



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

Technical Specification		
<b>Product:</b> Grilled Sweetcorn Kernals	<b>Last Update:</b> 31/01/2020	<b>Product Code:</b> SWE017

**PACK SIZE** 1 x 10kg; 1 x 20kg;

**ORIGIN:** The Netherlands / Spain

**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.

**INGREDIENTS** Sweetcorn 98% Declare as: Sweetcorn  
Rapeseed or sunflower oil 2% (*Zea mays*)

**PROCESSING** Sweetcorn cobs are delivered fresh to the factory and each load is sampled and assessed for grade, foreign material and physical defects. The cobs are then de-husked, inspected, and washed before the kernels are cut from the cob. The kernels are then cleaned, blanched, roasted, cooled, inspected, frozen and filled into cartons. Each pallet of frozen sweetcorn is sampled and assessed against specification. The pallets are then labelled and transferred to the cold store at -23°C until required for packing.

**PACKING** During packing, the sweetcorn is 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.

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

Processing: - Raw material  
Final Product  
Temperature

Packing: - Metal detection  
Check weighing  
Final product physical defect levels  
Organolepsis  
Case quantity  
Case sealing  
Case coding and print quality

Doc Ref: PRO-SPE	Issue date: 31.01.2020	Issue No: 3	Prepared by: G. Oberto	Authorised by: Rhys Owen
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## **DEFECT TOLERANCES**

### **Per 1000g**

Foreign Matter	Nil
E.V.M.	1
Damaged/Broken Kernels	10% w/w
Empty Kernels/Peels	8% w/w
Poorly cut kernel (bottom)	5% w/w
Poorly cut kernel (top)	5% w/w
Corn without grill mark	15-80% w/w
Pieces burnt	10% w/w
Clustered Kernels	2
Colour Defect Pieces	5

## **DEFINITIONS OF DEFECTS**

### **Foreign Material**

This includes any material not derived from the sweetcorn plant, nor defined as EVM. Examples of foreign matter include insects, pieces of insect, wood, glass, stones, metal, snails, slugs etc. unacceptable.

### **EVM**

This includes any vegetable matter other than sweetcorn kernels which is derived from the sweet corn plant, such as husk or leaf larger in area than 6mm diameter, dark silks longer than 12mm, pieces of unattached cob greater than an equivalent circle of 3mm in diameter.

### **Poorly cut kernel (bottom)**

Base of the kernel that is not properly cut.

### **Poorly cut kernel (top)**

Too much of the kernel has been cut off.

### **Clustered kernels**

Number of kernels that are clustered together.

*The below minimum numbers of samples should be inspected and average result to be out-of-spec.*

Quantity Delivered (Kg)	Minimum samples to be taken (1Kg of product per each item)		
	10Kg Boxes	20Kg Bags	25Kg Bags
<1000	4	2	2
<2000	8	5	4
<5000	10	7	5
<10000	15	10	8
≤27000	20	15	12

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**ORGANOLEPSIS** (Carried out on a thawed sample.)

**COLOUR** A dark-yellow to brown colour, visible grill on 2 sides.

**FLAVOUR** Fresh, characteristic flavour of roasted sweetcorn without off-flavour.

**TEXTURE** Tender skin, easily chewable.



Average sample

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### **MICROBIOLOGICAL**

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

**ANALYTICAL** Product shall be blanched to give a negative peroxidase reaction (guaiaicol 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.

**SACKS** Blue food grade polythene liner 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 uncooked sweet corn typically contains: -

