

**HP FOODS LIMITED TECHNICAL DATA SHEET  
UK MANUFACTURED PRODUCT**

**TDS - A**

<b>PRODUCT NAME: WORCESTERSHIRE SAUCE 12X290ML</b>	<b>SPECIFICATION NO</b>	<b>60444</b>
<b>BRAND: LEA &amp; PERRINS</b>	<b>RECIPE / SUPPLIER CODE</b>	<b>9300</b>
	<b>HP DATE OF ISSUE:</b>	<b>15/03/06</b>
	<b>REPLACES</b>	<b>14/06/05</b>
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**THIS INFORMATION IS PRODUCT SPECIFIC.  
SHOULD SOMETHING NOT BE APPLICABLE TO THE FINISHED PRODUCT, N/A HAS  
BEEN INSERTED IN THE RELEVANT SECTION.**

**General and Organoleptic Description.**

<b>Attribute</b>	<b>Description</b>
Colour	Dark Brown
Flavour	A balanced blend of vinegar, spice, fruit and fish with heat.
Odour	A balanced blend of vinegar, spice, fruit and fish.
Texture	Thin Liquid
Particulate	Small visible flecks, with sedimentation.

**List of Ingredients with the Breakdown of Compound Ingredients and Percentage of Ingredient.**

These to be listed in descending order, with the exception of those ingredients that make up less than 2% of the product – these can be in any order.

Please give the ingredient %, however - these ingredients can be banded to protect product integrity, EXCLUDING the % information required for QUID

<b>Ingredient</b>	<b>Country of Origin</b>
Malt vinegar (from barley)	U.K.
Spirit vinegar	U.K.
Molasses	U.K.
Sugar	U.K.
Salt	U.K.
Anchovies	Mediterranean, S America
Tamarind Extract	India
Onions	U.K. Europe
Garlic	U.K. Europe
Spice	Various
Flavourings	U.K.

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**Claims or any special labelling requirements**

(eg Low Fat or Allergen Labelling)

Shake well before use, sedimentation may occur.

Cap does not need to be removed for recycling of the bottle.

**Product, Pack Size and Coding**

Please refer to the Definition Section at the end of this document for clarification on the packaging terms.

Units per case	12
Nominal Weight / Volume	290ml
Average Weight / Minimum Weight	Average
Drained Weight	N/A

***Coding on Primary packaging (Single Unit)***

Method (Inkjet / sticker etc)	Inkjet
Production date / code format	Julian code and hour
Durability / Shelf life format	Best before end * MM/YYYY Best Before * Use By *
Position on unit	Top of cap
Barcode number on unit	5000111001540
Any other coding (ie factory / country / line / time etc)	No

***Coding on Secondary Packaging (Single Case)***

Method (Inkjet / sticker etc)	Self adhesive label
Production date / code format	Julian code
Durability / Shelf life format	Best before end * MM/YYYY Best Before * Use By *

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Position on case	Side of case
Barcode number on case	05000111604444
Any other coding (ie factory / country / line / time etc)	Product code
Special Instructions / symbols for handling	N/A

**Coding on Pallet**  
(if applicable)

Method (Inkjet / sticker etc)	Self adhesive label
Number of labels on Pallet	One
Position of labelling	Long edge of pallet, top right corner
Barcode number on Pallet	N/A
Pallet number	N/A

**Microbiology**

<b>Micro-Organism</b>	<b>Specification / Maximum Level</b>	<b>Test Method Used</b>	<b>Frequency</b>
Yeasts	Absent	MRS +10ML Product, Aerobic / Anaerobic, 7 days @ 30c	Daily
Moulds	Absent	MRS +10ML Product, Aerobic / Anaerobic, 7 days @ 30c	Daily
Lactobacli	Absent	MRS +10ML Product, Aerobic / Anaerobic, 7 days @ 30c	Daily

F0 Value (for Cans, Bottles or Jars)	
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**Mycotoxins**

This section must be completed if the product has legislative maximum levels in the EU.

