6.14 Microbiological requirements

6.14.1 Commercially sterilized products

6.14.1.1 Microbiological spoilage

A product in its container, after incubation in accordance with 11.16 or after it has been kept at ambient temperature, shall be considered to have undergone microbiological spoilage if the container:

a) shows a positive pressure:

b) leaks; or

c) whether having a positive pressure or not, shows evidence of bacterial proliferation indicated, when compared with unincubated sound samples, by a significant change in pH value, or by disintegration or decomposition, or by significant discolouration of the product.

Evidence of bacterial proliferation shall be confirmed by cultural examination (see 11.17).

6.14.1.2 Requirement

Products in containers examined or tested or both, shall show no evidence of microbiological spoilage (see 11.17).

6.14.2 Pasteurized, semi-preserved, and salt-preserved products

6.14.2.1 Microbiological spoilage

A product in its container shall be considered to have undergone microbiological spoilage if the container:

a) shows a positive pressure;

b) leaks; or

c) whether having a positive pressure or not, shows evidence of bacterial proliferation indicated, when compared with sound samples, by a significant change in pH value, or by disintegration or decomposition, or by significant discolouration of the product.

Evidence of bacterial proliferation shall be confirmed microscopically or by cultural examination (see 11.17).

6.14.2.2 Requirement

Products in containers examined or tested or both, shall show no evidence of microbiological spoilage or of the presence of viable pathogenic organisms, or of organisms that are liable to cause spoilage of the product during storage at the temperature recommended by the canner, and, in the case of pasteurized products only, of viable non-spore-forming organisms (see 11.17).

7 Specific requirements for particular products

7.1 Stewed or braised meat, stewed oxtail, stewed tripe, stewed or braised kidneys, stewed or braised heart, stewed or braised liver, meatballs, stewed meat and kidney pudding, and similar stewed products, with or without gravy, sauces, or dressing

7.1.1 Preparation of meat and edible offal

Musculature meat for use in stewed or braised meat products shall be trimmed until it is free from perceptible fat, free surface-showing connective tissue and fascia, and where applicable it shall be cut into pieces of approximately the same size and shape that are not more than 50 mm long.

If the meat is minced and then formed into units, the units shall be approximately regular in size and shape. When determined in accordance with 11.3 and 11.4, the actual total meat content of ingoing units shall be not less than 50 % by mass. The ingoing units may contain starchy (farinaceous) material to the extent of not more than 6 % determined in accordance with 11.5 and calculated as crude starch. The units in the product described as meatballs, shall be formed into a characteristic shape and shall be readily separable. Meat patties shall be formed with substantially the same diameter as that of the container.

Kidneys shall be acceptably trimmed and free from adhering fat, connective tissue, renal ducts, urine flavour, and black or blue discolouration. Kidneys for use in kidney pudding shall be cut to acceptable size. Kidneys, liver, tongue, heart and tripe for use in stewed or braised products and puddings, shall be suitably prepared and cut into pieces that appear regular in size and shape, the smallest dimension of pieces of kidney being at least 10 mm. The product shall be free from any odour or flavour of urine.

Only oxtail, mutton and game meat from the ribs and neck may be packed on the bone. No free bone or sharp bones shall be present.

7.1.2 Texture of meat and edible offal in prepared product

In the prepared product, meat and edible offal shall not be fibrous, tough or mushy. Individual pieces of meat in stewed steak shall substantially retain their shape; pieces of meat shall be easily separable. The product shall be practically free from sinews and/or connective tissue.

7.1.3 Sauce, gravy or broth

Although vegetables and/or fruit shall not be present as chunks or as large pieces or whole units, they may be used in the preparation of sauce or gravy. The sauce or gravy may contain starchy (farinaceous) material that shall be not more than 6 % by mass determined in accordance with 11.5 and calculated as crude starch. The sauce or gravy may be suitably spiced.

Where the product is claimed to have been packed in natural broth, or in thick or rich sauce or gravy, the character of the packing medium shall, after equilibrium has been reached, be in accordance with the claim made. A canned meat product that has been packed in natural broth shall not be labelled as having been packed in gravy or in sauce.

7.1.4 Curing salts

The product shall not contain curing salts unless its name indicates the presence of cured meat.

7.1.5 Composition

The composition of the product shall comply with the relevant requirements given in table 1, the specified meat content and edible offal content percentages being applicable to the drained mass determined in accordance with 10.5. In addition, coagulated exuded fat shall not constitute more than 12 % of the required meat content or edible offal content and shall not be considered to be part of the drained mass requirement of the product.

Table 1 – Composition of particular products

1	2
Product category	**Requirements**
Stewed or braised meat with or without kidney or other edible offal ingredient in exuded juice or thin, watery broth or thin watery packing medium.	When determined in accordance with 10.5, the drained mass of meat with or without edible offal shall be at least 50 % of the d.n.m. of the container. Where the name of an edible offal ingredient appears in the name of the product, the drained mass of that edible offal ingredient, when determined in accordance with 10.5, shall be at least 12,5 % of the d.n.m.
Stewed or braised meat of a specific sort with or without a minor meat ingredient and with or without kidney or other edible offal ingredient, and with gravy, sauce or dressing.	When determined in accordance with 10.5, the drained mass of meat with or without edible offal shall be at least 50 % of the d.n.m. Where the name of any minor meat or edible offal ingredient present appears in the name of the product, the mass of that ingredient shall be at least 10 % of the d.n.m. Where the meat is mutton-on-the-bone or game-on-the-bone or a similar pack, the meat-on-the-bone content shall be at least 60 % of the d.n.m. and the bone content shall not exceed 12,5 % of the d.n.m. Free bone, especially chips, splinters or sharp pieces of bone, shall not be present. In a product labelled as goulash and packed in a thick sauce or a thick rich gravy, at least 50 % of the d.n.m. shall be meat.
Hearts stewed or braised; kidneys, stewed, braised, or in brine; liver, stewed or braised, and similar packs, with or without gravy, sauce or dressing.	When determined in accordance with 10.5, the drained mass of edible offal shall be at least 60 % of the d.n.m. except where the product is packed in thick rich gravy, sauce or other dressing in which case at least 55 % of the d.n.m. shall be edible offal.
Meat patties, with or without gravy, sauce or dressing.	Where the product is packed in gravy, sauce or dressing, at least 55 % of the d.n.m. shall be preformed units of meat, as determined in accordance with 10.5. Where the product is packed dry, at least 70 % of the d.n.m. shall be preformed units of meat.
Meatballs, with or without gravy or sauce; sausages in gravy or sauce; and similar packs.	Where the product is packed in gravy or sauce, at least 50 % of the d.n.m. shall be preformed units of meat, as determined in accordance with 10.5. Where meatballs are packed dry, at least 70 % of the d.n.m. shall be preformed units of meat.
Tripe, stewed with or without sauce or dressing, or in brine.	When determined in accordance with 10.5, the drained mass of tripe in stewed tripe or tripe in brine shall be at least 65 % of the d.n.m. Where the product is packed with sauce or dressing, at least 55 % of the d.n.m. shall be tripe.
Oxtail, with or without gravy, sauce or dressing.	In the case of a dry pack at least 60 % of the d.n.m. shall be oxtail on bone, as determined in accordance with 10.5. Where the product is packed in gravy, sauce or dressing, at least 45 % of the d.n.m. shall be oxtail on bone.
Pork, with or without gravy, sauce or dressing or fat.	In the case of a dry pack at least 65 % of the d.n.m. shall be pork, as determined in accordance with 10.5. Where the product is packed in gravy, sauce or dressing or fat, at least 50 % of the d.n.m. shall be pork.

7.2 Stewed meat products containing meat or edible offal or both with vegetables (or fruit) or cereal or both

7.2.1 Preparation of meat and edible offal

The requirements of 7.1.1 for the preparation of meat and edible offal for use in stewed or braised meat products and the requirements of 7.1.2 for the texture of meat and edible offal in the prepared product shall apply.

7.2.2 Vegetables (or fruit) and cereals

Vegetables and/or fruit may be used as such or as preparations. Root vegetables shall be in the form of clean-cut dice, slices or pieces, except that, if of acceptable size, these vegetables may be packed whole. Dice shall be approximate cubes. The thickness of slices shall not exceed 15 mm. Pieces shall appear regular in size and shape and shall be practically free from scrap pieces. The texture shall be soft but not broken up or disintegrated. Onions, fresh or pickled, shall be sliced, diced, shredded or chopped, or, if of acceptable size, they may be used whole. Dehydrated onion may also be used. Grains of rice shall separate easily. Beans and peas shall be mostly intact and not split or broken, and shall be free from loose shells. Cereals such as spaghetti and noodles shall not be disintegrated or abnormally broken up, and the texture shall not be abnormally mushy or soggy.

7.2.3 Sauce, gravy or broth

The sauce or gravy shall not contain more than 6 % by mass of starchy (farinaceous) material and it may be spiced.

Where the product is claimed to have been packed in exuded broth or in thick or rich sauce or gravy, the character of the packing medium shall, after equilibrium has been reached, be in accordance with the claim made.

A product packed in exuded or thin broth shall not be labelled as having been packed in gravy or sauce. A product that claims to have been packed in tomato sauce, shall have a characteristic tomato colour and the sauce shall not be thin and watery.

The ingredients of the sauce, gravy or broth shall not tend to separate from one another when the product is turned out of the container.

7.2.4 Curing salts

The product shall not contain curing salts unless its product name indicates the presence of cured meat.

7.2.5 Drained mass and washed mass

When determined in accordance with 10.5, the drained mass of products other than pudding packs shall be at least 60 % of the d.n.m. Where the product is required to be washed (see 10.5), the drained mass shall be not less than 50 % of the d.n.m.

7.2.6 Composition

The composition of the product shall comply with the relevant requirements given in table 2, the specified meat content and edible offal content percentages being applicable to the drained mass, determined in accordance with 10.5, except in the case of products where chemical analysis is specified. In addition, coagulated exuded fat shall not constitute more than 5 % by mass of the required meat contents of the container, and shall not be considered as part of the drained mass requirement of the product.

Table 2 Product category and requirements

1 Product category	2 Requirements
Products that contain beef and vegetables (or fruit) or cereal or both with or without packing medium.	When determined in accordance with 10.5, the drained mass of meat shall be at least 25 % of the d.n.m., except in the case of spaghetti bolognaise where the actual total meat content determined in accordance with 11.3 and 11.4, shall not be less than 25 %.
Products that contain mutton, including mutton-on-the-bone, or game-on-the-bone or similar packs, and vegetables (or fruit) or cereal or both, with or without packing medium.	In the case of mutton products other than mutton-on-the-bone, at least 25 % of the d.n.m. shall be mutton (without bone), as determined in accordance with 10.5. Where the meat is mutton-on-the-bone or game-on-the-bone at least 30 % of the d.n.m. shall be meat-on-the-bone. The bone-to-meat ratio, determined by weighing, shall not exceed 1:4. Free bone, especially chips, splinters or sharp pieces of bone, shall not be present.
Products that contain pork and vegetables or cereal or both, with or without packing medium.	When the drained mass is determined in accordance with 10.5, at least 25 % of the d.n.m. shall be pork with lean meat to fat proportions (see 10.6) of at least 3:1.
Products that contain meatballs, and vegetables (or fruit) or cereal or both, sausages and vegetables or cereal or both, and similar packs, with or without packing medium.	When determined in accordance with 10.5, the drained mass of the units of meat shall be at least 25 % of the d.n.m.
Products that contain steak or edible offal (other than tripe) or both and onion, with or without packing medium, or formed patties or meat balls and onion, with or without packing medium.	When the drained mass of ingredients is determined in accordance with 10.5, at least 50 % of the d.n.m. shall be steak or edible offal (other than tripe) or both, as relevant, or patties or meat balls, and at least 10 % of the d.n.m. shall be onion.
Products that contain liver or, other edible offal (other than tripe) or both, and vegetable(s) (or fruit) (other than onion alone) or cereal or both with or without packing medium.	When the drained mass of the ingredients is determined in accordance with 10.5, at least 25 % of the d.n.m. shall be liver or other edible offal (other than tripe) or both, as relevant.
Products that contain oxtail and vegetables (or fruit) or cereal or both, with or without packing medium.	When determined in accordance with 10.5, the drained mass of oxtail with bone shall be at least 25 % of the d.n.m.
Steak and kidney pie, chicken and ham pudding, steak and ham pudding, and similar packs.	When the drained mass of ingredients is determined in accordance with 10.5, at least 25 % of the d.n.m. shall be meat or meat plus edible offal. Where the name of an edible offal or minor meat ingredient appears in the name of the product, that edible offal or minor meat ingredient shall be at least 7 % of the d.n.m.
Puddings that contain meat of a specific sort, and vegetables (or fruit) or cereal, or both, with or without a minor meat or edible offal ingredient, or puddings that contain edible offal and vegetables (or fruit) or cereal or both, and similar packs.	When the drained mass of ingredients is determined in accordance with 10.5, at least 25 % of the d.n.m. shall be meat or edible offal or both, as relevant, and, where the name of a minor edible offal or minor meat ingredient appears in the name of the product, that minor edible offal or minor meat ingredient shall be at least 5 % of the d.n.m. The vegetable (or fruit) content or the cereal content or the vegetable (or fruit) and cereal content, as relevant, of the part of the product within the pie crust shall be at least 15 % of the d.n.m.
Products that contain meat (cured or uncured) and potato or other vegetable(s) (or fruit) or cereal or both as a solid pack.	When determined in accordance with 11.3, the actual lean meat content shall be at least 35 %. The appearance of the product shall clearly and prominently reflect the presence of the meat ingredient in accordance with this requirement.

