



PRINCES LIMITED PRODUCT SPECIFICATION

CANNED TUNA PACKED IN BRINE

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The conditions of this specification shall not be altered without prior written approval from Princes Limited.



1. GENERAL PRODUCT CONDITION

1.1 General Description

Princes brands (Princes and Cucumber) canned Tuna products shall be manufactured from cooked tuna fish which has been skinned, headed, eviscerated, trimmed of all blood muscle and scorched or oxidized surface tissue and packed with vegetable oil, sunflower oil, olive oil or brine in hermetically sealed cans and sterilised by the application of heat. Skipjack {*Euthynnus (Katsuwonus) pelamis* {L.}} is the only species of Tuna permitted for the manufacture of these products. Mixed species shall not be filled in the same can.

The product shall comply with the requirements of the European Community Council Regulation EC No. 1536/92. All manufacturing, processing and handling systems shall accord with the requirements of the British DoH Guidelines for the Safe Production of Heat Preserved Foods, of 1994 and EC Directive 91/493/EEC laying down the health conditions for the production and the placing on the market of fishery products.

1.2 Name of the Food Product

The official name of the food to be declared on the product label is "Tuna chunks in brine".

1.3 Allergen Notice

Where a recognised allergen is known to be present in the product this shall be declared within the ingredients listing. Recognised allergens involve those detailed in EU Regulation No 1169/2011 on the provision of food information to consumers.

This product contains tuna (fish).

1.4 Shelf Life and Storage Conditions

The palletised products may be stacked five pallets high. The total life of the product, from the date of manufacture, shall not be more than 36 months (brine) and 60 months (oil) at ambient temperature and the product shall remain in a fit and merchantable condition for at least these periods. The product on delivery shall be less than 12 months old from canning.

1.5 Fish Content and Quantity Ingredient Declaration

For QUID purposes a drained weight value shall be declared on the label in accordance with the values below:-



1. GENERAL PRODUCT CONDITION (Cont.)

PARAMETER	DECLARED WEIGHT	DESCRIPTION
Average net weight	1715g	i.e. nominal declared weight
Average drained weight*	1260g	

* According to Welmec Method

1.6 Out-turn

Tuna shall constitute the majority of the product. The condition of the products shall be typical of freshly cooked tuna light meat. The fish shall appear clean and bright, the flesh being typically pale yellow to flesh pink. The texture of the fish shall be tender but firm and the mouth-feel may be slightly dry. Evidence of pre-process deterioration such as dehydration, discoloration, softening etc., and of excessive heat-damage such as scorched colours, shall be absent.

Tuna Chunks shall consist of transversely cut loins of fish to appear as whole chunks of tuna which shall not exhibit the obvious addition of flake or shredded tuna. The addition of cleaned flake or shred will be tolerated to a limited degree provided it is randomly distributed throughout the pack and does not appear as a single pressed block. The out-turn tolerance for material that will pass through a 1/2 inch mesh shall not exceed 30 percent of the drained weight in any single can.

Tuna Flakes shall consist of whole flakes of tuna fillet of target dimensions 25 x 15 mm tapering to 2.5 mm, up to 50 x 20 x 3 mm, but not less than 15 x 5 x 2 mm. Not more than ten percent of flakes shall weigh in excess of 5g. The flakes shall be for the most part wholly intact and easily separated, and only limited shredding or fragmentation will be tolerated as specified below.



1. GENERAL PRODUCT CONDITION (Cont.)

1.7 Accompanying Liquors

The brine, consisting of water with or without added salt, shall be reasonably clear and "sweet".

The presence of small fish fibres suspended within the brine is acceptable to a limited degree. The salt concentration of the brine shall be sufficient to effect a finished product salt content of 0.8 - 1.5%.

1.8 Defect Tolerances

In any sample of 13 cans tolerable defects will be as follows:

DEFECT	DEFINITIONS	TOLERANCE
Foreign matter	Foreign matter includes any material not derived from the original raw material, such as wood, glass, stone, metal etc.	No foreign matter.
Struvite	-	No crystals of struvite
Extraneous Fish Matter	Extraneous fish matter concerns individual pieces of dark meat, fish bone, greater than 6mm square and skin and fish scales greater than 4mm square, or similar noticeable defects of lesser dimensions, where three are counted as one single defect.	- max 21 single items of extraneous fish matter.

1.9 Certification

The histamine content of all packs supplied to Princes shall be consistently below 50 ppm and Princes Limited shall be provided with formal certificates advising of histamine levels respective to each production batch shipped.

1.10 Packaging

Utilising a sealing compound lining the curl of the can end to form a gasket within the double seam closure, the product shall be packed in hermetically sealed cans which contain a positive vacuum. The standard of seal closure shall comply with the standard stipulated in section 3 of this specification relating to Manufacturing Aspects. The cans shall be substantially free from corrosion and shall accord with the following specification:-



1. GENERAL PRODUCT CONDITION (Cont.)

PACKAGING TYPE	SPECIFICATION	DIMENSION
Can	3-piece with welded side seam (1715g).	-156 x 113mm (1.715kg)
External tin coating	Ends may be plain, lacquered, or TFS.	5.6g tin per sq. metre,
Internal finish	Tin plated with sulphur resistant lacquer	2.8g/m ²

Can lacquering systems shall ensure all the requirements of EC Directive 90/128, as amended, and EU 1895/2005 as amended, are satisfied particularly with regard to migration of BADGE or BFDGE which shall not be detectable in the finished product.

