

FINISHED PRODUCT SPECIFICATION

Product title: Pork Pies 140g x 48

Retailer: N/A

Retailer approval/recipe: Yes

Launch date: Mid May

Inner barcode: N/A

Outer barcode: 05018833 023139

SPECIFICATION HISTORY OF AMENDMENTS

Version number	Reason for issue	Date of issue
1	New product	15.05.2024

Contact details of supplier and point of manufacture and packing:

Legal name and marketing description

Legal name: Seasoned cured pork baked in pastry

Marketing description: Seasoned cured pork baked in our hot water crust pastry

Recipe and Ingredient

Recipe

Please insert any compound ingredient, processing aid and detail different cuts of meat

For ingredients sourced from China include the region

Ingredient (Ingredients in bold Compounds in italic)	Grade, Source, Size, Shape, Storage, Shelf life, heat treatment, washing, food safety parameters (please give origin of additives)		Country of manufacture/ origin	Weight (g) before cooking (mixing bowl)	% of finished product
Base Pastry	Made on Site		United Kingdom	62g	
Fortified Wheat Flour (Wheat Flour, Calcium Carbonate, Iron, Niacin, Thiamin)	Ingredient of Pastry. Off white powder, Ambient, 12 months shelf life.		UK, France, India, China	35.10	25.07
Salt	Ingredient of Pastry. White Granulated powder. Ambient, Indefinite shelf life. Contains anti-caking agent: Sodium Ferrocyanide (E535)		United Kingdom	0.45	0.32
Hot Water	Ingredient of pastry. Mains Water – Heated on site		United Kingdom	10.85	0.00
Pork Lard	Ingredient of pastry. Liquid. Contains non declarable antioxidant E306 tocopherol.		Netherlands	15.60	11.15
Lid Pastry	Made on Site		United Kingdom	19g	

Fortified Wheat Flour (<i>Wheat Flour, Calcium Carbonate, Iron, Niacin, Thiamin</i>)	Ingredient of Pastry. Off white powder, Ambient, 12 months shelf life		UK, France, India, China	11.07	7.91
Salt	Ingredient of Pastry. White Granulated powder. Ambient, Indefinite shelf life. Contains anti-caking agent: Sodium Ferrocyanide (E535)		United Kingdom	0.13	0.09
Hot Water	Ingredient of pastry. Mains Water – Heated on site		United Kingdom	3.20	0.00
Pork Lard	Ingredient of pastry. Liquid. Contains non declarable antioxidant E306 tocopherol.		Netherlands	4.60	3.28
Pork Filling	Made on Site		United Kingdom	63g	
Pork	Ingredient of filling. 80VL Pork Trim. Fresh / Frozen. UK/EU welfare assured. Kill to pack max 7 days. Shelf life pack + max 10 days stored chilled / pack + 24 months stored frozen.		Netherlands, Belgium, Denmark, Germany, Poland, United Kingdom	44.28	31.63
Pork Fat	Ingredient of filling. Pork Fat. Fresh/Frozen. UK/EU welfare assured. Kill to pack max 5 days. Shelf life pack + max 10 days stored chilled / pack + 24 months stored frozen.		Netherlands, Belgium, Germany, Poland, Spain, United Kingdom	4.92	3.51
Potato Starch	Ingredient of Filling. White free flowing powder. pH 5-8. Contains S02 at <10ppm. Storage: Ambient, Max life: 5 years stored at ambient.		Germany, Netherlands, France	0.98	0.70

Rusk	Ingredient of filling. Particulate powder and a mix of all ingredients below – Contains non declarable processing aid Ammonium Bicarbonate E503ii – Nil/Trace. Aw ~0.21. Maximum moisture 5%. Baked in temperatures in excess of 200°C for organoleptic purposes only. Shelf life 24 months stored at ambient.		United Kingdom	N/A	N/A
Fortified Wheat Flour (<i>Wheat Flour, Calcium Carbonate, Iron, Niacin, Thiamin</i>)	Sub Ingredient of rusk. Powder. Maximum moisture 15%. Shelf life 12 months stored at ambient.		United Kingdom, Germany, Denmark, France	2.90	2.07
Salt	Sub Ingredient of rusk. Powder. pH 7. Shelf life indefinite. Contains non declarable anti-caking agent – sodium ferrocyanide at <15ppm.		United Kingdom, Netherlands	0.06	0.04
Water	Ingredient of filling. Mains Potable		United Kingdom	7.87	0.00
Seasoning Bag	Ingredient of filling. Powder and a mix of all ingredients below. Salt minimum 18.65%. Shelf life 12 months stored at ambient.		United Kingdom	N/A	N/A
White Pepper	Sub Ingredient of seasoning bag. <i>Piper nigrum</i> . Powder. Max moisture 14%. Heat process: 115°C for 180 secs / 120°C for 30-50secs. Shelf life 36 months stored at ambient.		India, Vietnam	0.10	0.07
Black Pepper	Sub Ingredient of seasoning bag. <i>Piper nigrum</i> . Powder. Max moisture 12%. Heat process: 125°C for 240 secs / 120°C for 40-50secs. Shelf		India, Vietnam	0.08	0.06

