

SPECIFICATION CODE:	51800.SID.FIN.SPEC.doc	PRODUCT TITLE:	Lemon Meringue Pie (1 x 12 pre-portioned)
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PRODUCT SPECIFICATION

COMPANY NAME:	C D T Sidoli (Welshpool) Ltd	TELEPHONE NUMBER:	01938 555 234
COMPANY/ PRODUCTION UNIT ADDRESS:	Henfaes Lane Welshpool Powys SY21 7BE	FAX NUMBER:	01938 555 013
		E-MAIL ADDRESS:	sales@sidoli.co.uk

ORIGINATION DATE:	18/06/01	REVISION DATE:	09/11/20	REVISION NUMBER:	31
				TEMPLATE NUMBER:	400
PRODUCT CODE:	51800	INNER BAR CODE:	Not applicable	OUTER BAR CODE:	5015091518001
PRODUCT TITLE:	LEMON MERINGUE PIE				
PRODUCT DESCRIPTION:	A sweet short crust pastry case with a lemon filling, which is topped with peaks of piped meringue. This pie is pre-portioned into 12 portions and packed 1 pie per outer.				
INGREDIENT DECLARATION: (In descending order)	Water, sugar, WHEAT flour (with added calcium, iron, niacin, thiamin), shortening (palm oil, rapeseed oil), EGG yolk, modified maize starch, margarine (palm oil, rapeseed oil, water, emulsifier (mono- and diglycerides of fatty acids), flavouring), dextrose, lemon juice concentrate (2%), dried EGG white, stabilisers (agar, locust bean gum), salt, natural flavouring, thickener (cellulose gum), colour (curcumin), acidity regulator (citric acid).				
	MADE IN A FACTORY THAT ALSO HANDLES THE FOLLOWING ALLERGENS: MILK & NUTS.				
	NUTRITION: Typical values, 100g contains: Energy 1124kJ/267kcal, Fat 10.3g (of which saturates 3.7g), Carbohydrate 40g (of which sugars 27g), Fibre 0.7g, Protein 3.2g, Salt 0.14g				

TOTAL SHELF LIFE:	24 months from date of manufacture	SHELF LIFE INTO DEPOT:	8 months (minimum)
COUNTRY OF ORIGIN:	Produced in the U. K.	EEC CODE:	Not applicable
MINIMUM NET CASE WEIGHT:	1.600kg	MAXIMUM GROSS CASE WEIGHT:	2.150kg
UNITS PER PACK:	1 x 12 PRE-PORTIONED	PACKS PER CASE:	1 x 12 PRE-PORTIONED
PORTIONS PER CASE:	1 x 12 PRE-PORTIONED		
STORAGE:	At or below -18°C (0°F)	PRODUCTION CODE:	4 digit code (Year, 3 digit Julian calendar code)
HANDLING INSTRUCTIONS:	Defrost prior to serving. Meringue topping may be damaged due to portioning.		Keep refrigerated once defrosted. Use within 48 hours of defrost. Do not re-freeze once defrosted.
DEFROSTING INSTRUCTIONS:	Whole: Remove all packaging including the cakeboard, place on a serving platter, cover and defrost under refrigeration (8°C or below) for approximately 12 hours. Portion: Remove portion, place on a plate, cover and defrost under refrigeration (8°C or below) for approximately 3 hours.	REHEATING INSTRUCTIONS:	Not applicable

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SUPPLIER, RECIPE & NUTRITIONAL INFORMATION

SUPPLIER DETAILS & RECIPE FORMULATION: C D T Sidoli (Welshpool) Ltd reserve the right to keep all recipe formulations confidential and change ingredient suppliers, as the result of fluctuations within ingredient market trends and costs. We will ensure that the product's quality will not be affected and that ingredient declarations will be correct.

