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	Date : 13.06.05	Revised Date : 18/06/2019
	Product Name : Fresh Pasteurised Homogenised Whole Milk	
	Section : GTD.QAM 018 PB 014	Authorised By: G McAuley

**& CONFIDENTIAL**

<b>Product Name:</b> Fresh Whole Milk		<b>Brand Name :</b> Dale Farm
<b>Pack Size :</b> 250ml Elopak carton, 1 Pint, 1 Litre, 2 Litre & 3 Litre Polybottles, Pergal, Pallecon & Bulk		
<b>Customer Name :</b> Various		
<b>Customer Contact Name :</b>		<b>Customer Address :</b>
<b>Position :</b>		
<b>Supplier Product Code:</b>		
<b>Manufacturing Site/Address:</b> Pennybridge Industrial Estate Larne Road Ballymena Co.Antrim N.Ireland BT42 3HB		
<b>Health Mark :</b> UK NI 215M EC		
<b>Telephone:</b>		028 256 61520
<b>Fax:</b>		028 256 61521

**Product Description :**

Fresh Pasteurised homogenised standardised Whole Milk with a fat content of >3.5% produced from raw milk of good bacteriological quality. Free from off colours, off flavours, discolouration and foreign matter.

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### INGREDIENT DECLARATION

(in descending order by weight)

INGREDIENTS	DESCRIPTION	%	SUPPLIER	COUNTRY OF ORIGIN
Fresh Raw Milk		100	United Dairy Farmers	N.Ireland

Ingredient list for declaration purposes on packaging

Added Ingredients (e.g. fruit mixes) –

Name	Declaration

### FOOD INTOLERANCE DATA

FREE FROM	YES/NO	Identify Source
Additives	Yes	
Benzoate (E210 - E219)	Yes	
Colours + AZO + Coal Tar Dyes	Yes	
Corn/Maize Derivatives	Yes	
BHA/BHT (E320, E321)	Yes	
Egg & Egg Derivatives	Yes	
Flavour Enhancers	Yes	
Gluten	Yes	
Milk & Milk Derivatives	No	
Yeast & Yeast Derivatives	Yes	
Garlic	Yes	
Honey	Yes	
Added Sugar	Yes	
Added Salt	Yes	
Lactose, Galactose and galactosides	Yes	
Gelatine	Yes	
Cocoa	Yes	
Hydrolysed Vegetable Protein	Yes	
Sweeteners Containing Aspartame	Yes	
Polyols	Yes	
Glutamates - MSG	Yes	
Natural Colours	Yes	
Preservatives	Yes	
Animal products (other than milk products )	Yes	
Genetically Modified Soya & Maize	Yes	



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Caffeine	Yes	
Malt Extract	Yes	
Nuts & Nut Derivatives	Yes	
Fruit & Fruit Derivatives	Yes	
Seafood / Seafood Derivatives	Yes	
Seeds & Seed Derivatives	Yes	
Sesame Seeds /Oil	Yes	
Soya & Soya Derivatives	Yes	
Sulphur Dioxide (E220 - E228)	Yes	
Wheat & Wheat Derivatives	Yes	

Suitable For	Y/N	Identify Source
Suitable for OVA - Lacto Vegetarians	Yes	
Suitable for Vegans	No	
Kosher	<b>Yes</b>	<b>Not certified</b>
Halal	<b>Yes</b>	<b>Not certified</b>
Coeliacs	<b>Yes</b>	
Diabetics	<b>Yes</b>	
PKU (phenyl ketone uriacs)	<b>Yes</b>	

See allergens in bold: Contains **Milk**

### NUTRITIONAL INFORMATION

Information (Source National Dairy Council)	
Typical values per 100ml	
Energy	266kJ/64kcal
Fat	3.5g
of which saturates	2.2g
Carbohydrate	4.7g
of which sugars	4.7g
Protein	3.2g
Salt	0.14g
Vitamin B <sub>12</sub>	0.4µg (16% NRV)
Calcium	120mg (15% NRV)



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## Primary

Item	Material	Supplier	Pack Wt	Pack Dimensions (mm)		
				W	D	H
250 ml Carton	PE-B-PE	Elopa k	See Tare Wts	70mm	70mm	80mm
1 Pint Carton	PE-B-PE	Namp ak		87.5mm	71.5mm	138mm
1 Litre	HDPE	Namp ak		87.5mm	71.5mm	225mm
2 Litre	HDPE	Namp ak		130mm	92mm	247mm
3 Litre	HDPE	Namp ak		173mm	90.6mm	263mm
Cap	HDPE	Cover is		N/A	N/A	N/A
1 Litre Label	Polypropylene	Stam piton		N/A	N/A	N/A
2 Litre Label	Polypropylene	Stam piton		N/A	N/A	N/A
3 Litre Label	Polypropylene	Stam piton		N/A	N/A	N/A
Bag in Box	Polypropylene	CHEP		N/A	N/A	N/A

## Secondary

Pallet configuration dependant on customer order

Item	Item Code	Material	Supplier	Case Wt	Case Dimensions (mm)		
					W	D	H
Shrinkwrap	PPLS00003	Polyethylene	Brow packaging	5.683	315	160	112

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### ANALYTICAL REQUIREMENTS

#### CHEMICAL ANALYSIS

TEST	TARGET	Report	FREQUENCY
Taste	Normal	Abnormal	1 <sup>st</sup> & Last Samples
FPD (°H)	≥ 535	< 530	1 <sup>st</sup> & Last Samples
Phosphatase	< 300	> 300	1 <sup>st</sup> & Last Samples
Antibiotics	≤ 0.006iu		1 <sup>st</sup> & Last Samples
Butter Fat	>3.5%		1 <sup>st</sup> & Last Samples

