

Finished Product Specification

Noodle

Finished Product Details:	
Product Name:	Lucky Boat No1 Noodles
Legal Name:	Lucky Boat No1 Thick Noodles
Product Code:	63030
Barcode:	5015821157401
Product Description:	Yellow in colour, dry nest of fine noodles.
Product RTE (Ready to Eat)	Product is NOT ready to eat.

Unit Weight:				
Target:	4kg			
Tolerance:	T1	3.940kg	T2	3.880kg

Supplier Contact Information:				
Head Office Address:				
Westmill Foods, 26 Crown Road, Enfield, Middlesex, EN1 1DZ.				
Manufacturing Site Address:				
Westmill Foods, 2 Main Avenue, Trafford Park, Manchester, M17 1FD.				
Contacts:	Name	Email	Mobile No	Telephone No
Quality/Technical:	Lucy Ozanne	Lucy.Ozanne@westmill.co.uk	07720 657 407	0161 886 2959
Customer Service:	ATC	Westmill.consumercare@alliedbakeries.co.uk	-	0800 090 2385
Specifications:	Sheena Belton Antony Chubb	Sheena.Belton@westmill.co.uk Antony.Chubb@westmill.co.uk	07922 379 360	0161 886 6911

Product Information:	
Noodle Strand Dimensions:	
Length:	29.5" (62.5-87.5cm)
Thickness:	1.26mm x 2mm

Coding Details:	
Coding Example:	DD/MM/YY

Shelf Life & Storage Instructions:	
Shelf Life (From Manufacture) (Days):	365
Shelf Life (From Opening) (Days):	273
Minimum Shelf Life on Delivery (Days):	273
Is this product Suitable for Freezing?	No
Storage Conditions:	Store off the floor in a cool dry place at ambient temperature
Storage In Transit:	Store off the floor in a cool dry place at ambient temperature
Storage Once Opened:	Store in a cool dry place, off the floor, at ambient temperature within an airtight container.

Ingredient Declaration:
Wheat Flour (with Calcium, Iron, Niacin and Thiamin (B1)), Salt, Colours (Paprika Extract and Carotenes), Acidity Regulators (Sodium Carbonate, Potassium Carbonate, Citric Acid), Antioxidant (Ascorbic Acid).

Ingredient List:			
	% QUID	Country Of Origin	E Number
Wheat Flour (with calcium carbonate, iron, niacin, thiamin)	75-80	UK	
- Calcium Carbonate	0.1	UK	E170
- Iron	0.1	USA	
- Niacin	0.1	India	
- Thiamin	0.1	China	
Water	20-23	UK	
Salt	<2	UK	Contains anti-caking agent (E535)
Natural Colour - Paprika/Carotene Blend	<1	UK	E160c & E160a(iii)
Potassium Carbonate	<1	Italy/France	E501
Citric Acid	<1	Belgium/Austria	E330
Sodium Carbonate	<1	UK	E500
Ascorbic Acid	<1	China	E300

-Please note **Wheat Gluten** may be added to flour within this product to meet protein specification. Gluten may originate from any of the listed countries: UK, Belgium, France, Germany, Lithuania. All Gluten is fully approved.

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Allergy Advice & Claims:

For allergens, including cereals containing gluten, see ingredients in bold.
Ingredients used by Westmill are sourced from Approved Suppliers.

Nutritional Data:	per 100g	Determined By:	As Sold/Consumed
Energy (kj)	1507	Calculation	Sold
Energy (kcal)	355	Calculation	Sold
Fat (g)	1.1	Analysis	Sold
of which saturates (g)	0.2	Analysis	Sold
of which mono - unsaturates (g)	-	-	-
of which polyunsaturates (g)	-	-	-
Carbohydrate (g)	71.6	Analysis	Sold
of which sugars (g)	1.7	Analysis	Sold
of which polyols (g)	-	-	-
of which starch (g)	-	-	-
Fibre	3.7	Analysis	-
Protein (g)	12.9	Analysis	Sold
Salt (g)	1.7	Calculation	Sold

Nutritional analysis is carried out by a UKAS accredited Laboratory nominated by Westmill.