	life max 36 months stored at ambient.				
Nutmeg	Sub Ingredient of seasoning bag. <i>Myristica Fragrans</i> . Powder. Max moisture 12%. Heat process: 95°C for 180 secs. Shelf life 24 months stored at ambient.		Indonesia	0.08	0.06
Mace	Sub Ingredient of seasoning bag. <i>Myristica Fragrans</i> . Powder. Aw 0.65. Moisture 12%. Heat process: 95°C for 7 mins. Shelf life 24 months stored at ambient.		Indonesia	0.05	0.04
Salt	Sub Ingredient of seasoning bag. Mineral. Contains non declarable anti-caking agent E535 sodium ferrocyanide at<15ppm. Powder. Moisture 0.06%. Salt >99.9%. Shelf life indefinite stored at ambient.		United Kingdom, China	0.20	0.14
Fortified Wheat Flour (<i>Wheat Flour, Calcium Carbonate, Iron, Niacin, Thiamin</i>)	Sub Ingredient of seasoning bag. Powder. Moisture 8%. Shelf life 12 months stored at ambient.		United Kingdom, China, Denmark, France, Germany	0.14	0.10
Rusk	Sub Ingredient of seasoning bag and a mix of ingredients below. Powder. Moisture 6%. Shelf life 12 months stored at ambient.		United Kingdom	N/A	N/A
Fortified Wheat Flour (<i>Wheat Flour, Calcium Carbonate, Iron, Niacin, Thiamin</i>)	Sub Ingredient of rusk. Powder. Moisture 6%. Shelf life 12 months stored at ambient.		United Kingdom	0.15	0.11
Salt	Sub Ingredient of rusk. Powder. Moisture 0.06%. Salt >99.9%. Shelf life indefinite stored at ambient.		Bulgaria, China, Denmark, France, Germany, Italy, Netherlands	0.00	0.00

Flavour Enhancer (Mono Sodium Glutamate)	Sub Ingredient of seasoning bag. Synthetic. E621. Powder. pH 6.7-7.5. Moisture 0.5%. Shelf life 36 months stored at ambient.		China, Egypt, Indonesia, Thailand, Vietnam	0.10	0.07
Emulsifier (Sodium Tripolyphosphate)	Sub Ingredient of seasoning bag. E451. Powder. pH 9.5-10.1. Moisture 0.5%. Shelf life 24 months stored at ambient.		Belgium, Thailand	0.08	0.06
Chicken Bouillon <i>[Salt, Maltodextrin, Yeast Extract, Potato Starch, Non Hydrogenated Palm Oil, Natural Flavouring, Dextrose, Garlic Powder, Turmeric, Nutmeg, Lovage Root Powder, Spice Extracts (Sage, Thyme)]</i>	Sub Ingredient of seasoning bag. Powder. Contains yeast extract. Natural flavouring complies with EC regulation 1334/2008. Maltodextrin and dextrose derived from non GM maize. Sustainable Palm Oil – SG/MG. Contains residual SO2 at 0.073ppm. Shelf life 12 months stored at ambient.		United Kingdom, Albania, Belgium, China, France, Germany, Hungary, Indonesia, Italy, Morocco, Poland, Turkey, United States, India, Netherlands, Bulgaria, Romania, Spain, Malaysia, Turkey, Vietnam, Canada	0.02	0.02
Cure Seasoning Bag	Powder and a mix of all ingredients below – Salt 99%. Shelf life 12 months stored at ambient.		United Kingdom	N/A	N/A
Salt	Sub Ingredient of cure seasoning bag. Contains non declarable anti-caking agent E535 sodium ferrocyanide at <15ppm. Powder. Salt >99.9%. Shelf life indefinite stored at ambient.		United Kingdom, China	0.95	0.68

