Pasta Foods Standard Commodity Specification

Title	STANDARD SEMOLINA		Product Nos.	49101	49102	49103
Status	APPROVED	Date of Issue	12 December 2018	Version	01/18	

SECTION 1

DESCRIPTION:

- A free flowing pale cream coloured granular powder milled from 100% durum wheat.
- Durum Wheat countries of origin: principally 100% sourced from France but can also be sourced from the United Kingdom, Canada & Spain, if required (other countries may be used according to availability). Semolina manufactured at Waveney Mills, Southtown Road, Great Yarmouth, Norfolk, NR31 0JB, United Kingdom.
- Available in **25 kg paper sack units,** 1 tonne flexible IBC or bulk tankers.

SECTION 2

GENERAL QUALITY REQUIREMENTS:

1. All preparation, processing, packaging and handling must be carried out according to Good Manufacturing Practice.
2. To be free from foreign matter and substantially free from black specks.
3. To comply with all current United Kingdom and European Union Food Regulations and appropriate European Food Directives and their subsequent amendments.
4. To be free from materials produced by irradiation, genetic modification or recombinant DNA technology.

SECTION 3

SPECIFIC QUALITY REQUIREMENTS:

Chemical:

Moisture:	Target 14.5% Range 14 - 15% ***(CCP Check)***	(See Method 1)
Protein (n x 5.7):	12.0% minimum (Dry Weight Basis)	
Falling Number:	250 seconds minimum.	(Standard Test)
Gluten:	Wet 25 g minimum Dry 9.2 g minimum	(See Method 3)
Ash:	1.20% maximum (Dry Weight Basis)	(See Method 2)

Physical:

Particle Size Distribution: (See Method 4)

Standard semolina is milled to produce a particle size range between 425 µ and 150 µ. Particles outside this range are permissible to the limits shown below:-

>500 micron	0 - 10%
>425 micron	5 - 15%
>300 micron	20 - 40%
<150 micron	0 - 18%

Speck Count:	10 maximum		(See Method 5)
Colour:	L*	78 - 90	(See Method 6)
	B*	20 minimum	

SECTION 4

MICROBIOLOGICAL:

Regular microbiological testing is carried out to a defined audit regime and records exist to demonstrate our compliance.
Individual loads will therefore not be checked. Semolina produced at Waveney Mills complies with the following microbiological standards:

TEST	FREQUENCY OF TESTING	TARGET	REJECT
Total Viable Count	Once per week	<50,000 cfu/g	>100,000 cfu/g
Coliform *(Presumptive)*	Once per week	<10 cfu/g	>100 cfu/g
Escherichia coli	Once per week	<10 cfu/g	>10 cfu/g
Staphylococcus aureus	Once per week	<20 cfu/g	>200 cfu/g
Clostridium perfringens *(Presumptive)*	Once per week	<20 cfu/g	>30 cfu/g
Bacillus cereus *(Presumptive)*	Once per week	<20 cfu/g	>100 cfu/g
Salmonella *(Test contracted out to ALS via Premier Analytical Services)*	Once per week	Negative in 250g	Positive in 250g
Yeasts & Moulds	Once per week	<2,000 cfu/g	>5,000 cfu/g

SECTION 5

NUTRITION INFORMATION:

100g of this product typically contains (corrected to 14.0% moisture)

Energy	kJ / 100g	1446
	kcal / 100g	341
Fat g/100g		1.5
of which saturates g/100g		0.4
of which monounsaturates g/100g		0.2
of which polyunsaturates g/100g		0.8
of which trans fatty acids g/100g		0.0
Carbohydrate g/100g		68.3
of which sugars g/100g		2.3
of which polyols g/100g		0.0
of which starch g/100g		66.0
Dietary Fibre g/100g (AOAC)		2.8
Protein g/100g (nx6.25)		13.4
Salt g/ 100g		<0.03
Salt content is exclusively due to the presence of naturally occurring sodium		

The minerals and vitamins are typically below 5% RDA

Specific Allergen Data Statement

This product contains	Wheat and Wheat Gluten

Specific Dietary Information

	Suitable	Qualifying Comments
Vegetarians	YES	
Vegans	YES	
Coeliacs	**NO**	Contains Wheat Protein (Gluten)
Lactose Intolerants	YES	
Nut Allergy Sufferers	YES	
Sesame Allergy Sufferers	YES	
Kosher Diet	YES	
Muslim Diet	YES	

