Leathams
innovators in food

Product specification for

SMF016

LL ROAST SMOKED SALMON PIECES X 1KG

Product Specification SMF016

Supplier	Leathams Ltd
Country	United Kingdom
Supplier Address	Unit 10-12 The Circle, Queen Elizabeth Street, London, SE1 2JE

Product Record

Product Information		Supplier Information	
Leathams Item Code	SMF016	Supplier Name	Confidential
Item Name	LL ROAST SMOKED SALMON PIECES X 1KG	Leathams Supplier Code	Confidential
Supplier Product Code	Confidential	Supplier Type	Manufacturer
Legal Name	LL ROAST SMOKED SALMON PIECES X 1KG	EC Establishment Number	Confidential
Brand	Leathams Label	Third Party Accreditation	BRC A+
Sub Title	n/a	Secondary	Confidential
Item Weight (g)	1100	EC Establishment Number	Confidential
Ready Status	Ready To Eat	Third Party Accreditation	n/a
Temperature	FROZEN		

Ingredients SMF016

Ingredient declaration	Salmon (Salmo salar) 99% (FISH), Salt. Smoked with beechwood

Type	Ingredient	Ingr Weight	Ingr %	Declare Ingr	Quid	Origin	Country Of Origin	Ingr Supplier Name	Manufacturing Site	Country Of Manufacture	State	Max Life	Storage Temp	p H	Aw	Max Moisture	Min Salt	Process Heat Duration	Filling Conditions	Max Cooling Time	Micro	Washing Controls	Other Controls	Status Of Manu Area	Cust Reqs
Finished Product	LL ROAST SMOKED SALMON PIECES X 1KG	1000	100	n/a	-	Poland	Poland	Confidential	Confidential	Poland	Solid, hot smoked	12 months	Frozen	6.0 - 6.5	n/a	57-70%	1,8 - 2,5%	Hot smoked. Smoking the time of smoking 1h - 3h, Chamber temperature 30°C, steaming to obtain the value of 2.5 Lethal Rate inside for each detector placed in the core, Below the value of the 2.0 Lethal Rate inside crossing the critical limit CCP 5	n/a	Up to 4 hours to 2°C	n/a	n/a	n/a	High risk	N/A
Primary Ingredient	Salmon (Salmo Salar)	-	99	Yes	Yes	Norway	Norway	Confidential	Confidential	Norway	Raw	24 hours	0 - 5	n/a	n/a	n/a	n/a	n/a	n/a	n/a	No	n/a	n/a	High Care	N/A
Primary Ingredient	Salt	-	1	Yes	No	Germany, Denmark	Germany	Confidential	Confidential	Germany	Crystal	n/a	Ambient	n/a	n/a	n/a	0.999	n/a	n/a	n/a	No	n/a	n/a	High Care	N/A
Sub-Ingredient	NaCl	-	-	-	-	-	-	Confidential	Confidential	-	-	-	-	-	-	-	-	-	-	-	-	-	-		N/A
Sub-Ingredient	Ca	-	-	-	-	-	-	Confidential	Confidential	-	-	-	-	-	-	-	-	-	-	-	-	-	-		N/A
Sub-Ingredient	Water	-	-	-	-	-	-	Confidential	Confidential	-	-	-	-	-	-	-	-	-	-	-	-	-	-		N/A
Sub-Ingredient	Sulfur dioxide	-	-	-	-	-	-	Confidential	Confidential	-	-	-	-	-	-	-	-	-	-	-	-	-	-		N/A
Sub-Ingredient	E536-Potassium ferrocyanide (Anti-caking agent 10mg/kg)	-	-	-	-	-	-	Confidential	Confidential	-	-	-	-	-	-	-	-	-	-	-	-	-	-		N/A

Supply Chain Map SMF016

Type	Ingredient	Supplier Type	Accreditation	Risk Category	Risk Type	Identified Risk	Risk Mitigation Controls	Evidence
Finished Product	LL ROAST SMOKED SALMON PIECES X 1KG	Processor	IFS, BRC	n/a	Not applicable	n/a	n/a	n/a
Primary Ingredient	Salmon (Salmo Salar)	Producer	GG	low risk	Not applicable	n/a	n/a	n/a
Primary Ingredient	Salt	Processor	suppliers GFSI certificate	low risk	substitution	substitution of lower quality salt	cooperation with a certified manufacturer from the European Union, ingredient testing according to the schedule, quality assessment of deliveries	Ciech Saltz COID: 82670 (IFS); Dansk Salt COID: DNK-1-6756-011673 (FSSC22000)
Sub-Ingredient	NaCl				Not applicable			
Sub-Ingredient	Ca				Not applicable			
Sub-Ingredient	Water				Not applicable			
Sub-Ingredient	Sulfur dioxide				Not applicable			
Sub-Ingredient	E536-Potassium ferrocyanide (Anti-caking agent 10mg/kg)				Not applicable			

Food Intolerance SMF016

Suitable

Coeliacs	Yes
People who are lactose intolerant	Yes
People with a nut / seed allergy	Yes
Vegans	No
Vegetarians (Non-Vegan)	No

Certified

Halal	No
Kosher	No

Additives

This product does not contain Additives

Additive	Name	Function	Quantity PPM

Food Intolerance SMF016

Dyes

Does the product contain ?