<b>Mycotoxin</b>	<b>Specifciation / Maximum Level</b>	<b>Frequency of Testing</b>
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Total Aflatoxin	Raw Material	Annual
B1 Aflatoxin		
Ochratoxin A	Raw Material	Annual

This is subject to annual review.

**Chemical Analysis**

<b>Parameter</b>	<b>Target</b> (Please state unit of measure)	<b>Range</b> (Please state unit of measure)
Total solids		
Refractometer Solids	28.5 %	27.5% – 29.5%
Titrateable Acidity (as Acetic Acid % W/W)	3.4 %	3.3% – 3.5%
Salt	3.6 %	3.3% – 3.9%
Sugars	19 %	18% - 20%
pH	3.5	3.3 – 3.6
Moisture / Water Activity		
Water Absorption		
Vacuum		
Ash		
Ash in Soluble Ash		
Volatile Oil		
Viscosity (Specify units)		
Non Volatile oil		

<b>Any other Chemical Attributes Unique to this Product and Essential to Product Safety</b>		
<b>Parameter</b>	<b>Target</b> (Please state unit of measure)	<b>Range</b> (Please state unit of measure)
<p>HP Foods can confirm that the raw materials affected by EU Decision 2004/92/EC, are independently analysed by a UKAS accredited laboratory. HP Foods conform to the FSA guidelines on limits of detection on the above Decision as amended May 2005. HP Foods Limited can confirm that Sudan I –IV and Para red are not detected in our raw materials used in the manufacture of Lea &amp; Perrins Worcestershire sauce</p>		

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**Physical Analysis**

<b>Parameter</b>	<b>Target</b> <small>(Please state unit of measure)</small>	<b>Range</b> <small>(Please state unit of measure)</small>
Breakage Permitted		
Piece Size Tolerance		
Count		
Sieve Size		
Bulk density		

<b>Any other Physical Attributes Unique to this Product and Essential to Product Safety</b>		
<b>Parameter</b>	<b>Target</b> <small>(Please state unit of measure)</small>	<b>Range</b> <small>(Please state unit of measure)</small>

**Pesticides**

This product conforms to legislative maximum levels in the EU.

Scope of Test	General organophosphate and organochloride
Frequency of Testing	Minimum of annual

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**Trace Elements**

This product conforms to legislative maximum levels in the EU.

<b>Legal Max Level in EU</b>	<b>Element</b>	<b>Specification / Max Level</b>	<b>Frequency of Testing</b>
	Lead	< 1mg / Kg	Annual
	Cadmium		Annual
	Mercury	<0.01mg / Kg	
<b>Good Practice (Not EU Max Level)</b>	<b>Element</b>	<b>Specification / Max Level</b>	<b>Frequency of Testing</b>
	Arsenic	< 0.5mg / Kg	Annual
	Copper		Annual
	Mercury		Annual

This is subject to annual review.

**Nutrition**

All Nutritional information is given per 100g. This information is required for dietary purposes.

Nutritional information results have been

Calculated	Yes
Internally or Externally Analysed	Yes

<b>Parameter</b>	<b>% per 100gm</b> <i>(Please state measure if different)</i>
Energy (Kjoules)	392
Energy (Kcals)	92
Protein	1.9g
Carbohydrates	22.2g
Carbohydrates – of which sugars	15g
Fat	0.2g
Fat – of which Saturates	0.1g

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<b>Parameter</b>	<b>% per 100gm</b> (Please state measure if different)
Fat - of which Monounsaturated	
Fat - of which Polyunsaturated	
Trans Fatty Acids	
Fibre	< 0.2g
Sodium	1.1g
Total Salt	
Added Salt	
Alcohol	

**Dietary Needs**

<b>Dietary Condition</b>	<b>Suitable for Diet</b>
Ova Lacto Vegetarians	NO
Vegan	NO
Coeliac	YES
Galactosaemia	YES
Phenylketonuria	YES
Lactose Intolerance	YES
Kosher diet	YES
Halal Diet	YES

Please note

The information provided above on Dietary needs is correct to the best of our knowledge. The information has been obtained through supplier and third party specialist organisations. There has been no medical or specialist research undertaken by HP Foods Limited to verify this information.