7.3 Sliced bacon and sliced cured shoulder of pork

7.3.1 Preparation

Sliced bacon shall be cured and prepared from the bacon strip of a pig. Sliced cured shoulder of pork shall be cured and prepared from the shoulder of a pig.

7.3.2 Meat

Meat used in the preparation of bacon shall be derived from the carcasses of gilts or barrows that are suitable for the manufacture of bacon. Meat from boars of an age not exceeding 6 months may be used.

7.3.3 Curing

The product shall be adequately cured and may be smoked or unsmoked.

7.3.4 Packing

The product shall be packed in containers and in the form of rashers of uniform size, thickness and shape, that may be interleaved with clean parchment paper, cellulose film or other suitable material. The rashers shall be readily separable one from the other.

7.3.5 Appearance

The product shall be of attractive appearance and colour, and shall, when determined in accordance with 10.6, have a meat-to-fat ratio of at least 3:1 for bacon and 7:1 for shoulder of pork, and shall be free from seed, bruises, rust, discolouration, unsightly pieces of skin and excessive cartilage.

7.3.6 Fill of container

The container shall be filled as full as is practicable.

7.4 Corned mutton

7.4.1 Preparation

Corned mutton shall be adequately cured, and shall be prepared as a solid pack of mutton.

7.4.2 Meat

The meat used shall be obtained only from the skeletal musculature of sheep, and shall not include meat from the head, the masseter muscles excepted, or any offal other than skirt (diaphragm). Mechanically recovered meat shall not be used. The meat shall be well trimmed until free from perceptible sinews, tendons and other tough connective tissue. Thin flank and skirt shall, if used, be well trimmed and such that the connective tissue content of the end product does not detract from its appearance. The actual lean meat content, determined in accordance with 11.3. shall be at least 108 %.

7.4.3 Fat origin

The product shall not contain any intestinal or kidney fat, and only fat of ovine origin shall be permitted (see 12.1.2.5).

7.4.4 Fat content

The fat content, determined in accordance with 11.4, shall not exceed 25 % by mass.

7.4.5 Natural binder

If used, not more than 5 % by mass of natural binder shall be added to the product (see 5.23 and 12.1.2.5). Only natural binder of ovine origin is permitted.

7.4.6 Salt

In the preparation of the product, salt may be added to give a concentration of total chlorides, determined in accordance with 11.6 and expressed as sodium chloride, of not more than 3 % by mass.

7.4.7 Gelatine, agar-agar and carboxymethyl cellulose

The product may contain added gelatine, agar-agar or carboxymethyl cellulose and, in the case of the last two, not more than 1,0 % by mass and 0,5 % by mass, respectively, may be added to the product.

7.4.8 Phosphates

No phosphates shall have been added to the product.

7.4.9 Appearance, colour and texture

The product shall be of attractive appearance and shall have an acceptably uniform colour and a uniform firm coarse meat texture, both characteristic of this type of product. The original muscle structure shall be predominantly retained.

There shall be no excessive exudation of gelatinous matter or moisture. When determined in accordance with 10.7, exuded fat, if any, shall not exceed 7 % of the d.n.m. The exuded fat shall be distributed in a reasonably even layer around the entire product surface and it shall not be hard at ambient temperature. Internal fat shall be evenly distributed in the product; no lumps of fat shall be present. The product shall be sliceable at a product temperature of between 10 °C and 15 °C. The product shall not stick to the sides of the container and it shall be free from large surface cavities and discolouration.

7.5 Corned beef

7.5.1 Preparation

Corned beef shall be adequately cured and prepared as a solid pack of beef.

7.5.2 Meat

The meat used shall be obtained only from the skeletal musculature of bovines, but not more than 5 % may be heart meat, or the masseter muscles of head meat, or skirt meat (diaphragm), or any combination thereof. Mechanically recovered meat shall not be used. The meat shall have been trimmed until free from perceptible sinews, tendons and other tough connective tissue. The actual lean meat content determined in accordance with 11.3, shall be at least 108 %.

7.5.3 Fat origin

The product shall not contain intestinal fat, and only fat of bovine origin shall be permitted (see 12.1.2.5).

7.5.4 Fat content

Corned beef shall have been packed only as:

a) "Corned beef" without further qualification, in which case the fat content determined in accordance with 11.4, shall not exceed 20 % by mass, or

b) "Lean corned beef" in which case the fat content determined in accordance with 11.4, shall not exceed 15 % by mass, or

c) "Special lean corned beef", "Special lean-cut corned beef", or "Extra lean-cut corned beef", in which case the fat content determined in accordance with 11.4, shall not exceed 12 % by mass.

Words qualifying the title shall be in accordance with the regulations framed under the current Foodstuffs, Cosmetics and Disinfectants Act.

7.5.5 Natural binder

If used, not more than 5 % by mass of natural binder (see 5.23 and 12.1.2.5) of bovine origin shall be added to the product. Its presence shall be declared in the ingredients panel of the label in plain type of not less than 1,5 mm face measurement.

7.5.6 Salt

In the preparation of the product, salt may be added to give a concentration of total chlorides, determined in accordance with 11.6, and expressed as sodium chloride, of not more than 3 % by mass.

7.5.7 Gelatine, agar-agar and carboxymethyl cellulose

In the preparation of the product, gelatine, agar-agar or carboxymethyl cellulose may be added, and in the case of the last two, not more than 1,0 % by mass and 0,5 % by mass respectively may be added to the product.

7.5.8 Phosphates

When tested in accordance with 11.15, no phosphates shall have been added to the product.

7.5.9 Appearance, colour and texture

The product shall be of attractive appearance and shall have an acceptably uniform colour and a uniform firm coarse meat texture, both characteristic of this type of product. The original muscle structure shall be predominantly retained. The product shall be free from a dispersion of denatured proteinaceous matter.

There shall be no excessive exudation of gelatinous matter or moisture. When determined in accordance with 10.7, exuded fat, if any, shall not exceed 10 % of the d.n.m. The exuded fat shall be distributed in a reasonably even layer around the entire product surface and it shall not be hard at ambient temperature. Internal fat shall be evenly distributed in the product; no lumps of fat shall be present. The product shall be sliceable at a product temperature of between 10 °C and 15 °C. The product shall not stick to the sides of the container and it shall be free from large surface cavities and discolouration.

7.6 Corned beef with cereal

7.6.1 Preparation

Corned beef with cereal shall be adequately cured, and shall be prepared as a solid pack of beef containing not more than 6 % of crude starch.

7.6.2 Meat

7.6.2.1 Actual lean meat content

The requirements given in 7.5.2 shall apply, but the actual lean meat content determined in accordance with 11.3, shall be at least 80 %.

7.6.2.2 Fat origin

The product shall not contain intestinal fat, and only fat of bovine origin shall be permitted (see 12.1.2.5).

7.6.2.3 Fat content

The fat content determined in accordance with 11.4, shall not exceed 20 % by mass.

7.6.2.4 Natural binder

If used, not more than 5 % by mass of natural binder shall be added to the product (see 5.23 and 12.1.2.5). Its presence shall be declared in the ingredients panel of the label in plain type of not less than 1,5 mm face measurement.

7.6.2.5 Salt

In the preparation of the product, salt may be added to give a concentration of total chlorides, determined in accordance with 11.6 and expressed as sodium chloride, of not more than 3 % by mass.

7.6.2.6 Agar-agar and gelatine

The product shall not contain added agar-agar. Not more than 1 % by mass of gelatine may be added to the product.

7.6.2.7 Phosphates

No phosphates shall be added to the product.

7.6.2.8 Appearance, colour and texture

The product shall be of attractive characteristic appearance and shall have an acceptably uniform colour and a characteristic fairly coarse texture, free from springiness. There shall be no significant amount of finely chopped or finely minced meat or emulsified material present. The product shall be sliceable at a product temperature of between 10 °C and 15 °C. Exuded fat, when determined in accordance with 10.7, shall not be more than 10 % of the d.n.m., and there shall be no excessive exudation of gelatinous matter, cereal or moisture. No lumps of fat or cereal shall be present. The product shall not stick to the sides of the container and shall be free from large surface cavities and discolouration.

7.6.3 Labelling

The product shall be labelled without further qualification of the title, either as:

a) "Corned beef with cereal", in which case all the words shall appear in type of the same size and prominence and in a colour that affords a distinct contrast to the background colour of the label, or as

b) "Corned beef containing 6 % cereal" or "Corned beef – contains 6 % cereal", in which case the words qualifying "corned beef" shall appear immediately below "Corned beef" in plain type of not less than half the size of that used for "corned beef" with a minimum size of 2,5 mm face measurement, and in a colour that affords a distinct contrast to the background colour of the label.

7.7 Corned meat

7.7.1 Preparation

Corned meat shall be adequately cured and shall be prepared as a solid pack of meat, with or without permitted edible offal. Mechanically deboned meat not exceeding 25 % by mass of the total ingoing mix may be added.

Not more than 6 % by mass of cereal may be added.

7.7.2 Meat

The meat used shall be obtained from the skeletal musculature of food animals. The meat shall be well trimmed until free from perceptible sinews, tendons and other tough connective tissue. The actual lean meat content determined in accordance with 11.3, shall be at least 60 %.

7.7.3 Permitted edible offal (see 12.1.2.5 and 12.1.2.6)

a) One of the following constituent limitations shall apply, and the nature of the offal shall be declared on the ingredients panel:

   1) Any one of heart, tongue, kidney or liver may be used to the extent of 10 % of the product.

   2) Any one other edible offal may be used to the extent of not more than 5 % of the product.

   3) Two or more edible offal may be used together to the extent of not more than 10 % of the product.

b) If more than 10 % (or more than 5 % in the case of lungs and spleen) but not more than 35 % of the product consists of one or more edible offal, the nature of the offal(s) shall be declared in the title of the product by name in print of the same colour and prominence as the rest of the title and in at least half the size of the print used for the rest of the title.

c) Where offal is the major meat ingredient as in a product described as "Corned offal and meat", the skeletal muscular meat content shall not be less than 20 % of the product.

7.7.4 Fat content (see 12.1.2.5 and 12.1.2.6)

When determined in accordance with 11.4, the fat content shall not exceed 25 % by mass.

7.7.5 Natural binder

Not more than 10 % by mass or, where edible offal is used, not more than 8 % by mass of natural binder shall be added to the product (see 5.23 and 6.13).

Its presence shall be declared in the ingredients panel of the label in plain type of not less than 1,5 mm face measurement.

7.7.6 Salt

In the preparation of the product, salt may be added to give a concentration of total chlorides, determined in accordance with 11.6 and expressed as sodium chloride, of not more than 3 % by mass.

7.7.7 Gelatine or agar-agar

The product may contain added gelatine or agar-agar and, in the case of the latter, not more than 1 % by mass shall be added to the product.

7.7.8 Phosphates

The product may contain added phosphates.

7.7.9 Appearance, colour and texture

The product shall be of attractive appearance and shall have an acceptably uniform colour and texture, both being characteristic of this type of product. It may be fine in texture, but shall not have a close, springy texture and shall not be soggy or doughy when cooled to between 10 °C and 15 °C. Emulsified matter shall not be predominant. When determined in accordance with 10.7, exuded fat, if any, shall not exceed 14 % of the d.n.m. The exuded fat shall be distributed in a reasonably even layer around the product surface and shall not be hard at ambient temperature. In addition, other exuded material, determined in accordance with 10.7, shall not exceed 5 % of the d.n.m. Internal fat shall be evenly distributed in the product. No lumps of fat or lumps of cereal or other material shall be present. The product shall not stick to the sides of the container and it shall be free from large surface cavities and discolouration.

7.7.10 Labelling

7.7.10.1 Where meat other than beef, pork, mutton or goats' meat is used, the kinds of meat present shall be disclosed in the product name, and, in all cases, the kinds of meat used shall be declared in the ingredients panel of the label if they do not appear in the title. Where fat of other origin than the kind(s) of animal(s) declared on the label is used, the kind(s) of fat origin shall also be declared.

7.7.10.2 Subject to 7.7.10.1 above, corned meat shall be labelled as "corned meat" without further qualification.

7.8 Ham, cured shoulder of pork, and cured solid pressed beef

7.8.1 Ham

Ham shall be prepared from the ham (gammon) of a pig and shall be adequately cured and canned, and either pasteurized or commercially sterilized by heat treatment. This product shall have a meat-to-fat ratio, determined in accordance with 10.6, of at least 9:1. The fat on the outside of the ham shall be fairly evenly distributed. In the case of hams labelled as defatted ham, all surface fat shall, as far as practicable, be trimmed off. The actual lean meat content, determined in accordance with 11.3, shall be at least 80 % by mass.

7.8.2 Cured shoulder of pork

Cured shoulder of pork shall be prepared from the shoulder of a pig and shall be adequately cured and canned, and either pasteurized or commercially sterilized by heat treatment. This product shall have a meat-to-fat ratio, determined in accordance with 10.6, of at least 7:1. The fat on the outside of the product shall be fairly evenly distributed. The description of this product shall not include the word "Ham", and in the description all the words used in the title shall appear in plain type of the same size and prominence. The actual lean meat content, determined in accordance with 11.3, shall be at least 80 %.

