


AMP SPEC SEMO 01		Document No.	AMP SPEC SEMO 01-06	 <b>ALLIED MILLS</b>
Status	Published – 21-04-2023	Revision	37	
Owner	Pilar Aparicio			
<b>360-Coarse Semolina</b>				

### Allied Mills / Customer Agreement:

<b>Supplier:</b>	Allied Mills		
<b>Approval name: (Please print)</b>		Specification reviewed and agreed.  If changes are made this specification will be reviewed and re-issued.	
<b>Approval signature:</b>			
<b>Job title:</b>			
<b>Date:</b>			
<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) **BRCGS Global Food Safety Standard**, 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.

AMP SPEC SEMO 01		Document No.	AMP SPEC SEMO 01-06	 ALLIED MILLS
Status	Published – 21-04-2023	Revision	37	
Owner	Pilar Aparicio			
360-Coarse Semolina				

**Name & Address:**

	<b>Supplier</b>	<b>Manufacturing site</b>
<b>Name:</b>	<b>Allied Mills</b>	<b>AM Tilbury</b>
<b>Address:</b>	AM Central Office Port of Tilbury Tilbury Essex RM18 7JR	Sunblest Mill Port of Tilbury Tilbury Essex RM18 7JR
<b>First Contact:</b>	Customer Services	Barry Kelly
<b>Position:</b>	Customer Services Administrator	General Manager
<b>Second Contact:</b>		<b>Pilar Aparicio</b>
<b>Position:</b>		Technical Services Manager
<b>Telephone no:</b>		
<b>Email address:</b>		
<b>Sedex No</b>	Tilbury	ZS4074258

**General Product Description:**


Purified middlings obtained by milling Durum Wheat

**Legal Name:**

Durum Wheat Semolina

**Storage Conditions:**

Store in Dry Ambient Conditions

AMP SPEC SEMO 01		Document No.	AMP SPEC SEMO 01-06	 ALLIED MILLS
Status	Published – 21-04-2023	Revision	37	
Owner	Pilar Aparicio			
360-Coarse Semolina				

**Shelf Life:**

<b>Unopened:</b>	183 Days
<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:** (For traceability)

<b>Bulk:</b>	Weighbridge Ticket Number AML Sales Order / Despatch Note Number
<b>Bag:</b>	Product Name / Product Code / Packing Date / Best Before Date / Job Number / Bag Number

**Packaging Materials Description – Bulk:**


<b>Primary:</b>	Bulk Tanker
-----------------	-------------

**Packaging Materials Description/Pallet Configuration - Bags**

	16kg Sack	25kg Sack
<b>Primary:</b>	Paper Sack, Glued and Sewn, 2 ply 38cmx74cm	Paper Sack, Glued and Sewn, 2 ply 42cmx82cm
<b>Secondary:</b>	Shrink Wrap / Corner Posts / Slip Sheet	Shrink Wrap / Corner Posts / Slip Sheet
<b>Pallet Layout:</b>	65 sacks per pallet 5 sacks per layer 13 layers	40 sacks per pallet 5 sacks per layer 8 layers
<b>Net Weight Per Pallet:</b>	1040 kg	1000 kg

**Sensory Characteristics:**

<b>General Appearance:</b>	Creamy Yellow Powder randomly speckled with naturally occurring small brown bran specs.
----------------------------	---

AMP SPEC SEMO 01		Document No.	AMP SPEC SEMO 01-06	 <b>ALLIED MILLS</b>
Status	Published – 21-04-2023	Revision	37	
Owner	Pilar Aparicio			
360-Coarse Semolina				

	Generally free from white and black specs.
<b>Aroma :</b>	No Adverse Odours
<b>Flavour:</b>	No Adverse Flavours
<b>Texture:</b>	Granular

**Recipe Breakdown:**


<b>Ingredient</b>	<b>Country of origin</b>	<b>%</b>
<b>Durum Wheat</b>	May originate from any of the listed countries either singly or as a blend: UK / Spain / France / Canada / US / Australia	100

**Processing Aids/Undeclared Ingredients**

<b>Ingredient</b>	<b>Function</b>	<b>%</b>
None		

**Ingredient Declaration:**

100% Durum Wheat. (May contain 3% Common Wheat)
---

AMP SPEC SEMO 01		Document No.	AMP SPEC SEMO 01-06	 ALLIED MILLS
Status	Published – 21-04-2023	Revision	37	
Owner	Pilar Aparicio			
360-Coarse Semolina				

<b>Allied Mills Ref:</b>	360	<b>LIMS Date of Issue:</b>	01.09.2020
<b>Supplier Ref:</b>	360	<b>LIMS Revision No:</b>	21
<b>Material Name:</b>	COARSE SEMOLINA		

