



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: Black Turtle Beans	Last Update: 31/01/2020	Product Code: BEA003

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

ORIGIN: USA / Canada / Argentina

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 Black Turtle Beans 100% Declare as: Black Turtle Beans
(*Phaseolus vulgaris*)

PROCESSING Dried black turtle beans delivered to the factory. Each load is sampled and assessed for foreign material, seed size and physical defects. The load is then soaked for 8 hours, cooked for a time sufficient to reduce the lectin levels to below 400 HAU, frozen and filled into bulk palletainers. The frozen beans are sampled and assessed against this 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, metal detected, palletised and stretch-wrapped before being returned to store at –18°C to await despatch.

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

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DEFECT TOLERANCES

Per 1000g

Foreign Matter	Nil
E.V.M.	1
Broken/Damage	5%w/w
Wrinkled Pieces	4
Skin	10
Blemish	20
Colour variant	6

DEFINITIONS OF DEFECTS

Foreign Material

This includes any material not derived from black turtle bean plant such as insects, pieces of insects, wood, glass, stones, metal, toxic berries, snails, slugs or any other material which will render the product unacceptable.

Extraneous Vegetable Matter (EVM)

This includes any vegetable matter other than the black turtle bean that is derived from the bean plant or other harmless vegetable material such as pieces of leaf.

Skin

Skin with no inner left attached.

Blemish

This includes units which are blemished through damage by disease or mechanical means or which have blackened, decomposed or discoloured areas where the area affected is at least 2mm in diameter or length either as a single blemish or as an aggregate of blemishes and which is not considered to be a major defect. Single blemishes of less than 2mm shall be ignored.

Colour variants

This refers to any unit which is conspicuously different in colour from the normal colour of the rest of the sample.

Broken/Damaged Beans

This includes beans that have damaged or have a portion of the bean missing or are in halves.

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

	Minimum samples to be taken (1Kg of product per each item)		
Quantity Delivered (Kg)	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 Black almost completely uniform throughout the sample.

FLAVOUR Characteristic black turtle bean flavour, no off flavours.

TEXTURE Smooth and tender.



Average sample

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MICROBIOLOGICAL

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

ANALYTICAL

Lectin Haemagglutination. Test shall give results <400 HAU.

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 sack 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 black turtle beans typically contains: -

Parameter	Value / 100g	Methodology
Energy - kcal	339	USDA Reference Release 28
Energy - kJ	1418	USDA Reference Release 28
Moisture	11.0g	USDA Reference Release 28
Carbohydrate	63.25.0g	USDA Reference Release 28
- as sugars	2.1g	USDA Reference Release 28
- as polyols	0.0g	USDA Reference Release 28
- as starch	61.1g	USDA Reference Release 28
Fat	0.7g	USDA Reference Release 28
- as saturates	0.2g	USDA Reference Release 28
- as mono unsaturates	0.08g	USDA Reference Release 28
- as poly unsaturates	0.4g	USDA Reference Release 28
Protein	21.3g	USDA Reference Release 28
Fibre	15.5g	USDA Reference Release 28
Sodium	9mg	USDA Reference Release 28
Vitamin A	Trace	USDA Reference Release 28
Vitamin B ₆	0.28mg	USDA Reference Release 28
Vitamin B ₁₂	0.0mg	USDA Reference Release 28
Vitamin C	0.0	USDA Reference Release 28
Vitamin D	0.0µg	USDA Reference Release 28
Vitamin E	0.21mg	USDA Reference Release 28
Thiamin	0.9mg	USDA Reference Release 28
Riboflavin	0.19mg	USDA Reference Release 28
Niacin	0.2mg	USDA Reference Release 28
Folic Acid	0.0µg	USDA Reference Release 28
Biotin	0.0µg	USDA Reference Release 28
Pantothenic Acid	0.9mg	USDA Reference Release 28
Calcium	160mg	USDA Reference Release 28
Phosphorus	440mg	USDA Reference Release 28
Iron	8.7mg	USDA Reference Release 28
Magnesium	160mg	USDA Reference Release 28
Zinc	2.2mg	USDA Reference Release 28
Iodine	0.0µg	USDA Reference Release 28
Potassium	1500mg	USDA Reference Release 28

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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: 31st 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: 31st January 2020

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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	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.				
<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
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
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: 31st January 2020

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.

BLACK TURTLE BEANS

Raw Material Receipt → QA Check



Pass over stone trap



Soaking



Inspection



Cooking



Cooling



Inspection



Freezing → -18°C QA Check



Inspection



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

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