

PPP-I-350C  
 October 30, 1981  


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 SUPERSEDING  
 Fed. Spec. PPP-I-350B  
 July 21, 1975

## FEDERAL SPECIFICATION

### INDIVIDUAL SERVINGS OF SUBSISTENCE; PACKAGING OF

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

#### 1. SCOPE

1.1 Scope. This specification covers the packaging requirements for individual servings of subsistence items for special feeding purposes. It also covers the labeling and marking requirements for those items where such requirements are not given in an applicable commodity specification. For storage time on these items see 6.3.

#### 2. APPLICABLE DOCUMENTS

2.1 The following documents, of the issues 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:

|                |   |  |
|----------------|---|--|
| C-H-571        | - | Honey, Extracted   |
| L-C-110        | - | Cellophane (Coated and Noncoated Regenerated Cellulose Film) |
| Z-F-1742/7     | - | Cranberry Sauce, Canned                                      |
| Z-F-1742/20-   | - | Marmalade, Orange  |
| Z-J-96         | - | Jams (Preserves); Fruit                                      |
| Z-J-191        | - | Jellies, Fruit   |
| Z-P-196        | - | Peanut Butter  |
| EE-M-131       | - | Mayonnaise and Salad Dressing                                |
| EE-M-821       | - | Mustard, Prepared  |
| JJJ-P-391      | - | Pickles  |
| JJJ-S-351      | - | Syrup  |
| JJJ-V-1746/25- | - | Catsup, Tomato   |
| PPP-B-566      | - | Boxes, Folding, Paperboard                                   |
| PPP-B-636      | - | Boxes, Shipping, Fiberboard                                  |

FSC PACK

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Federal Standard:

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

(Activities outside the Federal Government may obtain copies of Federal specifications, standards, and commercial item descriptions as outlined under General Information in the Index of Federal Specifications, Standards and Commercial Item Descriptions. The Index, which includes cumulative bimonthly 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, other Federal specifications, standards, and commercial item descriptions required by activities outside the Federal Government for bidding purposes are available without charge from General Services Administration Business Service Centers in Boston; New York; Washington, DC; Philadelphia; Atlanta; Chicago; Kansas City, MO; Fort Worth; Houston; Denver; San Francisco; Los Angeles; and Seattle, WA.

(Federal Government activities may obtain copies of Federal specifications, standards, and commercial item descriptions, and the Index of Federal Specifications, Standards and Commercial Item Descriptions from established distribution points in their agencies.)

Military Standards:MIL-STD-105 - Sampling Procedures and Tables for Inspection  
by Attributes

MIL-STD-129 - Marking for Shipment and Storage

(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:US Department of Health and Human Services

Title 21CFR, Chapter I - Food and Drug Administration

(The Code of Federal Regulations (CFR) and the Federal Register (FR) are for sale on a subscription basis by the Superintendent of Documents, US Government Printing Office, Washington, DC 20402. When indicated, reprints of certain regulations may be obtained from the Federal agency responsible for issuance thereof.)

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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:

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.)

Uniform Classification Committee, Agent

Uniform Freight Classification

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

3. REQUIREMENTS

3.1 Materials (see 6.5). The contractor shall assure that all preservation and packing materials conform to the provisions of the Food and Drug regulations found in Title 21 CFR, Chapter I.

3.2 Preservation. The product shall be preserved in accordance with level B or C as specified (see 6.2).

3.2.1 Level B.

3.2.1.1 Unit packs. The product shall be unit packed in accordance with table I and 3.2.1.1.1, 3.2.1.1.2 or 3.2.1.1.3, as applicable.

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TABLE I. Unit packing requirements (level B)