Chilli powder, Curry powder, Paprika, Turmeric and seasonings since2003 are not permitted to contain the following illegal food dyes; Sudan I – IV, Butter Yellow, Metanil Yellow, Sudan Red B, Sudan Red 7B, Orange Red G, Rhodamine B, Orange II, Para Red, Toluidine Red, Sudan Red G. Nor are spices allowed to contain the following colours: Annatto, Bixin, Norbixin (European commission decision 2003/460/EC & 2004/92/EC)	No

Pesticides

We are aware of all relevant legislation in respect of pesticides controls and permitted maximum residue levels. We abide by these and any amendments to local, UK and EU Regulations. We are aware of the risk of counterfeit pesticides and will take all reasonable precautions to avoid their use. We will ensure that all produce supplied to/by Leathams has been grown in accordance with Good Agricultural Practice. We encourage implementation of appropriate Integrated Crop Management as part of the crop protection strategy. We will ensure that all produce supplied by us is grown with due regard to the environment, and that all reasonable care is taken to avoid pollution. We are confident in our technical knowledge regarding pesticide use and application. Where necessary, we use the services of a suitably qualified professional advisor. Pesticide applications are applied by operators who are competent and trained to the necessary standard. Where a national approval scheme exists, we only use pesticides approved for the specific crop application. All applications are in accordance with manufacturer's guidance. Where product is not grown by us and is bought from our supplier, we will check proposed pesticide usage (PPU) information to ensure that the relevant pesticide legislation is followed and that any customer specific instructions (as notified by Greencore) are implemented as required. Detailed pesticide application records (pre and post-harvest) are maintained for all crops. These records will be made available for inspection upon request and will be held for a minimum of 5 years.	Yes
Please confirm that you comply with the Maximum Residue Levels stated in EU Pesticide Database.	Yes

Food Intolerance SMF016

Other Ingredients

Name	Yes No	Source	Factory Site YN	Risk Cont Man Site
Legumes	No	n/a	No	-
Caffeine	No	n/a	No	-
Chocolate	No	n/a	No	-
Kiwi	No	n/a	No	-
Banana,blackberry,peach,tomato	No	n/a	No	-
Buckwheat	No	n/a	No	-
Barley	No	n/a	No	-
Rye	No	n/a	No	-
Yeast&derivatives	No	n/a	No	-
Maize&derivatives	No	n/a	No	-
Aspartame	No	n/a	No	-
Fruit,vegetablesandtheirderivatives	No	n/a	No	-
Beef	No	n/a	No	-
Pork	No	n/a	No	-
Lamb/mutton	No	n/a	No	-
Poultry	No	n/a	No	-
Chestnuts	No	n/a	No	-
PotassiumChloride	No	n/a	No	-
Phenylalaline	No	n/a	No	-
Garlic	No	n/a	No	-
CowsMilk	No	n/a	No	-
GoatsMilk	No	n/a	No	-
BuffalosMilk	No	n/a	No	-
EwesMilk	No	n/a	No	-

Name	Yes No	Source	Factory Site YN	Risk Cont Man Site
Ingredientsfromananimal/insectsourcenotspecifiedabovee.g.fish,eggs,honey,gelatine,calfrennet,shellacwaxedfruits,Isinglass (fishfines)forfiltering,animalderivedflavoursorcolours?	Yes	Fish	Yes	Present in the product

Palm Oil SMF016

Palm Oil

This product does not contain Palm Oil

GMs SMF016

This product is completely free from GMs

Analytical & Nutritional SMF016

Is this Food or Drink?	Food
Service Size (g/ml)?	100.00000
Number of portion/serving per pack: (if applicable)	10

Nutritional

Nutritional Information	Per 100g/100ml	Per Serving	% Reference Intake (per 100g)	% Reference Intake (per serving)	Claim in ±20% Tolerance (Riskless claim)	Traffic Light Colour	Method	Frequency
Energy-kj:	929	929	11.06	11.06	N/A		Calculation	N/a
Energy-kcal:	223	223	11.15	11.15	Energy Free		Calculation	
Fat*	15.5	15.5	22.14	22.14	Fat Free		ISO1443	
of which saturates (g)*	2.3	2.3	11.5	11.5	Saturated Fat Free		PN-EN ISO 5508	N/a
Carbohydrate (g)*	0	0	0	0	N/A		Z WYLICZENIA	N/a
(of which sugars) (g)*	0	0	0	0	Sugar Free,Low Sugar		PN-A-867-40	N/a
Fibre (g)*	0	0	0	0			Analysis	N/a
Protein (g)*	20.9	20.9	41.8	41.8			PB-116	N/a
Equivalent as salt (g)*	1.6	1.6	26.67	26.67	Low Salt		Analysis	N/a
Moisture (g)	60.2	60.2	0	0	N/A		PN-62 A-86783	Daily
Ash (g)			0	0				

For nutritional information determined by an analysis

FSA Salt Category

Label claims declaration	n/a	Name of the laboratory used:	J.S Hamilton Poland Ltd. Sp.z.o.o. Laboratorium Accreditation: AB 079 Accreditation validity date: May 31, 2026 Accredited since: 15-10-1996	Product FSA Category:	Not applicable
Lab accreditation:	PCA (number AB079)	Accreditation Date:	31/05/2026	Salt Targets: (g salt or mg sodium per 100g):	N/A

Analytical & Nutritional SMF016

Chem/Physical Standards

Test	Target	Reject	Method	Frequency
Salt testing	1.8-2.5%	>2.5%	internal lab	each batch
Salmon Raw material CEZ 137	130bq/kg	>130bq/kg	LIMIT FR	twice per year
Salmon Raw material Strontium 90	100bq/kg	>100 bq/kg	LIMIT FR	twice per year
Finished product or semi product or raw material others type- dioxions	4.0 pg/g	>4.0pg/g	(WE) 1881/2006	twice per year
Finished product or semi product or raw material others type- PCB	4.0 pg/g	>4.0pg/g	(WE) 1881/2006	twice per year
Finished product or semi product or raw material others type- Pesticides	standard value 0.01mg/kg	>0.01mg /kg	(WE)396/2005	twice per year
Finished product or semi product or raw material others type- Benzo (a)pyrene	5,0 µg/kg	>5,0 µg/kg	(WE) 1881/2006	twice per year
for customers Finished product or semi product or raw material others type- histamine	100-200 mg/kg	>200 mg /kg	(WE) 2073/2005	twice per year
for customers Finished product or semi product or raw material others type- TVB-N	35mgN/100g	>35mgN/100g	(WE)2074/2005	twice per year
NACL level on finished product	1.8%-2.5%	<1.85 or > 2.5%	PN- 74 A86739	twice per year
Salmon raw material antibiotic residues	Absence	Presence	(WE)37/2010	twice per year

