



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: Soya Bean Kernels Edamame IQF	Last Update: 31/01/2026	Product Code: SOY001

PACK SIZE 1 x 10kg; 10 x 1kg;

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 Soya Beans (Edamame) 100% Declare as: Soya Beans (*Glycine max*)

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 -18°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 and metal detected, palletised and stretch wrapped before being returned to store at -23°C to await despatch to the UK at -18°C.

DEFECT TOLERANCES

Per 1000g

Clumps	5%w/w
Foreign Matter	Nil
E.V.M.	1
Major blemish	3% w/w
Minor blemish	7% w/w
Total Blemish (Major & Minor)	8% w/w
Damaged and Split Beans	5% w/w
Black Hilum	5%w/w

DEFINITIONS OF DEFECTS

Foreign Material

This includes any material not derived from the soya bean plant nor 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.

Doc Ref: PRO-SPE	Issue date: 31.01.2026	Issue No: 5	Prepared by: Filipe Soares	Authorised by: Gianluca Oberto
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Clumps

This is where 3 or more kernels are welded together so that they cannot be readily separated without causing damage to the product.

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.

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.

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ORGANOLEPSIS (Carried out on a thawed 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
<i>TVC @ 30°C</i>	1×10^5	1×10^6
<i>Total Coliforms</i>	1×10^3	3×10^3
<i>E. coli</i>	1×10^1	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 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 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.

FILM Clear, heat-sealed food grade polythene film of a minimum thickness of 110µm.

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NUTRITIONAL INFORMATION

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

100g of cooked soya beans typically contains: -

Parameter	Value / 100g	Methodology
Energy - kcal	141	McCance & Widdowson 7th Edition
Energy - kJ	590	McCance & Widdowson 7th Edition
Moisture	64.3	McCance & Widdowson 7th Edition
Carbohydrate	5.1g	McCance & Widdowson 7th Edition
- as sugars	2.1g	McCance & Widdowson 7th Edition
- as starch	1.9g	McCance & Widdowson 7th Edition
Fat	7.3g	McCance & Widdowson 7th Edition
- as saturates	0.9g	McCance & Widdowson 7th Edition
- as mono unsaturates	1.4g	McCance & Widdowson 7th Edition
- as poly unsaturates	3.5g	McCance & Widdowson 7th Edition
Protein	14.0g	McCance & Widdowson 7th Edition
Fibre	6.1g	USDA Nutrient Database Release 19
Sodium	1mg	McCance & Widdowson 7th Edition
Vitamin A	0µg	McCance & Widdowson 7th Edition
Vitamin B6	0.23mg	McCance & Widdowson 7th Edition
Vitamin B12	0µg	McCance & Widdowson 7th Edition
Vitamin C	Trace	McCance & Widdowson 7th Edition
Vitamin D	0µg	McCance & Widdowson 7th Edition
Vitamin E	1.13mg	McCance & Widdowson 7th Edition
Thiamin	0.12mg	McCance & Widdowson 7th Edition
Riboflavin	0.09mg	McCance & Widdowson 7th Edition
Niacin	0.5mg	McCance & Widdowson 7th Edition
Folic Acid	54µg	McCance & Widdowson 7th Edition
Biotin	25µg	McCance & Widdowson 7th Edition
Pantothenic Acid	0.18mg	McCance & Widdowson 7th Edition
Calcium	83mg	McCance & Widdowson 7th Edition
Phosphorus	250mg	McCance & Widdowson 7th Edition
Iron	3.0mg	McCance & Widdowson 7th Edition
Magnesium	63mg	McCance & Widdowson 7th Edition
Zinc	0.9mg	McCance & Widdowson 7th Edition
Iodine	2µg	McCance & Widdowson 7th Edition
Potassium	510mg	McCance & Widdowson 7th 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: 6 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	YES		Soya Beans 100%	
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/Celериac	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

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.

SOYA BEANS EDAMAME

Raw Material Receipt → QA Check



Shelling



Washing



Blanching



Cooling



Inspection



Freezing → -18°C QA Check



Cold Storage → -18°C



Tipping



Inspection



Carton Fill → QA Check



Check Weigh



Metal Detection → QA Check



Palletise



Cold Storage → -18°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
4	2	6/11/2025	Updated Nutritional values	G. Oberto
5	1	31/01/2026	3 Year update – general revision	F. Soares

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