| Item                             | Net weight          | Type of unit pack | Approximate dimensions (inches) |                |          | Unit packing material and reference paragraph |
|----------------------------------|---------------------|-------------------|---------------------------------|----------------|----------|---|
|                                  |                     |                   | Length                          | Width          | Depth    |   |
| Catsup, tomato, JJJ-V-1746/25    | 7/16 ounce (12.4 g) | Boat              | 2 in.                           | 1-5/8 in.      | 3/4 in.  | a, b or c, 3.2.1.1.1                          |
|                                  | 7/16 ounce (12.4 g) | Cup               |                                 | 1-3/4 in. dia. | 7/16 in. | 3.2.1.1.2                                     |
|                                  | 7/16 ounce (12.4 g) | Pouch             |                                 | 1/             | 1/       | a, b, c, d or e, 3.2.1.1.3                    |
|                                  | 7/16 ounce (12.4 g) | Pouch             |                                 | 1/             | 1/       | a, b, c, d or e, 3.2.1.1.3                    |
| Cranberry sauce, Z-F-1742/7      | 1/2 ounce (14 g)    | Boat              | 2 in.                           | 1-5/8 in.      | 3/4 in.  | a, b or c, 3.2.1.1.1                          |
|                                  | 1/2 ounce (14 g)    | Cup               |                                 | 1-3/4 in. dia. | 7/16 in. | 3.2.1.1.2                                     |
|                                  | 1/2 ounce (14 g)    | Cup               |                                 | 1-3/4 in. dia. | 7/16 in. | 3.2.1.1.2                                     |
| Honey, extracted, C-H-571        | 7/16 ounce (12.4 g) | Boat              | 2 in.                           | 1-5/8 in.      | 3/4 in.  | a, b or c, 3.2.1.1.1                          |
|                                  | 7/16 ounce (12.4 g) | Cup               |                                 | 1-3/4 in. dia. | 7/16 in. | 3.2.1.1.2                                     |
|                                  | 7/16 ounce (12.4 g) | Pouch             |                                 | 1/             | 1/       | a, b or e, 3.2.1.1.3                          |
|                                  | 7/16 ounce (12.4 g) | Pouch             |                                 | 1/             | 1/       | a, b or e, 3.2.1.1.3                          |
| Jams, (preserves); fruit, Z-J-96 | 1/2 ounce (14 g)    | Boat              | 2 in.                           | 1-5/8 in.      | 3/4 in.  | a, b or c, 3.2.1.1.1                          |
|                                  | 1/2 ounce (14 g)    | Cup               |                                 | 1-3/4 in. dia. | 7/16 in. | 3.2.1.1.2                                     |
|                                  | 1/2 ounce (14 g)    | Cup               |                                 | 1-3/4 in. dia. | 7/16 in. | 3.2.1.1.2                                     |
| Jellies, fruit, Z-J-191          | 1/2 ounce (14 g)    | Boat              | 2 in.                           | 1-5/8 in.      | 3/4 in.  | a, b or c, 3.2.1.1.1                          |
|                                  | 1/2 ounce (14 g)    | Cup               |                                 | 1-3/4 in. dia. | 7/16 in. | 3.2.1.1.2                                     |
|                                  | 1/2 ounce (14 g)    | Pouch             |                                 | 1/             | 1/       | a, b, c or e, 3.2.1.1.3                       |
|                                  | 1/2 ounce (14 g)    | Pouch             |                                 | 1/             | 1/       | a, b, c or e, 3.2.1.1.3                       |

TABLE I. Unit packing requirements (level B) (cont'd)