Packaging materials and can lacquering systems shall ensure all the requirements of EC Regulations 1935/2004, 2023/2006, 1895/2005 and 10/2011 are satisfied.

1.11 Can Coding Format

All packs and outer cases shall be marked with EU approval and country of production. All packs shall be legibly batch coded to enable the producing factory, product and date of manufacture to be identified. The batch code shall also be marked on outer cases or be visible through shrink-wrapping. All pack labels and outer cases shall clearly indicate the shelf life expiry date in the form of "best before end" followed immediately by the appropriate declaration in the form of either month and year, or year ending. Coding shall not fracture can surface lacquer or perforate the plate metal of the can. All coding shall be clearly legible and shall be easily recognisable as the batch and day codes.

1.12 Labelling

The supervision of labelling is of equal importance to that required at all stages of product manufacture, and must ensure that:-

Labels adhere correctly to the can with no loose edges, are close fitting to the can and are correctly aligned. Labels are whole, not torn or holed, labels do not show adhesive on the outer printed surface and rust or dirt marks are absent.



2. FORMULATORY ASPECTS

2.1 Formulations 1715g (typical)

INGREDIENTS	%	INGREDIENT DESCRIPTION
Brine		
Pre-Cooked Tuna	70	Skipjack Tuna
Water	30	Water, Salt

The fish fill weights shall be controlled to ensure the final product drained weight and quality requirements are satisfied.

All fish fill weights shall ensure the required minimum drained weight and maximum flake content values are satisfied. Salt addition shall be controlled to satisfy the required level in the finished product.

2.2 Ingredients Statement

Brine Variety

Ingredients: Tuna **(Fish)**, Water, Salt.

2.2 Commodity Description

Genetically Modified Materials

All materials used to produce this product shall consist exclusively of non-genetically modified product. This is to include initial materials and all derivatives.

Tuna

All fish used in the manufacture of Princes (and Cucumber) Tuna shall be derived from suitable raw material handled in a manner as approved by the Competent Authority of the Government of Philippines in accordance with the requirements of European Community Directive 91/493/EEC.

The permitted species for the manufacture of "Princes" & "Cucumber" brands of canned tuna fish is *Euthynnus (Katsuwonus) pelamis* (L.). The delivered fish shall be whole, raw and deep frozen less than -18 Celsius. The fish used for the manufacture of this product shall be wholesome and free from deterioration, spoilage, and off-odours.



2. FORMULATORY ASPECTS (Cont.)

Salt is present at typical 0.5 percent as a consequence of on-board freezing. Where the salt level in the fish is found to be deficient this shall be supplemented for flavour purposes to meet the requirements.

Princes Limited require that all tuna raw material sourced or purchased by any party packing canned tuna for Princes shall be caught only by long line, pole and line or purse seine methods and in employing these methods particular care shall be taken to avoid any situation which may be likely to endanger Dolphins, Porpoises or Whales. The use of high-seas drift netting and "setting-on" catching methods are specifically prohibited.

This requirement shall apply to all tuna fish raw material sourced or purchased by the packer irrespective of the particular customer or whether destined for human or pet food use. All packers shall be required to maintain comprehensive documented records attesting as to the origin of tuna raw material. This documentation shall detail the fishing vessel concerned, the date of catching, the geographic area of the catch and the method employed in the capture.

Satisfactory compliance with these requirements is prerequisite for endorsement for approval for the supply of product to Princes Foods.

Water

Ingredient water shall be potable and shall conform with EEC Directive 80/778 "relating to the quality of water intended for human consumption".



3. ANALYTICAL ASPECTS

3.1 Chemical Composition (typical per 100g of drained product)

Source of Data:	Average of Boughey Analysis						
Certificate Ref:	N/A						
PARAMETERS				BRINE VARIETY			UNITS
					CHUNK		
Energy					413		KJ/100g
Energy					97		Kcal/100g
Fat					0.6		g/100g
(Of which Saturates)					0.2		g/100g
(Of which Monounsaturates)					-		g/100g
(Of which Polyunsaturates)					-		g/100g
Carbohydrate					<0.1		g/100g
Sugars					<0.1		g/100g
Protein					23.0		g/100g
Salt					1.05		g/100g
Sodium					420		mg/100g
Fibre					0.0		g/100g
Average Moisture					73.27		g/100g
Ash					1.23		g/100g

3.2 Inorganic Constituents (mg per 100g)

PARAMETER	PER 100G	UNITS
Potassium	280	mg/100g
Calcium	7	mg/100g
Iron	1.1	mg/100g

3.3 Maximum Contaminant Limits (of drained product)

PARAMETER	PER 100G	UNITS
Histamine	50	ppm

3.4 Additional Data

PARAMETER	PER 100G	UNITS
Sodium Chloride	1.5 (MAXIMUM)	%
Free fatty acids	0.2 (MAXIMUM)	N/A
pH	5.8 - 6.2 (typically)	N/A

3.5 Microbiological Tolerances

Commercially sterile.