

AMP SPEC SEMO 01		Document No.	AMP SPEC SEMO 01-12	
Status	Published – 20-04-2023	Revision	39	
Owner	Pilar Aparicio			
700 Fine Semolina				

Supplier:	Bacarel & Co Limited		
Approval name: (Please print)		Specification reviewed and agreed. If changes are made this specification will be reviewed and re-issued.	
Approval signature:			
Job title:			
Date:			
Customer:			
Approval name: (Please print)		Specification reviewed and agreed.	
Approval signature:			
Job title:			
Date:			

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.

Name & Address:

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	Supplier	Manufacturing site
Name:	Allied Mills	AM Tilbury
Address:	AM Central Office Port of Tilbury Tilbury Essex RM18 7JR	Sunblest Mill Port of Tilbury Tilbury Essex RM18 7JR
First Contact:	Customer Services	Barry Kelly
Position:	Customer Services Administrator	General Manager
Second Contact:		Pilar Aparicio
Position:		Technical Services Manager
Telephone no:	0161 785 2971 / 2924 (Emergency 24 hr)	01375 363 111
Email address:	customer.services@allied-mills.co.uk amcentralplanning@allied-mills.co.uk	barry.kelly@allied-mills.co.uk pilar.aparicio@allied-mills.co.uk
Sedex No	Tilbury	ZS4074258

General Product Description:

Purified middlings obtained by milling Durum Wheat
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Legal Name:

Durum Wheat Semolina

Storage Conditions:

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Store in Dry Ambient Conditions

Shelf Life:

Unopened:	183 Days
Once Open:	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)

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

Packaging Materials Description – Bulk:

Primary:	Bulk Tanker
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Packaging Materials Description/Pallet Configuration – Bags:

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

Sensory Characteristics:

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General Appearance:	Creamy Yellow Powder randomly speckled with naturally occurring small brown bran specs. Generally free from white and black specs.
Aroma :	No Adverse Odours
Flavour:	No Adverse Flavours
Texture:	Granular

Recipe Breakdown:

Ingredient	Country of origin	%
Durum Wheat	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:

Ingredient	Function	%
None		

Ingredient Declaration:

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

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Allied Mills Ref:	700	LIMS Date of Issue:	03.09.2020
Supplier Ref:	700	LIMS Revision No:	22
Material Name:	FINE SEMOLINA		

Physical & Chemical Analysis:

Moisture: Maximum 14.99%

Protein: Minimum 11.0% (DM)

Ash @900oC: Maximum 1.1 % (DM)

Hagberg: Minimum 250secs

Sievings:

425 um	2.0 - 12.0 % retained
355 um	Target retained 12.5%
300 um	Target retained 30.0%
150 um	Target retained 45.0%
106 um	2.0 - 8.0% retained
106 um	0.0 - 1.0% thro's

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Semolina Microbiological Specification

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

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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.

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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

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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

Allergen	Contains Yes / No	Contamination Risk Yes / No	Comments, including source of allergen
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 ₂	NO	NO	

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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	

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Special Dietary Requirements:

Does this product meet the following claims:	Yes/No
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