

PEACH - TECHNICAL SPECIFICATIONS FOR FINISHED PRODUCT

Product : Canned peach halves - slices dices

Quality : CHOICE – GOOD STANDARD – STANDARD

Country of origin : GREECE

Container (size) : ½ tin(et), A2 ½ (1kg), A9 (European 3kg), A10, 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

c) water : potable EC Directive 98/83.

Ingredients : peach, water, sugar, glucose - fructose, citric acid,/or juice

INGREDIENTS :

LIQUID MEDIA	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%
WATER (EEC 80/778 potable)	33,5%	33,5%	31,7%	31,7%	31,0%	31,0%	37,2%	43,0%	28,2%
SUGAR (SO₂ ≤10ppm)	9m4%	7,1%	11,2%	8,4%	11,9%	9%	Absence	Absence	14,7%
GLUCOSE FRUCTOSE)	Absence	Min 2,3%	Absence	Min 2,8%	Absence	Min 2,9%	Absence	Absence	
CITRIC ACID	0,1%	0,1%	0,1%	0,1%	0,1%	0,1%		0,1%	0,1%
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 **			240 gr	470 gr	1.500 gr	1.750 gr	1.940 gr	2.400/3100 gr	

* : 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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Έγκριση από:Π.Δ.Σ.

Ημ/νια: 20-01-2010

Σελίδα:1/6

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 Hg

CHEMICAL COMPOSITION		INORGANIC CONTENT (mg per 100gr)		VITAMINS	
Moisture	80,42 g	Sodium, Na	1mg	Vitamin C	4 mg
Protein	0,4 g	Potassium, K	150 mg	Vitamin A, RAE	18 mcg
Fat	Trace	Calcium, Ca	4 mg	Vitamin E	0,49 mg
Carbohydrate	18 g	Iron, Fe	0,4 mg	Vitamin K	1,7 mg
Dietary Fibre	1 g	Carotene	260 mg	Niacin	0,5 mg
Ash	0,18 g	Magnesium Mg	5mg	Tianim	0,009 mg
Energy	69 Kcal	Zinc, Zn	0,09 mg	Pantothenic Acid	0,05 mg

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

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

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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.

Θ°C Exhauster : 75° – 82° C

T min Exhauster : 8-12 minutes

Θ°C Pasteurization : 96° – 99° C

T min Pasteurization : 20-30 minutes

Θ°C Can Center : 89° – 92° C

Θo C Cooling : 37° – 42° C

Θ°C Syrup filling : 70° – 75° C

Chlorination (ppm) : 0,5 – 1,5 ppm

C. Pesticide :

Residues checked in full scale for : 1) benamyl, Carbendazim, Thiophanate – methyl, 2) residues of Dithiocarbamates, 3) residues of Organophosphorus pesticides.

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TOLERANCE FOR DEFECTS**PEACH HALVES**

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

	$\frac{1}{2}$ 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	A12		
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) CHOICE, b)G. STANDARD, c)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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PEACH DICES**TOLERANCE FOR DEFECTS**

SHAPE :	NORMAL 14 mm X 14 mm X 14 mm cube
COLOR :	CHOICE = min 80% GOOD STANDARD = min 75%
TEXTURE	NORMAL, TENDER AND SLIGHTLY FIRM
TOTAL DEFECT :	SHOULD NOT EXCEED 10% OF THE TOTAL D.W.

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