

DETAILED TECHNICAL SPECIFICATIONS FOR FINISHED PRODUCT

Product : Canned peach halves – slices - **dices**

Quality : CHOICE – GOOD STANDARD – STANDARD

Country of origin : GREECE

Can size 73x109 (410 gr) 99x119 (820gr-A2.5)153x153 (2600gr-A9) 153x178 (1750 gr-A10)153x244 (2400 gr-A12)

Covering liquor : a) syrup, b) juice, c) water

a) syrup : i) sugar syrup or ii) sugar and glucose – fructose syrup

b) juice : grape juice from concentrate or pear juice from concentrate

c) water : potable EC Directive 98/83.

Ingredients : peach, water, sugar, glucose - fructose, citric acid (E 330),/or juice

INGREDIENTS :

LIQUID MEDIA	Sugar syrup and glucose fructose brix 12-14	Sugar syrup brix 14-16	Sugar syrup and glucose fructose brix 14-16	Sugar syrup brix 16-18	Sugar syrup and glucose fructose brix 16-18	Sugar syrup brix 17-19	Sugar syrup and glucose fructose brix 17-19	grape juice brix 9,5	Water pack	Extra heavy syrup brix 20-22
PEACH	Min 57%	Min 57%	Min 57%	Min 57%	Min 57%	Min 57%	Min 57%	Min 57%	Min 57%	Min 57%
WATER (EEC 80/778 potable)	34,84%	33,40%	33,40%	31,70%	31,70%	31,00%	31,00%	37,20%	42.9%	28,20%
SUGAR (SO₂ ≤10ppm)	5,86%	9.5%	7,20%	11,20%	8,40%	11,90%	9%	Absence	Absence	14,70%
GLUCOSE FRUCTOSE)	2,30%	Absence	Min 2,3%	Absence	Min 2,8%	Absence	Min 2,9%	Absence	Absence	
CITRIC ACID	0,10%	0,10%	0,10%	0,10%	0,10%	0,10%	0,10%		0,10%	0,10%
JUICE (brix 9,5)	-	-	-	-	-	-	-	≈5,8%	-	
				Size ½	Size A2 ½ (1kg)	Size A9 (kg)	Size A10	Size A10	Size A12	
Min net weight of 10 cans *				410 gr	820 gr	2.600 gr	3.060 gr	3.060 gr	4.200	
Average D.W. min of 10 cans **				230 gr	470 gr	1.500 gr	1.750 gr	1.940 gr	2.400/3100gr	

* : P.D. 740/78 (ex 165/74).

** A tolerance of +/- 5% on the above stated weights is permitted. Weight may vary according customers specifications.

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Έκδοση:3^η

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Έγκριση από:Π.Δ.Σ.

Ημ/νια: 20-01-2010

Σελίδα:1/7

Production process: Fresh peaches are pitted on the pitting machines, in halves, and the stone is removed. Next step is the fruit skin removal in a NaOH solution. Afterwards skinned peaches are washed several times with cooled water, and splitted up to the production lines, for the final inspection and defect removal. Then peaches are filled into the cans, which are then filled with syrup or juice or water. The product pass thru the exhausting process in order to obtain vacuum. Then cans are seamed with steam flow closure in a 4 head seamer. Seamed cans are going thru the pasteurization process, for certain period of time and temperatures, and then are cooled down in chlorinated water. Air blowers are used in order to remove excess water and cans are palletised and stored for 22 days in the warehouse in order to be incubated at ambient temperatures prior to their final release for labeling and export

Product controls : Finished product is tested hourly for gross weight, net weight, drained weight, brix, PH, Vacuum, HS, bad cut, pit fragments, skin remain, scab, soft pieces, green, temperature, filling weight.

Process controls : Cool water is tested hourly for free residual chlorine.

Temperatures are checked on hour basis, for the following points: can in exhaust box (before seamer), water in exhaust box, can after pasteurization, water in pasteurisation, fill – in syrup/ juice.

Can seam controls : Can seams are checked twice per shift for each of the four heads on the seamer.

Shelf life : at least 40 months at ambient temperature

Color : Bright yellow to orange (slight lack of uniformity of color may be permitted)

Texture : Normal, tender and slightly firm, easily cut with a spoon and not fall apart when being eaten.

Flavor : Characteristic of freshly canned peach, absence of unnatural flavors

Smell : Characteristic of suitable prepared fruit

Storage conditions : Ambient temperature, covered warehouses, clean, free from rats, under conditions that cause no damage to the package or its contents.

PH : 3,6 – 3,9

Acidity : 0,4%

Head space : I) 4-6 inch size ½ din(et), A2 ½ (1kg), II) 6-9 inch size A6 (A9, European 3kg), A10, III) 8-12 size A12

Vacuum : min 4 in Hq

Lead - maximum permitted level in can = 0,50 mg/kg

Tin – maximum permitted level in any can = 150 mgr / kgr EC No 1881/2006

Thermal Process - Microbiological characteristics

Commercially sterile: Absence of pathogenic microorganisms and microorganisms causing deterioration of the product or otherwise improper manipulation. After 10 days of incubation at 35° C there shall be no signs of alterations to the container, nor any physical, chemical or organoleptic changes in the product indicating deterioration.

