Rowse Honey Ltd
QUALITY ASSURANCE MANUAL
QAR 6-05 ROWSE SPECIFICATION

Product:	Hyve Pure Runny Honey 720g	**Product Code:**	28305
Spec Version No:	2	**Specification Issue Date:**	01/02/2022

1.0 SUPPLIER INFORMATION

Supplier Name	Rowse Honey Ltd / Valeo Foods UK (Valeo Foods UK is a trading name of Rowse Honey Limited)		
Supplier Address	Moreton Avenue, Wallingford, Oxfordshire, OX10 9DE		
Phone Number	01491 827 400		
Contacts	**Technical**	**Commercial**	**Specifications**
Contact Name	Gordon Wood / Ghazaleh Saberioon	Hanenne Madi	Besiana Chadzynski
Phone Number	07730696958 (Gordon) / 07919255205 (Ghazaleh)	01491 827458	01491 827400
E-Mail Address	gordon.wood@valeofoods.co.uk / ghazaleh.saberioon@valeofoods.co.uk	Hanenne.Madi@valeofoods.co.uk	Specification.technologist@valeofoods.co.uk
Emergency Contact Details	Gordon Wood 07730696958		

2.0 PRODUCT INFORMATION

Product Title	Hyve Pure Runny Honey 720g
Sub Text / Marketing Text	N/A
Strength Guide	N/A
Label Barcode	5011273083053
Outer Case Label Barcode	5011273683055
Unit Weight	720g
Origin Declaration	A blend of non-EU honeys. Packed in the UK.
Warning	**UNSUITABLE FOR INFANTS UNDER 12 MONTHS**
Date Code Location	Neck of Bottle
Product Coding Format	MMM/YYYY, 4 Digit Production code, line ID and packing time Example: JAN 2022 2452B 14:12 Where: Jan 2022 = BBE date
	
Product Life From Packing	BBE 18 months

Minimum Life On Delivery	13 months
Storage Conditions	Ambient 18- 24 °C, away from direct sunlight and strong odours. Clear honey may begin to crystallise if stored at low temperatures
Product Life Once Opened	Use by the end of BBE date
Post Opening Storage Conditions	Ambient 18- 24 °C, away from direct sunlight and strong odours. Clear honey may begin to crystallise if stored at low temperatures
Suitable For Freezing	No
Delivery Conditions	Clean dry area, delivered in ambient 18 – 24 °C

3.0 RECIPE & INGREDIENTS

Ingredient	% in recipe	Supplier	Country of manufacture	Country of origin
Honey	100	Rowse approved suppliers	UK	Argentina, Australia, Brazil, Chile, China, Guatemala, Mexico, New Zealand, Uruguay, Vietnam
Ingredient Declaration	N/A			

4.0 NUTRITIONAL INFORMATION

NUTRIENT	per 100g	Source of Data
Energy kJ	1398	Analysis
Energy kcals	329	
Fat (g)	<0.5	
of which saturates (g)	0.2	
Carbohydrate (g)	81.5	
of which sugars (g)	80.8	
Fibre (g)	<0.5	
Protein (g)	<0.1	
Sodium (mg)	12.0	
Salt (sodium x 2.5) (g)	0.03	

5.0 ALLERGENS AND SENSITIVE INGREDIENTS

5.1 Allergens

ALLERGEN	PRESENT IN PRODUCT (Yes/No)	PRESENT ON SITE (Yes/No)	CONTAMINATION RISK PRESENT (Yes/No)	DETAILS
Cereals containing gluten (e.g. wheat, spelt, rye, barley, oats etc)	No	No	No	
Crustaceans (e.g. prawns, crab, lobster, crayfish)	No	No	No	
Egg	No	Yes	No	

ALLERGEN	PRESENT IN PRODUCT (Yes/No)	PRESENT ON SITE (Yes/No)	CONTAMINATION RISK PRESENT (Yes/No)	DETAILS
Fish	No	No	No	
Peanuts	No	No	No	
Nuts; namely almond, hazelnut, walnut, cashew, pecan nut, Brazil nut, pistachio nut, macadamia nut	No	No	No	
Soybeans	No	Yes	No	
Milk (including lactose)	No	Yes	No	
Mustard	No	No	No	
Sesame	No	No	No	
Sulphur dioxide / sulphites, where added and at a level above 10ppb in the finished product.	No	Yes	No	
Lupin	No	No	No	
Molluscs (e.g. mussels, clams, oysters, scallops, snails and squid	No	No	No	
Celery	No	No	No	