| Item   | Net weight             | Type of unit pack | Appropriate dimensions (inches) |                   |          | Unit packing material and reference paragraph |
|--|------------------------|-------------------|---------------------------------|-------------------|----------|---|
|  |                        |                   | Length                          | Width             | Depth    |   |
| Marmalade, orange<br>Z-F-1742/20                               | 1/2 ounce<br>(14 g)    | Boat              | 2 in.                           | 1-5/8 in.         | 3/4 in.  | a, b or c, 3.2.1.1.1                          |
|  | 1/2 ounce<br>(14 g)    | Cup               |                                 | 1-3/4 in.<br>dia. | 7/16 in. | 3.2.1.1.2                                     |
| Mayonnaise, salad<br>dressing and<br>tarter sauce,<br>EE-M-131 | 7/16 ounce<br>(12.4 g) | Boat              | 2 in.                           | 1-5/8 in.         | 3/4 in.  | a, b or c, 3.2.1.1.1                          |
|  | 7/16 ounce<br>(12.4 g) | Cup               |                                 | 1-3/4 in.<br>dia. | 7/16 in. | 3.2.1.1.2                                     |
|  | 7/16 ounce<br>(12.4 g) | Pouch             |                                 | 1/                | 1/       | a, b, c or e, 3.2.1.1.3                       |
|  |                        |                   |                                 |                   |          |   |
| Mustard, prepared,<br>EE-M-821                                 | 1/3 ounce<br>(9.4 g)   | Boat              | 2 in.                           | 1-5/8 in.         | 7/16 in. | a, b or c, 3.2.1.1.1                          |
|  | 1/3 ounce<br>(9.4 g)   | Cup               |                                 | 1-3/4 in.<br>dia. | 7/16 in. | 3.2.1.1.2                                     |
|  | 1/5 ounce<br>(5.7 g)   | Pouch             |                                 | 1/                | 1/       | a, b, c or e, 3.2.1.1.3                       |
| Peanut butter,<br>Z-P-196                                      | 1/2 ounce<br>(14 g)    | Boat              | 2 in.                           | 1-5/8 in.         | 3/4 in.  | a, b or c, 3.2.1.1.1                          |
|  | 1/2 ounce<br>(14 g)    | Cup               |                                 | 1-3/4 in.<br>dia. | 7/16 in. | 3.2.1.1.2                                     |
| Pickle relish<br>JJJ-P-391                                     | 1/3 ounce<br>(9.4 g)   | Boat              | 2 in.                           | 1-5/8 in.         | 3/4 in.  | a, b or c, 3.2.1.1.1                          |
|  | 1/3 ounce<br>(9.4 g)   | Cup               |                                 | 1-3/4 in.<br>dia. | 7/16 in. | 3.2.1.1.2                                     |
|  | 1/3 ounce<br>(9.4 g)   | Pouch             |                                 | 1/                | 1/       | a, b, c, d or e, 3.2.1.1.3                    |
|  |                        |                   |                                 |                   |          |   |

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TABLE I. Unit packing requirements (level B) (cont'd)

| Item                              | Net weight         | Type of unit pack | Appropriate dimensions (inches) |                |           | Unit packing material and reference paragraph |
|-----------------------------------|--------------------|-------------------|---------------------------------|----------------|-----------|---|
|                                   |                    |                   | Length                          | Width          | Depth     |   |
| Syrup, imitation maple, JJJ-S-351 | 1-1/2 ounce (42 g) | Boat              | 3 in.                           | 2 in.          | 1-1/8 in. | a, b or c, 3.2.1.1.1                          |
|                                   | 1-1/2 ounce (42 g) | Cup               |                                 | 2-1/2 in. dia. | 1-5/8 in. | 3.2.1.1.2                                     |
|                                   | 1-1/2 ounce (42 g) | Pouch             |                                 | 1/             | 1/        | a, b or e, 3.2.1.1.3                          |

1/ The dimensions of the pouch shall be in accordance with the standard sizes of pouch commercially proven satisfactory by the contractor for the specific quantity of product being unit packed.

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3.2.1.1.1 Boats. The boats, as specified in table I, shall be fabricated from the following materials:

- a. Polyvinyl chloride
- b. Polyvinyl chloride-polyvinyl acetate copolymer
- c. Oriented polystyrene

The sides and bottom of the boat shall have a nominal thickness of 0.0035 inch. The boat shall be closed by applying a nominal 0.002 inch thick sheet of one of the materials specified above over the top edges of the boat and heat sealing. Alternatively, the cover shall be 0.002 inch thick polyvinyl chloride laminated to nominal 0.00035 inch thick aluminum foil or cellophane, or shall be a composite web composed of polystyrene, polyester, and aluminum foil.

3.2.1.1.2 Cups. The cups, as specified in table I, shall be fabricated from nominal 0.004 inch aluminum foil roll stock precoated with food-grade vinyl type resin coating having a nominal weight of 2 g per thousand square inches for honey, jellies, jams, cranberry sauce, marmalade, syrup and peanut butter, a nominal weight of 4 g per thousand square inches for catsup and relish, and a nominal weight of 8 g per thousand square inches for mustard, mayonnaise, salad dressing and tarter sauce. The cups shall be made with a flat rim of sufficient width to effect a seal between the cups and the lid. After filling, the cups shall be hermetically sealed with a round lid made of 45 pounds per ream (24 by 36-500) paper laminated to nominal 0.001 inch aluminum foil precoated with vinyl type resin as specified for the cup.