Preservative (Sodium Nitrite E250)	Sub Ingredient of cure seasoning bag. Chemical. Powder. Ph 7.0-9.0. Moisture 0.2%. Chloride 50mg/kg. Salt 1.22%. Shelf life 36 months stored at ambient.		Germany	0.01	0.01
Glaze	Pasteurised intensive liquid whole egg blended with water (60:40)		United Kingdom	1g	
Pasteurised Egg	Ingredient of glaze. Pasteurised liquid intensive hen egg.		United Kingdom	0.60	0.43
Water	Ingredient of glaze. Main Potable		United Kingdom	0.40	0.00
Jelly	Made on Site		United Kingdom	20g	
Pork Gelatine	Powder / Ambient		Belgium, France, United Kingdom, Ireland, Netherlands, Germany, Poland, Italy, Switzerland, Austria, Brazil, Bulgaria, Canada, Croatia, Cyprus, Czech Republic, Denmark, Estonia, Finland, Greece, Hungary, Iceland, Italy, Latvia, Liechtenstein, Lithuania, Luxembourg, Malta, Monaco,	0.94	0.67

			Norway, Portugal, Romania, Slovakia, Spain, Sweden, USA		
Water	Main Potable		United Kingdom	18.91	11.59
Salt	Ingredient of Jelly. White Granulated powder. Ambient, Indefinite shelf life. Contains anti-caking agent: Sodium Ferrocyanide (E535)		United Kingdom	0.15	0.11

Is there any rework used? Reworked pastry may be used in the lid pastry up to 50%

Ingredient list as declared on the label:

Ingredients:

Fortified Wheat Flour (**Wheat** Flour, Calcium Carbonate, Iron, Niacin, Thiamin), Pork (35%), Pork Lard, Water, Salt, Potato Starch, Pork Gelatine, Pasteurised **Egg**, Flavour Enhancer (E621), White Pepper, Black Pepper, Emulsifier (E451), Nutmeg, Mace, Bouillon [Salt, Maltodextrin, Yeast Extract, Potato Starch, Palm Oil, Natural Flavouring, Dextrose, Garlic Powder, Turmeric, Nutmeg, Lovage Root Powder, Spice Extracts (Sage, Thyme)], Preservative (E250).

Allergen advice: For allergens, including cereals containing gluten, see ingredients in **bold**.

Warning statement: Although every care has been taken to remove bones, small bones may remain.

Shelf life and storage instruction

Please attach shelf life validation

Total shelf life: 12 Months

Minimum shelf life into customer's: 9 Months

Shelf life once opened: Remainder of life if kept frozen <-18°C.

Use by

Format as displayed on the outer label: DD/MM/YY

Batch code format with explanation:

TRACEABILITY CODE on inner film: Julian code (date), time, line number. Example: 180 0945 L 11 (29th June @ 09:45 on line 11).

Storage temperature: Keep Frozen -18°C.

Storage temperature after opening: Keep Frozen -18°C.

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Storage information as declared on pack: N/A

Is the product suitable for freezing? Yes

If yes, shelf life after defrost: Once defrosted do not re-freeze.

Are there any additional storage requirements e.g. light conditions, humidity etc. ? N/A

Weight:

Target weight, individual pie: 140g

Is the e mark required? No

If average:

T1= 133.7g

T2= 127.4g

48 pies per box = Total Net weight of outer 6.72kg

Nutritionals

Number of serving per pack:

	/100g finished product	per serving Serving size= 70g / Per ½ pie	State source of data or method used
Energy (KJ)	1330	931	Lab Tested
(Kcal)	319	223	Lab Tested
Fat of which	20.1g	14.0g	Lab Tested
Saturates (g)	7.9g	5.5g	Lab Tested
Monounsaturates (g)	8.4g	5.9g	
Polyunsaturates (g)	2.8g	2.0g	
(mg) Cholesterol			
Available Carbohydrate(g)	23.6g	16.5g	Lab Tested
Sugars (g)	1.1g	0.8g	Lab Tested
Polyols (g)			
Starch (g)	22.5g	15.8g	

Fibre (g)	1.4g	1.0g	Lab Tested
Protein (g)	10.3g	7.2g	Lab Tested
Sodium (g)	0.561g	0.393g	
Salt (g)	1.40g	0.98g	Lab Tested
Potassium (g)			
Alcohol (g)			
Vitamins added where applicable			

Name of Lab: ALS

Lab accreditation:

Is the lab external or internal? External

Please attach nutritional results

Allergens and dietary data

ITEMS	Present In Product Y/N	Present on site Y/N	Cross contamination Y/N	Name or source
Nut and derived products	N	N	N	
Peanut and Peanut Oil (including ground nut/arachids)	N	N	N	
Cereals containing gluten (eg	Y	Y	N	Wheat Flour

Wheat/Rye/Barley/Oats and Bran)				
Crustaceans	N	N	N	
Egg	Y	Y	N	Pasteurised Egg in glaze
Soya and derivative products	N	N	N	
Milk, milk products, lactose (state if from cows or goats milk)	N	Y	N	Cows' Milk
Fish and fish derivatives	N	N	N	
Celery	N	N	N	
Mustard	N	N	N	
Sesame seeds and derivatives	N	N	N	
Sulphur dioxide and sulphites	N	Y	N	0.137ppm in finished product
Lupin	N	N	N	
Molluscs	N	N	N	
Additives	N	Y	N	Flavour enhancer: E621 mono sodium glutamate. Emulsifier: E451 sodium tripolyphosphate.
Preservatives	Y	Y	N	E250 sodium nitrite
Natural Colours	N	N	N	
Artificial Colours	N	N	N	
Nature Identical Colours	N	N	N	
Azo and Coal Dyes	N	N	N	
Artificial Flavourings	N	Y	N	
Natural Flavourings	Y	Y	N	Natural Flavouring within seasoning pack

Nature Identical Flavourings	N	N	N	
Flavour enhancers	Y	N	N	E621 mono sodium glutamate.
Sweeteners	N	N	N	
Palm Oil – where this is used it must be RSPO certified	Y	Y	N	Non hydrogenated palm oil within chicken bouillon in seasoning bag. RSPO SG/MG.
MSG (mono sodium glutamate)	Y	Y	N	E621 mono sodium glutamate in recipe.
Hydrolysed Veg Protein	N	N	N	
Hydrogenated Vegetable Fat	N	N	N	
BHA (Butylated Hydroxyanisole)/BHT (Butylated Hydroxtoluene)	N	N	N	
Corn/Maize and Derivatives	Y	Y	N	Maltodextrin and dextrose within seasoning bag derived from maize.
Coconut and derivatives	N	N	N	
Yeast	Y	Y	N	Yeast Extract with Chicken Bouillon in seasoning bag.
Animal Products: Beef, Lamb, Pork, Poultry.	Y	Y	N	Pork
Ingredient derived from animal origin	Y	Y	N	Pork
Gelatine	Y	Y	N	Pork Gelatine
Caffeine	N	N	N	

Genetic Modification:

Genetic Modification	Yes/No	Details
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Does the product contain any genetically modified DNA or protein?	No	
Does the product contain any ingredients or derivatives which although produced from a GM crop do not contain genetically modified DNA or protein?	No	
Is the product prepared using GM derived enzymes or cultures?	No	
Provide IP certification scheme for ingredients at high risk of potential GM contamination	N/A	

Process and HACCP

Please outline process steps for manufacture and indicate CCPs

Please refer to Process Flow

Process stage	Hazard	Control Measure	Critical Limit	Monitoring	Action (if out of spec)
CCP 1 – Oven Exit	Survival of vegetative pathogens e.g. Salmonella spp, E.coli, Listeria spp, Staph. aureus, Clostridium botulinum, Clostridium perfringens, Bacillus cereus due to inadequate baking temperature	All product must pass through a functioning oven	Site Target: Core temperature of product must be minimum 82°C Critical Limit: Core temperature of product must be minimum 70°C for 2 minutes	Temperature checks hourly or for every new product	Stop production and inform team leader. HOLD all product since the last satisfactory check. Engineers to adjust/repair. Record all actions on CCP documentation. Any product that has not met the critical limit will be rejected and managed through the non-conforming

