



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

DEFECT TOLERANCES

<u>1000g sample</u>	<u>Maximum</u>
Foreign Material	Nil
Batter and Oil pick up	65%
Dark Spots (>19x13mm)	0
Broken Rings	3
Concentric Layers	1
Double Rings	2
Coating Voids	6
Irregular Shape	4
Inner Diameter<7mm	4
Total Defect	10

DEFINITIONS OF DEFECTS

Foreign Material

This includes any material such as insects, wood, glass, stones, metal, snails, slugs or any other material which will render the product unacceptable.

Batter and Oil pick up

This is the weight percentage of the coating (which includes the oil) as part of the finished product, measured by peeling off the coating from the onion rings.

Dark Spots

These are dark spots greater than 19x13mm, i.e. bits of burnt fryer debris attached to or imbedded in the coating.

Broken Rings

These are onion rings that are broken or damaged.

Double Rings

This is when 2 onion rings are welded together and cannot be separated without causing

Coating Voids

This are onion rings whose coating is partly missing to the extent that the affected area is greater than 25mm² or 13mm in diameter.

Irregular Shape

These are onion rings whose shape is extremely irregular.

Inner Diameter<7mm

These are onion rings whose inner diameters are less than 7mm or present no hole at all.

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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

ORGANOLEPSIS (Carried out on a thawed sample.)

COLOUR Shall have a uniform white or creamy white colour. May Have very slight green-grey tints.

FLAVOUR Full, natural and characteristic onion flavour.

TEXTURE Diced onions shall be uniformly firm and tender



Average sample

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MICROBIOLOGICAL

Organism	Target	Maximum
<i>TVC @ 30°C</i>	1×10^5	1×10^6
<i>Total Coliforms</i>	1×10^3	5×10^3
<i>E. coli</i>	1×10^1	1×10^2
<i>Listeria mono</i>	Absent in 25g	1×10^2
<i>Salmonella</i>	Absent in 25g	Absent in 25g

ANALYTICAL N/A – Un-blanced product.

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 battered onion rings typically contains: -

Parameter	Value / 100g	Methodology
Energy - kcal	207	Calculated
Energy - kJ	868	Calculated
Carbohydrate	25.3g	Calculated
- as sugars	2.5g	Calculated
Fat	11g	Calculated
- as saturates	1.4g	Calculated
- as mono unsaturates	2.7g	Calculated
- as poly unsaturates	6.7g	Calculated
-of which trans fat	trace	Calculated
Protein	3.0g	Calculated
Fibre	2.0g	Calculated
Sodium	1.2mg	Calculated

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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 (**)	YES	Wheat, Corn		
Gluten	YES	Wheat		
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
E407	Carrageenan	Batter	-	Thickener	Approx 0.035% for all four additive
E412	Guar Gum	Batter	-	Thickener	
E450	Diphosphates	Batter	-	Emulsifier	
E500	Sodium carbonates	Batter	-	Raising Agent	

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.

BATTERED NATURAL ONION RINGS

RMs delivered to the Factory → QA Check



Cold Storage



Manual Sorting



Battering



Breading



Frying



Freezing → -18°C QA Check



Tipping



Cold Storage



Packing in PE Film



Metal Detection



Check Weigh



Carton Fill → QA Check



Palletise



Cold Storage → -23°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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