Does the product or any of its sub-components contain any of the following:	Product		Used on same line		Used in factory	
	Yes	No	Yes	No	Yes	No
Celery and products thereof	-	✓	-	✓	-	✓
Cereals containing gluten and products thereof	✓	-	✓	-	✓	-
Crustaceans and products thereof	-	✓	-	✓	-	✓
Eggs and products thereof	-	✓	✓	-	✓	-
Fish and products thereof	-	✓	-	✓	-	✓
Milk and dairy products (including lactose)	-	✓	-	✓	✓	-
Mustard and products thereof	-	✓	-	✓	-	✓
Nuts and nut products	-	✓	-	✓	-	✓
Peanuts and products thereof	-	✓	-	✓	-	✓
Sesame seeds and products thereof	-	✓	-	✓	✓	-
Soybeans and products thereof	-	✓	-	✓	✓	-
Sulphur dioxide and sulphites at concentrations of more than 10 mg/kg or 10 mg/litre *	-	✓	-	✓	✓	-
Lupin and products thereof	-	✓	-	✓	-	✓
Molluscs and products thereof	-	✓	-	✓	-	✓

Does the product or any of its sub-components contain any of the following:	Product		Used on same line		Used in factory	
	Yes	No	Yes	No	Yes	No
Shellfish	-	✓	-	✓	-	✓
Mollusc	-	✓	-	✓	-	✓
Other fish	-	✓	-	✓	-	✓
Pork	-	✓	-	✓	-	✓
Lamb	-	✓	-	✓	-	✓
Beef	-	✓	-	✓	-	✓

Suitable for:	Yes / No	Comments
Vegetarians	Yes	Not certified
Ovo-Lacto Vegetarians	Yes	Not certified
Vegans	Yes*	Please see statement below*
Coeliacs	No	Contains wheat, gluten.
Diabetics	No	Not tested for
Kosher	No	Not certified
Halal	No	Not certified

Products and packaging supplied by Westmill do not contain any genetically modified materials.

*Westmill, Trafford Manufacturing Site, produces Egg and Non-egg containing noodles. Due to commercial considerations it is not possible to schedule the production of non-allergenic products (i.e. non- egg containing) at the start of the production week. Westmill, Trafford Manufacturing Site, has in place a full changeover matrix and procedure and a full

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validation study is completed annually. Although our ingredients are suitable for vegans we don't hold any certification for them.



Process Information:			
Test	Frequency	Standards	Tolerance
Steaming	Every 1 hour	>92°C	N/A
Sieve Check	Daily	1.0mm Mesh	Absence of Foreign Bodies
Water Activity	Hourly for the first 3 hours then every 3 hours.	Aw >0.2 - <0.6	>0.2 - <0.6
Metal Detection	Hourly	3.0mm ferrous, 3.5mm non-ferrous and 3.5mm s/steel	No rejects
Kan Sui Tank Filter	After every batch of Kan Sui	1.5mm Mesh	Absence of Foreign Bodies

QC Checks			
Test	Frequency	Standards	Tolerance
Raw Materials	Every delivery	Within spec.	N/A
Weighing Ingredients	Every batch	Correct amount	N/A
Mixing Time	Every batch	8-12 minutes	Until the required texture is attained
Size Checking	Every batch	According to spec	+/- 50mm
Date Coding	One case per pallet by visual checking	Correct date code	N/A
Palletising	Continuous	No damage to the pallet & packaging	N/A

Microbiological Standards:		
	Target	Frequency
TVC @ 30°C	≤1000	Annually
Enterobacteriaceae	≤100	Annually
Salmonella	Not Detected in 50g	Annually
Staph. Aureus	≤20	Annually/Per clean down
Escherichia coli	≤10	Annually
Bacillus Cereus	≤20	Annually
Clostridium perfringens	≤10	Annually
Yeasts	≤20	Annually
Mould	≤20	Annually

Prior to a deep clean, noodle dough is sampled for Staphylococcus aureus analysis. This area is considered to have the greatest risk of Staphylococcus aureus growth. The testing is undertaken for monitoring purposes and is not a positive release mechanism.

Microbiological analysis is carried out by a UKAS accredited Laboratory nominated by Westmill.

