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## Product Specification

### Soya Bean Kernels Edamame

Date: 20<sup>th</sup> December 2007

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**PACK SIZE** 1 x 10kg

**ORIGIN:** China

**GENERAL** The product shall be prepared from fresh sound raw material that is free from all toxic residues and taints. The final product shall comply with all current U.K. and E.C. Food Legislation.

**INGREDIENTS** Soya 100% Declare as: Soya Beans  
(*Leguminosae glycine*)

**PROCESSING** Soya bean pods are delivered fresh to the factory, each load is sampled and assessed for foreign material and physical defects. The load is then shelled, cleaned, blanched, frozen and filled into bulk palletainers. The frozen soya beans are sampled and assessed against specification. The palletainers are then labelled and transferred to the cold store, where they are stored at  $-23^{\circ}\text{C}$  until required for packing.

**PACKING** During packing, the beans are inspected before weighing and filling into blue poly lined cartons. The cartons are Best Before and Production date coded, check weighed, metal detected, palletised and stretch-wrapped before being returned to store at  $-23^{\circ}\text{C}$  to await despatch.

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**QUALITY CONTROL** Checks are carried out on the following: -

Processing: -	Raw material Final Product Peroxidase Temperature
Packing: -	Metal detection Check weighing Final product physical defect levels Organolepsis Case quantity Case sealing Case coding and print quality

**DEFECT TOLERANCES** Product shall be checked at least hourly against the following tolerances for defects: -**Assessed on 500g Sample**

Foreign Matter	Nil
E. V.M.	Nil
Major blemish	3% w/w
Minor blemish	7% w/w
Total Blemish (Major & Minor)	8% w/w
Damaged and split Beans	5% w/w
Count per 500g	750 to 900 beans

**DEFINITIONS OF DEFECTS****Foreign Material**

This includes any material not derived from the soya bean plant or defined as EVM, such as insects, pieces of insects, wood, glass, stones, metal, toxic berries, snails, slugs or any other material which will render the product unacceptable.

**Extraneous Vegetable Matter (EVM)**

This includes any harmless vegetable matter other than bean which is derived from the soya bean plant or harmless vegetable material such as leaves or pod.

**Major Blemish**

A bean which is blemished to a major degree is one which has conspicuously discoloured (including dark purple staining and bruising) or blemished areas greater than an equivalent circle of 6mm in diameter, either as one blemish or as an aggregate of blemishes.

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**Minor Blemish**

A bean which is blemished to a minor degree is one which has conspicuously discoloured (including dark purple staining and bruising) or blemished areas less than an equivalent circle of 6mm in diameter, either as one blemish or as an aggregate of blemishes. Single blemishes of less than 2mm shall be ignored.

**Damaged & split Beans**

These are beans which are not whole and complete, and includes beans which have been physically crushed, damaged or broken by mechanical means and also pieces of beans such as separate broken or whole cotyledons and loose skin. Damage by natural agencies is also included. Split beans are those where the testa is split to more than 50% of its length, but in which the cotyledons remain complete.

**Count**

This refers to the number of beans which are present in 500g sample.

**ORGANOLEPSIS** (Carried out on a cooked sample.)**COLOUR**

Bright, characteristic green colour, but may lack uniformity throughout the sample.

**FLAVOUR**

Slightly weak characteristic flavour, typical of the variety. May be slightly bitter.

**TEXTURE**

Flesh slightly firm and/or slightly mealy. The skins may be rather firm or slightly tough.



Average Sample

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**MICROBIOLOGICAL**

Organism	Target	Maximum
T V C @ 30°C	1 x 10 <sup>5</sup>	1 x 10 <sup>5</sup>
Total Coliforms	5 x 10 <sup>2</sup>	1 x 10 <sup>3</sup>
E. coli	Nil/g	10/g
Staph aureus	<40/g	1 x 10 <sup>2</sup>
Salmonella	Absent in 25g	Absent in 25g
Listeria monocytogenes	Absent in 25g	1 x 10 <sup>2</sup>

**ANALYTICAL**

Product shall be blanched to give a trace positive peroxidase reaction (guaiacol test) between 60 and 90 seconds.

**WEIGHT CONTROL**

The product shall be packed to minimum weight.

**METAL DETECTION**

All cartons shall be passed through a metal detector. The system shall be tested at least hourly using 3.5mm ferrous and 3.5mm non-ferrous & 4.0mm stainless steel test pieces.

**CODING**

Best Before End shall be twenty four months following the month of packing e.g. if packed in May 2008 then BEST BEFORE END May 2010 or 01/01/2010.

Production / Traceability Code Four figure International date code (Year number, Day number) plus factory identification code and shift code e.g. product packed 1 January 2008 = **8001** or open code 01/01/2008.

**CARTON LINERS**

Dark blue food grade polythene liner of a **minimum** thickness of 45µm.

**CARTONS**

Corrugated fibreboard of glued construction, no metal staples to be used. Shall be sealed using dark blue adhesive tape.