DIETARY & INTOLERANCE DATA

No	Does this product contain:	Yes	No	Comments
1	MRM / MSM (Mechanically Recovered / Separated Meat)		✓	
2	Lactose / Milk / Dairy Products & all forms of Derivatives		✓	<i>See allergen statement (no:43)</i>
3	Animal Products (Meat & Meat Products)		✓	
4	Gelatine (State Source & Country of origin)		✓	
5	Beef / Beef Products (Meat & Meat Products)		✓	
6	Pork / Pork Products (Meat & Meat Products)		✓	
7	Fish / Marine Products		✓	
8	Shellfish		✓	
9	Poultry / Poultry Products (Meat & Meat Products)		✓	
10	Egg / Egg Products	✓		Liquid pasteurised egg yolk, reconstituted egg white, egg white powder
11	Wheat / Wheat Derivatives	✓		Wheat flour, dextrose
12	Rye / Barley / Oats / Oat Bran		✓	
13	Soya / Soya Derivatives		✓	
14	Maize / Maize Derivatives	✓		Modified maize starch
15	Genetically Modified Material		✓	Non G. M.
16	Gluten	✓		Wheat flour
17	Artificial Colours		✓	
18	Azo Dyes		✓	
19	Natural Colours	✓		
20	Artificial Flavours		✓	
21	Natural Flavours	✓		Natural

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DIETARY & INTOLERANCE DATA (Continued)

No	Does this product contain:	Yes	No	Comments
22	Artificial Preservatives		✓	
23	Preservatives		✓	
24	Additives	✓		E406, E410, E471, E330, E100, E466
25	Added Salt	✓		Salt
26	Added Sugar	✓		Sugar
27	Peanuts		✓	
28	Tree Nuts (Whole / Pieces)		✓	See intolerance group suitability data for nut allergy sufferers. See allergen statement (no:42 & 43)
29	Tree Nut Oils / Derivatives		✓	See intolerance group suitability data for nut allergy sufferers. See allergen statement (no:42 & 43)
30	Seeds (excluding spices)	✓		Rapeseed, E410, lemon
31	Irradiated Foodstuffs		✓	
32	Alcohol (State abv%)		✓	
33	Sulphur Dioxide		✓	
34	Coconut / Coconut Derivatives		✓	
35	Origin of Vegetable Contents / Derivatives	✓		Palm oil, rapeseed oil

INTOLERANCE GROUP SUITABILITY DATA

No	This Product is Suitable For:	Yes	No	Comments
36	Vegetarians	✓		
37	Vegans		✓	Egg content
38	Ovo-Lacto Vegetarians	✓		
39	Coeliacs		✓	Wheat flour
40	Lactose Intolerants	✓		
41	Diabetics		✓	Contains sugar in at least one form.
42	Nut Allergy Sufferers		✓	This product may not contain actual nuts and/or nut derivatives. However, as we process and handle nuts on site we can not guarantee any of our products to be nut free, as they may contain trace quantities of nuts.
43	Allergen Statement	Made in a factory that also handles the following allergens: Milk & Nuts.		