7.8.3 Cured solid pressed beef

Cured solid pressed beef shall be prepared from skeletal musculature beef and shall be adequately cured and canned, and either pasteurized or commercially sterilized by heat treatment. It shall be free from excessive exuded fat and moisture. After all gelatinous material or other jelled materials have been removed from the surface of the contents, the product shall have an actual lean meat content of at least 80 % by mass, determined in accordance with 11.3.

7.8.4 Meat

Meat used in the preparation of ham and cured shoulder of pork shall be derived from the carcasses of gilts or barrows up to baconer stage. The carcasses of sows and boars exceeding the age of six months shall not be used. Meat that is bruised, soft or oily shall not be used. Frozen meat shall have been stored at a temperature of -18 °C or lower. Soya and other non-meat proteinaceous materials shall not be used.

7.8.5 Gelatin or agar-agar

Gelatin or agar-agar may be added to the product. In the case of the latter, not more than 2 % by mass may be added.

7.8.6 Phosphates

Phosphates may be added to the product.

7.8.7 Curing

The product shall be adequately cured and, where necessary, shall be adequately cleaned after curing and before packing.

7.8.8 Smoking

The product may be either smoked or unsmoked (see 12.1.2.2.3).

7.8.9 Salt

In the preparation of the product, salt may be added to give a concentration of total chlorides, determined in accordance with 11.6 and expressed as sodium chloride, of not more than 3 % by mass.

7.8.10 Trimming and packing

The product shall be adequately trimmed and shall be free from bone. Whether the product is manufactured from one or more pieces, it shall be compact and permit slicing without breaking into pieces. Where the product is in the form of compressed pieces, and its appearance and sliceability suffer in consequence, this fact shall be conspicuously declared in the main panel of the label in compliance with the regulations under the current Foodstuffs, Cosmetics and Disinfectants Act.

Gammon may be packed with rind but only if the rind is intact and sliceable. Shoulder shall not be packed with rind. Gelatine or agar-agar may be used to solidify the juices provided that in the case of agar-agar, the content does not exceed 2 %. The juices in the container shall be a gel at a product temperature of 20 °C or lower. Shoulders shall be neatly tied.

7.8.11 Appearance and texture

Upon removal from the container, the product shall have essentially the same shape as that of the container and shall be as free as is practicable from surface cavities that significantly affect its appearance. The product shall be free from bruises, blood spots, discolouration, surface contamination and other forms of blemish. The original muscular structure shall be retained. Ham and cured shoulder of pork products shall not have a "chopped meat" texture. The texture of the product shall not have an emulsified appearance. Layers of fat shall be evenly distributed in the product. The manufacturing process shall be such as to ensure that the product has a cured colour and a texture that are characteristic. The product shall be sliceable at a product temperature of 20 °C or lower.

7.8.12 Freedom from defects

The product shall be free from hair follicles, loose fat, loose rind, gristle, cartilage, superficial glands and tough sinews. Poisonous and deleterious substances including solder and flux shall not be present. The product shall be free from scorched or burnt portions and the container shall be free from visible internal corrosion that might affect the product adversely.

7.8.13 Sliceable mass

The mass of the product, freed from adhering jelled materials and loose fat, and other unattached material from the surface of the contents shall be at least 80 % of the d.n.m. in the case of pasteurized ham, 75 % in the case of pasteurized cured shoulder of pork, and 65 % in the case of ham and cured shoulder of pork that have been commercially sterilized. In the case of cured solid pressed beef, the mass of the product, freed from adhering jelly, shall be not less than 80 % of the d.n.m.

7.8.14 Fill of container

The container shall be filled as full as is practicable.

7.8.15 Pasteurized products

Pasteurized products shall be stored under refrigeration at a temperature not exceeding 4 °C or at such lower temperature as might be desirable (see 12.1(e) for labelling).

7.9 Edible lard

7.9.1 Preparation

Edible lard shall be prepared by heat-rendering the fresh tissue fat of pigs that are in good health at the time of slaughter. Reprocessed lard or pressings from crackling shall not be included and the lard shall be free from flesh, fibrous tissue and crackling.

7.9.2 Rancidity

Freedom of the product from any odour or taste of rancidity shall be ensured by the method of processing.

7.9.3 Foreign fat

The rendered fat of any animal other than pig and any other foreign fat or oil shall not be present in the product.

7.9.4 Fill of container

Subject to the requirements of the regulations under the current Trade Metrology Act, the container shall be filled as full as is practicable.

7.9.5 Salt (sodium chloride)

Sodium chloride shall not be added to the product.

7.9.6 Physical and chemical requirements of the product

7.9.6.1 Iodine value

The Wijs iodine value, determined in accordance with 11.9, shall be within the range 52 to 77.

7.9.6.2 Refractive index

When determined at a temperature of 60 °C, in accordance with 11.13, the refractive index shall be within the range 1,4510 to 1,4535.

7.9.6.3 Melting point

The melting point, determined in accordance with 11.12, shall be within the range 25 °C to 46 °C.

7.9.6.4 Free fatty acids

The free fatty acid content, determined in accordance with 11.10 and calculated as oleic acid, shall not exceed 0,6 % by mass.

7.9.6.5 Saponification value

The saponification value determined in accordance with 11.11 shall be within the range 192 mg to 202 mg KOH/g.

7.9.6.6 Moisture

The moisture content of the lard, determined in accordance with 11.7, shall not exceed 0,25 % by mass.

7.10 Edible beef dripping

7.10.1 Preparation

Edible beef dripping shall be prepared by heat-rendering the fresh fat, exclusive of intestinal fat, of beef from animals in good health at the time of slaughter. Flesh and fibrous tissue shall be removed.

7.10.2 Rancidity

Freedom of the product from any odour or taste of rancidity shall be ensured by the method of processing.

7.10.3 Foreign fat

The rendered fat of any animal other than the bovine and any other foreign fat or oil shall not be present in the product.

7.10.4 Fill of container

Subject to the requirements of the regulations under the current Trade Metrology Act, the container shall be filled as full as is practicable.

7.10.5 Salt (sodium chloride)

Sodium chloride shall not be added to the product.

7.10.6 Physical and chemical requirements of the product

7.10.6.1 Iodine value

The Wijs iodine value, determined in accordance with 11.9, shall be within the range 35 to 48.

7.10.6.2 Refractive index

When determined at a temperature of 60 °C, in accordance with 11.13, the refractive index shall be within the range 1,4566 to 1,4587.

7.10.6.3 Melting point

The melting point, determined in accordance with 11.12, shall be within the range 40 °C to 46 °C.

7.10.6.4 Free fatty acids

The free fatty acid content, determined in accordance with 11.10 and calculated as oleic acid, shall not exceed 0,75 % by mass.

7.10.6.5 Saponification value

The saponification value, determined in accordance with 11.11, shall be within the range 193 mg to 205 mg KOH/g.

7.10.6.6 Moisture

The moisture content of the dripping, determined in accordance with 11.7, shall not exceed 0,25 % by mass.

7.11 Meat rolls (meat loaves)

7.11.1 Preparation

Meat rolls (meat loaves) shall be prepared from chopped or comminuted meat of bovines or pork. Any other meat used shall be declared on the main panel of the label. Permitted edible offal, seasoning and flavouring substances, water, fat, starchy (farinaceous) materials (see 5.17), phosphates, milk powder, eggs and other acceptable ingredients may be added.

7.11.2 Natural binder

Not more than 5 % by mass of natural binder may be added to the product. The nature of the natural binder shall be in accordance with the nature of the product: binder derived from pork shall not be used in a pure beef product nor shall binder derived from beef be used in a pure pork product (see 5.23 and 12.1.2.5).

7.11.3 Permitted edible offal (see 12.1.2.5)

The product shall contain only the following edible offal: heart, liver, kidney and tongue (see 7.12.4). The use of blood shall be limited to the preparation of blood sausage or blood roll.

7.11.4 Composition requirements

7.11.4.1 Meat rolls (loaves) other than liver rolls

Meat rolls (loaves) other than liver rolls shall comply with the following requirements:

a) the actual total meat content of the product, determined in accordance with 11.3 and 11.4, shall be at least 75 %, except that corned beef roll (loaf) shall have a actual total meat content of at least 80 %;

b) the fat content of the roll (loaf), determined in accordance with 11.4, shall not exceed 35 % of the actual total meat content, except that in corned beef roll (loaf) the fat content of the roll shall not exceed 30 % of the actual total meat contents;

c) the starchy (farinaceous) material determined in accordance with 11.5 and calculated as crude starch shall not exceed 6 % by mass;

d) corned beef roll (loaf) shall not contain heart, liver, kidney or tongue; and

e) in products other than corned beef roll (loaf), not more than 8 % by mass may consist of heart, liver, kidney, tongue or any mixture of these (see 12.1.2.5 and 12.1.2.6), provided that the presence of such edible offal is declared in the ingredients panel of the label in plain type of not less than 1,5 mm face measurement.

7.11.4.2 Liver roll (loaf)

Liver rolls (loaves) shall comply with the following requirements:

a) the actual total meat content determined in accordance with 11.3 and 11.4, shall be at least 70 %;

b) the liver content shall be at least 25 % by mass;

c) the fat content (see 12.1.2.5 and 12.1.2.6) of the product determined in accordance with 11.4, shall not exceed 40 % of the actual total meat content;

d) the starch content determined in accordance with 11.5 and calculated as crude starch shall not exceed 6 % by mass; and

e) not more than 10 % by mass shall be heart, kidney, or tongue or any mixture of these (see 12.1.2.5 and 12.1.2.6), provided that the presence of such edible offal is declared in the ingredients panel of the label in plain type of not less than 1,5 mm face measurement.

7.11.4.3 Meat rolls (loaves) with garnish

Where a product contains garnish, the specified meat content requirements shall be applicable to the meat constituent.

7.11.5 Curing salts

Corned beef roll (loaf) shall be adequately cured. Other products may contain curing salts (see 7.7).

7.11.6 Phosphates

Phosphates may be added to the product.

7.11.7 Agar-agar

The agar-agar content shall not exceed 0,2 % by mass.

7.11.8 Blood plasma

Except in the case of blood sausage or blood roll, blood plasma shall not be added to the product.

7.11.9 Appearance and texture

Discolouration that detracts from the appearance of the product shall not be present. The product shall not stick to the inside surfaces of the container. The exterior surface of the product, after the product has been removed from the container, shall be free from unevenness that detracts from its appearance. Exuded material, when determined in accordance with 10.7, shall not exceed 3 % of the d.n.m. The product shall be readily sliceable at a product temperature of 20 °C or lower. Except in the case of liver rolls, the product shall not have a doughy, soggy or pasty texture. The product shall be free from grittiness, cavities, perceptible sinews, tendons or other tough connective tissue.

7.11.10 Flavour

The product shall have a characteristic meaty flavour and not a predominantly spicy or non-meaty flavour, and shall not be excessively salty.

7.12 Poultry

7.12.1 Preparation

7.12.1.1 Poultry shall be prepared from chicken, duck, goose, turkey or game birds and, subject to 7.13.3, shall be packed as one of the following:

a) flesh only;

b) pressed meat;

c) dissected poultry; or

d) whole poultry.

7.12.1.2 Poultry packed as flesh only shall be free from bones.

7.12.1.3 Poultry packed as pressed meat, shall have a flavour characteristic of poultry, shall not have a soggy texture, and shall be sliceable at a product temperature of 20 °C or lower. After removal from the container, the product shall have essentially the same shape as that of the container. No surface cavities or discolouration shall be present. Colour variation shall not be present in the product.

7.12.1.4 All packs shall be free from arteries and tough tendon tissues, except that, in the case of whole poultry, the two main arteries that lead to the shoulders may be present and also those tendon tissues that, because of the nature of the pack, cannot be removed. Only birds that are free from deformities shall be packed as whole poultry. Edible offal may be included, provided that the product is so labelled as to disclose its true nature.

7.12.2 Trimming

The product shall be cleanly trimmed and shall be free from bruised and discoloured portions of flesh.

7.12.3 Packing

The product shall be packed in one of the following media:

a) a jellied medium that may, to assist in the formation of a firm jelly, contain added gelatine or agar-agar, the latter not exceeding 1 % by mass; the jellied medium shall be a gel at a product temperature of 20 °C or lower;

b) a suitable sauce or meat juice medium;

c) poultry fat;

d) lard, that shall only be used for whole poultry; or

e) with sauces or dressings, and with or without vegetables (or fruit) or cereal or both.

7.12.4 Drained mass and percentage of flesh

7.12.4.1 Packs without cereal and vegetables (or fruit)

Unless the product is packed in a prepared sauce medium or in exuded chicken broth, the drained mass, determined in accordance with 10.5 and expressed as a percentage of the d.n.m. shall be as follows:

a) flesh only packs: at least 70 %;

b) dissected poultry: at least 65 %;

c) whole poultry packs: at least 55 %; and

d) canned liver and canned heart packs: at least 70 %.

Where the product is packed in a prepared sauce medium or in chicken broth, the drained mass shall be at least 50 % of the d.n.m.

7.12.4.2 Packs with vegetables (or fruit) or cereal or both

The drained mass, determined in accordance with 10.5, shall be at least 55 % of the d.n.m. The mass of flesh in a pack that is bone-free shall be at least 25 % of the d.n.m. In a pack that contains dissected poultry the mass of flesh plus bone shall be at least 30 % of the d.n.m. and the ratio of bone to flesh shall not exceed 1:4. No free bone shall be present.