Micro Standards

Test	Unit	Target	Reject	Method	Frequency	Cof AAvailable
TVC	cfu/g	<5000	>10^6	PCA Aerobic Count Plate AGAR 72 h/30ºC	one sample from each day of production	yes
*coliforms	cfu/g	<100/g	>1000	RAPID E.coli/Coliform AGA 24-48 h/37ºC	check the random sample in an external lab(Yearly)	yes
*e. coli	cfu/g	<10/g	>10^2	RAPID E.coli/Coliform AGA 24-48 h/37ºC	check the random sample in an external lab(Twice a year)	yes
*Staph. aureus	cfu/g	<100/g	>10^3	Baird Parker/2x24h/37°C	check the random sample in an external lab(Twice a year)	yes
*Salmonella Spp/25g	cfu/25g	Negative in 25g	detected	BAX SYSTEM, method PCR	check the random sample in an external lab(Twice a year)	yes
Listeria .Mono	cfu/25g	Negative in 25 g	>100 cfu/g	BRILLIANCE LISTERIA 24-48 h / 37ºC	one sample from each day of production	yes
*Yeast	cfu/g	≤200 /g	>10000	YGC Count Plate AGAR 5 days/25ºC	check the random sample in an external lab(Yearly)	yes
*Moulds	cfu/g	≤200 /g	>500	YGC Count Plate AGAR 5 days/25ºC	check the random sample in an external lab(Yearly)	yes
Enterobacteriaceae	cfu/g	<50/G	>100000	VRBG Enterobacteriaceae AGAR 24 h/37ºC	one sample from each day of production	yes

Allergens SMF016

Allergens Declaration	
Contains:	FISH
May contain:	N/A

Detailed Allergen

Component	The allergen is present in the material	There are none in the material and none on site and there is no risk of cross contamination of raw materials	There is none in the material but used elsewhere in the factory in a segregated area, using segregated equipment	There are none in the recipe, but is made using equipment that, before cleaning, is used to make product which contains this allergen	There are none in the recipe, but the equipment used to make this material is used to make product which contains this allergen (no cleandown)	Instruction
Peanut or its derivatives e.g. Peanut – pieces, protein, oil, butter, flour and mandelona nuts (an almond flavoured peanut product) etc. Peanut may also be known as ground nut.	No	Yes	No	No	No	
Tree nuts including: Acorns, Almonds, Oyster Nuts, Peanuts (ground nuts), Beechnuts, Betal Nuts, Brazil Nuts, Bread Nuts/ Bread Fruit, Cashew Nuts, Chilean Wild Nuts, Cola Nuts, Hazelnuts (Filberts), Ginkgo Nuts, Heart Nuts, Jack Nuts, Jojoba Nuts, Litchi Nuts, Macadamia Nuts, Paradise Nuts, Pecans, Persian Walnuts, Pili Nuts, Pistachio Nuts, Quandong Nuts, Squari Nuts, Tahiti Nuts, Tallow Nuts, Tiger Nuts, Tropical Nuts, Walnuts, All cold pressed nut oils, Hickory	No	Yes	No	No	No	
Sesame or its derivatives e.g. paste and oil etc	No	Yes	No	No	No	
Milk or its derivatives e.g. milk caseinate, whey and yogurt powder etc	No	Yes	No	No	No	
Eggs or its derivatives e.g. frozen yolk, egg white powder and egg protein isolates etc	No	Yes	No	No	No	
Fish or its derivatives e.g. fish protein and extracts etc	Yes	No	No	No	No	
Shellfish (including crab, crayfish, lobster, prawn and shrimp) or its derivatives e.g. extracts etc	No	Yes	No	No	No	
Molluscs (including snails, clams, mussels, oysters, cockle and scallops) or their derivatives e.g. extracts etc	No	Yes	No	No	No	
Soy or its derivatives e.g. edamame, lecithin, oil, tofu and protein isolates etc	No	Yes	No	No	No	
Sulphites at concentrations of more than 10mg/kg or 10mg/litre expressed as SO2) e.g. sulphur dioxide, sodium metabisulphite etc	No	Yes	No	No	No	
Cereals containing Gluten (wheat, rye, barley, oats, spelt, kamut or their hybridised strains) or their derivatives e.g. flour, starches, bran etc	No	Yes	No	No	No	
Celery or its derivatives e.g. celeriac	No	Yes	No	No	No	

Detailed Allergen

Component	The allergen is present in the material	There are none in the material and none on site and there is no risk of cross contamination of raw materials	There is none in the material but used elsewhere in the factory in a segregated area, using segregated equipment	There are none in the recipe, but is made using equipment that, before cleaning, is used to make product which contains this allergen	There are none in the recipe, but the equipment used to make this material is used to make product which contains this allergen (no cleandown)	Instruction
Mustard or its derivatives	No	Yes	No	No	No	
Lupines or their derivatives e.g. flour etc	No	Yes	No	No	No	

Detailed Assessment of Process Steps

Process Step	Wheat & Derivatives	Cereal containing gluten	Milk & Derivatives	Egg Derivatives	Nuts, Peanuts & Derivatives	Sesame & derivatives	Soybeans & derivatives	Celery & derivatives	Mustard & derivatives	Sulphur dioxide & sulphites	Lupin & derivatives	Crustaceans, Molluscs & derivatives	Fish & derivatives
Raw material reception	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	High
Unloading	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	High
Cold storage	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	High
Transport to the technological line	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	High
De-Icing	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	High
Rinsing	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	High
Heading	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	High
Rinsing	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	High
Filleting	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	High
Trimming	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	High