3.2.1.1.3 Pouches. The pouches shall not leak when tested in accordance with 4.4.1. The product, as specified in table I, shall be unit packed in pouches made of the following materials:

a. A sheet formed by extruding or laminating polyethylene to a sheet of cellophane having a nominal thickness of 0.001 inch conforming to type II, type V, class 2 or type VI of L-C-110. The nominal thickness of each of the polyethylene lamina shall be 0.001 inch for jellies and honey; 0.002 inch for mustard and catsup; 0.00175 inch for mayonnaise, salad dressing and tarter sauce; 0.0015 inch for pickle relish and 0.003 inch for syrup. The filled pouch shall be heat sealed.

b. A sheet formed by extruding or laminating polyethylene to nominal thickness of 0.002 inch to a sheet composed of nominal 0.0005 inch aluminum foil, in turn, laminated to 24 pounds per ream glassine (24 by 36-500). After filling, the pouch shall be heat sealed.

c. A sheet formed by hot extruding or laminating polyethylene at not less than 0.002 inch thickness on aluminum foil of nominal 0.00035 inch thickness and laminating the other side of the foil to sulfite or kraft paper. The paper shall have a nominal basis weight of 25 pounds per ream (24 by 36-500) and shall be treated or processed to form a soft, pliable sheet. The adhesive used for laminating the foil to paper shall be a suitable, odorless and permanently water-resistant compound other than wax. The combined sheet shall show no evidence of delamination when made into bags or heat sealed. The filled pouch shall be heat sealed.

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d. A sheet formed by hot extruding or laminating nominal 0.0015 inch thick, medium density polyethylene to nominal 0.00035 inch thick aluminum foil and laminating the foil to nominal 0.001 inch thick cellophane conforming to type II, type V, class 2, or type VI of L-C-110. The foil shall be laminated to the cellophane with not less than seven pounds per ream of polyethylene. The combined sheet shall show no evidence of delamination when made into bags or heat sealed. The filled pouch shall be closed by a continuous heat seal.

e. A sheet formed by coating a supercalendered bleached sulphate paper or the uncoated side of a one side clay coated bleached sulphate paper with a nominal basis weight of eight pounds per ream (24 x 36-500) of emulsion polyvinylidene chloride (PVDC) and laminating a nominal 0.0015 inch thick polyethylene film to the PVDC coating. The supercalendered paper shall have a nominal basis weight of 25 pounds per ream (24 x 36-500), and the clay coated paper a nominal basis weight of 32 pounds per ream (24 x 36-500). The paper in use shall be treated or processed to form a soft, pliable sheet. The adhesive used for laminating the film to the PVDC shall be suitable, odorless and permanently water-resistant compound other than wax. The combined sheet shall show no evidence of delamination when made into bags or heat sealed. The filled pouch shall be heat sealed.

3.2.1.2 Intermediate containers. The unit packed product shall be placed in a carton, tray or fiberboard box as specified in table II. The cartons, trays or boxes shall be in accordance with 3.2.1.2.1, 3.2.1.2.2 and 3.2.1.2.3, as applicable.



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TABLE II. Intermediate container and packing requirements

| Item                                       | Type of unit pack | Number of unit packs per intermediate container | Number of intermediate containers per shipping container | Total number of unit packs per shipping container |
|--|-------------------|---|--|---|
| Catsup, tomato                             | Boat              | 20 per carton or tray                           | 10   | 200   |
|  | Cup               | 20 per carton or tray                           | 10   | 200   |
|  | Pouch             | 200 per carton <u>1/</u>                        | 5  | 1000  |
| Cranberry sauce                            | Boat              | 20 per carton or tray                           | 10   | 200   |
|  | Cup               | 20 per carton or tray                           | 10   | 200   |
| Honey, extracted                           | Boat              | 20 per carton or tray                           | 10   | 200   |
|  | Cup               | 20 per carton or tray                           | 10   | 200   |
|  | Pouch             | 200 per carton <u>1/</u>                        | 5  | 1000  |
| Jams, preserves, fruit                     | Boat              | 20 per carton or tray                           | 10   | 200   |
|  | Cup               | 20 per carton or tray                           | 10   | 200   |
| Jellies, fruit                             | Boat              | 20 per carton or tray                           | 10   | 200   |
|  | Cup               | 20 per carton or tray                           | 10   | 200   |
|  | Pouch             | 200 per carton <u>1/</u>                        | 5  | 1000  |
| Marmalade, orange                          | Boat              | 20 per carton or tray                           | 10   | 200   |
|  | Cup               | 20 per carton or tray                           | 10   | 200   |
| Mayonnaise salad dressing and tartar sauce | Boat              | 20 per carton or tray                           | 10   | 200   |
|  | Cup               | 20 per carton or tray                           | 10   | 200   |
|  | Pouch             | 200 per carton <u>1/</u>                        | 5  | 1000  |
| Mustard, prepared                          | Boat              | 20 per carton or tray                           | 10   | 200   |
|  | Cup               | 20 per carton or tray                           | 10   | 200   |
|  | Pouch             | 250 units per carton <u>1/</u>                  | 4  | 1000  |
|  |                   | 200 per carton <u>1/</u>                        | 5  | 1000  |
| Peanut butter                              | Boat              | 20 per carton or tray                           | 10   | 200   |
|  | Cup               | 20 per carton or tray                           | 10   | 200   |
| Pickle relish                              | Boat              | 20 per carton or tray                           | 10   | 200   |
|  | Cup               | 20 per carton or tray                           | 10   | 200   |
|  | Pouch             | 200 per carton <u>1/</u>                        | 5  | 1000  |