Different types of product may be labelled "Chicken Suprême" conditional on the descriptive title for each product accompanying the title. The product may consist of chicken meat in a rich prepared sauce, in which case it shall comply with the relevant requirement of table 2, or it may consist of chicken meat in a rich sauce with vegetables (or fruit), in which case the washed mass of the meat ingredient shall constitute at least 45 %, and the total drained mass at least 60 % of the d.n.m.

7.12.4.3 Pressed meat packs

In a pressed meat pack, the actual lean meat content determined in accordance with 11.3, shall be at least 80 %.

7.12.4.4 Dissected poultry packs

In a dissected pack the constituent parts present in the pack shall be in the same proportions as in whole poultry. Constituent parts may be packed separately, provided that the product is so labelled as to disclose its true nature. The ratio of bone to flesh shall not exceed 1:4. No free bone shall be present. The drained mass shall comply with the requirements for a dissected pack given in table 2, as relevant.

7.12.5 Freedom from defects

Feathers, including pinfeathers, shall not be present in the product. In the case of poultry packed on the bone, splinters or grit of bone or sharp bones shall not be present.

7.12.6 Texture

The meat or edible offal and, where present, the vegetables and/or fruit shall have a firm but tender texture. Chicken pie filling shall contain an acceptable proportion of visible muscle meat without bone, and shall have an acceptably viscous consistency.

7.13 Sausages, raw species sausage and raw mixed-species sausage

7.13.1 Preparation

Sausages, raw species sausage and raw mixed-species sausage shall be prepared from minced meat, with or without permitted edible offal. Seasoning and flavouring substances, water, fat, starchy (farinaceous) material, phosphates (see 6.8), milk powder (see 5.19), eggs and other acceptable ingredients may be added. Sausages shall be filled into casings with or without subsequent treatment or shall be otherwise formed into shape.

7.13.2 Natural binder

Natural binder (see 5.23, 12.1.2.5 and 12.1.2.6) shall not be more than 8 % by mass of the total sample contents. The nature of the natural binder used shall be in accordance with the nature of the product: binder derived from pork shall not be used in a pure beef product nor shall binder derived from beef be used in a pure pork product.

7.13.3 Permitted edible offal

The product may contain only the following edible offal: heart, liver, kidney and tongue.

7.13.4 Composition requirements

7.13.4.1 Sausages in brine, agar-agar or other aqueous medium, whether gelled or not

Sausages shall comply with the following requirements:

a) the composition, determined by chemical analysis, of the canned sausages after they have been drained on a sieve of nominal aperture size 2 mm and after any adhering packing medium has been removed, shall, subject to (b) below, comply with the appropriate requirements given in table 3; and

b) if the actual total meat content of the sausage, determined by chemical analysis, is less than the specified minimum of 65 % but the product of the actual total meat content percentage and the drained mass as a percentage of the d.n.m. (see 7.13.5.1) divided by 100 gives a value of at least 49, the product shall be regarded as acceptable in relation to meat content.

Table 3 □ Limits for sausage contents

1	2	3	4
Type of sausage	**Minimum actual total meat content[a] %**	**Maximum fat content as a percentage of actual total meat content[b] %**	**Maximum crude starch content[c] %**
Pork sausage	65	38	5
Beef sausage	65	30	5
Mixed meat sausage	65	35	5
Vienna sausage	65	25	5
Frankfurter sausage	65	25	5

[a] Determined in accordance with 11.3.
[b] Determined in accordance with 11.4.
[c] Determined in accordance with 11.5.

7.13.4.2 Sausages in fat and sausages without packing medium

The composition of the canned sausages (determined by chemical analysis) after any fat used as packing medium has been removed by gentle scraping, shall comply with the appropriate requirements as given in table 4.

7.13.4.3 Boerewors, raw species sausage and raw mixed-species sausage

At the point of packing into the container, boerewors, raw species sausage or raw mixed-species sausage shall have an actual total meat content of not less than 90 % by mass and an actual lean meat content of not less than 60 % by mass as determined by chemical analysis.

7.13.4.4 Content of permitted edible offal

In the case of sausages other than boerewors, not more than 5 % of the d.n.m. shall be heart, liver, kidney, or tongue used either singly or in combination, which might have been included in the product, provided that the presence of such permitted edible offal is declared in the ingredients panel on the label in plain type of not less than 1,5 mm face measurement. Boerewors shall not contain liver, kidney, heart or tongue.

Table 4 □ Limits for sausage contents

1	2	3	4
Type of sausage	**Minimum actual total meat content[a] %**	**Maximum fat content as a percentage of actual total meat content[b] %**	**Maximum crude starch content[c] %**
Pork sausage	75	43	5
Beef sausage	75	36	5
Mixed meat sausage	75	40	5

[a] Determined in accordance with 11.3.
[b] Determined in accordance with 11.4.
[c] Determined in accordance with 11.5.

7.13.5 Mass of sausage in pack[1)]

7.13.5.1 Except as allowed in terms of 7.13.5.2, the mass of sausage in a container when determined in accordance with 10.5, shall be at least 75 % of the d.n.m., except that in the case of frankfurters, viennas and cocktail viennas packed in natural casings, and provided that the container was packed to practical capacity with sausages, the drained mass shall be at least 60 % of the d.n.m. In the latter case, where the normal drained mass of 75 % cannot be achieved, the actual mass of sausages in the container shall be declared on the label, in addition to the net mass of the contents, in plain type of the same size and prominence as that used for the net mass.

In the case of boerewors packed in rich gravy, the mass of sausage packed shall be at least 70 % of the d.n.m.

7.13.5.2 If the actual drained mass of sausages packed as in 7.13.5.1, is less than the specified minimum of 75 % and the product of the actual drained mass as a percentage of the d.n.m. and the percentage of actual total meat content (determined in accordance with 11.3 and 11.4), divided by 100 gives a value of at least 49, the product shall be regarded as acceptable in relation to drained mass, provided that the product complies with 7.13.13.

1) The requirements of this clause are subject to compliance with the Regulations under the Trade Metrology Act, 1973.

7.13.6 Curing salts

The product may contain curing salts (see 6.7).

7.13.7 Blood plasma

Except in the case of blood sausages, no blood plasma may be added to the product.

7.13.8 Packing medium

Sausages other than viennas and frankfurters may be packed in fat characteristic of the meat used, in brine, or in a medium of agar-agar content not exceeding 2 % by mass. Viennas may be packed in brine of salt content 2 % to 6 %, or in a medium of gelatine content not exceeding 5 % by mass, or agar-agar content not exceeding 2 % by mass. Frankfurters shall be packed only in brine of salt content 2 % to 6 %. In the case of viennas and similar products, the packing medium shall not be uncharacteristically dark. When sausages are packed in a brine or clear packing medium, the packing medium shall not be turbid or cloudy, and shall be free of sediment.

7.13.9 Casings

Hog, sheep and synthetic casings that are of acceptable quality, sound and in a hygienic condition shall be used. Non-edible synthetic casings shall be removed from the sausage, without significant marking of the sausage, before it is canned.

7.13.10 Appearance and uniformity of size, shape and colour

The units in any one container shall be acceptably uniform in colour, size and shape and the shape of the units shall not be distorted or twisted. Any splitting and end-bursting shall not be such as to detract from the appearance of the product. Skinless units shall be completely separate one from the other. Cross-filling of units shall not be present. Cross-cut units shall be cleanly cut at right angles to the longitudinal axis. The units shall be free from impression marks, e.g. marks caused by the expansion rings of the side walls of a container.

7.13.11 Texture

Frankfurters, viennas and cocktail viennas shall have an evenly fine smooth and firm filled texture. The units shall be free from grittiness, coarse particles of natural binder, gristle and sinews, cavities or air pockets. The product shall not be soggy.

Sausages other than frankfurters, viennas and cocktail viennas, such as beef sausages, pork sausages and mixed meat sausages shall have a firm filled texture. It may be coarse, with pieces of meat characteristic of the product. The product shall be free from grittiness and internal and surface cavities. The product shall not be soggy.

7.13.12 Fill of container

The container shall be filled as full as is practicable with sausages.

7.13.13 Freedom from defects

The sausage units shall be free from staining, discolouration, serious rupturing of casings that detract from the normal appearance of the product, ragged ends, burst, damaged and broken units, and pieces of non-edible casings. The product shall be free from exuded fat or other material that detracts from its appearance. The sausage units shall not adhere to each other or to the inside surfaces of the container. The sausage units shall not be excessively salty.

The product shall be free from sour flavours and off-flavours.

7.14 Vienna pieces and vienna offcuts

7.14.1 Preparation

Vienna pieces and vienna offcuts shall be prepared from portions of vienna sausages that comply with the applicable requirements of 7.14.5. If held overnight or longer before packing, pieces and offcuts shall be kept under refrigeration.

7.14.2 Vienna pieces

The units shall be portions of vienna sausages that have been cleanly cut at right angles to their longitudinal axes, and their length shall be not less than 20 mm and not more than 25 mm. They shall not be stained, discoloured, ragged or broken, and in any one container the units shall, as far as is practicable, be of uniform length. The product shall be labelled "Vienna pieces" and both words shall appear in print of the same size and prominence.

7.14.3 Vienna pieces, irregular in size

The units shall be portions of vienna sausages that have been cleanly cut at right angles to their longitudinal axes. They shall not be stained, discoloured, ragged or broken, and in any one container the units may vary in length from 20 mm to 40 mm. There shall be not more than one flattened or malformed end per A1 or No. 1M can. In the cases of larger sizes of container, the count of such ends shall be proportionate to the volume capacity of the container relative to the A1 can. The product shall be labelled "Vienna pieces, irregular in size" and all the words shall appear in print of the same size and prominence.

7.14.4 Vienna offcuts, irregular in size and shape

The units shall be offcut portions of vienna sausages and may have flattened or malformed end portions, but shall not be stained or discoloured, and ragged ends shall not be present. The units may vary in length from 10 mm to 40 mm and may vary in shape.

The product shall be labelled "Vienna offcuts, irregular in size and shape" and all the words shall appear in print of the same size and prominence.

7.14.5 General

All other requirements given in 7.13 that are applicable and relevant to vienna sausages shall apply to the packs described in 7.14.2, 7.14.3 and 7.14.4.

7.15 Tongue

7.15.1 Preparation

Tongue shall be prepared from adequately cured tongues of food animals.

Tongue shall be neatly trimmed at the root end and shall be free from bone, epiglottis, external fat, glands, main arteries or veins and, in the case of ox tongue, skin. Tongue may be either precooked or cooked in the container or both. Ox tongue may be longitudinally cut and may be reduced (by cutting) only at the root end, if necessary for it to fit the container. Only one small additional loose portion of tongue may be added per container to make up mass.

7.15.2 Packing medium

Tongue may be packed in brine or in a medium prepared from bone stock, with or without the addition of gelatine or agar-agar or both, or in a medium prepared from gelatine or agar-agar or both, or in any other acceptable medium. The agar-agar content of the packing medium shall not exceed 2 % by mass. The packing medium shall be characteristic in appearance.

7.15.3 Mass of tongue in pack

When determined in accordance with 10.5, the drained mass of the tongue in a container shall, for ox tongue, be at least 80 % of the d.n.m. and for sheep tongue, at least 75 % of the d.n.m.

7.15.4 Appearance and texture

The product shall be uniformly cured and discolouration that detracts from the appearance of the product shall not be present. The product shall not be tough, soggy or damaged.

7.15.5 Flavour and odour

The product shall have a characteristic, pleasant fresh flavour and odour, and shall have no foreign flavours, foreign odours, off-flavours or off-odours.

7.15.6 Salt

In the preparation of the product, salt may be added to give a concentration of total chlorides, determined in accordance with 11.6, expressed as sodium chloride, of not more than 3 % by mass.

7.15.7 Labelling

The product shall be so labelled as to indicate the true nature and origin of the tongue.

7.16 Tongue slices

7.16.1 Preparation

7.16.1.1 Tongue slices shall consist of slices of the adequately cured tongue of food animals and the product shall be so labelled as to indicate the true nature and origin of the tongue.

7.16.1.2 The slices shall be obtained from tongue prepared in accordance with 7.16.1.1. The slices in any production lot shall be acceptably uniform in thickness and have a maximum thickness of 10 mm. Slices shall not be ragged or damaged.

7.16.2 Packing medium

The product may be packed in accordance with 17.6.1.1 or with sauce, gravy or dressing. If packed in brine, slices shall be fairly uniform in size.

7.16.3 Appearance and texture

The product shall be uniformly cured and discolouration that detracts from the appearance of the product shall not be present. The product shall not be tough or soggy.

7.16.4 Flavour and odour

The product shall have a characteristic, pleasant fresh flavour and odour and shall have no foreign flavours, foreign odours, off-flavours or off-odours.

7.16.5 Mass of tongue in pack

When determined in accordance with 10.5, the drained mass of the tongue in a container shall, in the case of tongue slices packed in accordance with 7.16.2, be at least 70 % of the d.n.m, and in the case of tongue slices packed in sauce, gravy or dressing, at least 50 % of the d.n.m.

7.16.6 Salt

In the preparation of the product, salt may be added to give a concentration of total chlorides, determined in accordance with 11.6, expressed as sodium chloride, of not more than 3 % by mass.