FOOD INTOLERANCE DATA:

Recipe Free From	YES/NO	Recipe Free From	YES/NO
Celery	YES	BHA / BHT	YES
Cereals – Wheat and Wheat Derivatives	**NO**	Colours – Artificial (Azo/Coal Tar)	YES
Gluten	**NO**	Colours - Natural	YES
Cereals (other) – oats, rye, barley	YES	Fruit and Fruit Derivatives	YES
Crustaceans and their Derivatives	YES	Glutamates	YES
Fish Excluding Shellfish	YES	GM derivatives	YES
Eggs	YES	GM materials/ingredients	YES
Lupin	YES	HVP/TVP	YES
Milk	YES	Irradiated food materials	YES
Molluscs and their Derivatives	YES	Maize and maize Derivatives	YES
Mustard	YES	Meat - Beef and Derivatives	YES
Nuts and Nut Derivatives	YES	Meat - Pork and Derivatives	YES
Peanuts and Peanut Derivatives	YES	Meat - Lamb/Mutton and Derivatives	YES
Sesame Seeds and Derivatives	YES	MSG	YES
Seeds (other) or their derivatives	YES	Preservatives	YES
Soybeans and Soya Derivatives	YES	Salt (added)	YES
Sulphur Dioxide & Sulphites - >10mg/kg	YES	Sugar (added)	YES
Additives	YES	Vegetables or their Derivatives	YES
Aspartame	YES	Yeast and Yeast Derivatives	YES
Benzoates	YES		

SECTION 6

FOOD SAFETY MEASURES:

Metal Detection *(CCP CHECK):*

Metal Detection Equipment	Safeline Metal Detector					
Sensitivity	Fe	1.0mm	Non-Fe	1.2mm	S/Steel	1.5mm
Frequency of system checks	Minimum one check every 6-hours					
Position in process	In-line – Prior to Packing/Out-Loading Bins					

Metal Detection Equipment	Safeline Metal Detector					
Sensitivity	Fe	2.0mm	Non-Fe	2.5mm	S/Steel	3.0mm
Frequency of system checks	Ferrous every pallet – Non-Ferrous & Stainless Steel every alternate pallet					
Position in process	Post Bag Sealing					

POTENTIAL FOOD CONTAMINANTS:

CONTAMINANT TYPE	SPECIFIC CONTAMINANT	EU Maximum Residue Level
MYCOTOXIN RESIDUES:	Ochratoxin A	3.0 µ/kg
	Aflatoxin B_1	2.0 µ/kg
	Aflatoxin B_1 + B_2 + G_1 + G_2 Total	4.0 µ/kg
	Deoxynivalenol (DON)	750 µ/kg
	Zearalenone	75 µ/kg
	T2 Toxin (T2)	No EU MRL – Target ≤200 µ/kg
	HT2 Toxin (HT2)	No EU MRL – Target ≤200 µ/kg
PESTICIDE RESIDES:	Multi-Residue Pesticide Screen (Details on request)	Individual EU MRLs
HEAVY METALS RESIDUES:	Arsenic	1.0 mg/kg
	Cadmium	0.2 mg/kg
	Lead	0.2 mg/kg

All of the above potential contaminants are surveillance tested on every imported wheat load or grist change or quarterly, whichever is the greater. All testing is completed by an approved UKAS accredited external laboratory.

SECTION 7

PACKAGING AND STORAGE

Sacks: **49101** - Natural Kraft two-ply, food grade paper sacks with LUDOX anti-slip finish - Grade 1/95NK + 1/80NK – Size 420 x 75 x 770mm – closed by blue stitching cotton – to contain not less than 25.0 Kg. of product – 40 sacks (8 layers of 5) per pallet.

Flexible IBCs (Bulk Bags): **49102** - On GKN pallets with pallet liners. Coated woven polypropylene 180gsm bulk bag with 4 polyester lifting loop straps and both infill and discharge spouts with a polypropylene inner skin 150gsm. Length - 96cm; Depth – 96cm; Height – 140cm. Each bulk bag to contain not less than 1 tonne of product.

Bulk: **49103** - Delivered in clean dedicated bulk tanker which is only used for durum semolina or durum flour.