**Free from Claims**

<b>Free From Components</b>		<b>In which Ingredient</b>
Beef	Yes	
Pork	Yes	

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<b><i>Free From Components</i></b>		<b>In which Ingredient</b>
Lamb / Mutton	Yes	
Poultry	Yes	
Preservatives	Yes	
Glutamates	Yes	
Natural Flavourings	Yes	
Nature identical Flavourings	No	Confidential
Artificial Flavourings	Yes	
HVP	Yes	
BHA / BHT	No	Trace residue carryover in flavouring
Production Enhancing Growth Promoting Hormones, including Bovine Somototrphin (BST)	Yes	
<b><i>Azo and Coal Tar Dyes</i></b>	Yes	
Please state E Number and Full Name of dye		
<b><i>Benzoates</i></b>	Yes	In which Ingredient
Please state Full Name of Benzoate		
<b><i>Sulphur Dioxide</i></b>		In Which ingredient
Please state E Number and Full Name		
<b><i>Caramel</i></b> Please state if E150A, B, C or D.	Yes	

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<b><i>Food Additives &amp; Preservatives</i></b>		Free from - means absolute absence of any additives (including modified starch but excluding natural flavouring) in the product or any of its ingredients. Declare all additives present in product, including non-declared additives (i.e. processing aids) and carry-over from compound ingredients:		
<b>E Number</b>	<b>Name</b>	<b>Function</b>	<b>Quantity in Ingredient mg/kg</b>	<b>In Which Ingredient</b>
E1520	Propylene Glycol	None (Carry over)		Present in Flavouring
E320	BHA	None – trace residue carryover		Present in Flavouring
E321	BHT	None – trace residue carryover		Present in Flavouring

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**Shelf Life**

In months (or days)

Un – Opened :	18 months
Opened	To BBE

**Storage Conditions**

(Chilled / Frozen etc.)

Un – Opened :	Ambient
Opened	Ambient

**Genetic Modification**

All ingredients used in the manufacture of this product are guaranteed NON GM, having been sourced from conventional crop within the threshold set by the EU (Regulation EC no 1830/2003) Random due diligence testing is part of our monitoring procedure.

**Supplier Details**

In the EU and UK this product is supplied by :-

HP Foods Limited  
Mollison Avenue  
Enfield  
Middlesex  
EN3 7JZ  
Tel (44) 0208 804 8788  
Fax (44) 0208 804 1006

Please direct any queries you may have on this product through your commercial contact.

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**Packaging**

**Primary Packaging**

Container Description	White flint glass bottle
Container Specification reference (HP use only)	Y0363
Closure Description	L&P Sprinkler
Closure Specification reference (HP use only)	Y0206
Dimension of sealed primary packaging (Container +closure)	61.3mm x 61.3mm x 214mm
Description of Tamper Evident Seal	Tear band
Dimensions of Tamper Evident Seal (Where appropriate)	N/A
Weight of primary packaging unfilled (Container +closure + TES) – Single unit	250.5g (includes label)
Total weight of single unit (Finished product in primary packaging once filled)	582g

**Waste Legislation breakdown**

Breakdown of primary packaging weights by material type: (Please give units mg, g, or kg)

<b>Paper (e.g. label)</b>	<b>Glass (e.g. bottle)</b>	<b>Aluminium (e.g. can)</b>	<b>Steel</b>	<b>Plastic (e.g. bottle + cap + TES)</b>	<b>Other</b>
1g	247g	0g	0g	2.5g	0g

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**Secondary Packaging**

Packaging Description	Shrink wrap tray	Shrink wrap	TUC label
Packaging Specification reference (HP use only)	Machine erect	Y7396	Y0267
Weight of secondary packaging unfilled	31g	10g	0.5g
Dimension of unit	250mm x 192mm x 216mm (ext case size)		
Primary packaging Units per Pack	12		
Configuration of Units in pack (eg 6 x 2)	4 x 3		
Total weight of secondary packaging once packed	7.03kg		
Sealing Tape Description (including Colour)	N/A		
Sealing Tape Specification (HP use Only)	N/A		

NO STAPLES ARE PERMITTED UNDER ANY CIRCUMSTANCES and Blue coloured tape and string are recommended.

