

FINISHED PRODUCT SPECIFICATION

Golden Bake Ltd.
4 Newtown Park, Malahide Road Industrial Park, Coolock, Dublin 17, Ireland



Product Code: **P31**

Date: **23.05.2023**

Version: **11**

1. PRODUCT DESCRIPTION

Product Name	Puff Pastry Sheets
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Product Description	Frozen unbaked plain puff pastry sheets		
Legal Name	Plain Puff Pastry Sheets		
CUC / EAN Code (Inner)	N/A		
TUC / ITF code (Outer)	05099339005584		
Country of Origin	Manufactured in Ireland	Quantity & Size	16 x 680g
Product Shelf Life	18 months from date of manufacture.	Net Weight	10.88kg
Minimum Shelf Life (75% out of the Shelf Life)	13.5 months	Average Weight	No
Baked Shelf Life	As this product would be classed as a component in a product, the baked shelf life would have to be determined by the end user as various components would affect its shelf life.	"e" mark	No

Claims (e.g., RSPO, Suitable for Vegetarian etc.)	Logo
✓ RSPO: RSPO-1106317	

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2. INGREDIENTS

Ingredients & Sub ingredients	E No.	Function	Allergen	Country of Origin
1. Puff Pastry (GBOD 200/201)				
1.1 Wheat Flour [RM025 / RM026 /RM140]			Wheat	UK
1.1.1 Wheat Flour				Germany, UK, USA, France, Sweden, Canada, Poland (*Due to weather conditions during harvest country of origin may vary). (Wheat Gluten may be added to this product to meet protein specification. Gluten may originate from any of the listed countries: UK, Belgium, France, Germany, Lithuania)
1.1.2 Statutory Nutrients				UK and EU Compliant
1.1.2.1 Calcium Carbonate				France
1.1.2.2 Iron				India, USA, Sweden
1.1.2.3 Niacin				China, India
1.1.2.4 Thiamin				China
1.1.3 Alpha-Amylase (Processing aid)		Flour treatment agent		Finland, France, Germany, Netherlands, Denmark, Sweden
1.2 Pastry Margarine [RM027/RM131]			N/A	UK
1.2.1 Palm Oil				Papua New Guinea, Solomon Isles, Malaysia, Indonesia, Colombia, Guatemala, Costa Rica, Honduras, Peru, Ecuador, Brazil
1.2.2 Water				UK
1.2.3 Rapeseed Oil				Austria, Australia, Belgium, Bulgaria, Croatia, Cyprus, Czech Republic, Denmark, Estonia, Finland, France, Germany, Greece, Hungary, Italy, Ireland, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Poland, Portugal, Romania, Russia, Serbia, Slovenia, Slovakia, Spain, Sweden, Ukraine, Uruguay, and UK
1.2.4 Salt				UK
1.2.5 Mono- and Diglycerides of Fatty Acids	E471	Emulsifier		Denmark
1.2.6 Citric Acid (Processing aid)	E330	Chelating agent		UK, Belgium, China, Turkey
1.2.7 Sodium Hexacyanoferrate (Processing aid)	E535	Anticaking agent		China
1.3 Water			N/A	Ireland
Ingredients: Wheat Flour [Wheat Flour, Calcium Carbonate, Iron, Niacin, Thiamin], Margarine [Vegetable Oils (Palm, Rapeseed), Water, Salt, Emulsifier (Mono-and Diglycerides of Fatty Acids)], Water.				

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ALLERGENS:

Contains: For allergens, including cereals that contain gluten, see ingredients in **bold**.

May Contain: May also contain traces of barley, oats, milk, egg, soya, and mustard.

Detailed production recipe confidential.

For details, see recipes no.: GBOD 200/201

Special consumer consideration:	Not suitable for infants and people with difficulties consuming solid food and for people with allergies to Gluten (present in all products), Milk, Egg, Soya, and Mustard. Each product is labelled accordingly for allergens present in the product and "May contain" allergens.
Intended use by Consumer:	Suitable for general population.
Handling and preparation:	Frozen, must be baked as per baking guideline present on the label.