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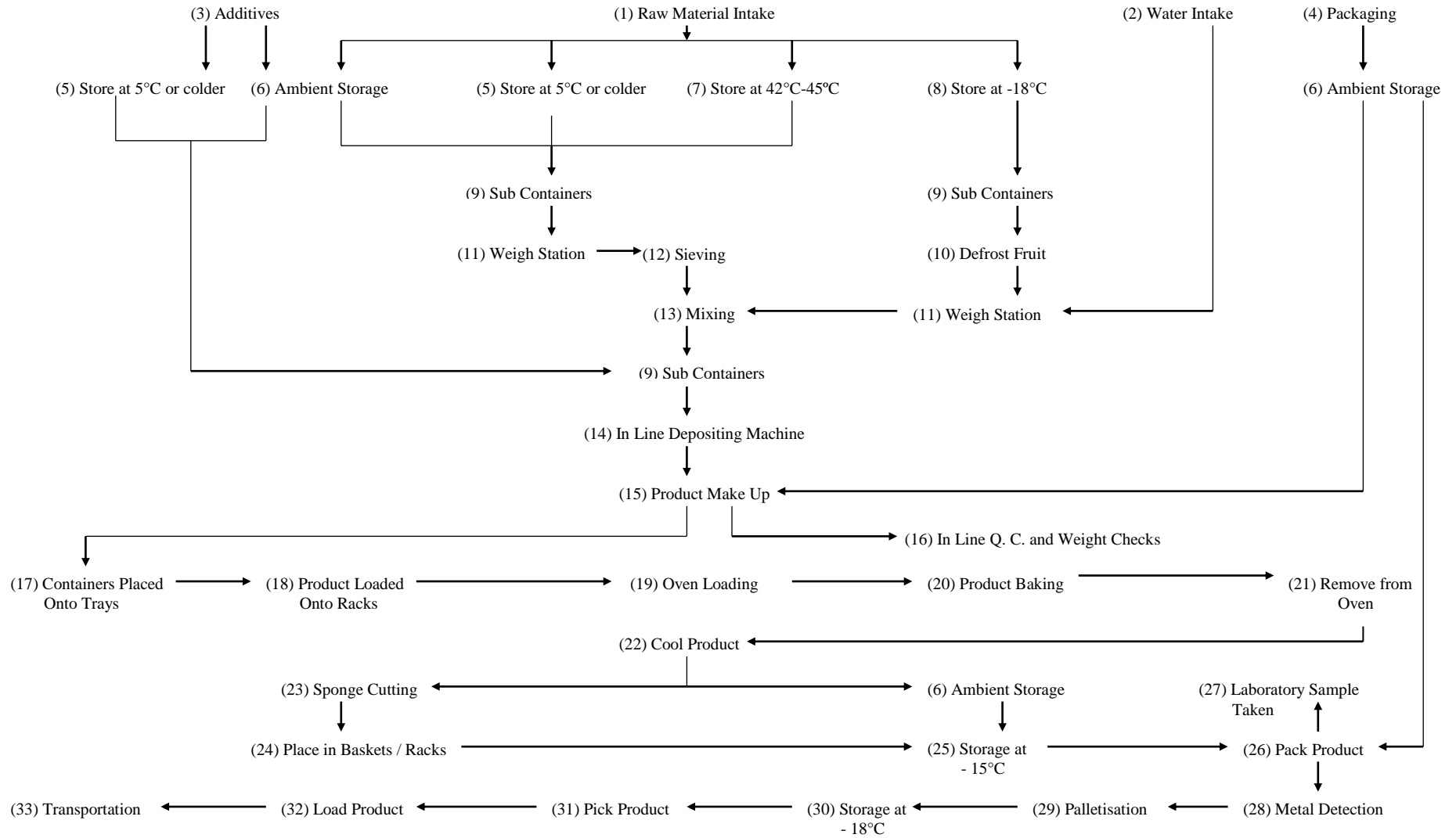
SUBJECTIVE QUALITY STANDARDS

(Physical Attributes / Sensory & Physical Description / Characterising Features / Organoleptic Assessment)

