the product exceeds 1/8 inch (3 mm) in any dimension or more than four particles of any size up to 1/8 inch (3 mm) (see 6.2.4).
		204	More than fifteen very minute (pepper size) particles (see 6.2.6).
		205	Presence of discoloration of the product adjacent to the key weld or side seam which exceeds four individual spots each being greater than 1/4 inch (6 mm) in any dimension or any single spot greater than 3/4 inch (19 mm) in any dimension (see 6.2.3). <u>2/ 4/</u>

1/ The finding of any major A defect shall be cause for rejection of the lot.

2/ Measure to a tolerance of 1/8 inch or 3 mm.

3/ Measure to a tolerance of 1/16 inch or 2 mm.

4/ Measure to a tolerance of 1/4 inch or 6 mm.

4.3.1.5.1 Examination of can labeling (for Military agencies). When can labeling is required to be accordance with MIL-L-1497, examination of cans for labeling shall be in accordance with the examination criteria of that specification.

4.3.1.5.2 Examination of can coating. When exterior coating of can is required to be in accordance with TT-C-495, examination of can coating shall be in accordance with the examination criteria of that specification.

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4.3.1.5.3 Examination of partitions, pads and liners. Examination of partitions, pads, and liners for level A and B pack shall be in accordance with the end item examination criteria of PPP-F-320. In addition, the following defects shall be included in the table of examination: (1) Cans not completely separated. (2) Partitions, not type, size or grade specified.

4.3.1.5.4 Examination of shipping containers (for levels A, B, and C pack). Examination of shipping containers for levels A and B pack shall be in accordance with the examination criteria of PPP-B-636. In addition, the following defects shall be included in the table of examination. Major: Marking, missing, incorrect or illegible. Minor: Arrangement not as specified. For level C pack the examination shall be in accordance with the foregoing specification except that only the defects applicable to marking and arrangement shall apply.

4.3.1.5.5 Examination of unit load. Examination of palletization shall be in accordance with the examination criteria of MIL-L-35078.

4.3.1.6 Sampling procedures and acceptance criteria for testing of finished product. Procedures for the testing of fat, moisture, protein and salt shall be in accordance with 4.4.2. The lot size shall be expressed in cans. The sample for testing shall be a one-pound (0.45 kg) composite derived from the number of cans indicated by inspection level S-1. Fat shall be reported to the nearest percent and moisture, protein and salt to the nearest 0.1 percent. The lot shall be rejected if test results indicate noncompliance with one or more test requirements.

4.3.1.7 First article inspection. First article samples of the product which the supplier intends to supply shall be inspected to assure compliance with 3.5.

4.4 Test methods. Examination and test procedures which differ from those specified herein unless otherwise excepted, may be used by the supplier if they provide a quality assurance equivalent to that specified. If the Government contracting officer determines that such procedures and controls do not provide, as a minimum, such quality assurance, the supplier will use the test procedures set forth herein. In case of dispute as to test results, the test methods specified herein will govern.

4.4.1 Can vacuum analysis. After processing, sample cans of the round shape shall be selected which are free of dents or other visible damage. The can and contents shall be allowed to reach a temperature of $75^{\circ}\text{F.} \pm 5^{\circ}\text{F.}$ ($24^{\circ}\text{F.} \pm 3^{\circ}\text{C.}$). The vacuum reading shall be taken with a puncture-type vacuum gauge, making the puncture as near as possible to the double seam to

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minimize error due to distortion. The vacuum shall be sufficient to indicate a definite reading on the gauge. Cans of rectangular or truncated shapes shall be tested for satisfactory vacuum by holding cans which are free of visible defects or damage for at least 24 hours at 90°F. (32°C.) and testing immediately on removal from the 90°F. (32°C.) temperature as follows: Lay a straight edge from bead to bead along the center of one side of the can other than the side seam side and observe the profile directly under the straight edge. The distance from the straight edge to the can side shall be greater at the middle of the can than it is near the beads (end seam).

4.4.2 Chemical analysis. Chemical analysis shall be in accordance with the following methods from the Official Methods of Analysis of the Association of Official Analytical Chemists, Chapter: Meat and Meat Products, Section: Meat. Salt, fat, moisture and protein shall be reported to the nearest 0.1 percent. The percent fat shall be rounded to the nearest whole percent.