### **Physical & Chemical Analysis:**


**Moisture:** Maximum 14.99%

**Protein:** Minimum 11.0 %(DM)

**Ash @900oC:** Maximum 0.8 %(DM)

### **Sievings:**

<b>425 um</b>	40.0 - 60.0 % retained
<b>355 um</b>	20.0 - 30.0 % retained
<b>300 um</b>	15.0 – 25.0 retained
<b>150 um</b>	Max 10.0 % retained
<b>106 um</b>	Max 1.0 % retained
<b>106 um</b>	Max 1.0 thro's

AMP SPEC SEMO 01		Document No.	AMP SPEC SEMO 01-06	 ALLIED MILLS
Status	Published – 21-04-2023	Revision	37	
Owner	Pilar Aparicio			
360-Coarse Semolina				


### Allied Mills Microbiological Specification for Semolina

Test	Target	Maximum
Total Aerobic Count	$<1 \times 10^5$ (<100,000) cfu/g	$5 \times 10^5$ (500,000) cfu/g
Mould	$<1 \times 10^3$ (<1000) cfu/g	$5 \times 10^3$ (5000) cfu/g
Yeast	$<1 \times 10^3$ (<1000) cfu/g	$5 \times 10^3$ (5000) cfu/g
Mesophilic Spores	$<1 \times 10^2$ (<100) cfu/g	$8 \times 10^2$ (800) cfu/g
<i>Escherichia coli</i>	$<1 \times 10^1$ (<10) cfu/g	$1 \times 10^2$ (100) cfu/g
<i>Staphylococcus aureus</i>	$<2 \times 10^1$ (<20) cfu/g	$1 \times 10^2$ (100) cfu/g
<i>Clostridium perfringens</i>	$<1 \times 10^1$ (<10) cfu/g	$1 \times 10^2$ (100) cfu/g
<i>Bacillus cereus</i>	$<1 \times 10^2$ (<100) cfu/g	$5 \times 10^2$ (500) cfu/g
<i>Salmonella</i> species	Absent in 25g	Absent in 25g
<i>Listeria monocytogenes</i>	Absent in 25g	$1 \times 10^2$ (100) cfu/g
Thermophile Aerobic Spore Count	$<1 \times 10^1$ (<10) cfu/g	$5 \times 10^1$ (50) cfu/g
Thermophile Anaerobic Spore Count	$<1 \times 10^1$ (<10) cfu/g	$1 \times 10^1$ (10) cfu/g

*Bacillus* species not included as products containing large volumes of Semolina are not typically affected by 'rope' (*B.subtilis*) and adequate cover in specification for Mesophilic spore forming organisms.

#### **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

AMP SPEC SEMO 01		Document No.	AMP SPEC SEMO 01-06	 ALLIED MILLS
Status	Published – 21-04-2023	Revision	37	
Owner	Pilar Aparicio			
360-Coarse Semolina				

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.


AMP SPEC SEMO 01		Document No.	AMP SPEC SEMO 01-06	 <b>ALLIED MILLS</b>
Status	Published – 21-04-2023	Revision	37	
Owner	Pilar Aparicio			
360-Coarse Semolina				

## Semolina Nutrition Information

### Tested Eurofins Report 400-2023-00084222-Feb 2023

Parameter	Typical Values, per 100g
Energy	1491 kJ
Energy	352 kcal
Fat	2.7 g
of which saturates	0.55 g
mono-unsaturates	0.46 g
Polyunsaturates	1.53 g
Carbohydrate	63.88 g
of which sugars	4.6 g
Protein (N x 6.25)	15.8 g
Sodium	<0.01 g
Salt	<0.025 g
Dietary Fibre (AOAC)	4.5 g
Moisture	12.0 g
Ash	1.1 g




AMP SPEC SEMO 01		Document No.	AMP SPEC SEMO 01-06	 ALLIED MILLS
Status	Published – 21-04-2023	Revision	37	
Owner	Pilar Aparicio			
360-Coarse Semolina				

### **Allergen / Food Intolerance Information**


**Please note:** The contamination risks identified below are likely adventitious contaminants of semolina. 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 Durum 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	

AMP SPEC SEMO 01		Document No.	AMP SPEC SEMO 01-06	 <b>ALLIED MILLS</b>
Status	Published – 21-04-2023	Revision	37	
Owner	Pilar Aparicio			
360-Coarse Semolina				

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	
M.S.G. and Glutamates	NO	NO	
Added Salt	NO	NO	
Potassium based salt substitute	NO	NO	
Added Sugar	NO	NO	
Sweeteners	NO	NO	

AMP SPEC SEMO 01		Document No.	AMP SPEC SEMO 01-06	 <b>ALLIED MILLS</b>
Status	Published – 21-04-2023	Revision	37	
Owner	Pilar Aparicio			
360-Coarse Semolina				

**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