Parameter	Value / 100g	Methodology
Energy - kcal	98	McCance & Widdowson 6 <sup>th</sup> Edition
Energy - kJ	415	McCance & Widdowson 6 <sup>th</sup> Edition
Moisture	76.0g	McCance & Widdowson 6 <sup>th</sup> Edition
Carbohydrate	17.0g	McCance & Widdowson 6 <sup>th</sup> Edition
- as sugars	2.0g	McCance & Widdowson 6 <sup>th</sup> Edition
- as polyols	0.0g	McCance & Widdowson 6 <sup>th</sup> Edition
- as starch	14.6g	McCance & Widdowson 6 <sup>th</sup> Edition
Fat	1.8g	McCance & Widdowson 6 <sup>th</sup> Edition
- as saturates	0.2g	McCance & Widdowson 6 <sup>th</sup> Edition
- as mono unsaturates	0.8g	McCance & Widdowson 6 <sup>th</sup> Edition
- as poly unsaturates	0.7g	McCance & Widdowson 6 <sup>th</sup> Edition
Protein	3.4g	McCance & Widdowson 6 <sup>th</sup> Edition
Fibre	1.5g	McCance & Widdowson 6 <sup>th</sup> Edition
Sodium	1mg	McCance & Widdowson 6 <sup>th</sup> Edition
Cholesterol	0g	McCance & Widdowson 6 <sup>th</sup> Edition
Vitamin A	16µg	McCance & Widdowson 6 <sup>th</sup> Edition
Vitamin B <sub>6</sub>	0.15mg	McCance & Widdowson 6 <sup>th</sup> Edition
Vitamin B <sub>12</sub>	0µg	McCance & Widdowson 6 <sup>th</sup> Edition
Vitamin C	8.0mg	McCance & Widdowson 6 <sup>th</sup> Edition
Vitamin D	0µg	McCance & Widdowson 6 <sup>th</sup> Edition
Vitamin E	0.69mg	McCance & Widdowson 6 <sup>th</sup> Edition
Thiamin	0.16mg	McCance & Widdowson 6 <sup>th</sup> Edition
Riboflavin	0.05mg	McCance & Widdowson 6 <sup>th</sup> Edition
Niacin	1.9mg	McCance & Widdowson 6 <sup>th</sup> Edition
Folic Acid	41µg	McCance & Widdowson 6 <sup>th</sup> Edition
Biotin	0.0µg	McCance & Widdowson 6 <sup>th</sup> Edition
Pantothenic Acid	0.73mg	McCance & Widdowson 6 <sup>th</sup> Edition
Calcium	3.0mg	McCance & Widdowson 6 <sup>th</sup> Edition
Phosphorus	91mg	McCance & Widdowson 6 <sup>th</sup> Edition
Iron	0.7mg	McCance & Widdowson 6 <sup>th</sup> Edition
Magnesium	37mg	McCance & Widdowson 6 <sup>th</sup> Edition
Zinc	0.4mg	McCance & Widdowson 6 <sup>th</sup> Edition
Iodine	0µg	McCance & Widdowson 6 <sup>th</sup> Edition
Potassium	260mg	McCance & Widdowson 6 <sup>th</sup> Edition

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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: Gianluca Oberto

Job Title: Technical Manager

Signature: 

Date: 31<sup>st</sup> January 2020

### **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: 31<sup>st</sup> January 2020

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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/Crustations/Molluscs	NO			
Cereals (**)	YES		Sweetcorn 100%	
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/Celeryiac	NO			
Lupins	NO			
*Including any product derived from slaughtered animals, e.g. gelatine, rennet				
**Including wheat, corn, barley, rye, oats, etc.				
<b><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></b>				
<b>Is this product Suitable for:</b>				
<b>Vegans</b>	Yes (Not certified)	<b>Vegetarians</b>	Yes	<b>Organic</b> No
<b>Halal</b>	Yes (Not certified)	<b>Kosher</b>	Yes (Not certified)	

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### **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					

### **COSHH Data**

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 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: Gianluca Oberto

Job Title: Technical Manager

Signature: 

Date: 31<sup>st</sup> January 2020

Signed on behalf of the Customer:

Name:

Job Title:

Signature:

Date:

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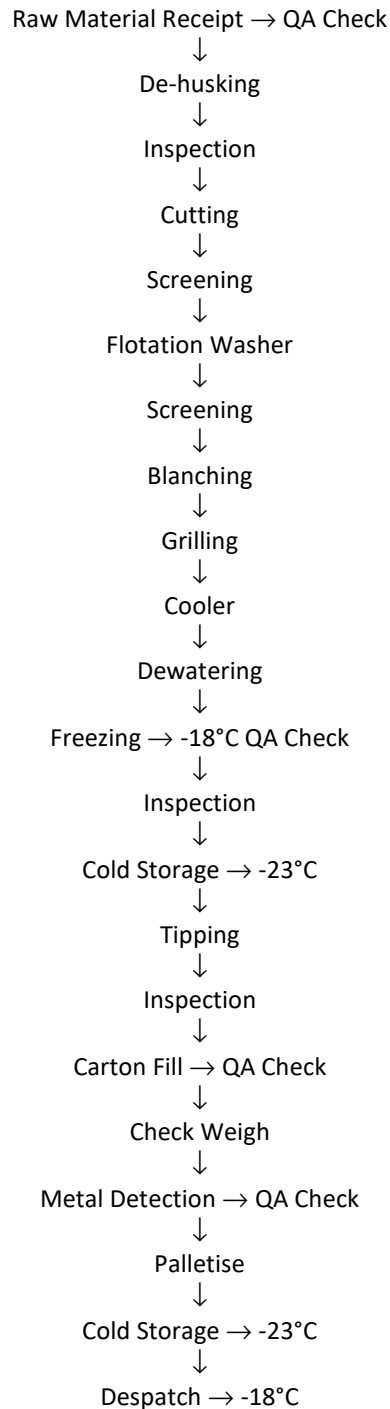
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## PROCESS INFORMATION

### PROCESS FLOW CHART\*

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

#### GRILLED SWEET CORN KERNAL



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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

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