Attribute (Dry)	Green	Red
Appearance	In the dry state the noodles form a 'nest' in which the noodles are stuck together to form a discreet unit. The individual noodles are rigid and fragile. The noodles are bright yellow in colour.	Dull yellow colour. Excessive fading. Excessive patchiness throughout nest.
		
Texture	In the dry state the noodles are rigid and should remain in nest form.	The noodles are soft in the centre and are not rigid.
Aroma	The dry noodles should have a mild cereal note.	Any off or unexpected aromas, e.g. rancidity or taints.

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Attribute (Cooked)	Green	Red
Appearance	Cooked noodles are flexible and move freely over each other. The noodles are bright yellow in colour.	Starchy/Sticky clumped noodles. Noodles are not uniform in length. Noodles are rigid and excessively rough. Excessively dark noodles. Excessively pale noodles. Any incorrect cut noodles.
Texture	The cooked noodles should exhibit good elasticity, have a firm bite and a smooth mouth feel.	Soggy, non-elastic, stodgy, sticky noodles that clump together in a mass with no bite.
Aroma	The cooked noodles should have a mild cereal note.	Any off or unexpected aromas. Rancidity or taints.
Flavour	Cooked noodles are used as a carrier for various sauces and flavours. In themselves they are fairly bland, although a sensitive palate may detect a slight saltiness and mild wheat notes.	Any sour or off notes. Rancidity or taints.

Cooking Methods & Instructions:

1. Place the noodles in boiling water.
2. Remove from heat and leave them to soak for 8 minutes.
3. Stir frequently to separate noodles.
4. Drain and refresh by running under cold water.

Stir Frying: Place the noodles in boiling water. Remove from heat and leave them to soak for 7 minutes. Stir frequently to separate noodles. Drain and add the noodles to stir fry and heat for 1 minute. Serve immediately.

Packaging Details:

	Primary	Secondary	Tertiary
Description	Cardboard Box	-	Pallet/Pallet Wrap/Clear Tape
Material	Corrugate	-	Wood/-/-
Weight	350g	-	-
Gauge	-	-	N.A/ 17µm/-
Dimensions	290x250x332mm	-	1000 x 1200mm/ 500mm width/-
Recyclability	100%	-	-

Packing Details:

Units per Pack	-
Packs per Outer	1
Outers per Layer	16
Number of Layers	4
Packs Per Pallet	-
Is double stacking permitted?	No
Finished Pallet Weight	-
Finished Pallet Height	1.5m

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Warranty Statement:

The foodstuff, packaging and labelling conform to all relevant UK and EU legal requirements at the time of supply.

The product is prepared, processed, packaged and handled under strict hygiene conditions consistent with the principles of good manufacturing practice.


The product has not been treated by irradiation.

Materials shall be transported in clean vehicles of a high standard suitable for the transportation of food. They shall be free from infestation and contamination and provide the appropriate conditions of temperature.

The contents of this specification are confidential and should not be disclosed to a third party without the written approval of the Westmill Technical Manager.

There shall be **NO DEVIATION** from this specification without prior agreement with Westmill.

Westmill Authorisation:

Name:	Position:	Signature:	Date:
Lucy Ozanne	Technical Manager		22.01.20

Customer Acceptance:

Please sign and return to Westmill. Failure to do so within 14 days of receipt of the specification will signify acceptance of the contents herein.

Signed on behalf of (Company Name)

Name:	Position:	Signature:	Date:

Document Control:

Version:	Effective From:	Status:	Comments:
12	05/05/2016	Superseded	Nutritional results amended. Quality characteristics, packaging & finished product appearance added.
13	05/04/2019	Superseded	Review and update to new Westmill format. Addition of Vegan statement. Allergens updated, Celery and Mustard no longer handled on site. Contacts updated.
14	17/06/2019	Superseded	Flour countries of origin updated. Addition of gluten countries of origin statement. Allergens handled on site updated. Contacts updated.
15	04/07/2019	Superseded	Flour type changed resulting in nutritional amends, countries of origin updates and packaging updates. Ingredient declaration changed, now includes Ascorbic Acid.
16	08/10/2019	Approved	Barcode added. Specification contact updated. Ingredient declaration updated.

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