3. PROCESS

Process Description

Step 1: Intake of Raw Materials
Step 2: Storage of Raw Materials
Step 3: Decant/ Debox of Raw Materials (if applicable)
Step 4: Sieving of dry ingredients (Flour)
Step 5: Weigh up of ingredients
Step 6: Mixing on Line (trimmings added at this stage)
Step 7: Extrusion of fat and dough
Step 8: Lamination of pastry dough
Step 9: Euroline cutter
Step 10: Weight Checks – Pastry/ Finished Product
Step 11: Freezing- Spiral Freezer
Step 12: Bake Tests
Step 13: Packing & Labelling
Step 14: Metal Detection (CCP1)
Step 15: Checkweigher
Step 16: Palletisation/ Shrink Wrap
Step 17: Freezer- Storage Freezer (-18°C)
Step 18: Despatch

Process Control Points / Critical Control Points

- * Raw Materials intake checks and inspection
- * Storage temperature checks
- * Correct Ingredients / Recipe
- * In process raw material / mix temperature
- * Pastry trimmings pH Level
- * Fat vs dough ratio checks

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Date: **23.05.2023**

Version: **11**

- * Finished product weight checks
- * Finished product dimension checks
- * Bake off Tests
- * Finished product core temperature checks
- * Coding and Labelling
- * Metal detection (CCP1)
- * Finished Product case weight
- * Finished Product box count
- * Average pallet temperature check and trailer temperature at dispatch

4. SPECIFIC QUALITY REQUIREMENTS

Weight Control

EU legislation in use. Minimum weight system.

System in use: Continuous online check weigher. Pack weight automatically recorded on system.

Minimum Weight Product:

Net weight: 10.88kg Gross weight: 11.30kg

Metal Detection

Test pieces used:

Ferrous: 2.0mm

Non-Ferrous: 2.5mm

Stainless steel: 3.0mm

MD Program used: Frozen. Small Metal Pieces

Program can be changed to Frozen Large Metal Pieces Fe:3.0mm NF:3.5mm SS:4.0mm (refers to temperature sensitive product where the temperature is close to -5°C).

5. NUTRITION

Nutritional Analysis

Calculated

Frozen

Analysed

Baked

Typical Values	Per 100g	% Reference Intake per 100g	Reference Intake (RI*)
Energy (kJ)	1664	21	8400kJ
Energy (kcal)	400	21	2000kcal
Fat (g)	27	41	70g
Saturates (g)	14	70	20g
Mono-unsaturates (g)	9.4		
Polyunsaturates (g)	2.8		
Trans Fatty Acids (g)	0.0		
Carbohydrate (Available) (g)	32	14	260g
Sugars (g)	<0.5	4	90g

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Fibre (g)	1.6		
Protein (g)	6.0	12	50g
Sodium (mg)	195		
Salt (g)	0.49	9	6g
Ash(g)			
Moisture (g)			

*Reference intake of an average adult.

This pack contains **16** servings.

6. MICROBIOLOGICAL ANALYSIS

Microbiological Analysis (for more details see GBOD 401)			
Test Carried Out	Target (cfu/g)	Maximum (cfu/g)	Frequency
TVC@30°C, 48 hrs	<1 x 10 ⁶	1 x 10 ⁷	Each product type, when in production to be sampled monthly.
Lactic Acid Bacteria	<1 x 10 ⁶	1 x 10 ⁷	
Staph. aureus	<1 x 10 ²	5 x 10 ²	
Yeasts	<1 x 10 ³	<1 x 10 ⁵	
Moulds	<1 x 10 ³	<1 x 10 ⁴	
Bacillus cereus (spp)	<1 x 10 ³	1 x 10 ⁴	

7. ALLERGEN/DIETARY TABLE

	Present in Product	Used on the line	Used on Site
Cereals containing GLUTEN	YES	YES	YES
- WHEAT	YES	YES	YES
- SPELT	NO	NO	NO
- RYE	NO	NO	NO
- BARLEY	NO	YES	YES
- OATS	NO	YES	YES
CRUSTACEA and products thereof	NO	NO	NO
FISH and products thereof	NO	NO	NO
PEANUTS and products thereof	NO	NO	NO
EGGS and products thereof	NO	YES	YES
SOYA and products thereof	NO	YES	YES
MILK and products thereof	NO	YES	YES
MUSTARD and products thereof	NO	YES	YES
NUTS (almond, hazelnut, walnut, cashew nut, pecan, brazil, pistachio, macadamia / Queensland nut) and products thereof	NO	NO	NO
CELERY and products thereof	NO	NO	NO
SESAME and products thereof	NO	NO	NO
SULPHUR DIOXIDE and SULPHITES (at levels above 10mg/kg)	NO	YES	YES