<u>Chapter</u>	<u>Section</u>	<u>Test</u>	<u>Method</u>
Meat and meat products	Meat	Fat	Crude fat or ether extract (using petroleum ether)
		Moisture	Air drying
		Salt	Salt
		Protein	Nitrogen (Kjeldahl method)

4.4.3 Tin coating weights. Tin coating weights shall be determined by any method specified in PPP-C-96.

5. PREPARATION FOR DELIVERY

5.1 Packaging. Corned beef shall be packaged in accordance with level A or C, as specified (see 6.1).

5.1.1 Level A. Six pounds (2.7 kg) of corned beef shall be packaged in a size 400 by 400 by 1110, size 402 by 310 by 1204 to 1210, or size 402 by 314 by 1200 can. The can shall be a hermetically sealed, key opening style, rectangular metal can with soldered side seam and compound-lined, double-seamed ends. The can shall be provided with a corrosion resistant key attached to the bottom by soldering or welding, using a noncorrosive flux. The can shall be made throughout from not less than commercial 0.75/0.25 pound differential electrolytic tin plate per base box (see 4.4.3). Alternatively, the can may be made from not less than 0.25 pound electrolytic tin plate per base box provided the can is coated overall on the inside with an enamel suitable for the product. The can shall be coated on the outside with a coating conforming to type I of TT-C-495. The can shall be closed under sufficient vacuum to pass the test specified in 4.4.1.

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5.1.2 Level C. Corned beef shall be packaged in accordance with 5.1.2.1 or 5.1.2.2, as applicable.

5.1.2.1 Civil agencies. Six pounds (2.7 kg) of corned beef shall be packaged in a commercial metal can with or without a commercial exterior coating. The can shall be round, rectangular, or truncated, sanitary, open-top style. If rectangular or truncated, the can shall be a key opening style with the key attached to the bottom of the can.

5.1.2.2 Military agencies. Corned beef shall be packaged in accordance with 5.1.1, except that cans with or without commercial exterior coating will be acceptable.

5.2 Packing. Six cans of corned beef, arranged three in length, two in width, and one in depth, shall be packed on end in a snug-fitting shipping container in accordance with level A, B, or C, as specified (see 6.1 and 6.3).

5.2.1 Level A. The shipping container shall be a fiberboard box, constructed, closed and reinforced in accordance with style RSC-L, V2s, of PPP-B-636. The container shall be furnished with full height partitions and top and bottom pads. Partitions and pads shall be constructed of W5c fiberboard in accordance with PPP-F-320. The container shall be reinforced in accordance with PPP-B-636, except that two bands shall be used, one band being applied girthwise, centered over the top, sides and bottom, and one centered horizontally, encircling the sides and ends. The longer band shall be applied first. When unit loading is specified, reinforcement is not required.

5.2.2 Level B. The shipping container shall be a fiberboard box, constructed and closed in accordance with style RSC-L, V3c, V3s, or V4s, of PPP-B-636. The container shall be furnished with full height partitions and pads and reinforced as specified in 5.2.1.

5.2.2.1 When specified (see 6.1 and 6.4), the shipping container specified in 5.2.2 shall be reinforced with nonmetallic strapping or pressure sensitive adhesive, filament reinforced tape in accordance with the appendix of PPP-B-636, except that two bands shall be used, one band applied girthwise, centered over the top, side, and bottom, and the other band centered horizontally around the sides and ends.

5.2.3 Level C. The shipping container shall be in accordance with the Uniform Freight Classification or National Motor Freight Classification, as applicable. Slotted fiberboard shipping container shall be closed in accordance with the appendix of PPP-B-636.

5.3 Unit loads. When specified (see 6.1), the cans of corned beef, packed as specified in 5.2, shall be arranged in unit loads in accordance with MIL-L-35078 for the type and class of load specified.

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5.4 Labeling and marking.

5.4.1 Civil agencies.

5.4.1.1 Unit containers. Any commercial labeling that complies with the Federal Food, Drug, and Cosmetic Act and Regulations Promulgated Thereunder is acceptable.

5.4.1.2 Shipping containers. Shipping containers shall be marked in accordance with FED-STD-123 and with such other pertinent information as specified (see 6.1) by individual agencies.

5.4.2 Military agencies.

5.4.2.1 Cans. Cans shall be labeled in accordance with MIL-L-1497.

5.4.2.2 Shipping containers. Shipping containers shall be marked in accordance with MIL-STD-129.

5.4.2.3 Unit loads. Unit loads shall be marked in accordance with MIL-L-35078.

6. NOTES

6.1 Ordering data. Purchasers should select the preferred options permitted herein and include the following information in procurement documents:

- (a) Title, number and date of this specification.
- (b) Type of product required (see 1.2).
- (c) When a first article is required (see 3.1, 4.3.1.7 and 6.8).
- (d) When other than the supplier is required to perform the examination and tests (see 4.1).
- (e) When final inspection is to be made other than after delivery to point of destination (see 4.7).
- (f) When in-process examination is not required by Civil agencies (see 4.3.1.4).
- (g) Levels of packaging and packing required (see 5.1 and 5.2).
- (h) When packing specified in 5.2.2.1 is required (see 6.4).
- (i) Type and class of unit load when unit loading is specified (see 5.3).
- (j) Additional marking information required for Civil agencies (see 5.4.1.2).

6.2 Definition of terms. For the purpose of this specification the following terms shall apply:

6.2.1 Bone. Bone is connective tissue whose matrix is hardened by various salts of calcium or potassium. Functional definition - Bone is calcified tissue greater than 1/4 inch (6 mm) in any dimension. Calcified tissue 1/4 inch (6 mm) or less shall not be classified as bone.