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TABLE II. Intermediate container and packing requirements (cont'd)

| Item                   | Type of unit pack | Number of unit packs per intermediate container | Number of intermediate containers per shipping container | Total number of unit packs per shipping container |
|------------------------|-------------------|---|--|---|
| Syrup, imitation maple | Boat              | 20 per fiberboard box or tray                   | 5  | 100   |
|                        | Cup               | 20 per fiberboard box or tray                   | 5  | 100   |
|                        | Pouch             | 100 per fiberboard box                          | 2  | 200   |

1/ Alternatively, 200 or 500 unit packs may be packed into an intermediate fiberboard box in accordance with 3.2.1.2.3. One thousand unit packs (5 or 2 fiberboard boxes) shall be packed into a shipping container.

3.2.1.2.1 Cartons. The carton shall be a paperboard folding box constructed and closed in accordance with PPP-B-566, style I, type A, class a or style II, type D or E, class a. When boats are procured in accordance with 3.2.1.1.1c, paperboard trays may be used. The cartons or trays containing boats in accordance with 3.2.1.1.1c shall be inclosed in a close conforming bag constructed from a copolymer of vinylidene chloride and vinyl chloride having a nominal thickness of 75 gauge or constructed from cellophane complying with type IV, class 2 of L-C-110. The bag shall be closed by heat sealing.

3.2.1.2.2 Trays. The trays shall be the molded pulpboard type commercially used for nesting 20 cups, 5 in length and 4 in width.

3.2.1.2.3 Fiberboard box. The fiberboard box shall conform to style RSC, type CF (variety SW) or SF, class domestic, grade 125 of PPP-B-636. Each box shall be closed in accordance with method II as specified in the appendix of PPP-B-636.

3.2.2 Level C. The product, in the weights specified in table I shall be pre-served to protect it from deterioration and physical damage during shipment from the supply source to the first consuming activity.

3.3 Packing. The product shall be packed in accordance with level B or C, as specified (see 6.2). When the product is in trays, the top tray in pack shall be covered with a chipboard or nontest fiberboard pad having the same dimensions as the outer dimensions of the tray.

3.3.1 Level B. The product, in quantities and intermediate containers specified in table II, shall be packed in a snug-fitting fiberboard box constructed, closed and reinforced in accordance with style RSC, V3c, V3s or V4s of PPP-B-636.

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3.3.1.1 Nonmetallic reinforcement of shipping containers. When specified (see 6.2 and 6.4), the shipping container specified in 3.3.1 shall be reinforced with nonmetallic strapping or pressure-sensitive adhesive reinforced tape in accordance with the appendix of PPP-B-636, except that two reinforcing bands may be used, one lengthwise and one girthwise.

3.3.2 Level C. The product, preserved as specified in 3.2 shall be packed in a manner to ensure carrier acceptance and safe delivery at destination at the lowest transportation rate for such supplies. The shipping container shall be in accordance with the Uniform Freight Classification or National Motor Freight Classification, as applicable, except that the closure of fiberboard boxes shall be in accordance with method II as specified in the appendix of PPP-B-636.

#### 3.4 Labeling and marking.

##### 3.4.1 Civil agencies.

3.4.1.1 Unit packs. Any commercial labeling and additional labeling as specified, complying with Title 21 CFR, Chapter I of the Food and Drug Administration is acceptable.