Detailed Assessment of Process Steps													
Process Step	**Wheat & Derivatives**	**Cereal containing gluten**	**Milk & Derivatives**	**Egg Derivatives**	**Nuts, Peanuts & Derivatives**	**Sesame & derivatives**	**Soybeans & derivatives**	**Celery & derivatives**	**Mustard & derivatives**	**Sulphur dioxide & sulphites**	**Lupin & derivatives**	**Crustaceans, Molluscs & derivatives**	**Fish & derivatives**
Pin Bone Removal (machine)	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	High
Manual pin bones removal	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	High
Cut into portions	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	High
Cold storage	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	High
Injection/Brining	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	High
Placing on trays	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	High
Placing trays on Smoking trolleys	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	High
Trolley load Weighting	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	High
Maturing	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	High
Drying	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	High
Hot smoking and steaming	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	High
chilling	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	High
Sorting the broken pieces	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	High
Skin removal	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	High

Detailed Assessment of Process Steps													
Process Step	**Wheat & Derivatives**	**Cereal containing gluten**	**Milk & Derivatives**	**Egg Derivatives**	**Nuts, Peanuts & Derivatives**	**Sesame & derivatives**	**Soybeans & derivatives**	**Celery & derivatives**	**Mustard & derivatives**	**Sulphur dioxide & sulphites**	**Lupin & derivatives**	**Crustaceans, Molluscs & derivatives**	**Fish & derivatives**
Packing into bag	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	High
Vacuum sealing	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	High
Unpacking leacky packings	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	High
Vacuum sealing	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	High
Composing in boxes	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	High
Freezing	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	High
Metal detection	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	High
Labelling	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	High
Packing into the carton	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	High
Building pallets	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	High
Frozen storage	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	High
dispatch	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	High

Additional question for Nuts, Peanuts & Sesame Allergens only	
Question	**Response**
Do raw material suppliers for your Products produce nut / seed products in their factory / harvesting / handling systems?	no

Packaging SMF016

Package Inner

Package Outer

Finished Label Inner

Finished Label Outer

Packaging

Component	Pack Type	Material	Description	Colour	Weight Per Unit	Food Ctct Pack	Length	Width	Height	Diameter	Gauge	Grade	Supplier	Supplier Acc	Country	Tamp Ev Det	Sealing Type	Sealing Colour	Suit Rec	Perc Rec	Print Method
Bag (OW3036) and label	Primary	PA/PE	Clear Plastic bag	Clear	14.00	Yes	220	340		n/a	120	food	Worek Prozniowy	none	Poland	Heat Sealed	Heat Sealed	clear	No	0	-
Outercase (OK2086) and Label	Secondary	Cardboard	White Cardboard Case	White	780.00	No	584	384	160	n/a	n/a	food	Smurfit Kappa	IOP	Poland	Tape on box	Tape	White	Yes	96	-
Pallet	Tertiary	wood	wooden pallet	brown	25000.00	No	1200	800	150	n/a										0	-

Packaging SMF016

Packaging Value		**Shelf Life Data (Days)**		**Palletisation**			
Total Weight Primary Packaging (g)	14	Life From Production	360	Units per case	20	Container or Pallet Delivery	Pallet
Total Weight Secondary Packaging (g)	780	Lead time (order to delivery)	5	Cases per layer	4	Pallets/Transit cases per container	2
Total Weight Pallet/Transit Packaging (g)	25000			Layers per pallet	8	Container size	-
Total Weight of Packaging per Case (g)	1060	Guaranteed minimum life into Leathams depot:	300	Type of Pallet (i.e. CHEP - 1000x1200mm, EURO-800x1200mm or other please specify)	Euro	Sea Freight or Road freight	Road
Total Weight of packaging per Pallet/transit case (g)	58920	% of life on delivery	83	Method of pallet Wrap & Stabilisation	-		
Number of PRIMARY units per Case/Outer	20			Cases per pallet	32	Transport Temperature (°C)	Frozen -18°C
Total Weight per case (kg)	21.06	Total Weight per Transit Case (kg)	698.92	Units per Pallet	640		
Total cases per container	64			Units per layer	80	Pallet Height (m)	1430
Logos and enviornmental claims	none						

Weight Control

Using Minimum Weight	
Choose Unit	-
Net	Drained
0	0

Using Average Weight

Net	TNE	T1	T2	Drained
1000	1.5%	985	970	0

Packaging SMF016

Supply Chain Standards			
Question	**Comply Yes No**	**When Comply By**	**Accepted Yes No**
Do you use shelf ready packaging (retail products only)	n/a		
The method of closure shall not compromise food safety by being a foreign body issue, nor shall it obscure any labels including barcodes or outer case labels	Yes		
The outer case label shall comply with this label	Yes		
The outer case label barcode shall scan, using a calibrated verifier at Grade B or Above or C if direct printed on the case.	n/a		
The outer case labels shall be placed in duplicate one on the short edge and one on the long edge	n/a		
The base shall be covered with a layer of cardboard	Yes		
The pallet shall contain a pallet label stating the products on the pallet	Yes		
The pallet shall not contain mixed durability dates or if it does there shall be a pallet label indicating the durability dates present	Yes		
The goods shall not protrude over the edges of the pallet.	Yes		
The pallet shall be wrapped with where possible coloured shrink wrap	Yes		
The pallet corners shall be protected with pallet uprights	Yes		
The product shall be delivered by a vehicle which is food grade, clean and free from debris	Yes		
If the delivery is temperature controlled the goods can be supplied with a temperature printout history on demand	Yes		
Tranporters shall be audited as to their suitability	Yes		

