



The Supreme Sausage Manufacturer
MILLENNIUM WAY, HIGH CARR BUSINESS PARK,
NEWCASTLE-UNDER-LYME, STAFFS, ST5 7UF

PRODUCT SPECIFICATION

PRODUCT CODE: GR63PK
NAME OF PRODUCT: Gastro Pork Sausage
DESCRIPTION OF PRODUCT: Oven Cooked, Gastro Pork Sausage – 63g +/- 3g
INGREDIENT DECLARATION: Pork (80%), Water, Rusk (**WHEAT** Flour (Fortified With Calcium Carbonate, Iron, Niacin, Thiamin), Raising Agent (Ammonium Hydrogen Carbonate)), Pork Fat, Potato Starch, Salt, Dextrose, Flavourings, Yeast Extract (Yeast, Salt), Onion Powder, Stabiliser (Sodium Triphosphate), Spices (Coriander, Nutmeg), Preservative (Sodium Metabi**SULPHITE**), Herb, Antioxidant (Ascorbic Acid).
For Allergens see Ingredient in BOLD

RECIPE IN PERCENTAGES

JTB Approved 80vl Fresh Pork Trim, Shoulder, Belly	36.6%
JTB Approved 50vl Frozen Pork Trim	43.3%
Water	9.7%
Rusk	4.7%
Seasoning	4.5%
Rusk (Superfine)	1.2%

MANUFACTURING PROCESS:

The meat used to manufacture this product is delivered in fresh (0-5°C or below) and frozen (-18°C or below). The fresh meat is stored in a chiller and the frozen meat is stored in a cold store until they are required for use in production. The temperatures of the chiller and the cold store are monitored continuously. Once required for use in production, the frozen meat is tempered to an approximate temperature of -12°C before it is used and the fresh meat is used immediately upon removal from the chiller.

The frozen meat is deboned; block flaked and weighed to the correct batch size. The fresh meat is weighed to the correct batch size and is placed into the mince mixer, along with the frozen meat. The meats are minced through an 8mm mince plate, down to 5m and are returned to the mince mixer, where they are mixed, whilst all of the remaining ingredients are added. Once the timer has elapsed, the completed mix is discharged, through an 8mm mince plate, with a degridle head, into a clean, stainless steel tote bin.

The tote bin of sausage meat is transferred to the Handtmann filler, where it is manufactured into sausages. The weights of the sausages are constantly monitored and recorded, by trained machine operatives or Quality Control, throughout production.

Once production is complete, the product is covered with a blue liner, is dated and is transferred to the chiller area of the cooking plant.

COOKING PROCESS

The sausages are stored chilled (0°C -5°C or below) until required by production for cooking. Once required, the sausages are transferred to the low risk production area and are placed onto the inline fryer; where they are cooked until an internal core temperature of 75°C and colour is achieved. The sausages are then transferred to the spiral freezer by stainless steel transfer belt. The transfer and primary packing areas are High care and have filtered (F4 & F8) positive air pressure.

The product is spiral frozen and weighed into printed, food grade, polythene bags. The bags are labelled, heat sealed and transferred to low care secondary packing via the X-Ray detection system. The bags are then boxed (10 x 1kg) and are palletised (77 boxes per pallet). The product is then allergen labelled and transferred to the cold store prior to despatch.

GM DATA: This product is manufactured using ingredients that are GM free.

DECLARED MEAT CONTENT: 80% Pork

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COUNTRY OF ORIGIN RECIPE:

INGREDIENT	COUNTRY OF ORIGIN
JTB Approved 80vl Fresh Pork Trim, Shoulder, Belly	UK
JTB Approved 50vl Frozen Pork Trim	UK
Water	Severn Trent
Rusk	Please see rusk country of origin breakdown
Seasoning	Please see seasoning country of origin breakdown
Rusk (superfine)	Please see Rusk (Superfine) country of origin breakdown

(SEASONING) COUNTRY OF ORIGIN BREAKDOWN

INGREDIENT	COUNTRY OF ORIGIN
Potato Starch	Germany, Denmark
Salt	Poland, Germany, Netherlands, France, Spain
Dextrose	UK, Belgium, Hungary, Germany, France, Italy, Spain
Flavourings	UK, India, Netherlands
Yeast Extract	Germany
Onion Powder	Netherlands, France
Stabiliser	Germany, Belgium
Spices	Indonesia, Egypt, Morocco, Spain, India, Ukraine, Russian Federation, Syria
Rusk	UK, Norway
Preservative	Italy
Herb	Turkey
Antioxidant E300	China

(SEASONING) ADDITIVES LIST:

E Number	Name of Additive	Ingredient Additive Present in	Quantity in Finished Product mg/kg	Function in ingredient
E220	Sulphur dioxide	E223	676.7217	Carryover
E223	Sodium metabisulphite	Added	1024.965	Preservative
E300	Ascorbic acid	Added	324.99	Antioxidant
E450 (iii)	Tetrasodium diphosphate	Added	1374.975	Stabiliser
E535	Sodium Ferrocyanide	Salt	4.4127	Anti-caking agent

COUNTRY OF ORIGIN RUSK

INGREDIENT	COUNTRY OF ORIGIN
Wheat flour	UK, Germany, France, Belgium, Netherlands
Raising Agent (E503)	Germany

(RUSK) ADDITIVES LIST:

E Number	Name of Additive	Ingredient Additive Present in	Quantity in Finished Product mg/kg	Function in ingredient
E170	Calcium Carbonate	Wheat flour	140.906	Nutritional Supplement
E503	Ammonium Carbonate	Raising Agent in rusk	33.041	Processing Aid
E504	Magnesium Carbonate	E503 within rusk	0.329	Processing Aid

COUNTRY OF ORIGIN RUSK (Superfine)

INGREDIENT	COUNTRY OF ORIGIN
Wheat flour	United Kingdom, Germany, France, Belgium, Netherlands
Salt	UK
Raising Agent E503	Germany

(RUSK - SUPERFINE) ADDITIVES LIST:

E Number	Name of Additive	Ingredient Additive Present in	Quantity in Ingredient mg/kg	Function in ingredient
E535	Sodium Ferrocyanide	Salt	<0.12	Processing Aid
E170	Calcium Carbonate	Wheat Flour	35.22	Nutritional Supplement
E503	Ammonium Carbonate	E503	85.164	Processing Aid
E504	Magnesium Carbonate	E503	0.864	Processing Aid

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SKIN TYPE: Natural Hog Casing

TARGET WEIGHT: 63g +/- 3g

PACKAGING UNIT WEIGHT: 1kg per bag
10 x 1kg per box

PALLET QUANTITY: 77 boxes per pallet
7 layers per pallet
11 boxes per layer

STORAGE/ INSTRUCTIONS: Store -18°C

BATCH CODING SYSTEM: Label on bag/box

BEST BEFORE: 12 months from date of production

SUITABILITY DATA:

Suitable for: = Yes Unsuitable for = No

Ova-Lacto Vegetarians No
Vegans No
Coeliacs No
Kosher No
Halal No

INTOLERANCE DATA:

Is the product free from?

Allergen	Present in Recipe	Absent in Recipe	Present on Site	Source of Allergen
Gluten	√		√	Present in Seasoning
Wheat/Wheat products	√		√	Present in Seasoning
Barley/Barley Products		√	√	Present in other seasoning – full clean down in place
Crustaceans and products		√		
Molluscs and Products		√		
Eggs and Egg products		√	√	Present in recipes on site full clean down in place
Fish and Fish products		√		
Peanuts and products		√		
Lupin and Products		√		
Soya Beans and products		√	√	Present in other seasoning – full clean down in place
Milk/Milk products		√	√	Present in other seasonings – full clean down in place
Nuts and Nut products		√		
Celery/Celery products		√		
Mustard/Mustard products		√		
Sesame Seeds/products		√		
Sulphites >10ppm	√		√	Present in seasoning
Animal/Animal products				
Beef/Bovine products		√	√	Present in other recipes – full clean down in place
Pork/Pork products	√		√	Present in recipe
Lamb/Lamb products		√	√	Present in other recipes – full clean down in place

DEFECT TOLERANCES:

Bone	<5mm 4 per 10kg > 5mm Reject
Gristle	<5mm 4 per 10kg > 5mm Reject

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MICROBIOLOGICAL SPECIFICATION:

	Frequency	Target	Acceptable Upper Limit	Unacceptable
TVC	As per sampling plan	<1000 cfu/g	5000 cfu/g	>5000 cfu/g
Enterococci	As per sampling plan	<10 cfu/g	50 cfu/g	>50 cfu/g
E. coli	As per sampling plan	<20 cfu/g	50 cfu/g	>50cfu/g
Staph. Aureus	As per sampling plan	<20 cfu/g	100 cfu/g	>100 cfu/g
Salmonella	As per sampling plan	ND in 25g	ND in 25g	Detected in 25g
Listeria	As per sampling plan	ND in 25g	ND in 25g	Detected in 25g

LEAD TIME FOR ORDERING OF PRODUCT

	LEAD TIME	APPLICABLE TO CUSTOMER
Standard Product	10 – 12 working days (excluding Weekends and Bank Holidays)	√
Positive Release Product	15 working days (excluding Weekends and Bank Holidays)	
Nutritional Release Product	15 working days (excluding Weekends and Bank Holidays)	

NUTRITIONAL INFORMATION

NUTRITIONAL INFORMATION – TYPICAL PER 100 GRMS		
	Per 100g	Source of Information
Moisture		103°C Oven
Protein	13.9	Dumas Method
Sodium		Flame Photometry
Sodium as Salt	1.91	Analyzed
Total Fat:	19.7	NMR (Nuclear Magnetic Resonance)
Of which Saturates :	7.84	Gas Chromatography
Mono-unsaturates:		Gas Chromatography
Poly-unsaturates:		Gas Chromatography
Trans-unsaturates:		Gas Chromatography
Fibre		AOAC
Total Carbohydrate (by difference)	7.5	Analyzed
Energy as kcalories (kc/100g)	262	Analyzed
Energy as kjoules (kj/100g)	1089	Analyzed


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This Specification has been agreed by both parties:-

SIGNATURE: On behalf of James T Blakeman & Co Ltd	
PRINT :	Claire Scott
POSITION :	Technical Manager
DATE :	19.10.2015

COMPANY NAME :	
SIGNATURE :	
PRINT :	
POSITION :	
DATE :	

If this specification is not returned signed within fourteen days it will be deemed to be formally agreed by both parties.

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