




AMP SPEC IRE 02 External		Document No.	AMP SPEC IRE 02-62	 ALLIED MILLS
Status	Published 17/10/ 2022	Revision	6	
Owner	David Kerr			
2732 Snowflake Soda				

LIMS Date of Issue: 8th December 2011 (1621)		
LIMS Revision No: 19 (1621)		
Supplied as:	Bulk	Bags

Allied Mills / Customer Agreement:

Supplier:	Allied Mills	
Approval name: (Please print)	DAVID KERR	Specification reviewed and agreed. If changes are made this specification will be reviewed and re-issued.
Approval signature:		
Job title:	TECHNICAL SERVICES MANAGER	
Date:		
Customer:		
Approval name: (Please print)		Specification reviewed and agreed.
Approval signature:		
Job title:		
Date:		
Customer:		

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Warranty:

All products and packaging supplied by Allied Mills do not contain any genetically modified materials, additives or processing aids.


All products and packaging supplied by Allied Mills will comply with one of the following:

- i. British Retail Consortium Certification, AIB or equivalent
- ii. All applicable hygiene and food safety legislative and regulatory requirements.

These certifications, legislative and regulatory requirements include reference to Mycotoxins, Pesticide Residues and Heavy Metals, further information available on request.

This flour will comply with the following:


- i. Bread and Flour Regulations 1998
- ii. Bread and Flour Regulations (Northern Ireland) 1998
- iii. Commission Regulation (EU) No 231/2012 of 9 March 2012 laying down specifications for food additives listed in Annexes II and III to Regulation (EC) No 1333/2008 of the European Parliament and of the Council
- iv. Regulation (EC) No 1925/2006 of the European Parliament and of the Council of 20 December 2006 on the addition of vitamins and minerals and of certain other substances to foods

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Flour Specification

Name & Address:

	Supplier	Manufacturing site
Name:	Allied Mills	AM James Neill
Address:	AM Central Office Port of Tilbury Tilbury Essex RM18 7JR	1 College Place North Belfast BT1 6BG
First Contact:	Customer Services Administrator	Barry Kelly
Position:		General Manager
Second Contact:	(Orders)	David Kerr
Position:	Customer Services Administrator	Technical Services Manager
Telephone no:	0161 785 2971	07894 295690 02890 260 793
Fax no:	0161 788 9590	02890 248196
Email address:	customer.services@allied-mills.co.uk	barry.kelly@allied-mills.co.uk david.kerr@allied-mills.co.uk
Emergency 24 hr Telephone no	0161 785 2971	
Sedex number	AM James Neill	ZS1022123

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General Product Description:

Wheat Flour with Statutory Additives, Raising Agent and Salt added.

Legal Name:

Wheat Flour with Statutory Additives, Raising Agent and salt added

Storage Conditions:

Cool & Dry.

Shelf Life:


Unopened:	9 Months
Once open:	This product is best used as soon as possible after opening, however when stored according to the specified storage conditions in a sealed container, kept dry and free from contaminants this product may be used until the BBE date.

Coding Details:

Bulk: - Weighbridge Ticket Number. AML Sales Order, Despatch Note Number.
Bags - As above plus sequential bag nos. Packing date. Best Before Date. Job Number

Packaging Materials Description/Pallet Configuration:

Primary:	1.5kgs 1ply
Secondary:	Bags: Shrinkwrap per case
Tertiary:	Bags: Stretchwrap complete pallet
Pallet Layout:	10 (10 x 1.5kgs) x 7
Net Weight Per Pallet:	1.050 tonnes (excl pallet)

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Sensory Characteristics:

General Appearance:	White Flour milled from cleaned wheat, free flowing and free from infestation or extraneous matter.
Aroma:	No adverse odours
Flavour:	No adverse flavours
Texture:	Free flowing fine powder


Recipe Breakdown:

Ingredient		Country of origin	%
Wheat Flour		UK	93-95%
Statutory Nutrients (UK and EU Compliant)	Calcium Carbonate	France	0.4%
	Thiamin (Thiamine Hydrochloride)	China	
	Niacin (Nicotinamide)	China / India	
	Iron (Reduced Iron Powder)	India	
Raising Agent: Sodium Acid Pyrophosphate (E450i)		Germany / France/ Thailand	<5.0%
Raising Agent: Sodium Bicarbonate (E500)		UK	
Salt		UK	1.0%

Ingredient Declaration:

Wheat Flour (with Calcium, Iron, Niacin, Thiamin), Raising Agents: Disodium Diphosphates, Sodium Hydrogen Carbonates, Salt


For allergens, including cereals containing Gluten, see ingredients highlighted in **bold**.