					product procedure
CCP 2a – Jelly Transfer to High Risk	Survival of vegetative pathogens e.g. Salmonella spp, E.coli, Listeria spp, Staph. aureus, Clostridium botulinum, Clostridium perfringens, Bacillus cereus, due to inadequate jelly heating	Jelly must be heated to 85°C for 6 minutes before being transferred	<p>Site Target: The temperature of jelly must reach a minimum of 85°C for 6 minutes before being transferred</p> <p>Critical Limit: Temperature of jelly on transfer must be minimum 70°C for 2 minutes</p>	Temperature checks every jelly make up and every transfer.	<p>Do not transfer jelly. Stop production and inform team leader. HOLD all product since the last satisfactory check. Engineers to adjust/repair. Record all actions on CCP documentation. Any product that has not met the critical limit will be rejected and managed through the non-conforming product procedure</p>
CCP 2b – Jelly Holding / Jelly Header Tanks	Growth of spore forming pathogens e.g. Clostridium botulinum, Clostridium perfringens, Bacillus cereus, due inadequate holding temperatures of jelly	Jelly must be held at 80°C.	<p>Site Target: Temperature of jelly when holding must be minimum 80°C.</p> <p>Critical Limit: Temperature of jelly must be minimum 70°C for 2 minutes</p>	Temperature checks every 30 minutes or at the start of each product run	<p>Stop production and inform team leader. HOLD all product since the last satisfactory check. Engineers to adjust/repair. Record all actions on CCP documentation. Any product that has not met the critical limit will be rejected and</p>

					managed through the non-conforming product procedure
CCP 3 – Chilling to <5°C within 4 hours	Growth of spore forming toxigenic pathogens e.g. Clostridium botulinum, Clostridium perfringens, Bacillus cereus and consequent toxin production, due to inadequate cooling temperatures within specified time	All product must be cooled to <5°C within 4 hours (done in conjunction with Spiral and Final coolers)	<p>Site Target: Core temperature of product must be <5°C within 4 hours post final coolers/spiral chilling</p> <p>Critical Limit: Core temperature of product must <5°C within 6 hours post final coolers/spiral chilling</p>	Temperature checks every 30 minutes and at the start of each product run	<p>Stop production and inform team leader. HOLD all product since the last satisfactory check. Engineers to adjust/repair. Record all actions on CCP documentation. Any product that has not met the critical limit will be rejected and managed through the non-conforming product procedure</p>
CCP 4 – Metal Detection	Survival of metallic foreign bodies due to failure of the metal detector	Metal detectors tested at start up, every hour and end of run	<p>Lines PL1, PL2, 7, 9, 10, 11 and 12 use 1.5 mm ferrous, 2.0 mm non-ferrous, 3.5 mm stainless steel.</p> <p>Lines 14 and 15 use 2.5 mm ferrous, 3.0 mm non-ferrous, 5.0 mm stainless steel.</p>	Metal detector checks at start, hourly and end of run of each wrap run	<p>If fail at start up do not wrap product and ask for engineering assistance. If fail at an hourly check or end of run ask for QA assistance. All product since last successful check will be placed on HOLD pending re-metal detection</p>

Product tests:

Microbiological standards

Microorganism	Target	Reject	Frequency	Method
Bacillus cereus	<100	>10000	Monthly	
Enterobacteriaceae	<100	>100	Monthly	
Staphylococcus aureus	<20	>20	Monthly	
E.Coli	<10	>10	Monthly	
Listeria spp	ND in 25g	report if detected	Monthly	
Listeria spp enumeration	<10	>10	Monthly	
Salmonella spp	ND in 25g	report if detected	Monthly	

Name of Lab: ALS

Is it external or internal? External

Lab accreditation:

Chemical standard:

Test	Target	Tolerance	Frequency	Method
Full Nutritionals			Annually	

Product Claims

Claim	Yes/No	Certification	Verification of Claim (Controls/Analysis)
Vegetarian	No		
Vegan	No		
Gluten free	No		
Lactose free	No		

Kosher	No		
Halal	No		
High Fibre	No		
High Protein	No		
Low Carbs	No		
Low saturated fat	No		
Source of vitamin B12 and Iron	No		
MSC	No		
PGI/PDO	No		
Organic	No		
GMO free	No		

Attach current certification and validation where applicable

Packaging

Overall packaging description: Each pie individual flow wrapped, 48 packs per outercase

Primary packaging

Component	Material	Gauge	Weight	Dimension	Tamper evidence	Recyclable (yes/no)
Film	Plastic OPP	25 micron	1.6g	260x150mm	Yes	Yes – Recycle with bags at large supermarket
Supplier	Country of origin	Third party accreditation	Certification (eg FSC)	% Recycled Content Plastic		
Coveris Burnley	UK		N/A	N/A		

Secondary packaging

Component	Material	Gauge	Weight	Dimension	Tamper evidence	Recyclable (yes/no)
Outercase	Corrugated Board	474 GSM	302g	325 x 320 x 155mm	Taped	Yes
Supplier	Country of origin	Third party accreditation	Certification (eg FSC)	Additional information		
Sheard Packaging	UK		N/A	N/A		

Pallet configuration:

Number of units per case: 48 individually wrapped pies per case