Product is stored at least for 22 days.

No indication of foreign material or other dirt or toxic substances that might affect the quality of the product or present a health hazard for the consumer.

⊙°C Exhauster : 75° – 82° C

T min Exhauster : 8-12 minutes

⊙°C Pasteurization : 96° – 99° C

T min Pasteurization : 20-30 minutes

⊙°C Can Center : 89° – 92° C

⊙o C Cooling : 37° – 42° C

⊙°C Syrup filling : 70° – 75° C

Chlorination (ppm) : 0,5 – 1,5 ppm

Laboratory analysis is made for : moulds and yeasts, aerobic total count in P.C.A at 30 C for 72 hours, total coliforms , esteria coli, clostridium perfringens, lattobacillus, staphylococcus, salmonella spp , pseudomonas aeruginosa , listeria monocytogenes.

. **Pesticide** : EU regulation 396/2005/EC and 1881/2006/EC

Residues are also checked in full scale. E.g for : 1) benamyl, Carbendazim, Thiophanate – methyl, 2) residues of Dithiocarbamates, 3) residues of Organophosphorus pesticide.

Heavy metals: . EU regulation 1881/2006/EC

metals researched are; arsenic as As, cadmium as Cd, chromium as Cr, phosphorus as P, mercury as Hg, nickel as Ni , lead as Pb, tin as Sn **Other information:**

No enzymes are used and the ingredients or the product are treated with **no** irradiation . The product it is also declared as **GMO** free , as well as **allergen free**. Product is checked on the presence of foreign materials (wood, metal, glass etc) and it is also declared as free of all above , according to the EC food law.1829/2003 and 1830/2003

Shelf life: at least 40 months from the production date when closed at ambient temperatures and 3 days when opened refrigerated.

Certification: ISO 9001-2008 , HACCP, IFS, BRC

		EXTRA HEAVY SYRUP	BRIX 17/19	BRX 14/16	WATER PACK	JUICE PACK
Energy kcal		96	74	54	24	44
Energy Kj		402	310	226	100	184
Protein	g	0,47	0,45	0,45	0,44	0,63
Total lipid(fat)	g	0,03	0,1	0,03	0,06	0,03
Carbohydrate	g	26,06	19,94	14,55	6,11	11,57
Fiber total dietary	g	1,0	1,3	1,3	1,3	1,3
Sugars total	g	-	18,64	13,25	4,81	10,27
Sodium, Na	mg	8	6	5	3	4
Fatty acids, total saturated	g	0,03	0,01	0,003	0,006	0,004
Fatty acids total monounsaturated	g	0,011	0,035	0,012	0,021	0,012
Fatty acids, total polyunsaturated	g	0,014	0,047	0,015	0,028	0,016

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Σελίδα: 3/7

TOLERANCE FOR DEFECTS**PEACH HALVES**

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Ημ/νια: 20-01-2010

Σελίδα:4/7

COUNT**5-7 pieces****6-12 pieces****25-35 pieces****30-40 pieces****40-60 pieces**

	½ ST	½	½ CH	1KG	1kg	1kg CH	A9	A9	A9	A10	A10	A10 CH	A12		
		G.STD		ST	G.STD		STD	G.STD	CH	STD	G.STD		STD	G.STD	CH
Color (same color)	Max 75%	Min 75%	Min 80%	Min75%	Min 75%	min 80%	Min 75%	Min 75%	min 80%	Min 75%	Min 75%	min 80%	Min 75%	Min 75%	min 80%
Size (same size)	Min 75%	Min 75%	min 80%	Min 75%	Min 75%	min 80%	Min 75%	Min 75%	min 80%	Min 75%	Min 75%	min 80%	Min 75%	Min 75%	min 80%
D1 peel rest	Max 1	Max 1	Max 1	Max 3	Max 2	Max 2	Max 7	Max 5	Max 3	≤20%	Max 8	Max 5	≤20%	Max12	Max 7
D 2 minor stone fragments	Max 1	Max 1	Max 1	Max 2	Max 2	Max 1	Max 3	Max 3	Max 2	Max 5	Max 3	Max 3	Max 5	Max 4	Max 4
D 3 minor blemish	Max 2	Max 1	Max 1	Max 3	Max 2	Max 2	≤20% Max 7	Max 5	Max 3	≤20% max 8	Max 8	Max 5	≤20% max 8	Max12	Max 7
D4 crushed – broken	Max 2	Max 1	Max 1	Max 2	Max 2	Max 2	≤20%	Max 5	Max 3	≤20%	Max 8	Max 5	≤20%	Max12	Max 7
D5 minor EVM	Max 2	Max 2	Max 1	Max 3	Max 2	Max 1	Max 3	Max 2	Max 1	Max 4	Max 3	Max 2	Max 5	Max 4	Max 3
D6 mechanical damage	Max 2	Max 2	Max 1	Max 4	Max 3	Max 2	≤20%	Max 5	Max 3	≤20%	Max 8	Max 5	≤20%	Max 9	Max 6
D7 major stone fragments pit > 5mm	Max 2	Max 1	0	Max 2	Max 1	1	Max 3	Max 2	Max 2	Max 4	Max 3	Max 2	Max 5	Max 4	Max 3
D8 foreign materials	0	0	0	Major veg. Matter.	0	0	Major veg. Matter.	0	0	Major veg. Matter.	0	0	Major veg. Matter.	0	0
TOTAL DEFECTS	max 2	Max 2	Max 1	Max 4	Max 3	Max 2	≤30%	Max 7	Max 4	≤30%	Max 8	Max 5	≤30%	Max12	Max 7

