



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

Technical Specification		
Product: Orange Pulp, Bitter, 1.5mm	Last Update: 31/01/2026	Product Code: ORA009

ORIGIN: 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 not intended for direct consumption.

INGREDIENTS Bitter Orange (80-100%), Water (0-20% maximum);

PROCESSING All fruit is washed and rinsed, prior to sorting to eliminate under and over ripe fruit, infested and damaged oranges. Fruit is conveyed to the Kelly machine which is set to quarter the oranges and separate the peel from the fruit centres. The peel is shredded to 1.5 mm (+/- 0.5mm) in width with no cross cut applied thus being natural length. The peel and the dummy are cooked to inactivate enzymes. The peel, dummy and water, if required, are blended together, by percentage, to give the equivalent in the original orange and the pulp is heated to min 87C for canned product or min 98C for aseptic product.

PACKING Pulp passes through a metal detector and is either: a) hot-filled into lacquered cans or: b) pasteurized and filled into aseptic bags in drums. Finished product is stored at ambient.

QUALITY Free from rot, pips, blemishes and foreign material.

ORGANOLEPSIS Yellow-orange coloured pulp with orange peel pieces. Typical bitter orange flavour and aroma.



Average sample

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MICROBIOLOGICAL Commercially sterile.

ANALYTICAL

percentage of peel	min 28%
pH	<4
Brix (uncorrected, 20C)	7.0 – 10.0
Closedown test on the tin	

METAL DETECTION Pulp passes through the metal detector located before filling into cans or aseptic bags.

SHELF LIFE

Cans: 24 months from manufacture;
Drums: 18 months from manufacture;

TRACEABILITY INFO Production Date (as Julian Code) or Best Before Date + Lot Number.

STORAGE CONDITIONS Store ambient at < 30C.

Canned products: once opened, use immediately;
Aseptic drums: once opened, store chilled (0 to 5C) and use within 24 hours.

PACKAGING

a) Food grade lacquered cans in cardboard carton, sealed with blue tape.

unit weight 4.2 or 4.5 kg minimum fill depending on processor

Can – 155 x 260 mm	weight 360 - 400 g
Carton – 470 x 270 x 340 mm	weight 380 - 640 g

b) Aseptic bags in conical metal drums with plastic lids
unit weight 225 kg minimum fill.

Bag: 1575 x 890mm x 2 inner PE layers each min 30µm weight:
approx. 550g.

Conical Drum: 975 (h) x max 575 (ø) mm weight approx. 14 kg.

NB all dimensions are approximate and will vary according to processor.

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NUTRITIONAL INFORMATION

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

100g of bitter orange pulp typically contains: -

Parameter	Value per 100g
Energy – kcal	49.6
Energy – kJ	208
Fat	0.3 g
-as saturates	trace
Carbohydrate	11.9g
- as sugars	9.1 g
Fibre	2.8 g
Protein	1.1 g
Sodium	<1 mg



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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/Crustaceans/Molluscs	NO				
Cereals (**)	NO				
Gluten	NO				
Yeast/Yeast Extract	NO				
Soya/Soya Derivatives	NO				
Fruit & Fruit Derivatives	Yes	Orange 100%			
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.					
<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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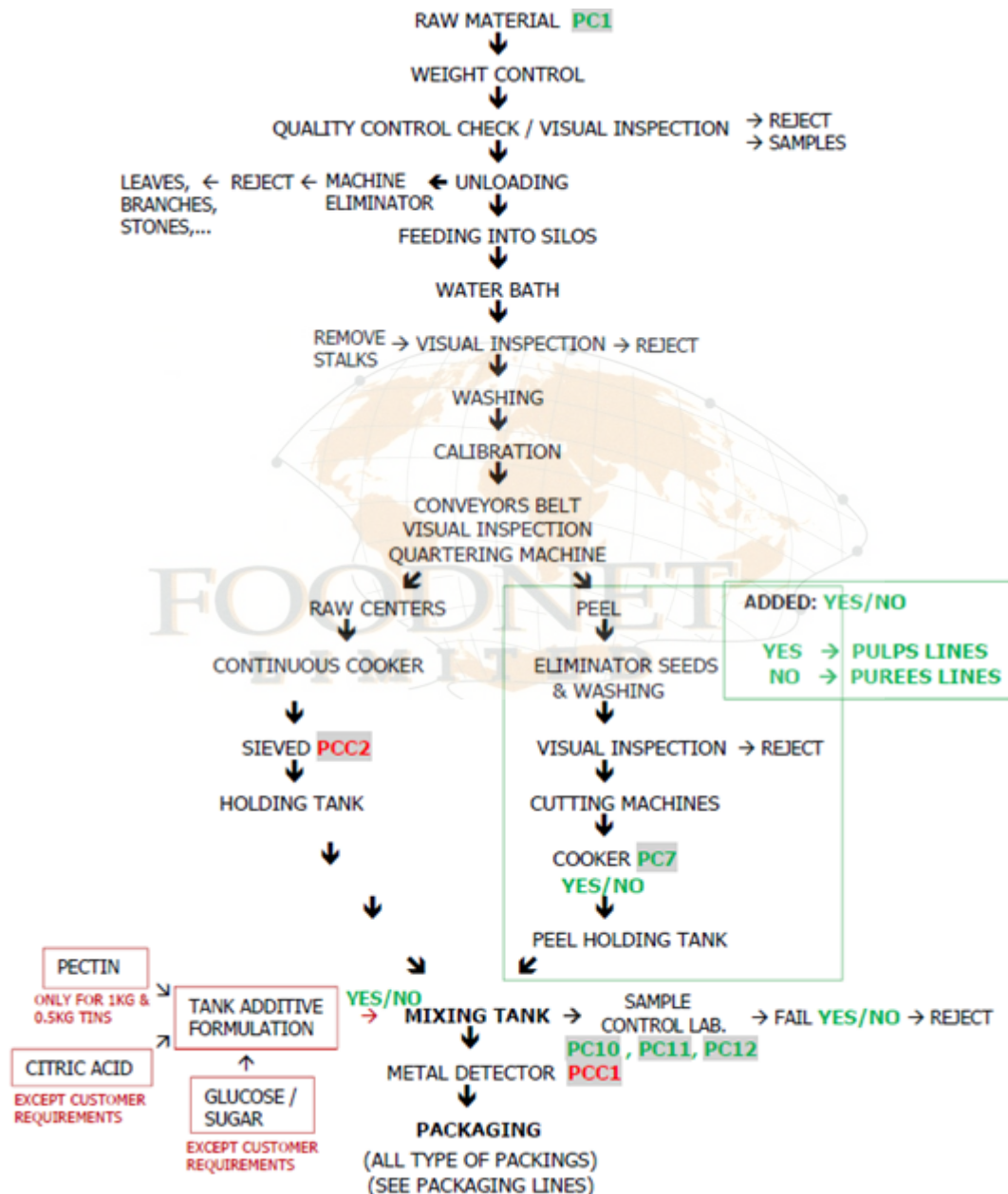


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PROCESS INFORMATION

PROCESS FLOW CHART*

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



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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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