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**NUTRITIONAL INFORMATION**

This data conforms to the requirements of EC Council Directive 90/496/EEC

100g of uncooked soya beans typically contains: -

Parameter	Value / 100g	Methodology
Energy - kcal	141	USDA Nutrient Database Release 19
Energy - kJ	590	USDA Nutrient Database Release 19
Moisture	68.6g	USDA Nutrient Database Release 19
Carbohydrate	11.1g	USDA Nutrient Database Release 19
- as sugars	1.0g	USDA Nutrient Database Release 19
- as polyols	0.0g	USDA Nutrient Database Release 19
- as starch	10.1g	USDA Nutrient Database Release 19
Fat	6.4g	USDA Nutrient Database Release 19
- as saturates	0.7g	USDA Nutrient Database Release 19
- as mono unsaturates	1.2g	USDA Nutrient Database Release 19
- as poly unsaturates	3.0g	USDA Nutrient Database Release 19
Protein	12.3g	USDA Nutrient Database Release 19
Fibre	4.2g	USDA Nutrient Database Release 19
Sodium	14g	USDA Nutrient Database Release 19
Vitamin A	156µg	USDA Nutrient Database Release 19
Vitamin B <sub>6</sub>	0.06mg	USDA Nutrient Database Release 19
Vitamin B <sub>12</sub>	0 µg	USDA Nutrient Database Release 19
Vitamin C	17mg	USDA Nutrient Database Release 19
Vitamin D	0 µg	USDA Nutrient Database Release 19
Vitamin E	0 µg	USDA Nutrient Database Release 19
Thiamin	0.26mg	USDA Nutrient Database Release 19
Riboflavin	0.15mg	USDA Nutrient Database Release 19
Niacin	1.2mg	USDA Nutrient Database Release 19
Folic Acid	0 µg	USDA Nutrient Database Release 19
Biotin	0 µg	USDA Nutrient Database Release 19
Pantothenic Acid	0.13mg	USDA Nutrient Database Release 19
Calcium	145mg	USDA Nutrient Database Release 19
Phosphorus	158mg	USDA Nutrient Database Release 19
Iron	2.5mg	USDA Nutrient Database Release 19
Magnesium	14mg	USDA Nutrient Database Release 19
Zinc	0.1mg	USDA Nutrient Database Release 19
Iodine	0 µg	USDA Nutrient Database Release 19
Potassium	539mg	USDA Nutrient Database Release 19

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**GMO DECLARATION**

Does the product, or any of its ingredients contain any genetically modified material (whether viable or not)? YES / NO

Is the product or any of its ingredients not substantially equivalent as a consequence of the use of genetic modification? YES / NO

Is the product or any of its ingredients produced from, but not containing any genetically modified material? YES / NO

Have genetically modified organisms been used as processing aids or additives used in connection with the production of the food or any of its ingredients? YES / NO

Have genetically modified organisms been used to produce processing aids or additives but where such genetically modified organisms are not present in the processing aid as used in connection with the production of the food or any of its ingredients? YES / NO

Name: Alan Gosling Job Title: Technical Consultant

Signature:  Date: 10<sup>th</sup> December 2008

**IRRADIATION POLICY**

I confirm that the product supplied by Foodnet Limited under this specification has not undergone any irradiation treatment or process. I further confirm that no ingredient or processing aid used in conjunction with this product has undergone irradiation treatment.

Name: Alan Gosling Job Title: Technical Consultant

Signature:  Date: 10<sup>th</sup> December 2008

Where any answer is YES, see details below.

Product or Material	Details of Genetic Modification

I confirm I have made any necessary enquiries and obtained relevant written assurances from suppliers to verify the accuracy of the details provided above. I confirm the above data supplied is correct and can be used without reservation to advise customers.