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Physical & Chemical Analysis:

Test	Method	Min	Target	Max
Protein	NIR (N x 5.7)	9.0		10.4
Moisture	NIR	13.2		14.6
Water Absorption	NIR	54.5		58.0
CO2	Chittick	0.7		1.0
Tristimulus L* - b*	NIR	77.0		

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White Flour Microbiological Specification

Test	Target	Maximum
Total Aerobic Count	<5x10 ⁵ (<500,000) cfu/g	1x10 ⁶ (1,000,000) cfu/g
Mould	<1x10 ³ (<1000) cfu/g	5x10 ³ (5000) cfu/g
Yeast	<1x10 ³ (<1000) cfu/g	5x10 ³ (5000) cfu/g
Mesophilic Spores	<1x10 ² (<100) cfu/g	8x10 ² (800) cfu/g
<i>Escherichia coli</i>	<1x10 ¹ (<10) cfu/g	1x 10 ² (100) cfu/g
<i>Staphylococcus aureus</i>	<2x10 ¹ (<20) cfu/g	1x10 ² (100) cfu/g
<i>Clostridium perfringens</i>	<1x10 ² (<100) cfu/g	1x10 ³ (1000) cfu/g
<i>Bacillus</i> species	<1x10 ² (<100) cfu/g	8x10 ² (800) cfu/g
<i>Bacillus cereus</i>	<1x10 ² (<100) cfu/g	5 x10 ² (500) cfu/g
<i>Salmonella</i> species	Absent in 25g	Absent in 25g
<i>Listeria monocytogenes</i>	Absent in 25g	1x10 ² (100) cfu/g

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Notes

. Microbiological contamination in grain-milling is typically primarily associated with outer layers of grain; more processed components might therefore be expected to have relatively lower microbial loading. There are no control processes in the milling of grains to remove microorganisms present on the raw material. Levels of organisms present on the grain may fluctuate due to the growing environment, harvesting & storage conditions and processing.

It is anticipated that wheat flour and pre-mixes will, at a minimum, receive a thermal treatment at least equivalent to a bread baking process as part of the manufacture of the final product. Such processes should be sufficient to inactivate all vegetative cells but may not inactivate all bacterial spores or destroy pre-formed heat stable toxins.

Semolina might be expected to receive more minimal heat processing (short exposure to boiling water). The antimicrobial effect is much less quantifiable but is likely to inactivate some vegetative cells and spores.

To avoid promoting growth of vegetative cells and development of spores or toxins, it should be noted that Good Manufacturing Practices must be employed by the customer at all points from receipt of milled products through to use in product.

Allied Mills does not recommend that products are eaten raw e.g. used as a dusting post heat processing.

Specification Setting

Target limits are based on the following information: -

- Review of 2017 AML flour test results and previous recommendations made in report 17_0410.
- NABIM Members Report MB/REP/142847 - The Microbiological Condition of *White Flours Milled from 2017 New Harvest Wheats*. See **Appendix I** for summary comparison compared to 2016 NABIM data and 2017 AML data. AML results overall were comparable or better than those obtained by NABIM.
- IFST, 1999: Development and use of Microbiological Criteria for Foods.
- Customer requirements for Semolina


Maximum limits listed are for guidance where target values are exceeded. Maximum limits are based on three criteria: -

- Typical minimum levels present of organisms capable of causing food poisoning or formation of toxins.
- Reduction of numbers of viable organisms by baking (bread products are taken to be the typical product of Flour, Bran and Germ).
- Pathogen levels required to meet 'ready to eat' guidelines [issued by the Health Protection Agency] should flour come into contact with post bake product.

Microbiological analysis is carried out annually as per industry survey and routine testing.


Microbiological sampling is random and is representative of the Mills products.

Flour is not positively released on microbiological results.