QUALITIES: a)CH= CHOICE, b)G.STD=GOOD. STANDARD, c)STD=STANDARD

TOLERANCE FOR DEFECTS PEACH SLICES
QUALITIES: a) CHOICE, b)G. STANDARD, c)STANDARD

	$\frac{1}{2}$ ST	$\frac{1}{2}$ G.STD	$\frac{1}{2}$ CH	1KG ST	1kg G.STD	1kg CH	A9 STD	A9 G.STD	A9 CH	A10 STD	A10 G.STD	A10 CH
Color	Max 75%	Min 75%	Min 80%	Max 75%	Min 75%	Min 80%	Max 75%	Min 75%	Min 80%	Max 75%	Min 75%	Min 80%
Size	Max 75%	Min 75%	Min 80%	Max 75%	Min 75%	Min 80%	Max 75%	Min 75%	Min 80%	Max 75%	Min 75%	Min 80%
D1 foreign matter	(-)	(-)	(-)	(-)	(-)	(-)	(-)	(-)	(-)	(-)	(-)	(-)
D 2 major stone fragments >5mm	2	1	0	3	2	1	5	4	3	6	5	4
D 3 minor stone fragments <5mm	3	2	2	3	2	2	5	4	4	6	5	5
D4 minor EVM	3	2	2	3	2	2	5	4	3	6	5	4
D5 major blemishes	3	2	1	4	3	2	7	6	4	9	8	6
D6 minor blemishes	4	5	3	8	7	5	16	15	9	23	22	16
D7 mechanical damage	10	9	4	16	15	7	22	21	12	26	25	18

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TECHNICAL SPECIFICATION FOR FINISHED PRODUCT 2010 crop**Product : Diced peaches in syrup A12**

Quality : A) CHOICE grade , B) STANDARD grade
 Ingredients : Peaches - water – sugar- citric acid(one per thousand)- glucose/fructose
 Description : Yellow cling diced peaches packed in syrup
 Colour : Bright yellow to orange (slight lack of uniformity of color may be permitted)
 Size and Shape : Fruit diced : 14X14 mm, reasonably uniform–
 Character : Typical texture of properly fresh yellow cling peach, peeled and Pitted.it shall be tender and slightly firm. Slight unevenness will be tolerated.

Defects

	A) CHOICE	B) STANDARD
Pit Rest =	2	10
Peel rest = :	4	12
Slight soft = :	20	45
Minor Blemishes :	20	35
Slivers =	7%	15-17%

PRODUCTS SPEC'S AFTER PROCESSING

Vacumm	: 06 – 25	06-25
Brix	: 14 – 16°	14-16
PH	:3,65 –4.00	3.65-4.00
N.W.	: 4.200 gr min	4200 gr min
D.W.	: 3.000 gr min	3000 gr min

MICROBIOLOGICAL SPEC'S : COMMERCIALY STERILE PRODUCTS

Θ° Exhauster : 75° – 80°
 T min Exhauster : 10– 12
 Tmin Pasterization:18-22
 Θ° C Pasterization : 97° – 99°
 Θ° Can Center : 91° – 92°
 Θ° C syrup filling : 70° – 75°
 Chlorination PPM : 1,5
 Θ° C can center cooling : 38-45
 Incubation analysis 14 days at 32° C.

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 Σελίδα:6/7

Date 30/05/2010

ALLERGEN STATEMENT

KRONOS SA , states that the following allergens (referring to the list of E.C.Directive 2003/89 , amended be EC directives :2006/142 and 2007 / 68) are not present in our products : canned peaches , apricots , fruit cocktail and all ingredients when tested do comply with establishment standards.

Crustaceances & their products	Absent
Egg & Egg products	Absent
Fish & Fish products	Absent
Milk & Milk products	Absent
Gluten (Wheat, rye , barley , oats, malt, spelt , triticale and their hybridized strains)	Absent
Wheat (including wheat starch)	Absent
Nuts (tree nuts and nut products)	Absent
Sesame seeds (and products , including Sesame oil)	Absent
Soybeans (and products thereof)	Absent
Peanuts (and products including Peanut oil)	Absent
Sulphites (<10ppm)- sulphur dioxide (SO2)<10mg/kg	Absent
Lupin and products thereof	Absent
Mollucs and products thereof	Absent
Mustard	Absent
Cinnamon	Absent
Cocoa	Absent
Legumes/ pulses	Absent

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