3.4.1.2 Intermediate containers and shipping containers. Unless otherwise specified (see 6.2), intermediate containers and shipping containers shall be marked in accordance with FED-STD-123 with such other information as specified by individual agencies, and with the additional markings in 3.4.2.3 and 3.4.2.3.1.

##### 3.4.2 Military agencies.

3.4.2.1 Unit packs. Unit packs shall be labeled in accordance with Title 21 CFR, Chapter I of the Food and Drug Administration and in accordance with the requirements of the applicable commodity specification.

3.4.2.2 Intermediate containers and shipping containers. Intermediate containers and shipping containers shall be marked in accordance with MIL-STD-129 and as specified in 3.4.2.3 and 3.4.2.3.1.

3.4.2.3 Additional markings. In addition to other markings specified, shipping containers shall be marked with a date of pack (month, day, and year) and an inspection/test date consistent with 6.3. Location of inspection/test date shall be adjacent to date of pack marking; for example, DATE PACKED 3/1/80 - Inspection/Test 3/1/81.

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3.4.2.3.1 Precautionary marking. The following information shall be printed or stenciled on top of the shipping container in bold letters between 1 and 1-1/2 inches high, all letters being the same height:

KEEP REFRIGERATED

(40°F (4°C) OR BELOW)

DO NOT FREEZE

#### 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 prescribed requirements.

4.1.1 Quality conformance inspection. Unless otherwise specified, sampling for inspection shall be performed in accordance with MIL-STD-105.

4.2 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.

4.2.1 Examination of material for the fabrication of boats, cups, and pouches. Examination of material for identity as specified in 3.2.1.1.1 through 3.2.1.1.3 shall be ascertained by examination of labels, invoices, or other valid documents. Nonconformance shall be cause for elimination of the material from fabrication or rejection of the finished product made therefrom.

#### 4.3 Packaging inspection.

4.3.1 Unit pack examination. The unit packs shall be examined for the defects listed in table III. The lot size shall be expressed in units of filled and sealed unit packs. The sample unit shall be one filled and sealed unit pack. The inspection level shall be I. The acceptable quality level (AQL) shall be 1.0 major and 4.0 total (major and minor combined) defects per hundred units.

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TABLE III. Unit pack defects

| Defect   | Category |       |
|--|----------|-------|
|  | Major    | Minor |
| Not closed, insecure seal, or delamination of material | 101      |       |
| Punctured, torn, cut, or porous (tiny holes)           | 102      |       |
| Leaks <u>1/</u>  | 103      |       |
| Delamination, after leakage examination <u>1/</u>      | 104      |       |
| Labeling missing, incorrect, or illegible              | 105      |       |
| Not fabricated of the material specified               | 106      |       |
| Not clean  |          | 201   |

1/ Applicable to pouches only. Examination procedure for leakage shall be as specified in 4.4.1. Delamination examination shall be done after pouch is removed from water.

4.3.1.1 Net weight examination. The unit packs shall be examined for the defects listed in table IV. The lot size shall be expressed in units of filled and sealed unit packs. The sample unit shall be one filled and sealed unit pack. The inspection level shall be S-4. The AQL shall be 2.5 defects per hundred units. In addition, the lot shall be rejected if the lot average net weight per unit pack, based on the sample examined, is less than the net weight specified in table I.

TABLE IV. Unit pack net weight defects 1/

| Examine                       | Defect                          | Category |
|-------------------------------|---------------------------------|----------|
|                               |                                 | Minor    |
| 1/5 ounce (5.7 g) unit pack   | Net weight less than 5.2 grams  | 201      |
| 1/3 ounce (9.4 g) unit pack   | Net weight less than 8.9 grams  | 202      |
| 7/16 ounce (12.4 g) unit pack | Net weight less than 11.9 grams | 203      |
| 1/2 ounce (14 g) unit pack    | Net weight less than 13.5 grams | 204      |
| 1-1/2 ounce (42 g) unit pack  | Net weight less than 40.5 grams | 205      |

1/ Report weights to nearest 0.1 gram.

4.3.1.2 Shipping container contents and individual container examination. The lot size unit and the sample unit shall be one filled shipping container. The inspection level shall be I. The two intermediate containers from each shipping container, selected for the contents examination in 4.3.1.2.1 shall be used as the sample for the examination in 4.3.1.2.2

4.3.1.2.1 Contents examination. The shipping containers and the intermediate containers shall be examined for the defects listed in table V. The AQL shall be 2.5 defects per hundred units.