7.17 Meat paste, potted meat and chopped meat

7.17.1 Preparation

7.17.1.1 Meat paste and potted meat

Meat paste and potted meat shall be prepared from meat, with or without edible offal (see 7.17.2), that has been so comminuted as to form a spreadable paste, with or without the addition of tomato, starchy (farinaceous) material, and other acceptable ingredients. Bone shall not be used in any form in the product other than in chicken paste and similar pastes derived from dressed whole poultry, in which milled bone may be present, provided that it does not detract from the quality in any way and that bone content in the end product is not in excess of the bone-to-flesh ratio that naturally exists in dressed whole poultry.

7.17.1.2 Chopped meat

Chopped meat shall be cured and prepared as a solid pack of chopped meat which may contain a maximum of 5 % starchy (farinaceous) material, calculated as starch. Soya and other non-meat proteinaceous material shall not be added to the product.

7.17.2 Edible offal (see 12.1.2.5 and 12.1.2.6)

Where edible offal is used in the manufacture of the product, its nature and species origin shall be declared in the title of the product.

7.17.3 Natural binder (see 5.23, 12.1.2.5 and 12.1.2.6)

In potted meat and in pastes other than liver paste, added natural binder shall constitute not more than 5 % by mass. Natural binder shall not be added to liver paste or to chopped meat.

7.17.4 Composition requirements

7.17.4.1 Meat pastes

Where the product is described in the title as containing tomato, the actual total meat content determined in accordance with 11.3 and 11.4, shall be at least 65 % and the fat content shall not exceed 40 % of the actual total meat content. In other cases the actual total meat content determined in accordance with 11.3 and 11.4, shall be at least 70 % and, except in liver paste, not more than 40 % of the actual total meat content shall be fat. Liver paste shall contain at least 25 % of liver and not more than 45 % of the actual total meat and edible offal content, determined in accordance with 11.4, shall be fat.

Subject to the regulations under the current Foodstuffs, Cosmetics and Disinfectants Act, and the conditions governing the use of soya and other foreign protein (see 6.12), the product may contain these and milk powder and eggs. The starchy (farinaceous) material determined in accordance with 11.5 and calculated as crude starch, shall be not more than 6 % by mass. Approved colourants may be used.

7.17.4.2 Potted meat

When determined in accordance with 11.3 and 11.4, the actual total meat content of the product shall be at least 90 % and when determined in accordance with 11.4, the fat content shall not exceed 37 % of the actual total meat content. The starchy (farinaceous) material, determined in accordance with 11.5 and calculated as crude starch, shall not exceed 5 %.

7.17.4.3 Chopped meat

In case of chopped ham, the word "chopped" must be in letters of the same prominence and colour (and printed next to and on the same line) as the word "ham".

When determined in accordance with 11.3 and 11.4, the actual total meat content of the product shall be at least 90 % and, except in the case of a pork product, when the fat content is determined in accordance with 11.4, it shall not exceed 37 % of the actual total meat content. In a pork product the fat content shall not exceed 42 % of the actual total meat content when determined in accordance with 11.4. Colourants shall not be used.

7.17.5 Curing salts

The product may contain curing salts (see 6.7).

7.17.6 Phosphates

The product may contain added phosphates (see 6.8).

7.17.7 Texture and appearance

7.17.7.1 Pastes and potted meats

The texture of pastes and potted meat shall be such that they can be readily spread, and they shall be practically free from pieces of sinew, gristle, bone, sandiness and grittiness. The contents of any one container shall be acceptably uniform throughout and acceptably free from internal and surface cavities. The product shall be acceptably free from separated fat, starch or aqueous material. Discolouration, other than light surface discolouration due to oxidation, shall not be present.

7.17.7.2 Chopped meat

Chopped meat shall have a coarse to medium-coarse, firm, compact and chopped texture. The muscular structure shall be visible in the chopped pieces of meat. The product shall not have a predominantly emulsified texture. Fat present shall be evenly distributed throughout the product. The product shall be free from visible exuded material. Chopped meat shall have a characteristic meaty flavour and shall be free from surface and internal cavities. It shall be free from pieces of bone, cartilage and gristle and shall be free from discolouration. The contents shall not adhere to the insides of the container. A chopped ham product shall not be presented or packed in such a way as to mislead the consumer into believing that it is a ham or pork shoulder product as specified in 7.8.

7.17.8 Percentage fill of container

When determined in accordance with 10.4.3, the percentage fill of the container with product shall be at least:

a) 90 % in the case of cans; and

b) 85 % in the case of glass jars.

7.18 Brawn

7.18.1 Preparation

Brawn shall be prepared from meat that has been cured or cooked or both and shall be suitably dispersed in a gelling medium of gelatinous material derived from bovine, sheep or pig carcasses. It may be spiced.

7.18.2 Offal

Edible offal, other than trotters, shall not be used.

7.18.3 Meat content

When determined in accordance with 11.3 and 11.4, the actual total meat content shall be at least 65 %.

7.18.4 Curing salts

The product may contain curing salts (see 6.7).

7.18.5 Phosphates

Phosphates shall not be added to the product.

7.18.6 Cereal

The product shall not contain cereal or cereal products.

7.18.7 Colourants

The product may contain colourants (see 5.21).

7.18.8 Agar-agar

The product shall not contain agar-agar.

7.18.9 Appearance

The product shall be attractive in appearance, and the meat particles shall be evenly dispersed throughout the product.

7.18.10 Set

The product shall have a firm set at 4,5 °C, and shall be sliceable.

7.19 Infant foods prepared with meat

7.19.1 Preparation

Food intended for use in the diet of infants and that includes meat shall be prepared from meat, with or without a vegetable or a mixture of vegetables and other acceptable ingredients.

7.19.2 Offal

The product may contain brain, heart, pancreas, thymus, kidney and tripe provided that the type and species origin of edible offal is declared in the title of the product.

7.19.3 Natural binder

Natural binder shall not be added to the product.

7.19.4 Nitrate and nitrite

Nitrate and nitrite shall not be added to the product other than when bacon or ham is a constituent of the product, in which case it may be present to an extent not exceeding a mass fraction of 0,002 %.

7.19.5 Freedom from harmful ingredients

Ingredients of the product shall be known to be non-injurious to infants (see 5.1).

7.19.6 Stabilizers

The product may contain natural edible vegetable gums and agar-agar in a total concentration not exceeding 1 %. Artificial thickeners, phosphatic additives, chemical emulsifiers and thickeners, and anti-oxidants other than ascorbic acid shall not be used.

7.19.7 Composition

When determined in accordance with 11.3 and 11.4, the actual total meat content shall be at least 10 % by mass of which the fat content shall not exceed 25 % of the actual total content, except that, in the case of products that contain bacon, the fat content shall not exceed 30 % of the actual total meat content.

7.19.8 Salt content

The total chloride content, determined in accordance with 11.6 and expressed as sodium chloride, shall not exceed 1,0 % by mass.

7.19.9 Fibre content

The fibre content, determined in accordance with 11.8, shall not exceed 1,5 % by mass.

7.20 Minced meat and minced meat in gravy

7.20.1 Preparation

Minced meat and minced meat in gravy shall be prepared by canning minced meat in its own juice or in a prepared gravy. Spices and other seasoning may be present.

The meat used shall be obtained from the skeletal musculature of food animals. The product shall not contain edible offal or added natural binder.

7.20.2 Composition

When determined in accordance with 11.3, the actual lean meat content (see 2.2) of minced meat canned in its own juice, shall be at least 70 %. The actual lean meat content of canned minced meat in gravy and canned minced meat in gravy containing invisible onions and peppers shall be at least 60 %. When determined in accordance with 11.5, the starchy (farinaceous) material, calculated as crude starch, shall not exceed 5 % by mass.

7.20.3 Appearance

The product shall have a characteristic processed minced meat appearance. The texture shall be uniformly minced without containing excessively large coarse pieces but shall also not be finely ground or be emulsified or be smooth or pasty. The fibre of the meat shall be visible and be free from excessive pieces of sinew and connective tissue. Coagulated exuded fat shall not be present at ambient temperature. Excessive exuded material shall not be present.

7.21 Minced meat with vegetables (or fruit) or cereal or a combination of these in gravy

7.21.1 Preparation

Minced meat with vegetables (and/or fruit) or cereal or both in gravy shall be prepared by canning minced meat together with one or more vegetables or fruit or a cereal or both in gravy. The meat used shall be obtained from skeletal musculature of food animals. The product shall not contain edible offal or added natural binder.

7.21.2 Composition

In the case of minced meat with onions or peppers that contains a visible quantity of onions or peppers, the actual lean meat content, determined in accordance with 11.3, shall be at least 55 %.

In the case of minced meat with vegetables (or fruit) or cereal or both, the actual lean meat content (see 2.2), determined in accordance with 11.3, shall be at least 40 %. The drained mass, determined in accordance with 10.5, of the cereal or the vegetables (or fruit) or both, shall be at least 35 % of the d.n.m.

7.21.3 Appearance

The appearance of minced meat shall be as given in 7.20.3. The vegetables (or fruit) or cereals or both shall be as given in 7.2.2.

7.22 Unspecified meat products

7.22.1 General

Any meat product for which requirements are not specifically prescribed in 7.2 to 7.22 inclusive but which falls within the scope of this specification, shall comply with the relevant requirements given in sections 4, 5, 6, 8, 9 and 12 of this specification.

7.22.2 Drained mass

In the case of packs other than solid packs, the drained mass shall be at least 70 % of the d.n.m, except that in the case of products packed in sauce or gravy the washed or drained mass, when determined in accordance with 10.5, shall be at least 50 % of the d.n.m.

7.22.3 Curing salts

Packs other than those that contain cured meat shall not contain curing salts.

7.22.4 Freedom from defects

The product shall be free from sand, grit, pieces of shell, dirt and other extraneous contaminants.

7.23 Snails

7.23.1 Packing

The product may be packed in clear brine, water, or sauce. It may be spiced. The product shall be neatly packed. The container shall be filled to practical capacity, over-filling being avoided.

7.23.2 Drained mass

The drained mass, determined in accordance with 10.5, shall be at least 60 % of the d.n.m.

7.23.3 Appearance, texture and colour

The product shall be attractive in appearance and characteristic in colour. The units shall not have a greyish or brownish off-colour. The units in any one container shall be reasonably uniform in colour and size. The units shall not have a ragged appearance. The product shall have a characteristic firm but soft texture, and shall not be soggy or mushy or excessively tough or dry.

7.23.4 Flavour and odour

The flavour and odour of the product shall be fresh and characteristic. Off-flavours and off-odours shall not be present.

7.23.5 Freedom from defects

The product shall be free from sand, grit, and pieces of shell, dirt and other extraneous contaminants. Snail eggs shall be absent. When snails are packed in brine or in water, the packing medium shall not be turbid or cloudy and shall be free of sediment.

8 Containers

8.1 Types of container

Containers including lids or caps shall meet the following requirements:

a) be capable of maintaining the preservation of their contents in a sound, wholesome condition;

b) be made of a suitable material and constructed so that they can be easily closed and sealed;

c) be sufficiently durable to withstand mechanical and thermal stresses during the canning processes and to resist physical damage and maintain their normal appearance during normal distribution and storage;

d) protect the contents from contamination by micro-organisms or any other substance;

e) be suitable for the type of product and the conditions of storage and transportation;

f) their inner surfaces shall be adequately coated with a suitable material and shall not react with the contents in any way that would adversely affect the product or the containers;

g) the internal surface coating such as lacquer shall be uniformly applied and shall not become loose or peel off the surface of the can or lid during processing and normal storage conditions;

h) the outer surfaces shall be resistant to corrosion under normal storage and retail conditions;

i) the compound sealing material on lids or caps shall be suitable for the purpose and for the type of product used;

j) lids shall be tamper-proof, and a tamper detector shall be provided in cases where lids or caps can be removed by hand, such as with screw-on caps on jars; and

k) the containers shall be such that the contents can be easily emptied out.

8.2 Condition of containers

Containers or lids with signs of poor or doubtful container integrity shall not be used. The inner surfaces of all containers and closures shall, at the time of use, be clean and in the case of cans, free from corrosion, pinholes, evidence of detinning, delacquering, damages, serious solder splashing or excess application of solder. When lacquered cans or lids or both are used, the lacquer shall be free from drops or splashes of lacquer, significant scratches and other imperfections and it shall have no detrimental effect on the product such as off-flavours, off-odours and discolouration. The seam/s and seals, where applicable, shall be normal in appearance with a strong leakproof structure and quality. The sealing compound on closures shall be evenly applied around the entire contour with a normal appearance and adhesion.

Can bodies and lids with scoring lines for easy opening purposes of the final product by the consumer, shall be subjected to appropriate examinations for integrity. There shall be no signs of corrosion in the scoring lines.

8.3 Transport and storage of empty containers

Containers and lids or closures shall be delivered from the manufacturer wrapped or in covers and shall be transported and stored under protection against risk of contamination, damaging and the weather. The storage area shall be kept clean and shall be insect, bird and rodent proof. Containers and lids or closures shall be stored in a dry store, protected against wind, rain or vapour from the sea and away from steam, humidity, condensation or sudden temperature variations. The storage area shall be used solely for the storage of empty containers and lids.

The stacking of pallets with empty cans shall be such that the cans shall not be damaged. Empty cans or pallets with empty cans shall not be stepped on.

8.4 Cleaning of empty containers

Containers shall be cleaned immediately before use. Containers shall be in an inverted position when the cleaning is by means of blowing out with compressed air. After having been cleaned, the containers shall be protected against risk of contamination.