**Waste Legislation breakdown**

Breakdown of secondary packaging weights by material type: (please give units)

Paper (e.g. sack)	Cardboard (e.g. box)	Aluminium (e.g. can)	Steel	Plastic (e.g. box)	Wood (e.g. box)	Other
0.5g	31g	0g	0g	10g	0g	0g

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***Tertiary Packaging***

Packaging Description	Std White pallet	Stretchwrap
Packaging Specification reference (HP Use Only)	Wood	23m $\mu$ LLDPE
Weight of tertiary packaging unfilled	28kg	0.5kg
Dimension	1200mm x 1000mm x 150mm	R/W 500mm
Secondary packaging Units per Pack	100 cases	N/A
Total weight of tertiary packaging once packed	731.5kg (incl. Pallet)	N/A

***Palletisation***

	<b>STD WHITE PALLETS</b>	<b>EURO PALLETS</b>
Unit Description	Standard White	
Units per layer	25 cases	
Number of Layers	4	
Units per Pallet	100 cases	
Pallet Dimensions	1200mm x 1000mm	
Pallet Height	1014mm (incl. Pallet)	
Pallet Weight	731.5kg (incl. Pallet)	

**Legislation**

This product and its labelling conforms to all current UK and EU food regulations.

**Method of Manufacture**

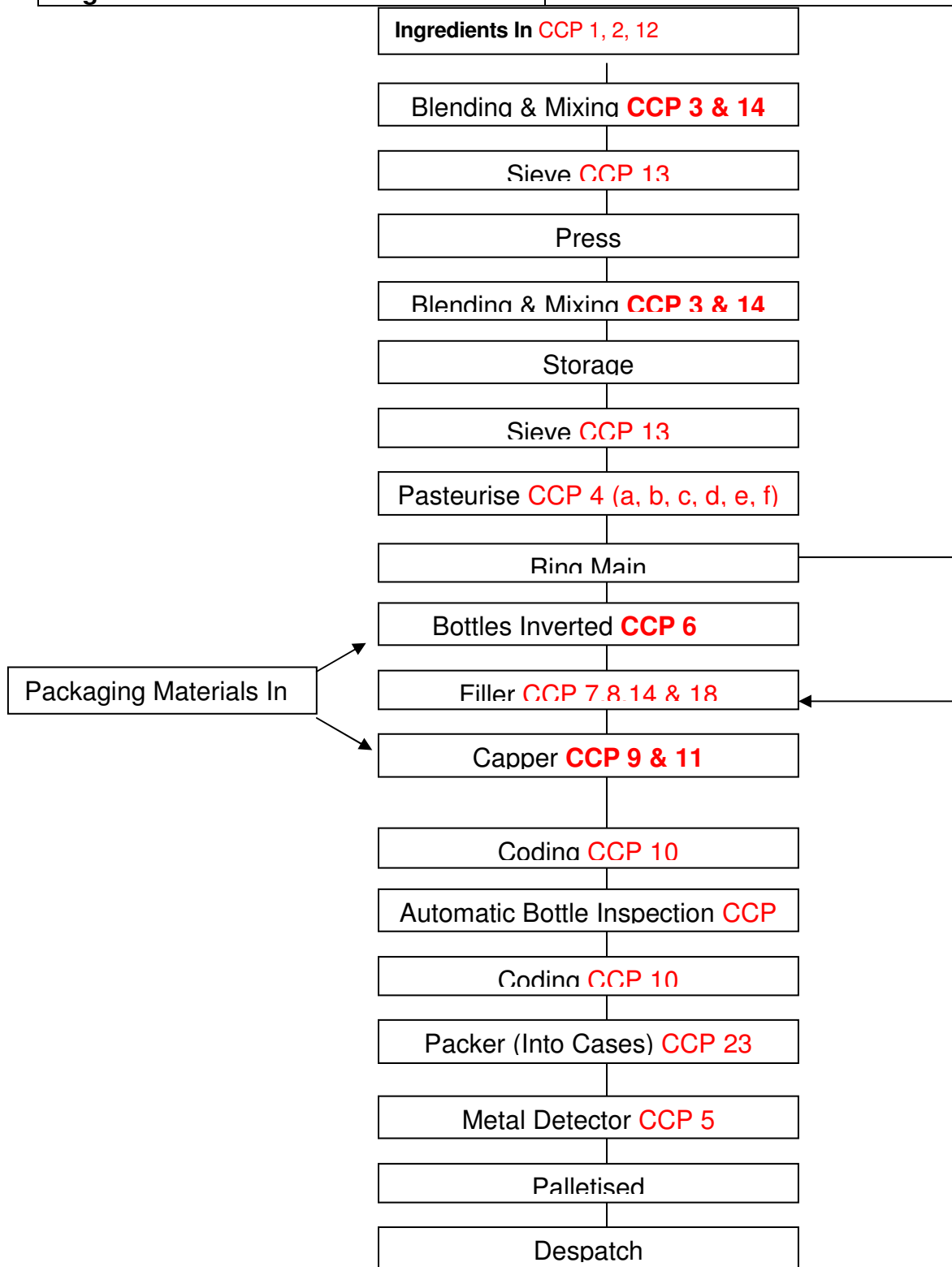
We confirm that there is a fully documented HACCP system in place for this product. Process Flow Chart is detailed below with Critical Control Points and Product Protection details indicated.