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TABLE V. Intermediate and shipping containers content defects

| Examine                      | Defect  | Category<br>Minor |
|------------------------------|---|-------------------|
| Intermediate container<br>1/ | Number of unit packs not as specified<br>in table II              | 201               |
| Shipping container           | Number of intermediate containers not as<br>specified in table II | 202               |

1/ Examine two intermediate containers from each shipping container in the sample.

4.3.1.2.2 Individual container examination. The individual containers shall be examined for the defects listed in table VI. The AQL shall be 2.5 defects per hundred units.

TABLE VI. Intermediate container defects

| Examine                                     | Defect   | Category<br>Minor |
|---|--|-------------------|
| Carton (paperboard)<br>and box (fiberboard) | Not constructed or closed as<br>specified        | 201               |
| Tray or carton<br>(paperboard)              | Not inclosed in bag as<br>specified 1/           | 202               |
| Tray (molded pulp)                          | Nesting arrangement other than<br>that specified | 203               |

1/ Applicable when paperboard trays or cartons are packed with boats fabricated in accordance with 3.2.1.1.1c.

4.3.1.3 Examination of fiberboard shipping containers. When shipping containers are required to be in accordance with PPP-B-636, examination for defects in construction, closing and reinforcement shall be in accordance with the appendix of PPP-B-636, except that the following additional defects shall be included in the examination:

|       |  |
|-------|--|
| Major | National stock number, item description, contract<br>number or date of pack markings missing, incorrect or<br>illegible. |
|-------|--|

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- |       |  |
|-------|--|
| Minor | <ul style="list-style-type: none"> <li>(1) Other required markings missing, incorrect, or illegible;</li> <li>(2) When applicable, intermediate containers not covered with a chipboard or fiberboard pad;</li> <li>(3) When applicable reinforcement with nonmetallic strapping or tape is not used.</li> </ul> |
|-------|--|

For level C containers, only the defects pertaining to marking and for the closure method specified in 3.3.2 shall be applicable.

#### 4.4 Methods of inspection.

4.4.1 Leakage examination. Test of pouch seals shall be performed as follows: Submerge the pouch to be tested in water contained in a vacuum desiccator or other suitable container. Draw a vacuum of 10 inches of mercury and hold for at least 10 seconds. Observe the pouch for (a) air leakage in larger quantities from any point, (b) for a fine stream of bubbles anywhere in the seal area, and (c) for failure to inflate. Pouches which do not inflate under vacuum should be opened and examined for water penetration. Leakage of air or wetting of the product, indicates failure and an unacceptable pouch.

#### 5. PACKAGING

(Not applicable).

#### 6. NOTES

6.1 Intended use. This specification covers the preservation and packing requirements for individual servings of subsistence items. (see table I).

6.2 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) Applicable level of preservation and packing (see 3.2 and 3.3).
- (c) When nonmetallic reinforcement is required for level B packing (see 3.3.1.1 and 6.4).
- (d) When commercial marking which does not contain all the information required by FED-STD-123, or additional marking is acceptable for direct delivery of individual servings to Civil agencies (see 3.4.1.2).

6.3 Storage life Product processed subsequent to the contract or order should have a shelf life of 1 year when stored at 40°F (4°C) or below.

6.4 Selection of nonmetallic reinforcement. The nonmetallic reinforcement specified in 3.3.1.1 should be selected for fiberboard shipping containers that are destined for transfer at sea or other specific overseas operation.

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6.5 Recycled material. It is encouraged that recycled material be used when practical as long as it meets the requirements of the specification (see 3.1).

6.6 Appropriate level of pack (military agencies). Based on conditions known or expected to be encountered during shipment, handling, and storage, the contracting officer should select the appropriate level of pack in accordance with the criteria established in AR 700-15/NAVSUPINST 4030.28/AFR 71-6/MCO 4030.33/DLAR 4145.7.

MILITARY INTERESTS:

Custodians

Army - GL  
Navy - SA  
Air Force - 50

Review Activities

Army - MD, SM  
Navy - MC, MS  
DLA - SS

CIVIL AGENCY COORDINATING ACTIVITY:

GSA-FSS

PREPARING ACTIVITY:

Army - GL

Project No. PACK-0640

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