CATEGORY	CHARACTERISING FEATURES (From the bottom to the top)
OVERALL APPEARANCE / VISUAL: <i>Variable Criteria:</i>	<p>A sweet short crust pastry case with a lemon filling, which is topped with peaks of piped meringue. Product must be free from visible contaminants that are classed as foreign bodies.</p> <p>Extraneous matter may be unavoidable, but will be kept to a minimum. Over weights will be accepted. The peaks of piped meringue will vary in height as this forms the characteristic of the product.</p>
COLOUR: <i>Pastry:</i> <i>Lemon filling:</i> <i>Meringue topping:</i> <i>Variable Criteria:</i>	<p>Colours to be consistent with each delivery.</p> <p>Typically shading dark golden to light brown.</p> <p>Mid to bright yellow lemon filling.</p> <p>White to off white meringue, with shades of golden brown peaks.</p> <p>Colours may vary due to the nature of the manufacturing & baking process, but will be kept to a minimum.</p>
TEXTURE: <i>Pastry:</i> <i>Lemon filling:</i> <i>Meringue topping:</i> <i>Variable Criteria:</i>	<p>The textures of the products components are to be consistent with each delivery.</p> <p>Crisp pastry.</p> <p>Dense, gelatinous lemon filling.</p> <p>Sticky and moist meringue.</p> <p>The amount of air whipped into the meringue will affect the consistency (wet/dry) of the meringue deposit.</p>
FLAVOUR / ORGANOLEPTIC / TASTE: <i>Pastry:</i> <i>Lemon filling:</i> <i>Meringue topping:</i> <i>Variable Criteria:</i>	<p>The product must be free from taint. Flavours are to be consistent with the product description and each delivery.</p> <p>Sweet short crust pastry.</p> <p>Tangy citrus lemon filling.</p> <p>Sweet meringue.</p> <p>No variable criteria.</p>
ODOUR / AROMA: <i>Variable Criteria:</i>	<p>The product must be free from off odours, be consistent and typical of the product's description, for each delivery.</p> <p>No variable criteria.</p>

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PROCESS FLOW DIAGRAM



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QUALITY / PROCESS CONTROL / CRITICAL PERAMETERS

Process Stage	Checking Frequency	Process Target	Minimum Tolerance	Maximum Tolerance	Corrective Action if Outside Tolerance	Person Accountable
Raw materials	Each delivery	As Supplier	As Supplier Spec	As Supplier Spec	Return to Supplier	Purchasing Department
Colours & flavours	Each delivery	Micro Analysis	As Supplier Spec	As Supplier Spec	Return to Supplier	Purchasing Department
Packaging	Each delivery	As Supplier	As Supplier Spec	As Supplier Spec	Return to Supplier	Purchasing Department
Batch ingredients	Each batch	As recipe	No Tolerance	No Tolerance	Re-weigh	Production Personnel
Sieving of powdered ingredients	Continuous	2mm square mesh	No Tolerance	No Tolerance	Re-place sieve	Q. C. & Production Personnel
Pastry deposit	Start up	3.5mm	No Tolerance	No Tolerance	Adjust deposit	Q. C. & Production Personnel
Lemon filling deposit weight	Start-up & Every ½ hour	0.900kg	No Tolerance	0.925kg	Re-weigh / adjust deposit	Q. C. & Production Personnel
Meringue topping deposit	Start-up & Every ½ hour	Peaked complete cover over lemon	No Tolerance	No Tolerance	Adjust deposit	Q. C. & Production Personnel
Baking Temperature	Each batch	170°C	160°C	180°C	Adjust temperature setting	Production Personnel
Baking Time	Each batch	50 Minutes	45 Minutes	55 Minutes	Adjust time setting	Production Personnel
Baking Temperature	Each batch	Minimum Core Temperature	80°C	100°C	Adjust temperature setting	Production Personnel
Organoleptic	Each batch	Free from taint	No Tolerance	No Tolerance	Reject	Q. C. & Production Personnel
Product make up	Continuous	As description	No Tolerance	No Tolerance	Reject	Production Personnel
Check weighed	Start-up & Every ½ hour	1.700kg	1.600kg	1.800kg	Reject under weights / adjust deposit	Q. C. & Production Personnel
Microbiological analysis	Each batch	As page 7	As page 7	As page 7	As page 7	Laboratory Personnel / Technical Manager
Portions Count	Continuous	12 portions	No Tolerance	No Tolerance	Reject	Q. C. & Production Personnel
Metal detection	Continuous	4mm ferrous/4mm non ferrous 6mm stainless steel	No Tolerance	No Tolerance	Reject	Q. C. & Production Personnel
Metal detector	Hourly	4mm ferrous/4mm non ferrous 6mm stainless steel	No Tolerance	No Tolerance	Retest previous hours production	Q. C. & Production Personnel
Case count	Continuous	1 x 12 portions	No Tolerance	No Tolerance	Correct	Production Personnel
Production code	Continuous	4 digit code (Year, 3 digit Julian calendar code)	No Tolerance	No Tolerance	Correct	Production Personnel
Best Before Date	Continuous	24 months from date of manufacture	No Tolerance	No Tolerance	Correct	Production Personnel
Bulk freezer temperature	-18°C or colder	9 x daily	Minus 15°C	Minus 23°C	Contract engineer called	Q. C. & Production Personnel

