

LUNCH, ASSAULT
(Stock No. 56-L-5785)

A. APPLICABLE SPECIFICATIONS.

A-1. The following specifications of the issue in effect on date of invitation for bids shall form a part of this specification:

A-1a. Joint Army-Navy Specifications:

JAN-C-237 - Coatings; Exterior, air-Drying, Camouflage, and Rust-Inhibiting, for Food Cans

JAN-C-238 - Coating, Exterior, Camouflage and Rust-Inhibiting (for Processed and Non-Processed Food Cans)

A-1b. Quartermaster Corps Tentative Specifications:

OQMG No. 94 - Marking of Outside Shipping Containers by Contractors

QPD No. 107 - Labeling and Marking of Metal Cans for Subsistence Items

PQD No. 377 - Covers, Waterproof, Small Arms

PQD No. 511 - Film, Waterproof, Flexible

A-1c. Specifications relating to individual components are noted in paragraph E-1.

B. TYPES AND GRADES.

B-1. The Assault Lunch shall contain the components packaged as herein specified.

B-2. The grades of material shall be as herein specified.

C. MATERIAL AND WORKMANSHIP.

C-1. All materials shall be manufactured, packaged, and assembled under modern sanitary conditions, in accordance with good commercial practice.

D. GENERAL REQUIREMENTS.

D-1. Except as herein specified, all deliveries shall conform in every respect to the provisions of the Federal Food, Drug, and Cosmetic Act and regulations promulgated thereunder.

E. DETAIL REQUIREMENTS.

E-1. The Assault Lunch shall consist of the following components:

<u>Product</u>	<u>No. of Units</u>	<u>Minimum Net Wt. of Unit Ounces</u>	<u>Related Paragraph</u>	<u>Related Specifications</u>
Chocolate Bar, Sweet	2	1		CQD No. 168
Caramels	2	8 (gram)	(maximum size 1 x 1 x $\frac{1}{2}$ inch)	To be issued by CQD
Fruit, Dried (Prunes* Bleached Raisins* Seedless Raisins*)	1	3		To be issued by CQD
Gum, Chewing, Stick* or Gum, Sugar Coated, Tablet*	1 2	5 (sticks) 2 (tablets)	E-2a E-2a	CQD 324 CQD 324
Nuts, Salted, Roasted (Almonds* Filberts* Peanuts* Pecans*)	1	2	E-2b	To be issued by CQD
Salt Tablets	1	4 (tablets)	E-2c	CQD No. 159
Cigarettes	1	20 (cigarettes)	E-2d	Good Commercial Quality
Matches	1	20 (sticks)		CQD No. 127
Tablets, Water Purification (Halazone)	1	12 (tablets)	E-2e	Medical Dept. Item 1K27507

*The item shall be specified in the procurement directive.

E-2. Packaging of Components.

The packaging of items not specifically described in this section shall be in accordance with the appropriate specifications listed in paragraph E-1, in effect on the date of invitation for bids. All materials used for packaging shall be free from any odor which may be transmitted to the contents.

E-2a. Gum, Chewing.

E-2a(1). Sugar Coated Tablet. Two candy-coated gum tablets shall be packaged in a suitable carton or tightly wrapped in waxed paper with an outer printed band or heat-sealed in a suitable cellophane.

E-2a(2). Stick, Gum.



E-2a(2)a. Each stick of gum shall be wrapped tightly in a sheet composed of 0.0003 inch aluminum or composition foil, laminated to dry waxed sulphite or glassine paper. The sulphite or glassine paper shall have a basis weight (unwaxed) of not less than 12 pounds per ream (24 x 36 — 500) and shall be waxed with not less than 3 pounds per ream. Each wrapped stick shall be banded in a kraft-colored paper label, in accordance with good commercial practice.

E-2a(2)b. Alternatively, each stick of gum shall be wrapped tightly in a sheet composed of glassine, having a minimum basis weight of not less than 16 pounds per ream (24 x 36 — 500), laminated with not less than 6 pounds of a permanently plastic water-vapor-proof adhesive to sulphite having a minimum basis weight of 17 pounds per ream. The laminated sheet shall be coated with a minimum of three pounds per ream of a water-vapor-proof lacquer. Each wrapped stick shall be banded in a paper label, in accordance with good commercial practice.