#### MICROBIOLOGICAL ANALYSIS


ORGANISM & TEST METHOD	TARGET LIMIT	REJECT LIMIT	FREQUENCY OF TEST
Entros	< 1	>5ml	Each Batch
TVC	< 5000	>10000	Each Batch
Salmonella	Abs	Present	Monthly
Listeria	Abs	Present	Monthly
S.Aureus	< 10	>10	Monthly

#### PHYSICAL ANALYSIS

METHOD	TARGET LIMIT	REJECT LIMIT	FREQUENCY OF TEST
Batch & Date Code	Correct & Legible		Each Batch
Temperature	< 5.0 oC	> 6.0 oC	Each Batch

#### ORGANOLEPTIC PARAMETERS

<b>Assessment Conditions</b>
<b>Appearance/Colour Uniform creamy white flowing liquid</b>
<b>Odour Free from any Uncharacteristic odours</b>
<b>Taste Sweet fresh creamy flavour</b>
<b>Texture Slight creamy mouth feel</b>
Sample from each batch is held until the end of shelf life and assessed.

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### SHELF LIFE AND STORAGE CONDITIONS

<b>Coding Format Used:</b> Use By Date	
<b>Inner</b>	Ink jet coded on top of carton Bottles – embossed on foil lid Polybottles – inkjet on side of bottle Pergal – ink stamp on box exterior
<b>Outer</b>	N/A
<b>Batch/Traceability Code</b>	From Use By Date


<b>Product Shelf Life :</b> Date of Fill + 11 days
<b>Once Opened Instructions :</b> Once opened +3 days
<b>Freezing Instructions / Suitable for Freeze</b>
<b>Delivery/Transport/Storage Conditions :</b>  Chilled Storage < 6oC Product distributed in clean vehicles, display in chilled units < 7oC

### **PRODUCT BARCODE INFORMATION**

Flavour / pack description	Single unit bar code	Sales unit bar code
250ml	5000245002666	
1 Litre	5000245002826	
1 Pint	5010386023000	
2 Litre	5000245001720	
3 Litre	5000245003212	

### **WEIGHT CONTROL (Specific Gravity 1.032g/ml )**

Declared Pack Weight	Product Tare Weight	Target Weight	T1	T2
250ml	15.7g	250	241	232
1 Litre	28.7g	1000	985	970
1 Pint	18.7 g	568	553	538
2 Litre	43 g	2000	1970	1940
3 Litre	71.5 g	3000	2955	2910

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### PALLETISATION

On returnable pallets / Wooden Pallets or Metal Supermarket Trolleys


Pack size	Pks / Row	Trays / layer	Layers /pallet	Trays /pallet	Pks /Trolley
250ml	10	N/A	N/A	N/A	NA
1 Litre	35	N/A	N/A	N/A	140
1 Pint	40	N/A	N/A	N/A	160
2 Litre	20	N/A	N/A	N/A	80
3 Litre	12	N/A	N/A	N/A	48

Pallet secured By : **Strapped on the Vehicle**

Pallet labelled with delivery details and storage conditions

### METHOD OF MANUFACTURE

- Raw milk intake and tanker acceptance - Before offloading raw milk tanker the following laboratory tests are conducted. FPD, Antibiotics, Taste, Temperature. The ACCOS process control system controls raw milk silo washing and all tankers are washed on daily basis. The filter checked and recorded daily.
- Connecting hose to tanker - This hose is kept with a blank end except when in use.
- Off load milk to raw milk silo via plate cooler
- Silo discharge - There is no rework of any kind to fresh milk products
- Centrifugal Separation standardisation - This system uses a density transmitter which is checked throughout each day by both milkoscan and gerber testing. The standardisation targets are 3.5% fat minimum for whole milk, 1.5 - 1.8% fat for semi skimmed milk, Maximum 0.3% fat skimmed target less than 0.1% for skimmed milk
- Homogenisation
- Pasteurisation - Divert set at 72.5oC checked daily and also fluorophos testing with a holding time of 30 seconds
- Cooling exit pasteurisation - The milk is chilled to between 1 and 5oC
- Pipelines to finished milk tanks
- Finished milk silos
- Lines to fillers - Inline filters on a PM schedule for inspection
- Packaging Delivery - On delivery of all packaging, the condition of the load is checked and recorded. The bottles are blown onsite by Nampak and are inverted prior to filling. The caps are supplied for IHS sealing and are received in bags from which the traceability information is recorded. The bags are decanted out of cardboard boxes and wheeled into the filling hall in covered plastic containers. All the bottle lines to fillers are covered.
- Filling machines - Each filling machine is positively released by biotrace prior to filling, and prestart checks completed to ensure that no foreign body risks exist. The milk is tested for butterfat, taste and FPD throughout production and all label changes are cross checked to

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ensure that the correct label is applied. Each unit is inkjet coded on the side of the bottle and this is cross checked by the laboratory and the operator. The bottles are sealed by Induction heat seal and the frequency, cold spot and tab are checked throughout production. A sentry emits and audible alarm should the foil be missing or cap high.

14. Transfer to trolleys - this is completed using a NEPAS/KLIKLOK trolley packer
15. Holding Chill - Controlled by scada system highlighting any temperature issues.
16. Despatch & Transport - Each unit is checked on loading, despatch and on delivery <5oC

### PERSONNEL TRAINING

All personnel receive induction training and are trained to the minimum level Food Hygiene standard. Machine operators receive full training on relevant machinery, cleaning systems, chemicals handling and use etc.

### GENERAL

All processes and procedures are carried out under hygienic conditions and in accordance with good manufacturing practices of the dairy and food industry.

The product to comply with all relevant UK and EC statutory requirements.

Signed : 

Date : 14/05/2018