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File ref - TDS January 2004 UK Manufactured Products

**HP FOODS LIMITED TECHNICAL DATA SHEET  
UK MANUFACTURED PRODUCT**

**TDS - A**

<b>PRODUCT NAME: WORCESTERSHIRE SAUCE 12X290ML</b>	<b>SPECIFICATION NO</b>	<b>60444</b>
<b>BRAND: LEA &amp; PERRINS</b>	<b>RECIPE / SUPPLIER CODE</b>	<b>9300</b>
	<b>HP DATE OF ISSUE:</b>	<b>15/03/06</b>
	<b>REPLACES</b>	<b>14/06/05</b>
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No	Process Stage	Hazard	Method Of Control Or Prevention	Q	Q	Q	Q	CC P	Specificati on / Critical Limits	Procedure	Frequency	Corrective Actions	Responsibility
				1	2	3	4						
1	Tanker Delivery	All potential hazards from delivery vehicle Physical from tanker hatch opened to take sample	Purchase from approved suppliers Keep hatch open for as short time as possible	Y Y	Y N		Y Y	CC P1	Signed copy of HP Spec returned to HP by supplier	R&D approved supplier procedure (SAM).	As per SAM.	As per SAM.	As per SAM.  *** Risk deemed to small to include.
2	Vegetables fall into empty drum and labelled with crop year	All hazards from empty drum  Loss of traceability if year becomes illegible	Clean new drum.  Mark with indelible ink	N Y	N Y			CC P2	Date always legible (See LPP07 / WILP89)	Audit of records & Hygiene Audit.	Monthly.	Dispose of drums where traceability has been lost.	QA.

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<b>BRAND: LEA &amp; PERRINS</b>	<b>RECIPE / SUPPLIER CODE</b> 9300
	<b>HP DATE OF ISSUE:</b> 15/03/06
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				1	2	3	4						
3	Concentrate blended with other ingredients to make WS	Micro if analysis out of specification.	Sauce tested against specification.	Y	N	Y	N	CC P 3	As per WILP79.	Sauce tested in bottle.	Twice each day.	Product held and disposed.	QA
4	Divert	Micro – Thermometer divert control not working properly.	External 6 monthly calibration.	Y	Y			CC P 4	Always calibrated & working correctly.	Process audit.	Monthly	Isolate suspect stock after inspection of micro results.	QA / FGM.
4a	Divert	Micro – Divert valve not operating correctly.	Daily divert checks and PPM.	Y	Y			CC P 4a	Divert valve always working correctly. (WILP86)	Record audit.	Weekly	Isolate suspect stock after inspection of micro results.	QA / FGM

