



<b>AMP SPEC IRE 02 External</b>		Document No.	AMP SPEC IRE 02-63	 <b>ALLIED MILLS</b>
Status	Published 08/08/2022	Revision	8	
Owner	David Kerr			
<b>2960 Original Medium Wholemeal 1.5Kgs</b>				

<b>LIMS Date of Issue: 12<sup>th</sup> June 2015 (New System)</b>			
<b>LIMS: Revision No: 12</b>			
<b>Supplied as:</b>	<b>Bulk</b>	<b>Bag</b>	

**Allied Mills / Customer Agreement:**

<b>Supplier:</b>	Allied Mills		
<b>Approval name: (Please print)</b>	DAVID KERR	Specification reviewed and agreed.  If changes are made this specification will be reviewed and re-issued.	
<b>Approval signature:</b>			
<b>Job title:</b>	TECHNICAL SERVICES MANAGER		
<b>Date:</b>	14/11/2022		
<b>Customer:</b>			
<b>Approval name: (Please print)</b>		Specification reviewed and agreed.	
<b>Approval signature:</b>			
<b>Job title:</b>			
<b>Date:</b>			


**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

<b>AMP SPEC IRE 02 External</b>		Document No.	AMP SPEC IRE 02-63	
Status	Published 08/08/2022	Revision	8	
Owner	David Kerr			
<b>2960 Original Medium Wholemeal 1.5Kgs</b>				

### Flour Specification

#### Name & Address:

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

<b>AMP SPEC IRE 02 External</b>		Document No.	AMP SPEC IRE 02-63	
Status	Published 08/08/2022	Revision	8	
Owner	David Kerr			
<b>2960 Original Medium Wholemeal 1.5Kgs</b>				

**General Product Description:**

Wholemeal Flour

**Legal Name:**

Wholemeal **Wheat** Flour

**Storage Conditions:**


Cool & Dry.

**Shelf Life:**

<b>Unopened:</b>	6 Months
<b>Once open:</b>	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:** (e.g. best before, production codes etc for traceability)

Bulk: - Order Number, Weighbridge Ticket no. Consignment ref. no. Mill ID  
Bags: As above plus sequential bag nos. Packing date. Best Before Date. Job Number

<b>AMP SPEC IRE 02 External</b>		Document No.	AMP SPEC IRE 02-63	 <b>ALLIED MILLS</b>
Status	Published 08/08/2022	Revision	8	
Owner	David Kerr			
<b>2960 Original Medium Wholemeal 1.5Kgs</b>				

**Packaging Materials Description/Pallet Configuration:**

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

**Sensory Characteristics:**

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


**Recipe Breakdown:**

<b>Ingredient</b>	<b>Country of origin</b>	<b>%</b>
<b>Wheat Flour</b>	UK	<b>100</b>

**Ingredient Declaration:**

Wholemeal <b>Wheat</b> Flour
------------------------------

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

<b>AMP SPEC IRE 02 External</b>		Document No.	AMP SPEC IRE 02-63	
Status	Published 08/08/2022	Revision	8	
Owner	David Kerr			
<b>2960 Original Medium Wholemeal 1.5Kgs</b>				


<b>LIMS Date of Issue: 12<sup>th</sup> June 2015 (New System)</b>		
<b>LIMS Revision No: 12</b>		
<b>Supplied as:</b>	<b>Bulk</b>	<b>Bag</b>

**Physical & Chemical Analysis:**

<b>Test</b>	<b>Method</b>	<b>Min</b>	<b>Target</b>	<b>Max</b>
<b>Protein</b>	<b>NIR (N x 5.7)</b>	<b>9.8</b>		<b>10.6</b>
<b>Hagberg Falling Number</b>	<b>NIR</b>	<b>270</b>		
<b>Moisture</b>	<b>NIR</b>	<b>13.8</b>		<b>14.6</b>
<b>Water Absorption</b>	<b>NIR</b>	<b>60.5</b>		<b>65.5</b>


**Sieving Analysis**

<b>Test</b>	<b>Method Simon Sifter</b>	<b>Min</b>	<b>Target</b>	<b>Max</b>
<b>Tails 10W</b>	<b>2194M</b>	<b>2.0</b>		<b>5.0</b>
<b>Tails 20W</b>	<b>1036M</b>	<b>24.0</b>		<b>30.0</b>
<b>Tails 26W</b>	<b>762M</b>	<b>6.0</b>		<b>8.0</b>
<b>Tails 64W</b>	<b>285M</b>	<b>6.0</b>		<b>8.0</b>
<b>Tails 8N</b>	<b>180M</b>	<b>1.0</b>		<b>5.0</b>
<b>Tails 10N</b>	<b>132M</b>	<b>3.0</b>		<b>8.0</b>
<b>Thros 10N</b>	<b>132M</b>	<b>44.0</b>		<b>50.0</b>