8.5 Distribution and handling of containers

Containers shall not be exposed to contamination or damaging to their bodies, seams or flanges while distributed, on runways or feeding lines. Containers shall be removed from the runways or feeding lines at the end of production unless the containers are adequately covered and protected against risks of contamination and damage.

8.6 Integrity of containers

In the end product, the containers and closures shall be free of integrity defects that could compromise the hermetic condition of the containers and closures or affect the product quality and appearance adversely.

9 Packing and processing requirements

9.1 Filling under hygienic conditions

The product shall be filled and processed under strictly hygienic conditions into containers that have been acceptably cleaned.

9.2 Processing

9.2.1 Where thermal processing of the product is required, it shall be carried out without delay after the sealing of the lids on the container.

9.2.2 Filled containers of product other than pasteurized products and semi-preserved products (see 6.11), shall be exhausted where appropriate, hermetically sealed or processed in such a way as to reduce the number or activity or both of viable micro-organisms to such an extent that none are detectable in the treated food by the methods given in clause 11. Containers of pasteurized products shall be exhausted, hermetically sealed, and pasteurized.

9.2.3 The filling, exhausting, sealing, and heat-processing of containers shall be performed in such a way that the ends of the cans or the caps of the jars

a) are not convex, or

b) do not become convex under normal transport and storage conditions.

There shall be no undue delay between filling, sealing of lids and the start of heat processing that could affect the product adversely. The thermal process shall be continuous (see 9.2.7).

9.2.4 When tested in accordance with 10.2, all container closures shall be strongly made. Cans of diameter 99 mm or less, shall not leak on vacuum leak testing under a maximum negative gauge pressure of 65 kPa, and cans of diameter greater than 99 mm shall not leak under a maximum negative gauge pressure of 50 kPa (see 10.2). Written records of seam examination shall be kept and shall be available for scrutiny for 2 years after the date of production.

9.2.5 The heat distribution in each retort used shall be determined and the heat penetration of each product in each can size at the coldest spot in the retort under the most unfavourable conditions likely to occur during processing, shall be determined to establish the time-and-temperature process necessary to obtain biological stability of the product. These tests shall be carried out by a competent body or person.

9.2.6 The time-temperature process in the case of heat-preserved products shall be conducted by adequately trained operators.

9.2.7 The time-temperature process (see 9.2.3) shall ensure

a) the destruction of pathogenic organisms, and

b) freedom from microbiological spoilage (see section 11).

9.2.8 Immediately after heat-processing, the filled containers shall be cooled as rapidly as possible to a container centre temperature not exceeding 50 °C.

9.3 Handling of sealed containers after heat processing

9.3.1 Any container whose process status before and after the retort process is unknown shall be immediately destroyed.

9.3.2 After having been removed from the retort in their baskets or trolleys the containers shall not be subjected to after-sterilization contamination. Hot or wet containers or containers having a positive internal pressure after the retort process shall not be removed out of their trolleys or baskets or be handled individually or be touched by hand. Containers shall not be handled or bulk-stacked before being thoroughly dried and cooled to an internal temperature not in excess of 50 °C.

9.3.3 A clean separated area for the sole purpose of cooling containers after retorting shall be provided. Such an area shall be:

a) enclosed with unauthorized entrance being restricted;

b) physically separated from areas in which steam is emitted; and

c) situated away from other normal factory traffic, other than the handling of trolleys or baskets with containers after retorting, there shall be no crossflow of other factory traffic along the route of the baskets or trolleys between the retorts and the cooling area.

9.3.4 After the containers have been cooled and dried, and only on instruction from a designated person, the baskets or trolleys may be moved out of the cooling area to a pick-up area. The process of removing the containers out of the trolleys or baskets and the stacking shall be done in such a way as to avoid rough handling or damaging of the containers or causing unnecessary stress to their seams or seals.

9.3.5 Containers, and in particular their seams, shall not be exposed to contamination. The equipment and conveyors used for the pick-up and stacking of containers shall be regularly sanitized. Hard metal surfaces against which the containers come into contact during the pick-up process in particular sharp points, projections or corners, shall where possible, be avoided or otherwise be covered with shock absorbing material to prevent damaging of the containers. Such pick-up equipment and conveyor lines shall be subjected to a regular routine inspection.

9.3.6 In the case of continuous cookers or retorts, the container runways on which the containers are transported from the cookers or retorts shall be maintained in a hygienic state and cans shall not roll on their double seams on the container runways.

9.4 Exterior of the end product container

The containers shall be clean with a normal appearance and metal cans shall be free from corrosion and shall not be deformed or have an abnormal appearance or be damaged. Containers shall be free from any defective seams, seals or closures, or signs of leaking or other defects.

Containers shall be free from abnormal stains.

9.5 Storage of the end product (see 4.2.22)

9.5.1 General

The end product storage areas shall be used solely for the intended purpose. The end product shall be stacked away from the floors and walls.

All containers of the same production code or batch code shall be stored together and not be mixed with containers of other production day's codes. Each stack or pallet with containers shall be identified with the code appearing on the containers and with their inspection status. Any production lots in which defects or a deviation were detected, shall be identified as such and shall be stored separately from other production lots. Any non-conforming production lots shall be identified as such and stored in an area physically separated from the rest of the end product stock.

9.5.2 Products not requiring refrigeration

Canned products not requiring refrigeration shall, both before and after labelling and packaging for commercial distribution, be stored in an orderly manner, in dry conditions, protected against steam, condensate, moisture, dust and the weather. Canned products shall not be stored under conditions that are conducive to corrosion of the containers or be exposed to temperature extremes.

The final product shall be stacked in such a way that container damage shall not occur due to pressure from the excessive mass of pallets with containers stacked above. Workers shall not be allowed to step on containers or on pallets with containers. Precautions shall be exercised to avoid container damaging in particular, with fork-lift truck handling.

9.5.3 Products requiring refrigeration

Where products are required to be stored under refrigeration, the storage temperature shall not exceed 4 °C (see 12.2.1(e). Refrigeration rooms shall be clean and shall be hygienically maintained. The product shall be protected against risks of corrosion.

10 Methods of physical examination

10.1 External and internal examination of containers

10.1.1 Code: Determine whether the code digits are legible and indelible and if embossed, examine for any abnormalities such as damaging the tinplate or lacquer.

10.1.2 Examine the seams, seals or closures and outer and inner surfaces of containers for any abnormalities or integrity defects.

10.2 External and internal examination of seams

10.2.1 Integrity of the hermetic sealing

Conduct external and internal examinations of container seams, seals or closures in accordance with the method provided by the container manufacturer to determine whether the container seam, seal or closure is in compliance with the prescribed specifications, parameters and attributes by the container manufacturer to ensure the integrity of the hermetic sealing.

10.2.2 Leak test by applying vacuum inside the can

10.2.2.1 Preparation of cans

a) Empty unused cans:

Immerse empty unused cans for 5 min in boiling water. Remove the cans from the boiling water and cool to 30 °C or below before testing.

b) End product:

In the case of 3-piece cans, open the end product by cutting out one of the lids of the can without damaging the circumference of the seam. In the case of 2-piece cans, remove the bottom of the can (opposite the seam) without damaging the expansion ring on the bottom end. After removal of the contents, immerse the can for 60 min in boiling water. Remove the cans from the boiling water and dry for 6 h at approximately 55 °C before testing.

10.2.2.2 Testing

Add sufficient water to submerge the entire seam. Place a rubber seal on the open end to cover the entire top of the circumference of the seam or expansion ring. Place a perspex plate hermetically connected to a vacuum tube on top of the rubber seal. Observe the entire seal covered with water at the opposite end of the can during the removal of air from the can. Appearance of a succession of air bubbles from the seam into the water indicates leakage through the seam at that particular point.

10.3 Determination of net mass of the contents of the container

10.3.1 Weigh unopened container.

10.3.2 Open container and remove the contents.

10.3.3 Wash, dry and weigh the container complete with lid.

10.3.4 Subtract the mass of the empty container from the mass of the unopened container. The resultant figure is the net mass.

10.4 Determination of the vacuum inside a container, the net headspace and the fill of the container

10.4.1 Vacuum

Tap the unopened container slightly on the surface of the inspection table to move the contents away from the inside surface of the lid. Impress the point of a vacuum gauge through the lid to measure the vacuum inside the container.

10.4.2 Net headspace

10.4.2.1 In case of:

a) a container with a lid attached by a double seam, partially cut out lid without removing or altering the height of the double seam; or in case of

b) another type of container, remove the lid.

10.4.2.2 Determine the average vertical distance, in mm, from the inside surface of the lid of the container to the upper level of the contents by taking measurements over the surface of the contents. The result is the net headspace.

10.4.3 Fill of container

10.4.3.1 In case of containers with lids attached by double seams, fill the container with water at room temperature to a vertical distance of 5 mm below the top level of the container. Weigh the container thus filled and determine the mass of the water by subtracting the mass of the container.

10.4.3.2 Draw off water from the filled container to the level of the contents as determined in 10.4.2, weigh the container with the remaining water and determine the mass of the remaining water by subtracting the mass of the container.

10.4.3.3 Divide the mass of the remaining water (see 10.4.3.2) by the mass of the water (see 10.4.3.1) and multiply by 100. The result is the percentage of the total volume capacity of the container occupied by the content expressed as the fill of the container.

10.4.3.4 In case of a container with a lid attached otherwise than by a double seam, remove the lid and proceed in accordance with 10.4.3.1 to 10.4.3.3, but fill the container to the top or to the level of the inside surface of the lid instead of to 5 mm below the top (see 10.4.3.1).

10.5 Determination of drained mass

10.5.1 Preparation of the product

10.5.1.1 Packs other than pudding packs

10.5.1.1.1 Maintain the container at room temperature approximately between 20 °C and 30 °C for a minimum of 12 h prior to examination.

10.5.1.1.2 Open and tilt the container to distribute the entire contents from the container on a pre-weighed sieve having a wire mesh with square openings of 2,8 mm × 2,8 mm.

10.5.1.1.3 Incline the sieve at an angle of approximately 17° to 20° and allow the contents to drain for 2 min, measured from the time the product is poured onto the sieve.

10.5.1.1.4 Immediately weigh the sieve containing the contents.

10.5.1.1.5 In case of a product with a sauce adhering to the contents or onto the sieve, wash the sauce off with a gentle spray of warm tap water (approximately 40 °C) using a wash bottle (e.g. plastic). Incline the sieve at an angle of approximately 17° to 20° and allow the contents to drain for 2 min, measured from the time the washing has finished.

10.5.1.1.6 Immediately remove adhering water from the bottom of the sieve by use of a paper towel and weigh the sieve containing the washed contents.

10.5.1.1.7 In case of products packed in a jelled medium that does not liquefy at a room temperature between 20 °C and 30 °C within 12 h, remove the jelled medium by hand and weigh the solid contents.

10.5.1.1.8 The drained or washed mass is obtained by subtracting the mass of the sieve from the mass of the sieve with the drained/or washed product.

10.5.1.1.9 In case of products containing optional ingredients such as vegetables, fruits, cereals or garnish, determine the total drained or washed mass as described above, then separate the optional ingredients and re-weigh. The mass of the material remaining on the sieve is the drained or washed mass of the meat content.

10.5.1.1.10 In the case of mutton-on-bone and similar packs, separate and weigh the bone after the total drained or washed mass has been determined.

10.5.1.1.11 If any edible offal or minor meat ingredient is mentioned in the name of the pack, separate and weigh it after the total drained or washed mass has been determined.

10.5.1.1.12 If a minimum content is specified for a vegetable or a cereal, or a combination of these, separate these ingredients and weigh the meat and/or edible offal ingredient after the total drained or washed mass has been determined.

10.5.1.2 Pudding packs

Proceed as in 10.5.1 after removal of the pastry from the product.

10.5.2 Expression of results

The percentage drained or washed mass (% D_m) is expressed as:

$$\% D_m = \frac{D_m}{d.n.m.} \times 100$$

where

D_m is the drained or washed mass;

d.n.m. is the declared net mass.

The percentage total drained or washed mass (% D_{tm}) (see 10.5.1.1.9) is expressed as:

$$\% D_{tm} = \frac{D_{tm}}{d.n.m.} \times 100$$

where

D_{tm} is the total drained or washed mass;

d.n.m. is the declared net mass.

The percentage drained or washed mass of the meat content (% D_{mmc}) is expressed as:

$$\% D_{mmc} = \frac{D_{mmc}}{d.n.m.} \times 100$$

where

D_{mmc} is the drained or washed mass of the meat content;

d.n.m. is the declared net mass.

Record the results as percentages of the *d.n.m.*

10.6 Meat-to-fat ratio

10.6.1 Remove the contents from the container.

10.6.2 Remove any packing material(s), fat or exuded material.

10.6.3 At ambient temperature, physically separate the fat from the meat. Determine the masses of the separated fat and the meat. Calculate the meat-to-fat ratio by dividing the mass of the meat by the mass of the separated fat.

10.7 Exuded fats and exuded material

10.7.1 Remove the contents from the container.

10.7.2 At ambient temperature, physically remove the exuded fat and determine the mass of the exuded fat. Calculate the percentage of exuded fat by dividing the mass of the exuded fat by the d.n.m of product and multiplying by 100.

10.7.3 At ambient temperature, physically remove any other exuded material and determine the mass of the exuded material. Calculate the percentage of exuded material by dividing the mass of the exuded fat by the d.n.m. of product and multiplying by 100.