Labelling Information SMF016

Pack Traceability				**Shelf Life**			
Durability date type:	Best Before			Shelf life (From Manufacture):	12 months	Shelf Life Validation Data Held On File:	YES
Durability date format:	MONTH/ YYYY			Is it safe to extend shelf life?	YES	How long is it possible to extend life?	optimally 15 months, maximum 18 months
Pack coding used:	Lot code			What evidence do you have to support this?	-		
Location of durability date:	On label on the side of the bag			Is the product packed in a modified atmosphere?	NO		
Lot/batch code format:	Example code would be 01P118047			Is the statement "Packed in a modified atmosphere" on the product label?	NO		
Inner barcode							
Inner barcode number (if sold CASE ONLY then type N/A)	4010871055500	Barcode Type:	EAN-13	if yes, state the composition of the gas used e.g. 30% C02/70% N2	NA		
Number of Digits:	13	Check Digit:	0				
Outer barcode				2D barcode		Packaging Code	
Outer barcode number:	15018095003822	Barcode Type:	ITF-14	Standard Packaging		Standard Packaging	-
Number of digits:	1	Check Digit:	2	Flash/Promo		Flash/Promo	

Labelling Information SMF016

Usage Instructions:	
Storage instructions:	Keep frozen until required.
Cooking instructions if applicable:	n/a
If delivered chilled or ambient, is product suitable for freezing?	n/a
Instructions for defrosting: temp / time:	Defrost in chilled conditions for 24 hours before use
Shelf life after defrost:	7 days
Shelf life once opened:	3 days
Storage once opened:	0-4°C
Health Mark:	PL 22121818 WE
Health Mark Shape:	Oval

Claims		
Claim No	Claim Type	Details

CCP SMF016

Process Controls						
Process Number	**Process Step**	**Level of Control**	**Control Measures (CCP only)**	**Limits (CCP only)**	**Monitoring Procedures (CCP only)**	**Action (when out of control)(CCOP only)**
1	Raw Material reception (chilled covered with ice pieces)	OPRP	1) Environmental chemical contaminants and pesticides 2) Quantity control 3) Quality control 4) Confirmation of authenticity 5) Microbiological analysis of raw material 6) Swab from the skin	1) According to Appendix 5 to IZ 11/2006 2) Compliance with the amount of the invoice delivery 3)According to the instruction IZ 1 to PR RW 4/3 RECEPTION OF RAW-FISH Classification features of raw material to appropriate quality class (E or A) 4) Acco	1) Once every six months 2)Each time during reception of raw material system Data Catch 3) and 4) Each time during reception of raw material document F 2/1 to PR RW 4/1 reception of the raw material, 5) and 6) Once for each batch of raw material process	
2	Unloading	None	N/a	N/a	N/a	
3	Cold storage	OPRP	1)Storage temperature 2)Storage room state	1) 0-4 degrees 2) No damages, no pollutions, clean rooms	1) 3 times a day F 4 to PR RW 4/1 Temperature control; Continuous temperature register Electronic record 2) Daily visual inspection - warehouse worker, quarterly - quality control, once a month - foreman - Infor EAM system	
4	Transport to the technological line	None	N/a	N/a	N/a	
5	De-Icing	None	N/a	N/a	N/a	
6	Heading	OPRP	Visual knife control	No damage or fractures	Each production line Before starting work and if damage is suspected	
7	Rinsing	None	N/a	N/a	N/a	
8	Filleting	OPRP	Checking the machine's cutting elements	No damage or fractures	Each production line Before starting work and if damage is suspected	

Process Controls						
Process Number	**Process Step**	**Level of Control**	**Control Measures (CCP only)**	**Limits (CCP only)**	**Monitoring Procedures (CCP only)**	**Action (when out of control)(CCOP only)**
9	Trimming	OPRP	1) Hall temperature 2) Quality assessment of filets during process 3)Visual knife control	1) Max 12°C 2) According to the raw material specification 3) No defects, cracks	1) 2 times a day F 27 to PR RW 4/1 Temmperature control of halls 2) For batches whose numbre is = 7 pallets F 38 to PR RW 4/2 Quality asse1) 2 times a day F 27 to PR RW 4/1 Temmperature control of halls 2) For batches whose numbre is = 5 pallets F 38 to PR RW 4/2 Quality assessment of raw material during filleting 3) Before and after work - foreman; Current control - production workerssment of raw material during filleting	
10	Pinbones Removal (machine)	OPRP	Technical condition control	The machine is complete, no losses	Each production line Before starting work and if damage is suspected	
11	Manual pinbones removal	OPRP	1)Control of pinbones presence 2) Pliers control	1)Pinbones, not more than 1long piece, 2 broken per 1 kg 2) Number of pliers handed over according to the number delivered, Complete pliers	Every 2 hour F45/1 to PR RW 4/2 Pinbones removal control 2) Before and after work - foreman, Current control - production worker	
12	Cut into portions	OPRP	1) Weight control portions 2) Quantity control 3) Checking the machine's cutting elements	1) According to the specification 2) Counted after cutting 3) No damage or fractures	1) Every 10 minutes F 74 to PR RW 4/2 Weight control 2) Each batch F 18 to PR RW 4/1 Production report. Pretreatment, Data Catch 3) Each production line Before starting work and if damage is suspected	
13	Cold storage	OPRP	1)Storage temperature 2)Storage room state	1) 0-5 degrees 2) No damages, no pollutions, clean rooms	1) 3 times a day F 4 to PR RW 4/1 Temperature control; Continuous temperature register Electronic record 2) Daily visual inspection - warehouse worker, quarterly - quality control, once a month - foreman - Infor EAM system	

