



F. Duerr & Sons Limited

Floats Road
Roundthorn Industrial Estate
Wythenshawe
Manchester, M23 9DR

F DUERR & SONS LTD
CONFIDENTIAL

PRODUCT SPECIFICATION

TITLE: FINE CUT MARMALADE

PRODUCT CODE: DUTTJP9670 **DATE OF ISSUE:** 12/03/14
RECIPE: TTJP **WEIGHT:** 20g

SUPPLIED BY: F DUERR & SONS LTD
FLOATS ROAD
ROUNDTORN INDUSTRIAL ESTATE
WYTHENSHAW
MANCHESTER M23 9DR
TEL: 0161 – 946 0535
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TECHNICAL MANAGER: Julie Fallows TEL:- 0161-946 7849
Julie.Fallows@duerrs.co.uk

PRODUCT DESCRIPTION:

A uniform dispersion of fine cut bitter orange pulp in a stable sugar/acid gel.
Flavour to be characteristic of Fine cut Orange Spread. Peel size 1.5mm thick by random length.
Prepared with 20g of fruit per 100g, Sugar content 68g per 100g.

ALLERGEN INFORMATION:

Contains sulphites but has no function in the final product but is less than 10ppm in finished product so non declarable.

Free from GMO.
Suitable for vegetarians and vegans.
Gluten free and suitable for Coeliacs.

INGREDIENTS: In descending order:

Ingredient Name
Glucose-Fructose Syrup
Oranges (Sulphites)
Sugar
Acidity Regulator: Citric Acid
Acidity Regulator: Sodium Citrate
Gelling Agent: Pectin



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Processing Dimethylpolysiloxane	Aid:
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LABEL DECLARATION:

Glucose-Fructose Syrup, Oranges, Sugar, Acidity Regulators: Citric Acid, Sodium Citrate,
Gelling Agent: Pectin.

Prepared with 20g of fruit per 100g, Sugar content 68g per 100g.

STORAGE CONDITIONS:

Ambient. Store in a cool dry place.

SHELF LIFE:

12 months from date of manufacture.

NUTRITIONAL DATA:

Typical Values per 100g

Energy	1196kJ/281kcal
Fat	<0.1g
Of which saturates	<0.1g
Carbohydrate	69.8g
Of which sugars	56.7g
Fibre	0.5g
Protein	0.2g
Salt	<0.1g

Source: Calculated

PROCESSING DETAILS:

1. All ingredients (except pectin) are pre-weighed and transferred into cooking vessels.
2. Ingredients are heated to a pre-determined temperature, 8.5°C below the finished temperature, when pectin is added.
3. Ingredients are boiled to a "finish" temperature when soluble solids content is checked by refractometer. The finished temperature is approximately 105°C, but is



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- dependant on atmospheric pressure. The boiling process takes between 10 - 12 minutes.
4. Finished product is discharged from cooking vessels to cooler. Citric acid solution is added during discharge.
 5. Product is pumped to volumetric piston filler, and passed through an in line metal detector.
 6. The jam is filled (max 85°C) into pre-formed portions, heat sealed foil.
 7. The portions are then packed 16 per tray and the trays packed into cardboard boxes as requested.
 8. During production constant quality control checks are taken to ensure consistency of formulation and maintenance of quality.

CODING:

Printed on the box label with “L” plus 4 figure julian date code plus Best Before End (month and year).

QUALITY ASSURANCE:

- | | | |
|------|------------------------|---|
| i) | Weight | Filled to Average Weight System, the total weight of the twin pack is controlled Target = 20g |
| ii) | Metal Detection | 2.5mm Ferrous and Non-Ferrous, 3.5mm stainless steel, challenged every 30 minutes. |
| iii) | H.A.C.C.P. | A full documented HACCP system is operated throughout the factory. |
| iv) | Quality Control | A comprehensive range of checks are done on all production and raw materials.
Analytical parameters:
T.S.S. 67 - 70%
pH 3.1 – 3.3
SO2 30ppm
Microbiological N/A – commercially sterile |
| v) | Accreditation | F. Duerr and Sons Limited is accredited to BRC Grade A. The laboratory is accredited to C.L.A.S. |

PACKAGING:

Blister Pack	Mono PVC, Clear in colour, Not Recyclable.
Foil Lid	Pre-printed foil PETP/PVDC. Not Recyclable.



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Tray

Machine Erect, glued at four corners, brown cardboard
271mm x 133mm x 19mm. 100% recyclable

Cardboard Box

20g -280mmLx140mmWx125mmH, 96 portions per box
100% recyclable

WARRANTY:

This product complies with the Food Safety Act 1990, and all other current relevant EU and UK legislation and is wholly fit for human consumption.

ISSUED BY: Melanie Armes

DATE: 12/03/14