



Head Office: The Old Grammar School, 3-7 Market Square, Amersham, Bucks. HP7 0DF
Tel: (44) 1494 434600 Email: foodnettechnical@foodnet.ltd.uk

Technical Specification		
Product: Straight Cut Water Chestnuts IQF	Last Update: 31/01/2026	Product Code: WAT005

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 and shall comply with all current UK/EU Food Legislation. The product is intended to be used as ingredient that is further processed and heat-treated before final consumption (minimum of +75°C for 30 seconds).

INGREDIENTS Water Chestnuts 100% Declare as: Water Chestnuts (*E. tuberosa*)

PROCESSING The water chestnuts are harvested, washed, sliced, blanched, inspected, and frozen and filled into bulk palletainers. The palletainers are then labelled and transferred to the cold store, where they are stored at -23°C until required for packing.

PACKING During packing, the water chestnuts are inspected before weighing and filling into blue poly lined cartons. The cartons are Best Before and Production date coded, checkweighed and metal detected, palletised and stretch wrapped before being returned to store at -18°C to await despatch to the UK at -18°C.

DEFECT TOLERANCES

Per 500g (Frozen)

Clumps (> 3 pieces)	10% w/w
Foreign Matter	Nil
E.V.M.	1 piece
Major Blemish (>6mm)	2% w/w
Minor Blemish (2-6mm)	6% w/w
Adhering Skin	3% w/w
Broken Pieces	5% w/w

Out of Size:

Thickness >6mm	10% w/w
Thickness <4mm	5% w/w
Short Dia (<15mm; >25mm)	10%w/w
Long Dia (<25mm; > 40mm)	10%w/w

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DEFINITIONS OF DEFECTS

Foreign Material

This includes any material not derived from the water chestnut plant or defined as EVM. Examples of Foreign Matter include insects, pieces of insects, wood, glass, stones, metal, toxic berries, seed or flower heads, snails, slugs or any other material which will render the product unacceptable.

EVM

This includes any harmless vegetable matter other than water chestnut which is derived from the water chestnut plant or harmless vegetable material such as pieces of leaves.

Major Blemish

This includes water chestnut slices that are blemished to the extent that the area affected is greater than 6mm in diameter, either as a single blemish or an aggregate of blemishes on the same slice.

Minor Blemish

This includes water chestnuts slices that are blemished to the extent that the area affected is between 2mm and 6mm in diameter, either as a single blemish or an aggregate of blemishes on the same slices. Blemishes less than 2mm in diameter shall be ignored.

Adhering Skin

Dice which have any water chestnut skin adhering.

Broken Slices

This includes slices which are less than half their original size.

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ORGANOLEPSIS (Carried out on a thawed sample.)

COLOUR Regular white colour, typical of water chestnuts.

FLAVOUR Typical of water chestnuts with no off flavours.

TEXTURE Shal be crisp without woodiness.



Average sample

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MICROBIOLOGICAL

Organism	Target	Maximum
<i>TVC @ 30°C</i>	5×10^5	1×10^6
<i>Total Coliforms</i>	5×10^2	3×10^3
<i>E. coli</i>	Nil	1×10^2
<i>Listeria mono</i>	Absent in 25g	1×10^2
<i>Salmonella</i>	Absent in 25g	Absent in 25g

ANALYTICAL Product shall be blanched to give a negative peroxidase reaction (guaiaacol test) between 50 and 60 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 every 2 hours using ferrous, non-ferrous and stainless-steel test pieces.

BEST BEFORE DATE The product shall be twenty-four months following the month of packing. Minimum BB date on delivery: 6 months.

TRACEABILITY INFO Production date or Lot number printed on the label as well as customer order number and/or delivery date.

STORAGE CONDITIONS Keep frozen at - 18°C at all times.

CARTON LINERS Blue food grade polythene liner of a minimum thickness of 30µm.

CARTONS Corrugated fibreboard of glued construction, no metal staples to be used. Shall be sealed using 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 water chestnuts typically contains: -