5.2 Contains

INGREDIENT	PRESENT IN PRODUCT (Yes/No)	PRESENT ON SITE (Yes/No)	CONTAMINATION RISK PRESENT (Yes/No)	DETAILS
Maize	No	Yes	No	
Additives (declared additives or processing aids)	No	Yes	No	
Antioxidants	No	No	No	
Natural Colourings	No	No	No	
Artificial Colourings (incl. NI)	No	No	No	
Natural Flavourings	No	Yes	No	
Artificial Flavourings (incl. NI)	No	No	No	
Flavour Enhancers	No	No	No	
Preservatives	No	Yes	No	

INGREDIENT	PRESENT IN PRODUCT (Yes/No)	PRESENT ON SITE (Yes/No)	CONTAMINATION RISK PRESENT (Yes/No)	DETAILS
Sweeteners	No	No	No	
Alcohol (abv %)	No	Yes	No	

5.3 Other Considerations

	Yes / No	Details if Yes
Is the product packaged in Modified Atmosphere?	No	
Is this product treated using ionising radiation?	No	
Does this product contain Genetically Modified Ingredients?	No	
Is this product a possible source of phenylalanine?	No	
Is this product a possible source of histamines?	No	
Does the product contain hydrogenated fats?	No	
Does the product contain palm oil?	No	

6.0 SUITABILITY DATA

	Yes / No	Declared	Details
Suitable for Vegetarians	Yes	No	
Suitable for Vegans	No	No	Product of bees
Halal Certified	No	No	
Kosher Certified	Yes	No	
Suitable for Coeliacs	Yes	No	Naturally gluten free however not tested for it
Organic Certified	No	No	

7.0 PACKAGING

7.1 Packaging details

Packaging Item / Level	Specification	Dimension (mm)	Material	Weight (g)	% Recycled Content	Recyclable (Yes/No)
Primary	30% rPET Round beehive squeezy bottle Colour: transparent clear	Height 167 Length 80 Depth 58	70% PET 30% PCR	30	30	Yes
Primary	Cap Gold, screw on, flip top cap. Tamper evidence inside cap	Height 19.50 Diameter 40.8	Plastic PP	6	0	Yes
Primary	Label Front and Back self adhesive label	98 x 51.5	Paper, self adhesive	1	0	Yes
Secondary	Black Cardboard Tray	345 x 95 x 45	Cardboard	40	95	Yes
Secondary	Outer Case Label	102 x 76mm	Self-adhesive paper	1	0	Yes

	Self-adhesive white label for trays					
Secondary	Shrink wrap for trays Colour: Clear	525 mm width x 35 micron	Plastic – LDPE	25	0	Yes

7.2 Palletisation Information

Units per outer	6
Outers per layer	37
Layers per pallet	5
Cases per pallet	185

8.0 FINISHED PRODUCT STANDARDS

8.1 Organoleptic Evaluation

	Acceptable	Unacceptable
Appearance	• The fill should be clean, level and reach the bottom of the neck ring. Air bubbles may be present in the shoulder of the bottle, which may look like slight foaming. • The ring of bubbles should be no more than 5mm thick. • There should be no particulates and on opening the jar, the product should have a glossy surface. • There should be minimal small air bubbles and no large bubbles present. • The product must be fluid, thin liquid which is consistent and pourable. • Free from foreign bodies.	• Low fill level. • Excessive air bubbles • Product is very thick and not poura-ble. • Moisture reject >20.0%
Colour	• Consistent medium amber colour and varies from being clear to very slightly opaque. • The product colour may vary slightly from batch to batch. • Colour lovibond comparator accept: 20-70mm pfund	• Very pale or dark, or very cloudy. • Colour lovibond comparator reject: <20 or >70mm pfund
Texture	• The honey is a viscous, pourable liquid. It dis-solves easily in the mouth and is not tacky and sticky. • Smooth and not grainy. • Crystallisation may occur over life.	• Larger sugar crystals in mouthfeel • Fully crystallized
Aroma	• A mild, sweet typical honey aroma that is not fermenting.	• Non honey aroma • Off odors present
Flavour	• A mild, sweet, candyfloss flavour. • Acidity should not dominate but may be pre-sent in the aftertaste. • The flavour may vary slightly from batch to batch.	• Tastes burnt. • Excessive acidic notes dominate. • Off, fermented or bitter flavours pre-sent.