Process Controls						
Process Number	**Process Step**	**Level of Control**	**Control Measures (CCP only)**	**Limits (CCP only)**	**Monitoring Procedures (CCP only)**	**Action (when out of control)(CCOP only)**
14	Injection	OPRP	1) Brine temperature, 2) Brine concentration, 3) Injection value, 4) Portions weight control after injection, 5) Checking the conditio of the needles	1) to 12 °C, 2) 15%, 3) 8-9%, 4) Depending on the type of product, according to the specification 5) No damage	1) and 2) Each time for newly prepared brine F 5/1 to PR RW 4/1 Control of brine concentration and temperature 3) and 4) 10 portions once an hour and / or each time after changing the injector parameters 5) 4 times a day (at the beginning and end of work, during breaks) F 4 to PR ZZ 2/1 Control of technical condition of injectors.	
15	Brining(1,8 - 2,5% target salt)	None	1) control of brine temperature 2) Brine concentration 3) brining time	1) Brine temperature maximum 12 degrees 2) brine concentration 21,5 % 3) brining 13 minutes	1) and 2) Each brine IZ2 to PR RW 4/1 Salting and marinating F 5/1 to PR RW 4/1 Control of brine concentration and temperature F 1 to IZ 2/2006 Brine and portions seasoning 3)Each time for batch F 1 to IZ 2 to PR RW 4/1 Brine and portions seasoning, IZ 2 to PR RW 4/1 Salting and	
16	Putting on the trays	None	N/a	N/a	N/a	
17	Putting trays on the smoking trolley	None	N/a	N/a	N/a	
18	Trolley load Weighting	OPRP	1)Weight of semi-product	1)Weight reading from an electronic balance	1) Once before maturing for each smoking trolleys F 77 to PR RW 4/1 Product card, System Data Catch	
19	Maturation	OPRP	1)Storage temperature 2)Maturing time 3)Chilling room state	1) 0-5 degrees 2) min 0,5h max 24h 3) No damages, no pollutions, clean rooms	1) 3 times a day F 4 to PR RW 4/1 Temperature control; Continuous temperature register Electronic record 2) For each trolley F 10 to PR RW 4/1 Drying control, CDN 3) Daily visual inspection - warehouse worker, quarterly - quality control, once a month - foreman - Infor EAM system	

Process Controls						
Process Number	**Process Step**	**Level of Control**	**Control Measures (CCP only)**	**Limits (CCP only)**	**Monitoring Procedures (CCP only)**	**Action (when out of control)(CCOP only)**
20	Drying	OPRP	1)Drying time 2) Drying temperature 3)Weight loss	1) around 2-4 hours According to the attachment Z 2 to IZ 3 to PR RW 4/1 2)In drying chamber 28 ±3°C In fish 23 - 28ºC (injection portions); In drying chamber 25±3°C, in fish 19 -24°C for brined portions 3) Around 6-9%	1) and 2) Each time during drying F 10 to PR RW 4/1 Drying control, CDN, IZ 3 to PR RW 4/1 Monitoring of CCP 5 in hot smoking and steaming process, Z 2 to IZ 3 to PR RW 4/1 Smoking process - Factory 2 2) IZ 3 to PR RW 4/1 Monitoring of CCP 5 in hot smokin	
21	Hot Smoking and steaming	CCP	1)Time and temperature (in smoking chamber) 2)Weight loss 3) Control of temperature detectors in smoke chambers	1) Critical limit – the value of the coefficient 2.0 for every detector (values below that are a violation of the CCP critical limit), Operational limit – value of the coefficient 2.5 for every detector 2)a) No damage, b) The detector and reference thermometer deviations can not exceed ± 1°C	1) a)Each time for cycle F 11 to PR RW 4/1 Smoking control IZ 3 to PR RW 4/1 Monitoring of CCP 5 in hot smoking process control by employee of smoking section, b) Verification of the process by QC, based on records registered in the SCADA system, once a week for each smoking chamber based on the selected production day 2) a) Every time you use the detector in the SCADA system b) Once a day in the morning at the first change in the SCADA system	1) a) Extending the smoking and brewing time to obtain the lethality coeffcient min. 2.0 for two detectors b) Adjust the additional charts from the chamber, Inform the coordinator of the smokehouse and quality director, Blocking the feed chamber 2) a) and b) Informing the Coordinator of the smokehouse, Pause the process in the chamber with defective detectors, Report for calibration or replacement of the detector, Lock the product from the last valid measurement
22	Chilling	OPRP	1) Chilling time 2) Chilling time in cold storage MPTS 47 3) Temperature in cold storage 47 4)Chilling room state 5) Portions temperature	1) 1 - 4 h to 2°C 2) 5-18h (if the temp. in the chilling room is >4°C), max 60h (if the temp. in the chilling room is <4°C) 3) 0-5°C 4)No damages, no pollutions, clean rooms 5) 0-4°C	1) For a representative trolley Electronic record 2) For each trolley 3) 3 times a day F 4 to PR RW 4/1 Temperature control; Continuous temperature register Electronic record 4) Daily visual inspection - warehouse worker, quarterly - quality control, once a month - foreman - Infor EAM system 5) Each trolleys F 15/1 to PR RW 4/1 Product card; CDN	
23	Sorting the broken pieces	None	N/a	N/a	N/a	
24	Skin removal	None	N/a	N/a	N/a	