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				1	2	3	4						
4b	Cooling Pack	Micro – pack not intact allowing water ingress.	External contractor 6 monthly pack gas inspection.	Y	Y			CC P 4b	Plate pack intact.	Process audit.	Monthly.	Isolate suspect stock after inspection of micro records.	QA / FGM.
4c	Pre-heat pack	Micro – pack not intact allowing water ingress.	External contractor 6 monthly pack gas inspection.	Y	Y			CC P 4c	Plate pack intact.	Process audit.	Monthly.	Isolate suspect stock after inspection of micro records.	QA / FGM.
4d	Flowmeter	Micro	.Correct setting of inverter & flow rate.	Y	Y			CC P 4d	As per N07, record on WILP86.	Record audit.	Weekly.	Isolate suspect stock after inspection of micro records	QA / FGM.

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				1	2	3	4						
4e			Flowmeter calibration	Y	Y			CC P 4e	Annual calibration.	Process Audit.	Monthly.	Isolate suspect stock after inspection of micro records.	QA / FGM.
4f	Pasteuriser	Micro if incorrect process settings used.	Only correct pasteuriser settings used.	Y	Y			CC P 4f	As per N07 recorded on WILP86.	Record audit.	Weekly.	Isolate suspect stock after inspection of micro records.	QA / FGM.
5	Metal detection	Physical – if metal detector not working	3 hourly check with certified test pieces.	Y	Y			CC P 5	Detect and reject ; - 1.5 mm ferrous, 3mm non ferrous, 5.5mm stainless steel (minimum).	Process audit.	Monthly.	Isolate stock pending metal detection.	QA / FGM.

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				1	2	3	4						
6	In line air cleaner	Physical – all hazards if in line air not working or not working properly.	In line air always working properly.	Y	Y			CC P 6	In line air working properly (as stated on WILP26).	Record audit.	Weekly.	Recall stock produced since last good check. Business Decision.	QA / FGM.
7	Filler	Physical – glass from site glass or from bottles broken after the in line air.	Glass Breakage Procedure (LPP10)	Y	N	Y	N	CC P 7	As per LPP10 (recorded on WILP93).	Hygiene Audit.	Monthly.	Operator re-training. Business decision on stock filled.	QA / TL / FGM (Management Committee).
8	Filler	Micro – dilution of product by water in filler bowl.	Sauce only filled at correct TS level.	Y	N	Y	N	CC P 8	As per N06 and N09.	Record audit.	Weekly	Isolate stock and dispose of any below TS spec.	QA

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No	Process Stage	Hazard	Method Of Control Or Prevention	Q	Q	Q	Q	CC P	Specificati on / Critical Limits	Procedure	Frequency	Corrective Actions	Responsibility
				1	2	3	4						
9	Capper	All hazards if capper not set up correctly.	Capper always set up correctly.	Y	Y			CC P 9	Capper set up correctly.	Process audit.	Monthly.	Stock held since set up last known (and could be proved) to be correct. Business decision.	QA / FGM.
10	Coder	All hazards due to loss of traceability if code not applied or incorrect.	Code applied & correct.	Y	Y			CC P 10	Code present, correct & legible (record on WILP33)	Record audit.	Weekly.	Stop line and hold product from last to next good check. 100% to remove faulty bottles.	QA / TL / FGM.

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				1	2	3	4						
11	Capper	All hazards if caps not on.	Heuft reject system.	Y	Y			CC P 11	Heuft always working (recorded on WILP33).	Record audit.	Weekly.	Isolate stock since last recorded good check. 100% sort to remove faulty bottles.	QA / TL / FGM.
12	Weighed into intermediate plastic tubs	Physical – all types from scoops and container spices weighed into Allergen – from cross contamination (coconut)	Operator training  Specific container for coconut only.	Y	N	Y	Y	CC P 12	Use only specific marked container for coconut.	Hygiene Audit.	Monthly.	Isolate stock pending Business Decision.	QA then Management Committee.