Markings: Each bag unit to be ink-jet printed with PRODUCT NAME, PACKING DATE, BEST BEFORE END DATE and UNIQUE BAG NUMBER.

Storage:	Pallets should be stored in a cool, dry, infestation free place.
Storage Life:	If kept under the correct storage conditions semolina should not deteriorate for 6 months but every effort should be made to use the product within 3 months.

SECTION 8

TECHNICAL ENQUIRIES: **Should be addressed to:**

Quality Assurance Department
Pasta Foods Limited
Pasteur Road
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NR31 0DW
United Kingdom
Tel: 01493 416 200
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E-mail: enquiries@pastafoods.com
Website: www.pastafoods.com

Approved for **Pasta Foods Limited**:

Sherrilee Bekker
Technical Manager

Date: 12 December 2018

SECTION 9

1. Moisture Content

Method

1. Grind sample (all particles to pass through 500µm sieve).

2. Accurately weigh approximately 10g of the ground sample in a suitable oven dish.

3. Place sample in a fan stirred oven pre-set to 105°C and leave for 4 hours.

4. Remove sample from oven and place in a desiccator until cool.

5. Re-weigh the sample and calculate moisture content.

N.B. Rapid moisture testers can be used but they must be regularly calibrated to achieve compatible results to the air oven method.

2. Ash Content

Method

ICC Standard No. 104/1 Approved 1960 revised 1990

3. Gluten

Equipment

1 Falling Number Glutomatic
2 Falling Number Centrifuge and Sieve
3 Falling Number Glutork
4 Falling Number Hammer Mill
5 Fine Sieve and Sieve Holder
6 Coarse Sieve and Sieve Holder
7 Buffered Salt Solution & Dispenser
8 Balance

Method

1. Place fine sieve in sieve holder and pre-wet with water.

2. Weigh out 10g of material and place in sieve holder. Shake gently to level.

3. Add 4.8ml buffered salt solution from dispenser, holding sieve at an angle and directing solution against side of sieve holder. Gently shake to distribute solution.

4. Fit sieve holder into position in Glutomatic.

5. Press green start button.

6. When cycle is complete, remove all gluten from wash chamber, rinse gently and shake dry.

7. Place gluten in centrifuge sieve and start centrifuge.

8. When programme is complete, take out centrifuge sieve, ensuring all gluten is removed from centrifuge.
9. Weigh the gluten which passed through the sieve, following by the total amount.

10. Record total amount of gluten (wet weight) as weight x 10.

11. Calculate and record gluten index.

Gluten index = (total gluten - passed through)
total gluten x 100

12. Place all gluten in pre-heated Glutork and switch on.

13. When buzzer sounds, take out dried gluten and weigh. Record dry weight as weight x 10.

4. Particle size distribution

Equipment

1 Balance
2 Simon Rotary Sifter
3 Pan Sieves, Sieve Pan and Lid
4 Rubber Balls

Method

1. Ensure there are 3 rubber balls in each sieve.

2. Weigh out 100g material and place in top (coarsest) sieve.

3. Place sieves, coarsest at the top, with sieve pan on the bottom, on rotary sifter and screw down lid.

4. Set timer on sifter for 3 minutes and start cycle.

5. When sieving is complete, weigh contents retained on each sieve and in pan, and record as percentages.

5. Speck count

Equipment
1. 55mm Diameter Contact Plates with Counting Grid.

Method
1. Overfill base of contact plate

2. Compact semolina by covering with lid and pressing down.

3. Invert dish and place the grid from a second contact plate over the dish and count the dominant specks within a 20 * 20mm square.

6. Colour determination

Equipment

1 Minolta Chroma Meter CR310
2 White Calibration Plate
3 Granular - Materials Attachment CR-A50
4 425 & 300 Micron Sieves
5 Endecott Test Sieve Shaker

Method

Sample Preparation

1. Sieve 100g semolina for 5 minutes using the 425 and 300 micron sieves.
2. Take product retained on the 300 micron sieve and carefully blend to ensure even particle distribution.

Analysis using the Minolta Chroma Meter

1. Calibrate the Minolta taking care to position the optical glass of the CR-A50 attachment centrally on top of the white calibration plate.
2. Fill granular attachment with sample, ensuring that the surface is level, and replace cap.
3. Carry out colour analysis.
4. Empty granular attachment and repeat analysis.
5. Calculate the average Laboratory indices and record results as necessary.