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Nutrition Information:

Analytical- State Test Method		Date of last review: October 2022
Theoretical – State Source of Data		
Parameter	Typical Values, per 100g	Test method/data source
Energy	1419 kj	Calculated using the values from McCance and Widdowson 7 th Edn
Energy	335 kcal	Calculated using the values from McCance and Widdowson 7 th Edn
Total Fat (g)	1.5	Calculated using the values from McCance and Widdowson 7 th Edn
Of which saturates (g)	0.4	Calculated using the values from McCance and Widdowson 7 th Edn
Mono-unsaturates (g)	0.2	Calculated using the values from McCance and Widdowson 7 th Edn
Polyunsaturates (g)	0.4	Calculated using the values from McCance and Widdowson 7 th Edn
Carbohydrate (g)	67.8	Calculated using the values from McCance and Widdowson 7 th Edn
Of which sugars (g)	0.6	Calculated using the values from McCance and Widdowson 7 th Edn
Protein (g) N x 6.25	10.6	AM Company Specification 9.7/5.7x6.25
Sodium (mg)	1470	Calculated
Salt (g)	3.7	
Dietary Fibre (g)	4.0	AOAC McCance


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Moisture (g)	13.9	AM Company Specification
Ash (g)	2.2	Typical Values
Calcium (mg)	120 (15% RI*)	Calculated (minimum levels)
Iron (mg)	2.1 (15% RI*)	Calculated (minimum levels)
Niacin (mg)	2.4 (15% RI*)	Calculated (minimum levels)
Thiamin (mg)	0.165 (15% RI*)	Calculated (minimum levels)

*RI – Reference Intake

Note: The values above are typical Allied Mills standards.


Nutrition Information	
	Typical Values Per 100g
Energy kj	1419 kj
Energy kcal	335 kcal
Fat (g)	1.5g
Of which saturates (g)	0.4g
Carbohydrate (g)	67.8g
Of which sugars (g)	0.6g
Protein (g)	10.6g
Salt (g)	3.7g

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Please note: *The contamination risks identified below are likely adventitious contaminants of flour. Wheat is cleaned before milling by a screen room designed to remove this contamination but we are unable to guarantee 100% removal if present.

Allergen Status


Allergen	Contains Yes / No	Contamination Risk Yes / No	Comments, including source of allergen
Cereals containing gluten (wheat) and products thereof	YES	N/A	Made from wheat
Cereals containing gluten (rye, barley, oats, spelt, kumat or their hybrid strains) and products thereof	NO	YES	*Potential contamination in raw material.
Crustaceans and products thereof	NO	NO	
Egg and products thereof	NO	NO	
Fish and products thereof	NO	NO	
Peanuts and products thereof	NO	NO	
Soybeans and products thereof	NO	YES	*Potential contamination in raw material.
Milk and products thereof	NO	YES	Cross contamination risk in statutory additive, whey powder used on same production line. Allergen controls and clean down in place absence validated via testing.
Nuts (almond, hazelnut, walnut, cashew, pecan, brazil, pistachio, macadamia and Queensland) and products thereof	NO	NO	
Celery and products thereof	NO	NO	
Lupin and products thereof	NO	NO	
Molluscs and products thereof	NO	NO	
Mustard and products thereof	NO	NO	
Sesame seeds and products thereof	NO	NO	
Sulphur Dioxide and sulphites at concentrations of more than 10	NO	NO	

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mg/kg or 10 mg/litre expressed as SO ₂			
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Food Intolerance Information

Food	Contains Yes / No	Contamination Risk Yes / No	Comments
Corn/Maize and products thereof	NO	YES	*Potential contamination in raw material.
Seeds and products thereof	NO	YES	*Potential contamination in raw material.
Fruit and products thereof	NO	NO	
Vegetable and products thereof	NO	NO	
Hydrolysed Vegetable Protein	NO	NO	
Textured Vegetable Protein	NO	NO	
Yeast	NO	NO	
Beef and products thereof	NO	NO	
Pork and products thereof	NO	NO	
Lamb/Mutton and products thereof	NO	NO	
Poultry and products thereof	NO	NO	
AZO and Coal Tar Dyes	NO	NO	
BHA/BHT	NO	NO	
Benzoates	NO	NO	
Natural and Artificial Colours	NO	NO	
Natural and Artificial Flavourings	NO	NO	
Caffeine	NO	NO	

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M.S.G. and Glutamates	NO	NO	
Added Salt	NO	NO	

Food Intolerance Information cont'd

Potassium based salt substitute	NO	NO	
Added Sugar	NO	NO	
Sweeteners	NO	NO	
Other additives	YES	N/A	Statutory additives(Calcium, Iron, Niacin, Thiamin), Salt, raising agents: E450i, E500

Special Dietary Requirements:

Does this product meet the following claims:	Yes/No
Suitable for Vegetarians	Yes
Suitable for Vegans	Yes
Suitable for Coeliacs	No
Suitable for Hindus	Yes
Kosher certificated	No
Halal certificated	No
Organic certificated	No

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