11 Methods of chemical analysis

11.1 General

During the analysis, use only reagents of recognized analytical grade and use only distilled water or water of equivalent purity.

11.2 Preparation of sample for chemical analysis

11.2.1 Corned beef, corned meat, meat rolls, chopped meat and similar solid packs, minced meat products, meat pastes and potted meats

11.2.1.1 Where a product such as ham or cured shoulder of pork is packed in a jelled packing medium, separate and remove the packing medium, scraping it off where it adheres.

11.2.1.2 In the case of ham or cured shoulder without the packing medium and other applicable products, pass the **entire** contents of the container twice through a meat grinder.

11.2.1.3 Mix the ground sample thoroughly, using a pestle and mortar. Store the prepared sample in a well-closed container, in a refrigerator until it is required for use.

11.2.2 Sausages, meat balls and similar products

After draining the product or, in the case of sausages packed in fat or agar-agar or other jellied packing medium, after scraping off the adhering packing medium, pass the product twice through a meat grinder and then proceed as in 11.2.1.3.

11.2.3 Packing medium

Where the packing medium is required for analysis, strain it through a sieve of nominal aperture size 2 mm, or scrape it off where jellied packing medium adheres to the interior sides of the container or to the units, mix thoroughly, and transfer it to a container and store it as in 11.2.1.3.

11.2.4 Fats for melting point determination

Melt 10 g to 20 g of the fat in a small beaker and allow it to cool, stirring occasionally, until a faint turbidity appears. Stir the sample until it is homogeneous and set it aside for 24 h at 10 °C before determining the melting point.

11.3 Determination of protein nitrogen, protein and actual lean meat contents

Use SANS 6317, *Methods of chemical analysis of meat and fish products*, to determine the protein nitrogen content and then calculate the protein content by multiplying the nitrogen content by 6,25 and calculate the actual lean meat by multiplying the nitrogen content by 30.

11.4 Determination of fat content

Use SANS 6317, *Methods of chemical analysis of meat and fish products*, to determine the fat content.

11.5 Determination of crude starch content

Use SANS 6317 *Methods of chemical analysis of meat and fish products*, to determine the starch content.

11.6 Determination of chloride content (as sodium chloride)

11.6.1 Reagents

11.6.1.1 Nitrobenzene.

11.6.1.2 Nitric acid, diluted 1:2.

11.6.1.3 Sodium carbonate solution, a saturated solution.

11.6.1.4 Specification potassium thiocyanate solution, c(KCNS) = 0,1 mol/L.

11.6.1.5 Specification silver nitrate solution, $c(AgNO_3)$ = 0,1 mol/L, accurately specificationized.

11.6.1.6 Ferric alum indicator

A cold saturated solution of ferric ammonium sulfate ($NH_4Fe(SO_4)_2.12H_2O$) to which a few drops of the diluted nitric acid (11.6.1.2) have been added.

11.6.2 Procedure

11.6.2.1 Weigh accurately a suitable quantity of the prepared sample into an evaporating basin or crucible, moisten with the sodium carbonate solution, and dry on a water bath.

11.6.2.2 Char the dried sample and ash it at a temperature not exceeding 500 °C.

11.6.2.3 Extract the residue with the dilute nitric acid and filter into a 100 mL volumetric flask. Repeat the extraction and filtration once, wash the filter thoroughly with the dilute nitric acid, dilute the solution in the flask to the mark with the dilute nitric acid, and mix.

11.6.2.4 To a suitable aliquot in a 250 mL Erlenmeyer flask add 25 mL of the specification silver nitrate solution, 5 mL of the nitrobenzene, 1 mL of the ferric alum indicator, and shake well.

11.6.2.5 Titrate with the specification potassium thiocyanate solution.

11.6.2.6 Carry out a blank determination omitting the sample.

11.6.2.7 The difference between the blank titre and the test titre is the volume of silver nitrate used in the determination.

11.6.2.8 Calculate the chloride content (as sodium chloride), expressed as a percentage (% NaCl) of the product, using the formula:

$$\% \text{ NaCl} = \frac{V \times 5{,}845 \times c}{m}$$

where

V is the volume, in millilitres, of specification silver nitrate solution used in the determination;

c is the concentration of specification silver nitrate solution, in moles per litre;

m is the mass, in grams, of original sample represented by the aliquot used in the titration.

11.7 Determination of moisture content

Use SANS 6317, *Methods of chemical analysis of meat and fish products,* to determine the moisture content.

11.8 Determination of fibre content

11.8.1 Reagents

11.8.1.1 Sulfuric acid solution (0,255 ± 0,005) N. 1,25 g H_2SO_4/100mL. Concentration must be checked by titration.

11.8.1.2 Sodium hydroxide solution (0,313 ± 0,005) N. 1,25 g NaOH/100 mL, free or nearly so from Na_2CO_3. Concentration must be checked by titration.

11.8.1.3 Prepared ceramic or asbestos fibre

Place 60 g ceramic or asbestos fibre in a blender, add 800 mL H_2O, and blend for 1 min at low speed.

11.8.1.4 Alcohol 95 % or reagent alcohol, methanol or isopropanol.

11.8.1.5 Antifoam

Polydimethylsiloxane compound diluted 1 + 4 with mineral spirits or petroleum ether, or polydimethylsiloxane emulsion diluted 1 + 4 with H_2O.

11.8.1.6 Bumping chips or granules

Aluminium 90 grit granules.

11.8.2 Apparatus

11.8.2.1 Digestion apparatus with a condenser to fit a 600 mL beaker, and a hotplate adjustable to a temperature that will bring 200 mL H_2O at 25 °C to a rolling boil in (15 ± 2) min.

11.8.2.2 Sinter quartz crucibles

11.8.2.3 Desiccator with efficient desiccant such as 4-8 mesh silica gel. $CaCl_2$ is not satisfactory.

11.8.3 Procedure

11.8.3.1 Extract 2 g of ground sample with ether or petroleum ether (If fat is < 1%, extraction may be omitted).

11.8.3.2 Prepare a blank by treating ± 2 g (dry mass) ceramic or asbestos fibre with acid and alkali as in the procedure below.

11.8.3.3 Transfer the sample to the 600 mL beaker, avoiding fibre contamination from paper or brush. Add ± 1,5 g to 2,0 g dry mass of prepared ceramic or asbestos fibre (see 11.8.1.3), 200 mL boiling 1,25 % H_2SO_4 and 1 drop diluted antifoam (see 11.8.1.5). Bumping granules (see 11.8.1.6) may also be added.

11.8.3.4 Place the beaker on the digestion apparatus with the pre-adjusted hotplate (see 11.8.1.1) and boil for exactly 30 min, rotating the beaker periodically to keep solids from adhering to the sides.

11.8.3.5 Remove the beaker and filter through a sinter quartz crucible.

11.8.3.6 Return the material and residue on the crucible to the beaker by washing with 200 mL boiling 1.25 % NaOH, and boil for exactly 30 min.

11.8.3.7 Remove the beaker and filter as in 11.8.3.5.

11.8.3.8 Wash the filter 3 times with boiling water. Drain free of excess water and wash with 25 mL alcohol.

11.8.3.9 Dry the crucible for 2 h at 130 °C ± 2 °C. Cool in a desiccator and weigh.

11.8.3.10 Ignite for 30 min at 600 °C ± 15 °C. Cool in a desiccator and reweigh.

11.8.4 Calculation

The percentage crude fibre in the ground sample is C

$$\text{where } C = \frac{(\textit{Loss in mass on ignition} - \textit{loss in mass of ceramic fibre blank}) \times 100}{\textit{mass of sample}}$$

11.9 Determination of iodine value (according to Wijs)

11.9.1 Reagents

11.9.1.1 Carbon tetrachloride, re-distilled.

11.9.1.2 Glacial acetic acid

11.9.1.3 Iodine trichloride solution, one ampoule.

11.9.1.4 Iodine

11.9.1.5 Iodine monochloride solution

Dissolve 8 g of iodine trichloride (ampoule) in ± 200 mL of glacial acetic acid. Dissolve 9 g of iodine in 300 mL of carbon tetrachloride. Mix the two solutions and dilute with glacial acetic acid to 1L.

NOTE Iodine monochloride solution should be kept in a stoppered bottle, protected from light and stored at a temperature not exceeding 15 °C

11.9.1.6 Specification sodium thiosulfate solution, $c(NaS_2O_3)$ = 0,1 mol/L, accurately specificationized.

11.9.1.7 Starch indicator solution

Mix approximately 0,5 g of soluble starch to a paste with a little cold water and run it, with constant stirring, into 25 mL of boiling water. Boil for 2 min and allow to cool. Use 0,5 mL of this solution for each determination.

11.9.2 Procedure

11.9.2.1 Accurately weigh out 0,1 g of the fat (lard or dripping) into a clean glass-stoppered iodine flask of capacity 250 mL.

11.9.2.2 Dissolve the fat in 10 mL of the carbon tetrachloride and add exactly 25 mL of the iodine monochloride solution.

11.9.2.3 Allow to react in the dark for exactly 60 min, add 100 mL of water and 20 mL of the potassium iodide solution.

11.9.2.4 Titrate the excess iodine with the specification thiosulfate solution using the starch solution as indicator.

11.9.2.5 Carry out a blank determination omitting the fat.

11.9.3 Calculation

Calculate the iodine value (Wijs) using the formula:

$$\text{Iodine value} = \frac{(V_1 - V_2) \times 12{,}69 \times c}{m}$$

where

V_1 is the volume, in millilitres, of specification sodium thiosulfate solution required for the blank;

V_2 is the volume, in millilitres, of specification sodium thiosulfate solution required for the fat;

c is the concentration of the specification sodium thiosulfate solution, in moles per litre;

m is the mass, in grams, of fat taken for the determination.

11.10 Determination of free fatty acids as oleic acid

11.10.1 Reagents

11.10.1.1 Diethyl ether.

11.10.1.2 Ethanol, 96 %.

11.10.1.3 Specification potassium hydroxide solution, c(KOH) = 0,1 mol/L, accurately specificationized.

11.10.1.4 Phenolphthalein indicator solution

A solution of 10 g/L in ethanol.

11.10.2 Procedure

11.10.2.1 Dissolve approximately 10 g of the fat, accurately weighed, in a mixture of equal volumes of the ether and the ethanol that has been neutralized with the specification potassium hydroxide solution to a faint pink shade using the phenolphthalein solution as indicator.

11.10.2.2 Titrate with the specification potassium hydroxide solution to a faint pink shade that persists for 15 s.

11.10.2.3 Calculate the free fatty acids (as oleic acid), expressed as a percentage by mass of the product, using the formula:

$$\%\ \text{free fatty acids} = \frac{V \times c \times 28{,}25}{m}$$

where

V is the volume, in millilitres, of specification potassium hydroxide used;

c is the concentration of the specification potassium hydroxide solution, in moles per litre;

m is the mass, in grams, of sample taken.

11.11 Determination of saponification value

11.11.1 Reagents

11.11.1.1 Alcoholic potassium hydroxide solution

Dissolve 1,5 g of silver nitrate in 3 mL of water and add the solution to 1 L of ethanol (96 %).

11.11.1.2 Specification hydrochloric acid solution, c(HCl) = 0,5 mol/L, accurately standardized.

11.11.1.3 Phenolphthalein indicator solution

Prepare as in 11.10.1.4.

11.11.2 Procedure

11.11.2.1 Accurately weigh approximately 2 g of fat into a 250 mL flask, add exactly 25 mL of the alcoholic potassium hydroxide, and heat under reflux for 1 h.

11.11.2.2 Cool, add 0,5 mL of the phenolphthalein indicator, and titrate with the 0,5 N hydrochloric acid.

11.11.2.3 Carry out a blank determination in the same way, omitting the fat.

11.11.2.4 Calculate the saponification value, expressed as milligrams KOH per gram of the product, using the formula:

$$\text{Saponification value} = \frac{(V_1 - V_2) \times 56{,}1 \times c}{m}$$

where

V_1 is the volume, in millilitres, of specification hydrochloric acid solution required for the blank;

V_2 is the volume, in millilitres, of specification hydrochloric acid solution required for the fat;

c is the concentration of the specification hydrochloric acid solution, in moles per litre;

m is the mass, in grams, of sample taken.

11.12 Determination of melting point

11.12.1 Apparatus

An acceptable Ubbelohde apparatus for flow and drop points.

11.12.2 Procedure

11.12.2.1 Fill the cup that fits on to the thermometer with the prepared fat sample (see 11.2.4), and so compress the sample that all air bubbles are excluded.

11.12.2.2 Attach the cup to the thermometer and use a cork to so fit the thermometer into a boiling tube that the cup is approximately 20 mm to 30 mm from the bottom of the tube.

11.12.2.3 Immerse the tube in a beaker of water equipped with a stirring device, and heat the water at a rate of 1 °C/min.

11.12.2.4 Regard the temperature at which the first drop of liquid falls from the cup as the melting point of the sample.

11.13 Determination of the refractive index

Determine the refractive index at the stated temperature in a Abbé type refractometer.

11.14 Determination of nitrite and nitrate contents

Use SANS 6317, *Methods of chemical analysis of meat and fish products*, to determine the nitrite and nitrate content.

11.15 Determination of phosphorus

Use SANS 6317, *Methods of chemical analysis of meat and fish products*, to determine phosphorus content.