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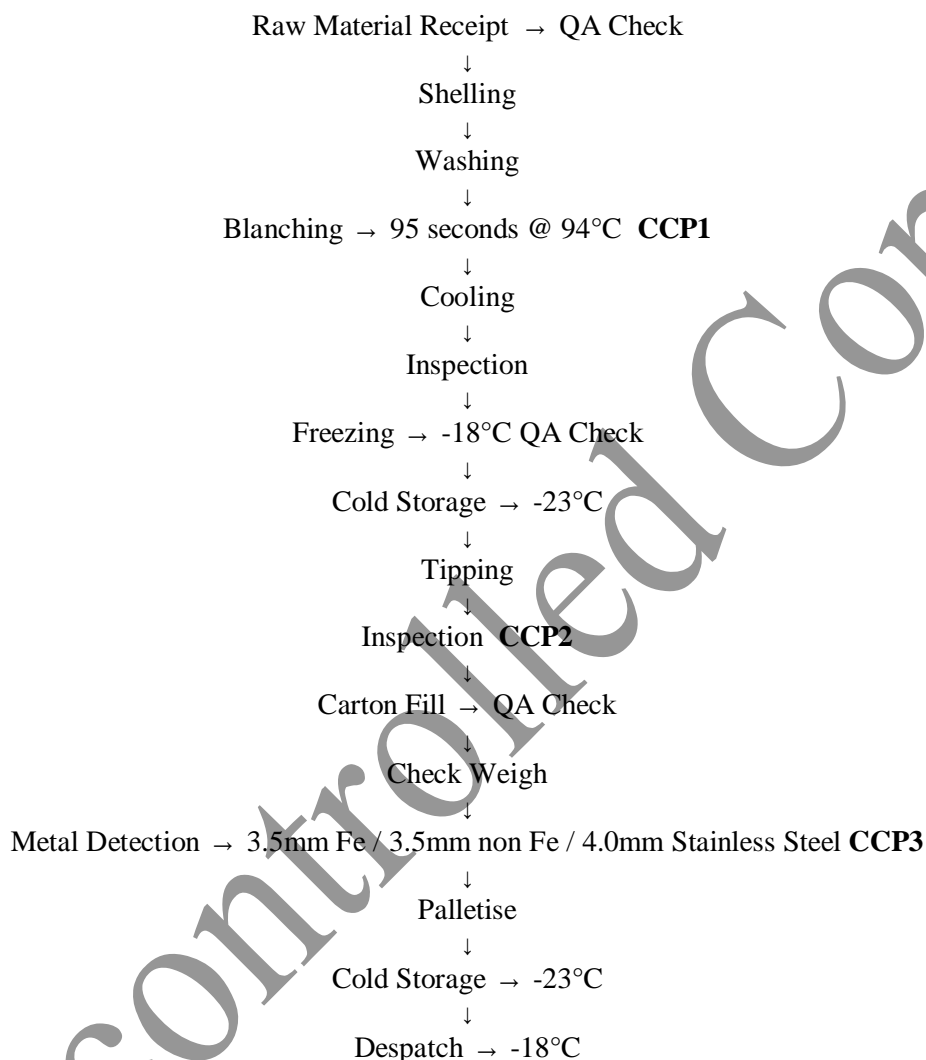
**FOOD INTOLERANCE**

<b>Food Intolerance Data</b>		
Does the material supplied contain any of the following? (NO) Absent, (YES) Present		
<b>Allergen</b>	<b>NO / YES</b>	<b>Reason for presence if YES</b>
Milk & Milk Derivatives	NO	
Egg & Egg Derivatives	NO	
Animal Products (*)	NO	
Fish/Shellfish/Crustaceans/Molluscs	NO	
Cereals (**)	NO	
Gluten	NO	
Yeast/Yeast Extract	NO	
Soya/Soya Derivatives	YES	100% soya bean kernels
Fruit & Fruit Derivatives	NO	
Beef & Beef Products	NO	
Pork & Pork Products	NO	
Lamb & Lamb Products	NO	
Poultry & Poultry Products	NO	
Legumes	NO	
Peanuts	NO	
Sulphite >10ppm	NO	
MSG	NO	
BHA / BHT	NO	
Benzoates	NO	
Glutamates	NO	
Azo & Coal Tar Dyes	NO	
Added Colour	NO	
Added Flavour	NO	
Preservatives	NO	
Antioxidants	NO	
Added Salt	NO	
Nuts/Nut Oils	NO	
Caffeine	NO	
Sesame Products	NO	
Garlic	NO	
Poppy Seeds	NO	
Mustard	NO	
Celery/Celariac	NO	
Lupins	NO	
*Including any product derived from slaughtered animals, e.g. gelatine, rennet		
**Including wheat, corn, barley, rye, oats, etc.		
Is the material suitable for:		
Vegetarians?	Y / N	
Vegans?	Y / N	
Kosher?	Y / N	
Halal?	Y / N	
Organic?	Y / N	

**FOOD ADDITIVES**

<b>E. Number</b>	<b>Name</b>	<b>In Which Ingredient</b>	<b>Function in Ingredient</b>	<b>Function in Final Product</b>	<b>% In Final Product</b>
None					

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**PROCESS INFORMATION****PROCESS FLOW CHART****SOYA BEANS****CRITICAL CONTROL POINTS:**

to include time / temperature / frequency / target and sensitivity of all process steps.

CCP Number	Process Step	Controls in place
CCP1	Effective blanching to minimise microbiological loading. Half hourly checks.	Continuous chart recoding of temperature and guaiacol test for adequate blanching.
CCP2	Inspection of the product. Continuous control	To remove foreign material via manual inspection
CCP3	Metal detector efficiency. Hourly checks.	Testing of detector using certified test pieces of 3.5mm Ferrous and non-Ferrous, 4.0mm Stainless Steel.

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## **COSHH Data For Frozen Vegetables**

Treat as you would any frozen material i.e. if engaged in prolonged handling of the vegetables wear gloves.

Care should be used when lifting full cases of frozen vegetables.

There are no other perceived COSHH implications regarding the use of frozen vegetables.

**THE CONTENTS OF THIS SPECIFICATION ARE CONFIDENTIAL TO FOODNET LTD AND THE CUSTOMER, AND MAY NOT BE DISCLOSED TO ANY OTHER PARTY.**

Signed on behalf of Foodnet Ltd:-

Name: Alan Gosling

Job Title: Technical Consultant

Signature: 

Date: 10<sup>th</sup> December 2008

Signed on behalf of the Customer:-

Name:

Job Title:

Signature:

Date:

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