E-2a(2)c. Five sticks shall be bundled in a tightly heat-sealed triple laminated overwrap consisting of a sheet of sulphite paper having a basis weight of not less than 20 pounds per ream (24 x 36 — 500), laminated to a sheet of aluminum foil not less than 0.0003 inch thick, laminated to a sheet of 300 MSAT or 300 PMB2CSX cellophane. The cellophane shall be on the outside of the package and shall be imprinted with the label data.

E-2b. Nuts, Salted. Two ounces of salted nuts shall be packaged and sealed in a laminated foil bag. The bag shall be made from an odorless vinyl film approximately .0020 inch thick which has been plasticized with about 20%, by weight of the finished film, of dibutylsibacate, laminated to a sheet of .001 inch thick aluminum foil with a permanently plastic lacquer-adhesive having a softening point of not less than 160° F. and a flow point at a temperature of not less than 200° F. The excess air shall be exhausted from the filled bag before sealing. The seals shall be sufficiently tight to prevent seepage of fat. The filled and sealed bag shall occupy a space not larger than 1-5/8 x 1-1/2 x 3 inches.

E-2c. Salt Tablets. Four salt tablets shall be packaged in an envelope, bag, or fin-seal packet made from a laminated material consisting of two sheets of 450 MSAT 82 or 84, or 450 PMB2CSX cellophane, laminated together with a minimum of 9 pounds per ream (24 x 36 — 500) of a permanently plastic lacquer adhesive having a softening point of not less than 160° F., and a flow point at a temperature of not less than 200° F. The package shall be completely heat-sealed.

E-2d. Cigarettes. Twenty cigarettes shall be packaged in a unit and wrapped and sealed with water-vapor-proof cellophane or an equivalent material, in accordance with good commercial practice.

E-2e. Water Purification Tablets (Halazone). Twelve water purification tablets shall be packaged in a glass bottle having an overall height of 1-3/16 inches and maximum body diameter of 19/32 inch. The bottle shall have a straight label space of 1/2 inch on the body and it shall be made from amber, green, blue or flint glass, preferred in the order mentioned, with a continuous thread finish GCA No. 425-13 mm.



The cap closure shall be constructed in accordance with GCA No. 425-13 mm. standards and shall be made from 0.50 pound electrolytic tin plate or commercial hot-dip tin plate coated inside and out with a suitable corrosion-resistant lacquer or enamel. The cap shall be lined with a white felt pulp, or cork backing material faced with waxed vinylite or waxed koroseal. When the cap is tightly screwed into position, a tight top seal shall be made and the cap shall not seat on the bead of the finish.

E-3. Labeling of Components.

All component packages shall be labeled plainly with the following information:

Name of product (in letters larger than any others used for the label)

Net weight

Directions for use (when necessary)

Name and address of manufacturer

E-4. Packing of Components. Unless otherwise specified, the components of this ration shall be packed for delivery to the assembly plants in containers complying with the requirements of the Consolidated Freight Classification. The inner packing shall be adequate to insure arrival of the product at the point of assembly in prime condition.

E-5. Marking for Domestic Shipment of Components. Unless otherwise specified, legible commercial marking of the shipping container is acceptable, provided that the following information is included:

Name of product

Number of units packed and net weight of each

Contract number

Date packed

Name and address of manufacturer

F. METHODS OF INSPECTION AND TEST.

F-1. Unless otherwise specified in the invitation for bids, inspection shall be made during the process of assembly and packaging.

F-2. Unless otherwise specified, physical tests on packing and packaging materials shall be made in accordance with the methods of the American Society for Testing Materials (ASTM) and those of the Technical Association of the Pulp and Paper Industry (TAPPI).

F-3. Submerge the package under a six inch head of water for a period of two hours. At the end of this time, open it and inspect the contents for the presence of water.