<b>AMP SPEC IRE 02 External</b>		Document No.	AMP SPEC IRE 02-63	
Status	Published 08/08/2022	Revision	8	
Owner	David Kerr			
<b>2960 Original Medium Wholemeal 1.5Kgs</b>				

Wholemeal /Brown Flour Microbiological Specification

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

<b>AMP SPEC IRE 02 External</b>		Document No.	AMP SPEC IRE 02-63	
Status	Published 08/08/2022	Revision	8	
Owner	David Kerr			
<b>2960 Original Medium Wholemeal 1.5Kgs</b>				

**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.

<b>AMP SPEC IRE 02 External</b>		Document No.	AMP SPEC IRE 02-63	 <b>ALLIED MILLS</b>
Status	Published 08/08/2022	Revision	8	
Owner	David Kerr			
<b>2960 Original Medium Wholemeal 1.5Kgs</b>				

**Nutrition Information:**

<b>Analytical- State Test Method</b>		<b>Date of last review:</b> <b>September 2019</b>
<b>Theoretical – State Source of Data</b>		
<b>Parameter</b>	<b>Typical Values, per 100g</b>	<b>Test method/data source</b>
Energy	1380 kj	Calculated using the values from McCance and Widdowson's 7 <sup>th</sup> Edn
Energy	327 kcal	Calculated using the values from McCance and Widdowson's 7 <sup>th</sup> Edn
Total Fat (g)	2.0	Calculated using the values from McCance and Widdowson's 7 <sup>th</sup> Edn
Of which saturates (g )	0.3	Calculated using the values from McCance and Widdowson's 7 <sup>th</sup> Edn
Mono-unsaturates (g )	0.2	Calculated using the values from McCance and Widdowson's 7 <sup>th</sup> Edn
Polyunsaturates (g )	0.9	Calculated using the values from McCance and Widdowson's 7 <sup>th</sup> Edn
Carbohydrate ( g )	61.0	Calculated using the values from McCance and Widdowson's 7 <sup>th</sup> Edn
Of which sugars (g )	1.4	Calculated using the values from McCance and Widdowson's 7 <sup>th</sup> Edn




<b>AMP SPEC IRE 02 External</b>		Document No.	AMP SPEC IRE 02-63	 <b>ALLIED MILLS</b>
Status	Published 08/08/2022	Revision	8	
Owner	David Kerr			
<b>2960 Original Medium Wholemeal 1.5Kgs</b>				

Protein ( g ) N x 6.25	11.2	AM Company Specification 10.2/5.7x6.25
Sodium ( mg )	2.0	Calculated
Salt ( g )	0.005	
Dietary Fibre ( g )	10.1	AOAC McCance
Moisture ( g )	14.2	AM Company Specification
Ash ( g )	1.6	Typical Values

**Note:** 1) The values above are typical Allied Mills standards.


<b>Nutrition Information</b>	
<b>Typical Values</b>	<b>Per 100g</b>
Energy Kj	1380 kj
Energy Kcal	327 kcal
Fat (g)	2.0g
Of which saturates (g)	0.3g
Carbohydrate (g)	61.0g
Of which sugars (g)	1.4g
Protein (g)	11.2g
Salt (g)	< 0.1g

<b>AMP SPEC IRE 02 External</b>		Document No.	AMP SPEC IRE 02-63	 <b>ALLIED MILLS</b>
Status	Published 08/08/2022	Revision	8	
Owner	David Kerr			
<b>2960 Original Medium Wholemeal 1.5Kgs</b>				

**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**

<b>Allergen</b>	<b>Contains Yes / No</b>	<b>Contamination Risk Yes / No</b>	<b>Comments, including source of allergen</b>
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	NO	
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 mg/kg or 10 mg/litre expressed as SO <sub>2</sub>	NO	NO	

<b>AMP SPEC IRE 02 External</b>		Document No.	AMP SPEC IRE 02-63	 <b>ALLIED MILLS</b>
Status	Published 08/08/2022	Revision	8	
Owner	David Kerr			
<b>2960 Original Medium Wholemeal 1.5Kgs</b>				

**Food Intolerance Information**

<b>Food</b>	<b>Contains Yes / No</b>	<b>Contamination Risk Yes / No</b>	<b>Comments</b>
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	
M.S.G. and Glutamates	NO	NO	
Added Salt	NO	NO	
Potassium based salt substitute	NO	NO	
Added Sugar	NO	NO	
Sweeteners	NO	NO	
Other additives	NO	NO	

<b>AMP SPEC IRE 02 External</b>		Document No.	AMP SPEC IRE 02-63	
Status	Published 08/08/2022	Revision	8	
Owner	David Kerr			
<b>2960 Original Medium Wholemeal 1.5Kgs</b>				

**Special Dietary Requirements:**

<b>Does this product meet the following claims:</b>	<b>Yes/No</b>
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