Process Controls						
Process Number	**Process Step**	**Level of Control**	**Control Measures (CCP only)**	**Limits (CCP only)**	**Monitoring Procedures (CCP only)**	**Action (when out of control)(CCOP only)**
25	Packing into bags	OPRP	1) Product weight 2) Amount of packed portions	1) Bags 1 kg According to the specification; Nominal amount of packed goods (According to the reference method) 2) Counted at the end of the process	1)Each bag , F 14/2 to PR RW 4/1 Production report from the line, CDN; According to the IZ 1 to PR ZZ 2/2 Internal control of packed goods system Printed record from TP-AXIS Batch assessement of packed goods 2) Every time for each assortment F 14/2 to PR RW 4/1 Production report from the line, CDN	
26	Vacuum sealing	OPRP	1) Hall temperature 2) Clean machinery and equipment 3) Vacuum control 4) Checking the tightness and closing of the packaging 5) Control of packed product 5) Sensory and quality assessment, 7) Temperature before packing 8) Product weight according to the specification 9) Content of benzopyrene and WWW	1) 12°C (max 14°C) 2) No breakage, no foreign body presents clean machines and devices 3) no air 4) tight closing, tight seal 5) Correct weight, auxiliary materials (foil, trays, boxes) 6) According to the specification 7) 0 - 4°C 8) Weight recorded from electronic scale (According to the reference method) 9) According to the regulation (UE) 835/2011 Benzopyren - 2uq/kg WWA -12 uq/kg	1) 2 times per day System EAM Infor 2) Before and after production System EAM Infor3) Machine setting for each assortment 4) The entire measure: - at the beginning and end of machine operation, - with each change of assortment, - after a machine failure, Every 2 hours control for one tray from the cycle 5) every batch CDN 6) and 7) Random samples from each assortment F 10 A to PR RW 4/2 Quality assessment of finished product 8) Accoording to the IZ 1 to PR ZZ 2/2 Internal control of packed goods system Printed record feom TP-AXIS Batch assessment of packed goods 9) Once every 6 months According to the attachment no. 5 to IZ 11/2006 Analysis reports from external laboratories	
27	Unpacking leacky packagings	None	N/a	N/a	N/a	

Process Controls						
Process Number	**Process Step**	**Level of Control**	**Control Measures (CCP only)**	**Limits (CCP only)**	**Monitoring Procedures (CCP only)**	**Action (when out of control)(CCOP only)**
28	Vacuum sealing	OPRP	1) Hall temperature 2) Clean machinery and equipment 3) Vacuum control 4) Checking the tightness and closing of the packaging 5) Control of packed product 5) Sensory and quality assessment, 7) Temperature before packing 8) Product weight according to the specification 9) Content of benzopyrene and WWW	1) 12°C (max 14°C) 2) No breakage, no foreign body presents clean machines and devices 3) no air 4) tight closing, tight seal 5) Correct weight, auxiliary materials (foil, trays, boxes) 6) According to the specification 7) 0 - 4°C 8) Weight recorded from electronic scale (According to the reference method) 9) According to the regulation (UE) 835/2011 Benzopyren - 2uq/kg WWA -12 uq/kg	1) 2 times per day System EAM Infor 2) Before and after production System EAM Infor3) Machine setting for each assortment 4) The entire measure: - at the beginning and end of machine operation, - with each change of assortment, - after a machine failure, Every 2 hours control for one tray from the cycle 5) every batch CDN 6) and 7) Random samples from each assortment F 10 A to PR RW 4/2 Quality assessment of finished product 8) Accoording to the IZ 1 to PR ZZ 2/2 Internal control of packed goods system Printed record feom TP-AXIS Batch assessment of packed goods 9) Once every 6 months According to the attachment no. 5 to IZ 11/2006 Analysis reports from external laboratories	
29	Putting into the boxes	OPRP	N/a	N/a	N/a	
30	Freezing	OPRP	1) Product temperature 2) Tunnel condition	1) Till achieving -18 degrees in fish 2) No breakage, no foreign body presents (glass, plastic, walls , floors) clean rooms	1)once during freezing, at the end of the process, each batch F 12 to PR RW 4/1 Control of freezing 2) Daily visual inspection - warehouse worker, quarterly - quality control, once a month - foreman - Infor EAM system	

Process Controls						
Process Number	**Process Step**	**Level of Control**	**Control Measures (CCP only)**	**Limits (CCP only)**	**Monitoring Procedures (CCP only)**	**Action (when out of control)(CCOP only)**
31	Metal detection	OPRP	1)Metal presence in the product 2)Efficiency of the detector 3) Closed jet box verification 4) Sequential test	1)No foreign body contamination of each portion greater than or equal to the test values 2)a)No visible damage; b) Efficient detector - signaling and rejection of packages containing test samples 3) closed jet case 4) Rejection of all tested products - three in a row	1)every piece, IZ14 do PR ZZ 3/1 Detekcja metali, F 48 to PR RW 4/2 Register of foreign bodies Nonconformity card (NND Integrum program) 2)a) Ongoing control machine parts Once per month IZ10 to PR ZZ 3/1 Glass & hard plastic management Z 23 to IZ10 to PR ZZ 3/1 Glass & hard plastic list – wysokie ryzyko (Factory 2) b) - before and at the end of work, - when changing the assortment,- every 2 hours,- after each device failure, - after each break in the detector operation,- after each interference in the detector settings F 1/1 to IZ 14 to PR ZZ 3/1 3) 3 times per shift: the beginning, middle and end of the device's work 4) 1 time a day for each detector	
32	Labelling	OPRP	1) Leak tightness control 2) Control of information on the label 3) Microbiological analysis of the finished product 4) Water content 5) Salt content	1) 100% sealed Vacuum packaging 2) The right expiration date 3) Total bacteria count = $5x10^3$/g, Enterobacteriaceae =50/g, Listeria monocytogenes nb 25g, *E.coli=10/g, *Coliformy =100/g, *Staphylacocus aureus=100/g, *Salmonella nb 25g, *Yeast=200/g, Mould=	1) each pack 2) every batch of labels IZ 32 to PR RW 4/1 Labeling and marking, F16 do PR RW4/1 Packing report of finished product F 16/2 to PR RW 4/1 Packing report of finished product3) Each production lot System LIMS 4) and 5) Each time for a given assortment System LIMS	
33	Packing into the carton	OPRP	1) Quantitive control 2) Control of the finished product	1) Counted after packing 2) According to the specification	1) For each assortment 2) Each time for a given assortment F 16 to PR RW 4/1 Packing report of finished product	
34	Stocking on the pallets	None	N/a	N/a	N/a	