11.16 Incubation and inspection of containers

11.16.1 Commercially sterilized cured products

11.16.1.1 Incubation at 37 °C

Incubate the containers at 37 °C for 14 d and then examine a representative sample(s), in accordance with 12.2 for evidence of spoilage.

11.16.1.2 Incubation at 55 °C

Incubate the containers at 55 °C for 10 d and then examine a representative sample(s), in accordance with 12.2, for evidence of spoilage.

11.16.2 All other products except rendered fats and semi-preserved products

11.16.2.1 Incubation at 37 °C

Incubate the containers at 37 °C for 14 d and then examine a representative sample(s), in accordance with 11.17, for evidence of spoilage.

11.16.2.2 Incubation at 55 °C

Incubate the containers at 55 °C for 10 d and then examine a representative sample(s), in accordance with 11.17, for evidence of spoilage.

11.16.3 Fats

Incubate the containers at 37 °C for 14 d and then examine a representative sample(s), in accordance with 11.17, for evidence of spoilage.

11.17 Examination for general spoilage organisms

Use SANS 6257 (SABS SM 1257), *Microbiological examination of canned meat and fish products*. Evaluate for compliance with 6.14.2.1.

11.18 Test for efficacy of cleaning and disinfecting of plant, equipment and utensils

Use SANS 5763 (SABS SM 763), *Efficacy of cleaning plant, equipment and utensils: swab technique*. Evaluate for compliance with 4.5.6.

11.19 Determination of the total count of viable organisms

Use SANS 4833/ISO 4833 (SABS ISO 4833), *Microbiology – General guidance for enumeration of micro-organisms: colony count technique at 30 °C*. Evaluate for compliance with 4.4.1.

11.20 Determination of the presence of E. coli

Use SANS 7251/ISO 7251 (SABS ISO 7251), *Microbiology – General guidance for the enumeration of presumptive Escherichia coli; Most probable number technique*. Evaluate for compliance with 5.19.

11.21 Microbiological examination of water

Use SANS 5221 (SABS SM 221), *Microbiological analysis of water – General test methods*. Evaluate for compliance with 4.4.1.

11.22 Determination of viable Salmonella organisms

Use SANS 6579/ISO 6579 (SABS ISO 6579), *Microbiology – General guidance on methods for the detection of Salmonella*. Evaluate for compliance with 5.20.

12 Labelling and marking of containers

12.1 Details required on each container, label or packing material

12.1.1 Details

Subject to 12.6 and in addition to the markings required in terms of the regulations promulgated under the Trade Metrology Act, as well as the Foodstuffs, Cosmetics and Disinfectants Act, the following information shall appear in legible and indelible marking on each container or on a label securely attached to each container:

a) The full name and physical address of the manufacturer, producer, proprietor, or controlling company or, in the case of containers packed for any other person or organization, the full name and physical address of that person or organization;

b) the name and true description, taking into cognizance the provisions of the Merchandise Marks Act 1941 (Act 17 of 1941) (as amended from time to time), of the contents (see also 12.1.2) including, where applicable, the nature of the medium in which the product is packed and the presence of bone that is, as such, a constituent of a product;

c) where applicable, a statement of ingredients, including the presence, as relevant, of non-meat proteinaceous material by name, and vegetable fat or oil, in descending order of quantities present on the ingoing basis and/or in the final product;

d) where applicable, the presence of artificial colourants in plain type of at least 1,5 mm face measurement;

e) where the product is required to be stored under refrigeration the words "Perishable - keep under refrigeration at a temperature not exceeding 4 °C", in a prominent position in plain type of at least half the size of that used for the name of the product with a minimum of 3 mm face measurement, except that the word "Perishable" shall be in bold type of at least 4,5 mm face measurement;

f) the declared net mass of the contents;

g) the product code, the date of canning, sub-code or the batch number (if used), and the factory identification embossed or otherwise indelibly marked on the container or, in the case of jars, on the cap or label; any mark or code used for the foregoing shall be disclosed for record purposes to the authority administering this specification;

h) information required in terms of the relevant clause dealing with the specific product; and

i) words indicating the country of origin where the product is produced.

12.1.2 True description of contents

12.1.2.1 Minimum meat content for meat product designation

A product presented or described as a meat product, or a product on which a statement or claim appears implying that the product is a meat product, or a product with wording in the product name or wording on the main panel implying that the product contains meat, shall contain at least 10 % by mass of actual total meat determined in accordance with the total result of 11.3 plus 11.4 or the drained mass of the meat content shall be at least 10 % of the d.n.m. determined in accordance with 10.5.

12.1.2.2 Designation of product

12.1.2.2.1 Unless the meat or edible offal or both (as appropriate) of a product consisting of meat or edible offal or both, and of vegetables, cereal, or other analogous ingredient, constitutes the largest single ingredient on the ingoing basis and, in the end product, constitutes at least 25 % of the d.n.m., the meat or edible offal or both (as appropriate) shall not appear first in the designation of the product.

12.1.2.2.2 In a product that consists of vegetables, cereal, and other similar ingredients with meat or edible offal or both (as such or in prepared form) and falls within the scope of this specification but does not comply with the particular requirements specified for meat or edible offal content, provided that the content of meat or edible offal or both is at least 15 % (10 % in the case of foods for infants), the presence of meat or edible offal shall be declared in the title of the product by means of descriptions such as "Y with X" or "Y containing X" where Y is the basic name of the product (e.g. baked beans in tomato sauce) and X is the meat or edible offal ingredient (e.g. meat balls, sausage).

12.1.2.2.3 Products which undergo a smoking process by exposure to generated smoke, shall be labelled "smoked X" on the main panel of the label or packing material. Any addition of a smoke-flavour that is not obtained by exposure to generated smoke, shall be declared on the main panel of the label. Smoke-flavoured products that have not undergone a process by exposure to generated smoke, shall be labelled as "smoke-flavoured" on the main panel of the label or packaging material. The qualifying word(s) e.g. "smoked" shall appear in immediate conjunction with the product name "X", in a letter size of at least half the size in which the name "X" is featured and of equal prominence and boldness.

12.1.2.3 Meat pastes

In a product, other than liver paste (see 7.17.4.1), in the name of which reference is made to one kind of meat only, at least 80 % of the total meat content shall consist of the named meat.

Where in the name of the product two kinds of meat are referred to, the named meats shall constitute at least 80 % of the total meat content. In addition, the kind of meat named first shall constitute at least 50 % of the total meat content, and that named second at least 20 %, except that if kidney or liver is named second, the minimum requirement shall be 10 % of the total meat and edible offal content.

If three kinds of meat are named in the description of the product, the named meats shall constitute at least 80 % of the total meat content. The meat named first shall constitute at least 40 % of the total meat content, and each of the other named meats at least 15 % (except that if kidney or liver is named second or third the minimum requirement for each shall be 10 % of the total meat and edible offal content). The three kinds of meat shall be named in descending order of contents.

For the purposes of true description of contents, cured pork may be regarded as ham.

12.1.2.4 Potted meat

In a product in the name of which reference is made to one kind of meat only, at least 85 % of the total meat content shall consist of the named meat.

In a product in the name of which two kinds of meat are referred to, the named meats shall constitute at least 85 % of the total meat content. In addition, the kind of meat named first shall constitute at least 50 % of the total meat content, and that named second at least 25 %. If three kinds of meat are named in the description of the product, the named meats shall constitute at least 85 % of the total meat content. The meat named first shall constitute at least 40 % of the total meat content, and each of the other named meats at least 15 %. The three kinds of meat shall be named in descending order of contents.

12.1.2.5 Use of generic names

When a generic name (or names) of animal meat(s) such as beef or pork appears in the name of the product, that product shall not contain any other meat, edible offal, fat, natural binder, etc., which did not originate from the type of animal meat that appear in the name of the product.

12.1.2.6 Origin of contents

The origin of edible offal, fats or natural binder or any preparation from types of animal other than those from which the meat used in the product is derived shall be declared on the label.

12.2 Labelling and marking

12.2.1 Labelling operations

12.2.1.1 Labelling area

Before the start of the labelling operation, the area shall be cleared of any stray cans. The labelling area shall be maintained in a clean, tidy and orderly condition.

12.2.1.2 Condition and handling of containers during labelling

Containers shall be in a condition complying with 9.4.

The handling of containers during the labelling process shall be done in a manner so as to avoid container abuse or damaging or that their seams are subjected to undue stress or mechanical shock.

12.2.1.3 Labels

Labels, outer wrappers, outer cartons, lithographic markings and printing on containers, pictorial presentation and colouring shall be in accordance with the labelling requirements of section 12.1.

The size of the label, outer wrapper, outer carton shall be suitable to the container size without being oversized. Printing shall be correct, proper and neat.

It is recommended that the authority administering this specification be consulted with regard to the printed lettering size, statements, pictorial presentation and colouring on newly designed labels, outer wrappers, outer cartons or lithographed cans before they are taken into use.

12.2.1.4 Attachment of labels

Labels, outer wrappers or outer cartons shall not be attached or applied to containers by any person other than the manufacturer or by his authorized agent.

Labels, outer wrappers or outer cartons on containers, shall be clean, neat, unspoiled, undamaged and labels or outer wrappers shall be securely attached at the time of despatch from the factory (or at the time of arrival when imported).

Misaligned labels, excess glue or lack of glue, or loose or pleated labels or outer wrappers shall not be present (see 12.2.1.9 and 12.2.1.10). Labels or outer wrappers shall not be superimposed over other labels or over outer wrappers that have been affixed on to containers or onto lithographic printed containers.

Materials such as adhesives or glues used for attaching or applying labels, outer wrappers or outer cartons or closing of packages shall not be hygroscopic, or liable to deteriorate during storage after being applied or conducive to corrosion of the can or lid.

12.2.1.5 Packages – outer containers

Packages in which containers are packed shall be clean, neat and undamaged. Outer containers such as boxes or cases shall be suitable for the purpose of use, be of correct size to avoid damaging of containers by squeezing or loose movement of the containers inside the outer container. Containers shall not be packed in outer containers in positions prone to cause damaging such as packing containers on their sides.

Outer containers shall be strong enough to protect the finished product.

12.2.1.6 Marking of packages

The following regarding the containers in the package shall be printed or stencilled on the outside of every package. The number and size or net mass of the containers and the information required by 12.1.1(a), (b), (f), (g), and (i) where applicable, (e), except that the business address of the manufacturer need not be the full address but shall be sufficient for identification purposes.

In addition to the date code required by 13.1 (g), any batch number or sub-coding indicating a time period of the production date, and/or any line or seamer number, which appeared on the containers shall also be printed or stencilled on every package. When a code system other than the conventional lettering and digital form such as a bar or edge coding system is used, sufficient information shall appear on the packages to identify the production date and any sub-coding.

12.2.1.7 Containers for export

Provided that the requirements of the importing country are met and subject to there being no attempt to misrepresent the product, products may be exported either unlabelled, or labelled differently from the requirements of this specification. The requirements of 12.2.1.6 shall, however, apply, except that a code mark may be used in lieu of the name of the manufacturer.

12.2.1.8 Control for correct labelling

Only production lots complying with this specification shall be labelled provided that containers of production lots which do not comply with or have not been manufactured in accordance with this specification shall not be labelled unless a sales permit has been issued by the authority administrating this specification and the label and consumer packages of the containers are in compliance with the conditions of that permit.

A system of control and precautionary measures shall be practised to prevent incorrect labelling or labelling of production lots or containers not qualified for a specific label. The system shall ensure that the correct label be identified and used.

Only production lots qualified and selected for that specific label used shall be labelled or be present in the labelling area during the time of labelling. Any containers of production lots not complying with the specific label used, shall not be within the immediate labelling area. Only containers of the same production lot code shall be labelled at a time. Lots existing out of a mixture of various production lot codes shall not be labelled.

Control checks shall be conducted on production lots immediately before labelling and after labelling. (See 12.2.1.9 and 12.2.1.10). Necessary screening of production lots such as for defected seams or defected, abnormal, rusted or damaged containers shall be completed before the production lots are taken into the labelling area.

Sighting stations for inspections shall be provided on the conveyor lines before and after labelling.

12.2.1.9 Control checks

Control checks shall be conducted and recorded on a regular basis during labelling (see 12.2.1.8 and 12.2.1.10). Such checks shall be done on the condition of containers and for the presence of abnormal containers (see 9.4 and 12.2.1.2), the condition of labels and incorrect labelling (see 12.2.1.3) defected attachment of labels (12.2.1.4), condition of packages (12.2.1.5), marking of packages (12.2.1.6 and 12.2.1.7) and for control for correct labelling (12.2.1.8) and condition of the labelling area (12.2.1.1).

12.2.1.10 Labelling records

12.2.1.10.1 A daily record shall be kept of the following:

a) product labelled;

b) code, including any sub-code or line code and container size;

c) label used;

d) where applicable, the serial number of the compliance certificate(s) of production lot(s) labelled;

e) number of containers labelled; and

f) destination of consignment with adequate information in case of a recall of the consignment.

12.2.1.10.2 Records shall be kept of control checks (see 12.2.1.8 and 12.2.1.9) done during labelling and consequent findings. Number of containers rejected due to obvious seam defects, damages and cans with an abnormal appearance shall be recorded.

12.2.1.11 Traceability and recall procedures

The record keeping system based on labelling records shall be established so that individual lots of the product in a consignment can be traced from the factory to the point of retail distribution. The recall procedures, when necessary, shall be established in consequence.