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Version: 11

LUPIN and products thereof	NO	NO	NO
MOLLUSCS and products thereof	NO	NO	NO
Artificial Colour	NO	N/A	N/A
Natural Colour	NO	N/A	N/A
Artificial Flavour	NO	N/A	N/A
Natural Flavour	NO	N/A	N/A
Hydrogenated Vegetable Oil (HVO)	NO	N/A	N/A
Artificial Trans Fatty Acids	NO	N/A	N/A
Artificial Preservatives	NO	N/A	N/A
Alcohol	NO	N/A	N/A
Seeds and products thereof	NO	N/A	N/A

8. PHYSICAL, CHEMICAL AND MICROBIOLOGICAL PARAMETERS

Physical Parameters				
Parameter	Test carried out	Minimum	Target	Maximum
Pastry Weight	In line weight check	680g	694g	N/A
Filling Weight	In line weight check	N/A	N/A	N/A
Topping Weight	In line weight check	N/A	N/A	N/A
Finished Product Weight	In line weight check	680g	694g	N/A
Length	Physical check	580mm	580mm	N/A
Width	Physical check	380mm	380mm	N/A
Finished Product Net Weight	Checkweigher	10.88kg	10.88kg	11.88kg
No. of units per outer case	Physical box count	N/A	16	N/A
Label check	Physical check	N/A	N/A	N/A
Finished Product Temperature	Freezing Core Temperature check	-22°C	-18°C	-5°C

9. SUITABILITY INFORMATION

SUITABLE FOR:	YES	NO
Suitable for VEGETARIANS	√	
Suitable for VEGANS		√
Kosher Approved / Certified		√
Halal Approved / Certified		√
Organic		√

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10.LABELLING

Additional Labelling Information	
Best Before and Consume By details	Lot Code & Best Before Date
Storage instruction	Store Frozen at -18°C or colder. Do not refreeze once defrosted.
Instruction for use	For best results, bake from frozen. All ovens may vary, and the following are guidelines only. Place pastry on a baking tray 3 cm apart in a preheated oven. Bake at 190°C for 20-23 mins. Ensure product is thoroughly baked.
Consumer services details	Produced by Golden Bake Ltd. 4 Newtown Park, Malahide Road Industrial Park, Coolock, Dublin 17, Ireland www.golden-bake.com contact@golden-bake.com
Any other label information	N/A

11.PACKING

Pastry is placed into the boxes lined with bubble wrap sheet and blue liner. Pastry sheets are packed into the blue liner and blue plastic sheet is added for every second pastry sheet. When the correct quantity is in, the liner is closed, and bubble wrap sheet is added on top of it. The outer case is closed and sealed with sellotape, then palletised and pallet is manually shrink wrapped.

Primary Packaging	
Blue Bags	
Description	Large blue liner [PK023]/ [PK097] – CDEF02
Material	[PK023]: MDPE / [PK097]: HDPE
Dimensions	[PK023]: 680 x 1100 x 825mm, Width+/- 2mm, Thickness 16mu+/- 2.5 [PK097]: W580 x L730 x sidefold 230mm, Thickness 16mu
Weight	[PK023] / [PK097]: 25g
Print Detail (if required)	N/A
Closure method	Product neatly packed in bag
Blue Sheeting	
Description	PK024
Material	MDPE
Dimensions	L584 x W381, Width+/- 2mm, Thickness 35mu+/- 2.5
Weight	49g (7sheets x7g)
Secondary Packaging	
Bubble Wrap	
Description	PK098
Material	LDPE
Dimensions	L650mm x W500mm
Weight	20g (10g x 2sheets)

