



Head Office: The Old Grammar School, 3-7 Market Square, Amersham, Bucks. HP7 0DF  
Tel: (44) 1494 434600 Email: [foodnettechnical@foodnet.ltd.uk](mailto:foodnettechnical@foodnet.ltd.uk)

Technical Specification		
<b>Product:</b> Soya Bean Kernels Edamame	<b>Last Update:</b> 31/01/2020	<b>Product Code:</b> SOY001

**PACK SIZE** 1 x 10kg; 10 x 1kg;

**ORIGIN:** China

**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** Soya Beans (Edamame) 100% Declare as: Soya Beans  
(*Glycine max*)

**PROCESSING** Soya bean pods are delivered fresh to the factory; each load is sampled and assessed for foreign material and physical defects. The load is then shelled, cleaned, blanched, frozen and filled into bulk palletainers. The frozen soya beans are sampled and assessed against 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 and metal detected, palletised and stretch wrapped before being returned to store at -23°C to await despatch to the UK at -18°C.

**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**

Clumps	5%w/w
Foreign Matter	Nil
E.V.M.	1
Major blemish	3% w/w
Minor blemish	7% w/w
Total Blemish (Major & Minor)	8% w/w
Damaged and Split Beans	5% w/w
Black Hilum	5%w/w

## **DEFINITIONS OF DEFECTS**

### **Clumps**

This is where 3 or more kernels are welded together so that they cannot be readily separated without causing damage to the product.

### **Foreign Material**

This includes any material not derived from the soya bean plant nor defined as EVM, 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 harmless vegetable matter other than bean which is derived from the soya bean plant or harmless vegetable material such as leaves or pod.

### **Major Blemish**

A bean which is blemished to a major degree is one which has conspicuously discoloured (including dark purple staining and bruising) or blemished areas greater than an equivalent circle of 6mm in diameter, either as one blemish or as an aggregate of blemishes.

### **Minor Blemish**

A bean which is blemished to a minor degree is one which has conspicuously discoloured (including dark purple staining and bruising) or blemished areas less than an equivalent circle of 6mm in diameter, either as one blemish or as an aggregate of blemishes. Single blemishes of less than 2mm shall be ignored.

### **Damaged & Split Beans**

These are beans which are not whole and complete, and includes beans which have been physically crushed, damaged or broken by mechanical means and also pieces of beans such as separate broken or whole cotyledons and loose skin. Damage by natural agencies is also included. Split beans are those where the testa is split to more than 50% of its length, but in which the cotyledons remain complete.

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### **Black Hilum**

Black mark left on the seed coat.

*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**

Bright, characteristic green colour but may lack uniformity throughout the sample.

#### **FLAVOUR**

Slightly weak characteristic flavour, typical of the variety. May be slightly bitter.

#### **TEXTURE**

Flesh slightly firm and/or slightly mealy. The skins may be rather firm or slightly tough.



Average sample

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#### **MICROBIOLOGICAL**

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

**ANALYTICAL** Product shall be blanched to give a trace positive peroxidase reaction (guaiacol test) between 60 and 90 seconds.

**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.

**FILM** Clear, heat-sealed food grade polythene film 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 soya beans typically contains: -

Parameter	Value / 100g	Methodology
Energy - kcal	370	McCance & Widdowson 7th Edition
Energy - kJ	1551	McCance & Widdowson 7th Edition
Moisture	8.5g	McCance & Widdowson 7th Edition
Carbohydrate	15.8g	McCance & Widdowson 7th Edition
- as sugars	5.5g	McCance & Widdowson 7th Edition
- as polyols	0.0g	McCance & Widdowson 7th Edition
- as starch	4.8g	McCance & Widdowson 7th Edition
Fat	18.6g	McCance & Widdowson 7th Edition
- as saturates	2.3g	McCance & Widdowson 7th Edition
- as mono unsaturates	3.5g	McCance & Widdowson 7th Edition
- as poly unsaturates	9.1g	McCance & Widdowson 7th Edition
Protein	35.9g	McCance & Widdowson 7th Edition
Fibre	4.2g	USDA Nutrient Database Release 19
Sodium	5mg	McCance & Widdowson 7th Edition
Vitamin A	0µg	McCance & Widdowson 7th Edition
Vitamin B6	0.38mg	McCance & Widdowson 7th Edition
Vitamin B12	0µg	McCance & Widdowson 7th Edition
Vitamin C	Trace	McCance & Widdowson 7th Edition
Vitamin D	0µg	McCance & Widdowson 7th Edition
Vitamin E	2.9mg	McCance & Widdowson 7th Edition
Thiamin	0.61mg	McCance & Widdowson 7th Edition
Riboflavin	0.27mg	McCance & Widdowson 7th Edition
Niacin	2.2mg	McCance & Widdowson 7th Edition
Folic Acid	370µg	McCance & Widdowson 7th Edition
Biotin	65.0µg	McCance & Widdowson 7th Edition
Pantothenic Acid	0.79mg	McCance & Widdowson 7th Edition
Calcium	240mg	McCance & Widdowson 7th Edition
Phosphorus	660mg	McCance & Widdowson 7th Edition
Iron	9.7mg	McCance & Widdowson 7th Edition
Magnesium	250mg	McCance & Widdowson 7th Edition
Zinc	4.3mg	McCance & Widdowson 7th Edition
Iodine	6.0µg	McCance & Widdowson 7th Edition
Potassium	1730mg	McCance & Widdowson 7th Edition

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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: 31<sup>st</sup> 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: 31<sup>st</sup> January 2020

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## **FOOD INTOLERANCE**

<b>Food Intolerance Data</b>				
Does the material supplied contain any of the following? (NO) Absent, (YES) Present				
<b>Allergen</b>	<b>NO / YES</b>	<b>Reason for presence if YES</b>		
Milk & Milk Derivatives	NO			
Egg & Egg Derivatives	NO			
Animal Products (*)	NO			
Fish/Shellfish/Crustations/Molluscs	NO			
Cereals (**)	NO			
Gluten	NO			
Yeast/Yeast Extract	NO			
Soya/Soya Derivatives	YES	Soya Beans 100%		
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.				
<b><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></b>				
<b>Is this product Suitable for:</b>				
<b>Vegans</b>	Yes (Not certified)	<b>Vegetarians</b>	Yes	<b>Organic</b>
<b>Halal</b>	Yes (Not certified)	<b>Kosher</b>	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

### **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: 31<sup>st</sup> 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.

#### **SOYA BEANS EDAMAME**

Raw Material Receipt → QA Check



Shelling



Washing



Blanching



Cooling



Inspection



Freezing → -18°C QA Check



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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