G. PACKAGING, LABELING, PACKING, AND MARKING FOR SHIPMENT.

G-1. Packaging. The components specified in E-1 shall be assembled neatly in the flat bag specified in G-1a. After the components have been placed in the bag, the sides of the mouth of the bag shall be folded inward on each side approximately 1 inch. The mouth of the bag shall be folded down along the face of the bag, to expel all excess air, and back in four flat folds of approximately

1/2 inch width. A one-inch wide waterproof pressure-sensitive cloth tape approximately 15 inches long shall be applied around the girth of the filled and folded bag with the tape centered over the end of the folded portion of the bag to effect a watertight closure. At least 90 percent of the packages shall be waterproof when tested in accordance with F-3. Not less than one out of each 1000 produced shall be so tested. The finished package shall have outside dimensions of approximately $5\frac{1}{2}$ x $3\frac{1}{2}$ x $1\text{-}\frac{3}{4}$ inches.

G-1a. Bag. The bag shall be made in accordance with Quartermaster Corps Tentative Specification PQD No. 377, Class A or B, of a translucent olive drab polyethylene film which when tested in accordance with specification PQD No. 511, shall comply with the following physical requirements:

Approximate dimensions	$7\frac{1}{2}$ (mouth) x $8\frac{1}{4}$ (length)
Maximum thickness	0.004 inch
Minimum tensile strength	5 pounds per inch
Minimum elongation	150 percent
Minimum tearing strength	300 g.
Blocking	Not greater than scale 3
Maximum loss of weight on heating	3 percent
Low temperature durability at	-15° F.

G-2. Labeling. No labeling required.

G-3. Packing.

Forty-five filled and closed bags shall be gas packed in a round, straight sided, full-opening, lug cover style, metal container made from 24 gauge bonderized steel throughout, with the body offset to permit stacking. The inside diameter shall be approximately $11\text{-}\frac{1}{4}$ inches and the overall height approximately $16\text{-}\frac{3}{4}$ inches. A six and one-half gallon capacity container of dimensions approximately as indicated will be acceptable. The side seam shall be welded and the bottom chime shall be compound-lined and double-seamed to the container body. The container body shall have ears firmly welded on and shall be fitted with a galvanized 8 gauge wire handle with a wooden grip. The top edge of the container body shall be curled outward. The container shall be fitted with a well seated lug cover having not less than 16 lugs and a securely affixed gasket of suitable composition. The lug cover shall be fastened securely to the metal container so that the closed can shall be watertight and gas tight.

The inside of the container and cover shall be coated with a suitable, odorless, sanitary food enamel. The container shall be coated overall outside with an olive drab corrosion-resistant lacquer or enamel complying with Joint Army-Navy Specification, JAN-C-237 or JAN-C-238.

Before closing the can, it shall be flooded with carbon dioxide with a resulting oxygen content not to exceed 2%. The lug cover shall be fastened to the metal container securely enough for one can of every one hundred produced to pass the test specified in F-3.

G-4. Marking.



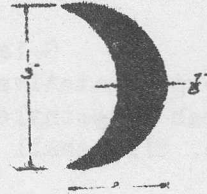
G-4a. OVERSEER. The following information shall be lithographed, printed, or legibly stenciled, in accordance with Quartermaster Corps Tentative Specification CQD No. 107, on the upper two-thirds of one side of the can, in bold capital letters between 1 and 1-1/2 inches high, all letters being of the same height:

CONT ----- (Contract No.)

LUNCH, ASSAULT

45 UNITS

WT 32 CU 1.5 (Actual gross weight to the nearest pound and cubic displacement to the nearest 1/10 cubic foot)



G-4b. On the opposite side of the can the following information shall be lithographed, printed, or legibly stenciled, as shown, in bold capital letters between 1/2 and 1 inch high, the space occupied having an area not greater than 42 square inches:

----- (Name of Contractor)

---- (Month and year packed) (In addition, if desired by the packer, identifying code marks)

REQ. ---- (Requisition No.) (Required on at least 10 containers nearest each door of the conveyance or on all containers sent as L. C. L. shipments)

G-4c. The following information shall be lithographed, printed, or legibly stenciled, as shown, on the lid of the can in bold capital letters, all letters being of the same height:

LUNCH, ASSAULT (1 inch letters)

45 UNITS (1/2 inch letters)

For use during initial hours (1/2 inch letters) of an assault mission. Issue 1 or 2 per man in addition to any normal daily ration. Item is not for resupply during that mission.

G-4d. No other markings except consignor-consignee data or those required by statute shall appear.

G-4e. The markings shall be yellow or white, shall take on the coated metal and shall be sunfast and waterfast.