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Outer case	
Description	GB16A
Material	Corrugated board
Dimensions	Internal size: L594 x W394 x H70mm External size: L604 x W405 x H74mm
Weight	324g
Label	
Description	Label printed on the box
Material	N/A
Weight	N/A
Tape	
Description	Clear/ White tape [PK047/PK052]
Material	Biaxially-Oriented (BO) Polypropylene (PP)
Dimensions	48mm x 28μ
Weight	5g
Tertiary Packaging	
Pallet	
Description	Standard pallet
Material	Wood
Dimensions	1200 x 1000mm
Weight	25kg
Pallet card	
Description	PK113
Material	Paper with acrylic based adhesive
Dimensions	210 x 295mm
Weight	2 sheets x 5g
Pallet wrapping material	
Description	Shrink Wrap [PK101]
Material	LLDPE
Dimensions	485mm x Thickness 14μ
Weight	310g

Pallet configuration	
No. of cases per layer	5
No. of layers per pallet	10
No. of cases per pallet	50
Height	900mm
Weight	590.32kg

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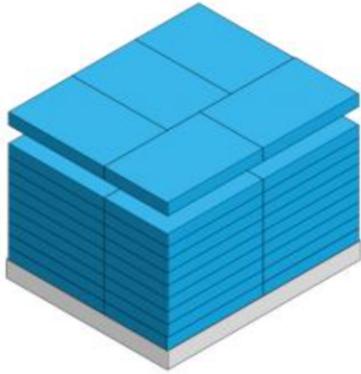
Product Code: P31

Date: 23.05.2023

Version: 11

Pictures (e.g., label, pallet configuration, product ...)

Pallet configuration:



Product frozen:



Product Baked:



Outer Case Label:

<p>Batch Code: L230861438 Best Before: 27/09/2024 Box No. 00001 02:38:PM Store Frozen at -18°C or colder. Do Not Refreeze Once Defrosted. Net Weight: 10.88 kg Gross Weight: 11.30 kg</p> 	<p>SINGLE PASTRY SHEET [680G X 16] SG. Ingredients: Wheat Flour (Wheat Flour, Calcium Carbonate, Iron, Niacin, Thiamin), Margarine (Vegetable Oils (Palm, Rapeseed), Water, Salt, Emulsifier (Mono- and Diglycerides of Fatty Acids), Water. Allergy Advice: For allergens, including cereals containing gluten, see ingredients in bold. May also contain traces of barley, oats, milk, egg, mustard and soya. Baking Instructions: For best results, bake from frozen. All ovens may vary and the following are guidelines only. Place pastry on a baking tray 3cm apart in a preheated oven. Bake for 20-23 minutes at 190°C. Ensure product is thoroughly baked. Produced by Golden Bake Ltd., 4 Newtown Park, Dublin, D17 CP26, Ireland, Tel: +353 (01) 847 0857.</p>	<p>P31</p>  <p>RSPO - 1106317</p> <p>Nutrition Information Frozen (as sold)</p> <table border="1"> <thead> <tr> <th>Typical Values</th> <th>Per 100g</th> </tr> </thead> <tbody> <tr> <td>Energy</td> <td>1664kJ</td> </tr> <tr> <td>Energy</td> <td>400kcal</td> </tr> <tr> <td>Fat</td> <td>27g</td> </tr> <tr> <td>of which Saturates</td> <td>14g</td> </tr> <tr> <td>Carbohydrate</td> <td>32g</td> </tr> <tr> <td>of which Sugars</td> <td><0.5g</td> </tr> <tr> <td>Protein</td> <td>6.0g</td> </tr> <tr> <td>Salt</td> <td>0.49g</td> </tr> </tbody> </table>	Typical Values	Per 100g	Energy	1664kJ	Energy	400kcal	Fat	27g	of which Saturates	14g	Carbohydrate	32g	of which Sugars	<0.5g	Protein	6.0g	Salt	0.49g
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12. DISTRIBUTION

On dispatch the product temperature must be -18°C. Temperature controlled transport must be used.

All transport trucks to be approved, clean, with no indication of pest infestation.

Golden Bake Ltd. is certified to BRC Global Food Safety Standard.

Golden Bake Finished Product Specifications are subject to review whenever changes occur to the product, process, or formulation, otherwise every 3 years at a minimum.

Name: Urszula O’Connell

Position: Technical Assistant