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				1	2	3	4						
13	Pumped through SWECO (460 mm).	Metal from SWECO deterioration  Physical – all non metal hazards if SWECO not intact or in place	Condition of SWECO checked each blend.  Condition of SWECO checked each blend.	N	N			CC P 13	SWECO always intact and in place (WILP76)	Audit of records.	Monthly.	Isolate stock pending Business Decision.	QA then Management Committee.
14	Filler	Micro if refractometer uncalibrated.	Refractometer calibrated.	Y	N	Y	N	CC P 14	As per SCM7/8/9 (dependant on model).	Calibration record audit.	Weekly.	Product held and disposed.	QA
18	Filler	Physical – metal from filler syphon, rubber from O rings.	PPM.	Y	N	Y	N	CC P 18	PPM Sticker in date.	Process audit.	Monthly.	Stop filling immediately until PPM complete. Business decision on stock filled since last PPM.	QA / TL / FGM (Management Committee).

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				1	2	3	4						
23	Accumulation.	Increased traceability mesh size. Business risk.	Accumulation emptied at end of each day.	Y	Y			CC P 23	Only stock of one date code on each pallet.	Process audit.	Monthly.	Identify stock with mixed production codes. Business decision.	FGM / Management Committee.

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**Food Intolerance data**

	<b>Present in Product</b>	<b>In which Ingredient</b>	<b>Used on the Site</b>	<b>Used on the Same line</b>	<b>Comments</b>
Dairy / Dairy Derivatives	NO		YES	YES	Food Colour. Sodium Caseinate.
Egg / Egg Derivatives	NO		NO	NO	
Wheat / Rye / Barley / Oats	YES	Vinegar	YES	YES	Trace of Barley in Malt Vinegar.
Maize	NO		YES	YES	Modified Maize Starch
Gluten	YES	Vinegar	YES	YES	Malt vinegar – Below Level for Coeliac diet.
Soya / Soya Products	NO		NO	NO	
Nut / Nut Derivatives	NO		NO	NO	
Sesame Seeds / oil	NO		NO	NO	
Mustard Seeds / Mustard	NO		NO	NO	
Mango	NO		YES	YES	Mango Chutney
Fish / Fish Derivatives	YES	Anchovies	YES	YES	Anchovies
Crustaceans (Shellfish) and all derivatives.	NO		NO	NO	
Sulphur Dioxide and Sulphites >10mg/kg or 10mg/ltr	NO		NO	NO	
Celery and derivatives	NO		NO	NO	
Gelatine (Please state Source)	NO				
Citric Acid	NO				
Acetic Acid	YES	Malt Vinegar			
Antioxidants	NO				
Added MSG	NO				
Artificial Sweeteners – Aspartame	NO				
Artificial Sweeteners – Saccharin	NO				
Artificial Sweeteners - Acesulfame K	NO				

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**Additional Information**

**Health & Safety Data**

This information is required UK Health and Safety at work compliance.  
This information is to be product specific.

Appearance: Thin brown sauce with cloudy appearance.  
Storage: Ambient, cool and dry.  
Fire / Explosive Risk: Nil  
Corrosivity / Irritant: Due to the vinegar and salt content, this product is quite corrosive. The sauce may be an irritant to the skin.  
Precautions: If heating the sauce, this should be done in a well ventilated room.

**FIRST AID**

Inhalation of vapour: Remove from exposure, rest and keep warm.  
Eyes: Irrigate thoroughly with water. If irritation persists seek medical attention  
Skin: Wash thoroughly with water  
Disposal: Flush away with water, ventilate to remove vapour.

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**Validation**

<b>COMPANY:</b>	HP FOODS LIMITED
<b>NAME:</b>	.....
<b>TITLE:</b>	.....
<b>SIGNATURE:</b>	.....
<b>DATE:</b>	.....

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