Process Controls						
Process Number	**Process Step**	**Level of Control**	**Control Measures (CCP only)**	**Limits (CCP only)**	**Monitoring Procedures (CCP only)**	**Action (when out of control)(CCOP only)**
35	Frozen storage	OPRP	1) Control of storage temperature 2) Storage condition	1) Minus 18 degrees 2) No breakage, no foreign body presents, clean rooms	1) 3 times a day F 4 to PR RW 4/1 Temperature control; Continuous temperature register Electronic record 2) Daily visual inspection - warehouse worker, quarterly - quality control, once a month - foreman - Infor EAM system	
36	Dispatch / expedition	OPRP	1) Microbiological analysis of ready product 2)Product temperature control 3)cleanliness of the transport means 4)The qualitative and quantitative customers requirements	1) Total amount of bacteria = 1x105 /g, Enterobacteriaceae = 1x105 /g *E. Coli = $1x10^2$/g, *Coliforms = $1x10^3$/g, Listeria monocytogenes = $1x10^2$ /g, *Staphylacocus aureus= $1x10^3$ /g, *Salmonella nb 25g *Moulds = 500 /g *Yeast = 1x104 /g * research carried	1) For each batch of raw material F 1 to PR RW 4/2 results of microbiological-chemical analysis or record in electronic form 2)Each pallets Temperature register appendix to F 2 do PR RW 1/2 Driver statement 3)Checked each time during dispatch and loadin	

CCP SMF016

Process Controls	
Question	**Answer**
If frozen, please provide worst case time/ temperature details for the defrosting process. In addition please confirm the temperature of th area in which material is defrosted.	n/a
For cured / salted fish only: What is the method of freezing used, i.e. blast frozen or IQF. Give times and temperatures of freezing, and the final temperature of the product after freezing.	After hot smocing fast chilling till 2°C, for final product temperature 0-4°C

QAS SMF016

1. Finished Product Standards - Primary Packaging

Acceptable / Green

Unacceptable / Red

Primary Packaging Image

Primary Packaging Description			

Acceptable / Green

Unacceptable / Red

Date Coding Description

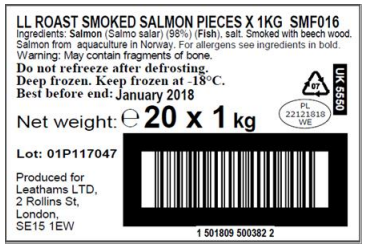
Best before end:
September 2021

Date Coding Description			

Acceptable / Green

Unacceptable / Red

Inner Label Image



QAS SMF016

2. Finished Product Standards - Secondary Packaging

Acceptable / Green

Unacceptable / Red

Outer Case/SRP Image

Acceptable / Green

Unacceptable / Red

Outer Label Image

Outer Case/SRP Description			

3. Finished Product Standards

Acceptable / Green

Unacceptable / Red

Appearance	Salmon pieces irregularly shaped broken, hot smoked with brown meat and without skin. Small protein ammounts between muscle structure (myomers)	Appearance	N/A
Flavour	Characteristic, lightly saalty, perceptible taste of smoking	Flavour	oxidised
Aroma	characterisitc, perceptible smell of smoking	Aroma	oxidised
Texture	Firm to tender	Texture	very mushy in appearance

QAS SMF016

4. Detailed QAS

Acceptable / Green

Unacceptable / Red

5. Product Physical Parameters

Name	Uof M	Target	Minimum	Maximum
Skin	Visual	No skin	No skin	Presence of Skin
Orange Liquid on defrost	Visual	-	Orange liquid on defrost is mainly fat. Orange comes from astaxantine which belongs to carotenoids. It is used in fish feed for making salmon colour. It very well dissolves in fat, so in case of drip loss you will observe orange liquid. It is not unusual. Hot smoked products (as SMF016) tend to have a lot of drip loss- when products await for packing/freezing	N/A
Pin Bones	pieces/kg	less than 3 pieces/kg	less than 3 pieces /kg	<3 per Kg
Any other bones >1mm width and 3mm height	Visual	Absence	Absence	Presence

Warranty SMF016

The Supplier Warrants:

The supplier warrants that the Product, the Manufacturing premises and Distribution facilities will comply in every respect with the provisions of existing legislation and statutes, of either the United Kingdom or EC origin, and all Regulations, Statutory Instruments, Directives, orders, decisions or any other requirements made thereunder, which relate to, or control the nature, substance, quantity, quality, fitness for purpose, packaging, packing, labelling, sale, offering for sale, use, marking, traceability, constitution, importation, exportation, transportation, possession, dealing, make-up or trade description of such goods.

The supplier is responsible for informing Leathams Ltd of any proposed changes in the specification (eg. formulation, manufacturing procedures or packaging materials etc.). No changes may be made without express written agreement. Leathams products' specifications are confidential and should not be sent to a Third Party by the Supplier without Leathams approval.

The supplier is responsible for ensuring that all products, as far as is reasonably possible, are manufactured in accordance with the specification, where there is a deviation that they inform Leathams of this in advance of shipping the goods.

The supplier warrants that any documents relating to the goods that are delivered to Leathams, a Third party Warehouse or Directly to a customer on behalf of Leathams are valid and that the information contained in the documents is correct.

The product shall be manufactured at all times to the best practice reasonably available in the industry, and where this cannot be achieved this should be highlighted to Leathams, and in this respect is responsible with keeping upto date with all regulations in force in Europe as it relates to the specific product and in general.

Leathams Ltd Warrants:

To be responsible for the content of the final artwork having received reasonable advise for the supplier.

Not to share information contained in this specification with a third party other than that which is stated above as the property of Leathams Ltd, without the knowledge and permission of the supplier.

To advise of specific Leathams requirements in terms of the end user.

Signed on Behalf of Leathams Ltd

Name:	**Chuan Ho**
Position:	**Food Technologist**
Date:	**23/06/2023**