8.2 Quality Analysis

Test	Frequency	Method	Accept	Reject
HMF at time of packing	Every Batch	Spectrophotometer	≤ 40 mg/kg	>40 mg/kg
Colour	Every Batch	Lovibond Comparator	20-70 mmpfund	<20 / >70 mmpfund
Moisture	Every Batch	Refractometer	≤ 20 %	>20 %

8.3 Veterinary Residues

Test	Target	Reject	Method	Frequency
Chloramphenicol	0-0.3 ppb	>0.3 ppb	VETRES02	Routine sampling of honey by batch verification
Streptomycin	0-10 ppb	>10 ppb	VETRES05	Routine sampling of honey by batch verification
Tetracycline's	0-10 ppb	>10 ppb	VETRES11	Routine sampling of honey by batch verification
Sulphonamides	0-5 ppb	>5 ppb	VETRES03	Routine sampling of honey by batch verification
Nitrofurans	0-0.5 ppb	>0.5 ppb	VETRES08	Routine sampling of honey by batch verification
Macrolides	0-2 ppb	>2 ppb	VETRES09	Routine sampling of honey by batch verification
Nitroimidazoles	0-1 ppb	>1 ppb	Imid.P	Routine sampling of honey by batch verification
Trimethoprim	0-5 ppb	>5ppb	VETRES09	Routine sampling of honey by batch verification

All honey is sampled for Veterinary Residues/Antibiotic testing by an accredited, independent laboratory in accordance with the European Union and United Kingdom regulations. Antibiotic residue testing is based on risk assessment. Rowse may alter the testing suite due to changes within the risk assessment.
Evidence of homogenisation is provided prior to delivery; all homogenised loads are sampled as per guideline of the square root +1 of the number of barrels in a container. If it is not homogenised sampling is done on a risk assessment basis.

8.4 Other Contaminants

Pesticide testing is completed annually by the Honey Association and results are all within the tolerances set in Regulation (EC) 396 2005, foods which do not have an MRL for any particular pesticide there is a general MRL of 0.01mg/kg.

8.5 Microbiological Analysis

Test	Method	Frequency	Units	Target	Reject
TVC	TP4100	Quarterly	Cfu/g	<10000	>10000
Yeast	TP4109	Quarterly	Cfu/g	<1000	>1000
Mould	TP4109	Quarterly	Cfu/g	<1000	>1000

8.6 Other

Certificate of Conformance:	An annual certificate of conformance can be supplied by email upon request.
Laboratory Details:	Internal: CLAS Accredited External: UKAS Accredited

9.0 AUTHORISATION

NAME	SIGNATURE	POSITION	DATE
Nicola Smith		Senior Nutritional, Regulatory and Specification Technologist	01/02/2022

REFERENCE

The honey supplied in this product complies to the following documents.

Honey (England) Regulations 2015
EC Directive 2001/110/EC relating to honey with Directive 2014/63/EU amendments
EC Directive 2008/772/EC on the approval of residue monitoring plans submitted by third countries in accordance with Council Directive 96/23/EC
Commission Regulations (EU) No 37/2010 on pharmacologically active substances and their classification regarding maximum residue limits in foodstuffs of animal origin
CODEX Standard for Honey 12-1981

CRYSTALLISATION OF HONEY

Honey is a natural product completely free of additives of any kind. As such, its constituent parts are variable according to the floral and geographic origin of the plants visited by the bees. Approximately 80% of honey is invert sugar in various forms. The two main ones are fructose and glucose. As a general rule, those honeys which are high in glucose will crystallise readily, perhaps within a matter of weeks and sometimes, exceptionally quickly, even before the honey is extracted from the comb. Conversely, honeys which are high in fructose will stay liquid for a greater length of time and in some cases indefinitely. The main bulk of honeys will re - crystallise naturally within about six months.

When honey sets some of the glucose comes out of the solution and forms crystals. The process can be accelerated by keeping the honey at the optimum temperature for crystallisation and by starting off with a nucleus of crystals on which further crystals can grow. Other matter, such as pollen, can also act in the same way and cause the precipitation of crystals to be accelerated. The process can be reversed by warming the honey, thus melting the crystals, but they will usually form again within a short period of time. It always follows that a honey with very little pollen in it will stay liquid for a longer period of time.

It is important to realise that honey which crystallises naturally does so more slowly and the formation of the crystals is less controlled and results in a coarse texture. There is nothing wrong with the honey, it is perfectly edible, and the only difference between it and smooth spreadable set honey is that the latter has been crystallised under strictly controlled temperature conditions.

THE STORAGE OF HONEY

Honey is formed from nectar which is converted by the bee into a concentrated solution containing many sugars, but in the main glucose and fructose.

All honey should be stored in a clean warehouse away from strong odours and out of direct sunlight.

Clear Honey

Clear honey should be stored at 20°C (68F) on average, but no higher than 24°C (75F) or lower than 15°C (59F). Lower temperatures will hasten the appearance of glucose crystals which, although harmless, detract from the appearance of the product.

SUMMARY OF SPECIFICATION CHANGES

SPEC VERSION NO	DATE	SUMMARY OF AMENDS
2	02/02/2022	New Template and full specification review