Parameter	Value / 100g	Methodology
Energy - kcal	46	McCance & Widdowson 6 th Edition
Energy - kJ	198	McCance & Widdowson 6 th Edition
Moisture	79.8g	McCance & Widdowson 6 th Edition
Carbohydrate	10.4g	McCance & Widdowson 6 th Edition
- as sugars	4.8g	McCance & Widdowson 6 th Edition
- as polyols	0.0g	McCance & Widdowson 6 th Edition
- as starch	5.6g	McCance & Widdowson 6 th Edition
Fat	0.2g	McCance & Widdowson 6 th Edition
- as saturates	Trace	McCance & Widdowson 6 th Edition
- as mono unsaturates	Trace	McCance & Widdowson 6 th Edition
- as poly unsaturates	0.1g	McCance & Widdowson 6 th Edition
Protein	1.4g	McCance & Widdowson 6 th Edition
Fibre	3.2g	McCance & Widdowson 6 th Edition
Sodium	12mg	McCance & Widdowson 6 th Edition
Vitamin A	0.0mg	McCance & Widdowson 6 th Edition
Vitamin B ₆	0.1µg	McCance & Widdowson 6 th Edition
Vitamin B ₁₂	0.0mg	McCance & Widdowson 6 th Edition
Vitamin C	5mg	McCance & Widdowson 6 th Edition
Vitamin D	0.0µg	McCance & Widdowson 6 th Edition
Vitamin E	0.0mg	McCance & Widdowson 6 th Edition
Thiamin	0.09mg	McCance & Widdowson 6 th Edition
Riboflavin	0.11mg	McCance & Widdowson 6 th Edition
Niacin	1.0mg	McCance & Widdowson 6 th Edition
Folic Acid	0.0µg	McCance & Widdowson 6 th Edition
Biotin	0.0µg	McCance & Widdowson 6 th Edition
Pantothenic Acid	0.0mg	McCance & Widdowson 6 th Edition
Calcium	8mg	McCance & Widdowson 6 th Edition
Phosphorus	70mg	McCance & Widdowson 6 th Edition
Iron	0.7mg	McCance & Widdowson 6 th Edition
Magnesium	14mg	McCance & Widdowson 6 th Edition
Zinc	0.0mg	McCance & Widdowson 6 th Edition
Iodine	0.0µg	McCance & Widdowson 6 th Edition
Potassium	530mg	McCance & Widdowson 6 th Edition

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GMO DECLARATION

I confirm that this product is not genetically modified or produced from genetically modified organisms. No genetically modified organisms have been used as processing aids or additives. This product does not require specific GM labelling as per Regulation (EC) 1829/2003.

Name: Gianluca Oberto

Job Title: Technical Manager

Signature: 

Date: 31st January 2026

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: Gianluca Oberto

Job Title: Technical Manager

Signature: 

Date: 31st January 2026

COSHH Data

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

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

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

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FOOD INTOLERANCE

Food Intolerance Data				
Does the material supplied contain any of the following? (NO) Absent, (YES) Present				
Allergen	NO / YES		Reason for presence if YES	
Milk & Milk Derivatives	NO			
Egg & Egg Derivatives	NO			
Animal Products (*)	NO			
Fish/Shellfish/Crustations/Molluscs	NO			
Cereals (**)	NO			
Gluten	NO			
Yeast/Yeast Extract	NO			
Soya/Soya Derivatives	NO			
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/Celeriac	NO			
Lupins	NO			
*Including any product derived from slaughtered animals, e.g. gelatine, rennet				
**Including wheat, corn, barley, rye, oats, etc.				
<u>Please be aware the manufacturing sites we supply this item from may handle allergens in production. Procedures are in place to prevent cross-contamination.</u>				
Is this product Suitable for:				
Vegans	Yes (Not certified)	Vegetarians	Yes	Organic No
Halal	Yes (Not certified)	Kosher	Yes (Not certified)	

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FOOD ADDITIVES

E. Number	Name	In Which Ingredient	Function in Ingredient	Function in Final Product	% In Final Product
None					

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: Gianluca Oberto

Job Title: Technical Manager

Signature: 

Date: 31st January 2026

Signed on behalf of the Customer:

Name:

Job Title:

Signature:

Date:

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PROCESS INFORMATION

PROCESS FLOW CHART*

*Note: this is a generic flow chart which does not refer to any specific production site.

SLICED WATER CHESTNUTS

Raw Material Receipt → QA Check



Selecting & Trimming



Cooking



Cooling



Peeling



Slicing



Washing



Blanching



Cooling



Freezing → -18°C QA Check



Inspection



Cold Storage → -23°C



Tipping



Inspection



Carton Fill → QA Check



Check Weigh



Metal Detection → QA Check



Palletise



Cold Storage → -23°C



Despatch → -18°C

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Issues & Amendments

Issue N°	Amend. N°	Date	Amendments	Compiled by
1	1	01/02/2016	New entry	G. Oberto
2	1	01/05/2017	Defect tolerances – minimum ref samples; Reviewed BB and Traceability info. Added Storage Conditions. Reviewed Food Intolerance table, Flow Chart and Amendment table.	G. Oberto
3	1	31/01/2020	3 Year update – general revision	G. Oberto
4	1	31/01/2023	3 Year update – general revision	F. Soares
5	1	31/01/2026	3 Year update – general revision	F. Soares

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