6.2.2 Excellent condition. Meat in excellent condition has a degree of freshness exhibited by meat maintained at an optimum temperature of 32° to 40°F. (0 to 4°C.). Normally the product will not be more than ten days old from the date of slaughter. However, the final determination of excellent condition shall be based on product characteristics. The meat shall be firm and dry and shall not show evidence of freezing or storage at improper temperatures. Only small areas of darkening, discoloration or dehydration that can be easily trimmed without affecting the appearance of the meat shall be permitted. Meat showing moderate degree of aging, darkening, discoloration, or stickiness shall not be considered to be in excellent condition. (This definition has been provided by the Department of the Army, Office of the Surgeon General, Washington, DC).

6.2.3 Discoloration. Discoloration shall be defined as any interaction between product and container which causes a harmless color change on the product surface during thermal processing.

6.2.4 Organic coating material. Organic coating material shall be defined as harmless coating of lithography particles frequently consisting of enamel charred by the soldering operation which has subsequently been transferred to the product.

6.2.5 Solder pellets. Solder pellets shall be defined as small metallic particles of the solder used in the can making operation.

6.2.6 Solder dust. Solder dust shall be defined as minute (pepper size) metallic particles which are normally found in the atmosphere surrounding the can soldering operation and may, on occasion, adhere to the container and subsequently be transferred to the product.

6.2.7 Cartilage. Cartilage is elastic, unossified bone tissue.

6.2.8 Foreign material. Foreign material is any extraneous matter which does not originally belong where found, which has been introduced from the outside, or which does not naturally occur in the quantity found at the location examined.

- (a) Hair or bristles. Ten or more single strands, each more than 1/4 inch (6 mm) in length. (Do not score hair or bristles 1/4 inch (6 mm) or less in length).
- (b) Hide or skin. One or more individual pieces, full thickness or split skin, that exceed 1/2 inch (13 mm) in greatest dimension or smaller pieces that in aggregate over an area of more than that of a circle 1/2 inch (13 mm) in diameter.

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- (c) String. One or more pieces that individually or in aggregate exceed two inches (51 mm) in length per sample unit.
- (d) Paper or plastic (usual to handling of raw products). One or more pieces that individually or in aggregate cover an area of more than that of a circle 3/4 inch (19 mm) in diameter per sample unit.
- (e) Specks (dust, dirt, carbon specks). One or more innocuous particles in excess of 1/4 inch (6 mm) in greatest dimension or smaller particles that in total aggregate cover an area of more than that of a circle 1/2 inch (13 mm) in diameter.
- (f) Smears or stains. One or more grease stains or discolorations that individually or in aggregate cover an area more than that of a circle 1/2 inch (13 mm) in diameter. (Do not score smears or stains which are readily discernible as marking ink or heme (meat pigment)).
- (g) Wood particles. One or more sharp splinters more than 1/8 inch (3 mm) in length or one or more smooth particles that individually or in aggregate cover an area more than that of a circle 1/2 inch (13 mm) in diameter.
- (h) Toxic material, metal, glass, hard plastic, whole insects, insects' parts, mold, tobacco. One or more particles which are visible to the naked eye.

The final decision with respect to the interpretation of the sanitary, wholesome or esthetic significance of foreign material defects shall remain with a Military veterinary officer for Military procurements.

6.3 Appropriate level of pack. Based on the conditions known or expected to be encountered during shipment, storage, and handling of the specific item being procured, the contracting officer shall select the appropriate level of pack in accordance with the criteria established in AR 700-15/NAVSUPINST 4030.28/AFR 71-6/MCO 4030.14D/DSAR 4145.7.

6.4 Packing specified in 5.2.2.1 is intended for transfer at sea operations or specific overseas operations.

6.5 Supplier's inspection. The supplier should be required to assure that the product conforms to the specification prior to submission to the Government for final inspection.

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6.6 Destination inspection (Civil agencies only). When the finished product has been inspected and passed at point other than destination, the contract should require that the product be inspected at destination for condition and quantity only.

6.7 Award of contract for the product specified in this document will be limited to plants known to maintain the required sanitation conditions of 3.6 (also see 4.2).

6.8 First article. When a first article is required, it shall be inspected and approved under the appropriate provisions of ASPR 7-104.55. The first article should be a preproduction sample. The first article should consist of 12 cans. The contracting officer should include specific instructions in all procurement instruments regarding arrangements for inspection and approval of the first article.

Custodians:

Army - GL
Navy - SA
Air Force - 45

Preparing activity:

Army - GL

Civil Agency Coordinating Activities:

Review activities:

Army - HD
Navy - MC, MS
DP - SS

GSA-FSS
HEW-NIH
UDSA-AMS
VA-DMS

Project No. 8905-0634

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