



QUALITY MANUAL 3.4.2

Product Specification Sweet Whey Concentrate

Issue Date 08/06/2016	Reference No. QM-3.4.2 WHEYCONCCON	
Revision No. 004	Issued By NSR	Authorised By NAP
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Sweet Whey Concentrate

Description

Pale yellow, opaque homogenous liquid produced as a by-product of hard cheese manufacture, separated, pasteurised at minimum 72°C for 25 seconds & concentrated by using reverse osmosis or evaporation.
Cheese is made from cows' milk which has been tested as negative for antibiotics.

Taste / Smell

Typical of whey and free from any non-whey odours. Clean & Sweet.

Delivery / Tanker

Delivered free from foreign bodies in clean food grade road tankers to the required volume / weight.
All tanks cleaned and sanitized daily, and CIP log accompanies the road tank. Inspection hatches are sealed and blank ends and hoses capped.
Load accompanied by delivery note showing seal numbers.

Analytical Specification - Typical	Typical	Limit
Temperature	8°C	10° Max
Total Solids	25 %	<22% / >32%
Fat	<0.5%	0.5% Max
pH	6.0	<5.5 / >6.5
Fines		<1,000 ppm
Protein (dry basis)	13%	<12%
Total Ash (dry basis)		>9.5%
Sodium (dry basis)		>1.0%
Potassium (dry basis)		>2.8%
Chloride (dry basis)		>1.8%
Nitrate	None Detected	None Detected
Nitrite	None Detected	None Detected
Hydrogen Peroxide	None Detected	None Detected
Antibiotic	None Detected	None Detected

A HACCP plan must be in place for the production of whey concentrate and a copy be held by Spear UK.

All whey concentrate must be vegetarian, Kosher and Halal approved.

Product is bought and/or sold on the understanding it will undergo further heat treatment prior to end use.



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Microbiological	Target	Limit
TVC	<25,000/ml	25,000/ml
Coliforms	None Detected	100/ml
Thermoturic	<3,000/ml	3,000/ml
Thermophiles	<500/ml	500/ml
Bacillus Cereus	<3/ml	3/ml
Aerobic Thermophilic/Thermoturic Spores	None Detected	Absent/ml
Sulphite Reducing Clostridia	<1/ml	<10/ml
Enterobacteriaceae	<10/ml	100/ml
E. Coli	<10/ml	10/ml
Yeasts	<100/ml	100/ml
Moulds	<100/ml	100/ml
Salmonella	None Detected	Absent/25ml

Allergen	Present / Absent in Product	Risk of Cross Contamination	Details
Cereal containing gluten (i.e Wheat, rye, barley, oats, spelt, kamut) & products thereof	Absent	No	<p>If products are handled on same production site then the risks are managed to allow free from declaration to be made in final product.</p> <p>This is covered with product suppliers at SPEAR-UK supplier approval stage.</p> <p>Customers may request further information when the product and production site can be confirmed.</p>
Crustaceans & products thereof	Absent	No	
Eggs & products thereof	Absent	No	
Fish & products thereof	Absent	No	
Peanuts & products thereof	Absent	No	
Soybeans & products thereof	Absent	No	
Milk & products thereof (including lactose)	Present	-	
Nuts i.e. Almonds, hazelnuts, walnuts, cashews, pecan nuts, brazil nuts, pistachio nuts, macadamia nuts, queensland nuts and products thereof	Absent	No	
Celery & products thereof	Absent	No	
Mustard & products thereof	Absent	No	
Sesame seeds & products thereof	Absent	No	
Sulphur dioxide & sulphites at concentrations of more than 10mg/kg or 10mg/litre expressed as SO2	Absent	No	
Lupin & Products thereof	Absent	No	
Mollusc & products thereof	Absent	No	



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Legislation

Product conforms to all aspects of UK & EU Legislation, including but not limited to:

- Food Safety Act 1990
- EC Regs 852/2005 & 853/2005

History of Amendments/Revisions:

Revision No.	Date	Revision Detail
001	08/06/2016	First Issue
002	05/06/2017	Pasteurisation time/temp added and added requirement for further heat treatment.
003	06/06/2018	Amendment to product description wording.
004	04/03/2024	Updated allergen detail, conformity statement & added spec approval date.



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