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FACTORY QUALITY ASSURANCE CHECKS

Check	Frequency	Standard	Corrective Action When Required	Person Accountable
Glass Substitutes Audit	Monthly	Damages / Breakages Reported	Damages / Breakages Addressed	Q. C. Personnel
Pest Control	12 technical and 4 routine visits per annum	Special Reporting Service	As recommended by Contractor	Technical Manager
Scales / Balance Log and Calibration Record	Weekly	Various, according to scales capacity (+/-1g / 5g)	Recalibrate scale / balance	Q. C. Personnel
Thermometers & Probe Calibration Record	Monthly	+/- 1°C	Recalibrate	Q. C. Personnel
Quality Control Check	Daily	In house	Address immediately	Q. C. Personnel
Hygiene	Daily	As cleaning schedules	Re-clean	Hygiene Supervisor
Random Product Taste Panel	Each batch	As set quality parameters	Assess and quarantine / release as necessary	Technical Manager/ Q. C. Personnel

MICROBIOLOGICAL STANDARDS

Test	Incubation Temperature	Incubation Period	Acceptable Limit	Rejection Limit	Action When > Rejection Limit
Enterobacteriaceae	37°C	24 Hours	<10 cfu/g	>10 cfu/g	Quarantine & retest 3 times. Release / reject
E. coli	44°C	24 Hours	<10 cfu/g	>10 cfu/g	Quarantine & retest 3 times. Release / reject
Total Viable Count	30°C	48 Hours	<100,000 cfu/g	>100,000 cfu/g	Quarantine & retest 3 times. Release / reject
Staphylococcus aureus	37°C	48 Hours	<20 cfu/g	>20 cfu/g	Quarantine & retest 3 times. Release / reject

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PACKAGING

Immediate / Inner:		
Material / Grade	Dimensions	Weight (per unit)
P.E coated food grade cakeboard	229mm	28.4g (x 1)
P.E coated food grade collar	865mm x 80mm	16.6g (x 1)
Collar Label	80mm x 40mm	0.17g (x1)
Grease Proof Paper	270mm x 270mm	2.3g (x1)

Secondary / Outer:		
Material / Grade	Dimensions	Weight (per unit)
Cardboard 135K/110B/130T	(L)291mm, (W)291mm, (H)90mm	163g (x 1)
Self adhesive label (black on white)	214mm x 140mm	2.8g (x 1)

Transit:		
Material / Grade	Dimensions	Weight (per unit)
Stretch wrap	Variable / not applicable	Variable / not applicable

PALLET CONFIGURATION

Units per outer case	1
Cases per layer	12
Layers per pallet	16
Total cases per pallet	192

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DECLARATION

This product specification is the property of C D T Sidoli (Welshpool) Ltd and should not be disclosed to a third party without prior written notice from an authorised member of C D T Sidoli (Welshpool) Ltd.

C D T Sidoli (Welshpool) Ltd reserve the right to change specifications of own label product as required.

The manufacture, primary processing, packaging and storage operations described within this specification are in accordance with all appropriate U.K and E.U food, hygiene packaging, weights & measures and trades description legislation, in operation at the current time.

This specification will supersede all previous specifications, for this product, supplied. If you do not respond in writing within the next 14 days, we will acknowledge this as your full acceptance of the details contained within this product specification.

Signed on behalf of:	C D T Sidoli (Welshpool) Ltd
Signature:	JA Williams
Name of Person Signing:	Jackie Williams
Title:	Specifications Technologist
01/06/17	09/11/2020