

**Rowse Honey Ltd**  
**QUALITY ASSURANCE MANUAL**  
 QAR 6-05 ROWSE SPECIFICATION

<b>Product:</b>	Rowse Squeezy Clear Honey	<b>Product Code:</b>	24069
<b>Spec Version No:</b>	6	<b>Specification Issue Date:</b>	23/06/2022

**1.0 SUPPLIER INFORMATION**

<b>Supplier Name</b>	Rowse Honey Ltd / Valeo Foods UK (Valeo Foods UK is a trading name of Rowse Honey Limited)		
<b>Supplier Address</b>	Moreton Avenue, Wallingford, Oxfordshire, OX10 9DE		
<b>Phone Number</b>	01491 827 400		
<b>Contacts</b>	<b>Technical</b>	<b>Commercial</b>	<b>Specifications</b>
<b>Contact Name</b>	Gordon Wood / Ina Kalinina	Hanenne Madi	Rob Cooper
<b>Phone Number</b>	07730696958 (Gordon) / 07919255205 (Ina)	01491 827458	01491 827400
<b>E-Mail Address</b>	gordon.wood@valeofoods.co.uk / Ina.kalinina@valeofoods.co.uk	Hanenne.Madi@valeofoods.co.uk	Specification.technologist@valeofoods.co.uk
<b>Emergency Contact Details</b>	Gordon Wood gordon.wood@valeofoods.co.uk 07730696958		

**2.0 PRODUCT INFORMATION**

<b>Product Title</b>	Rowse Squeezy Clear Honey
<b>Sub Text / Marketing Text</b>	Runny Honey
<b>Strength Guide</b>	N/A
<b>Label Barcode</b>	5011273040698
<b>Outer Case Label Barcode</b>	05011273640690
<b>Unit Weight</b>	340g
<b>Origin Declaration</b>	Blend of honeys from more than one country/ Blend of non-EU honeys.
<b>Warning</b>	<b>Unsuitable for infants under 12 months. Not for external use.</b>
<b>Date Code Location</b>	Best Before End: See Lid
<b>Product Coding Format</b>	MMM/YYYY, 4 Digit Production code, line ID and packing time  Example: MAY 2022 2316D 14:12  Where: MAY 2022 = BBE date

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<b>Product Life From Packing</b>	BBE 18 months
<b>Minimum Life On Delivery</b>	13 months
<b>Storage Conditions</b>	Ambient 18- 24 °C, away from direct sunlight and strong odours.  Clear honey may begin to crystallise if stored at low temperatures. For further details on crystallisation, see statement at the bottom of the spec.
<b>Product Life Once Opened</b>	Use by the end of BBE date
<b>Post Opening Storage Conditions</b>	Ambient 18- 24 °C, away from direct sunlight and strong odours. Use by the end of BBE date
<b>Suitable For Freezing</b>	No
<b>Delivery Conditions</b>	Clean dry area, delivered in ambient 18 – 24 °C

**3.0 RECIPE & INGREDIENTS**

Ingredient	% in recipe	Supplier	Country of manufacture	Country of origin
Honey	100	Rowse approved suppliers	UK	Argentina, Australia, Brazil, Chile, China, Guatemala, Mexico, New Zealand, Uruguay, Vietnam, United Kingdom.
<b>Ingredient Declaration</b>	N/A: Honey is a single ingredient product.			

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**4.0 NUTRITIONAL INFORMATION**

NUTRIENT	per 100g	Source of Data
Energy kJ	1398	Analysis
Energy kcals	329	
Fat (g)	<0.5	
of which saturates (g)	0.19	
Carbohydrate (g)	81.5	
of which sugars (g)	80.8	
Fibre (g)	<0.5	
Protein (g)	<0.5	
Sodium (mg)	12.0	
Salt (sodium x 2.5) (g)	0.03	

**5.0 ALLERGENS AND SENSITIVE INGREDIENTS**

**5.1 Allergens**

ALLERGEN	PRESENT IN PRODUCT (Yes/No)	PRESENT ON SITE (Yes/No)	CONTAMINATION RISK PRESENT (Yes/No)	DETAILS
Cereals containing gluten (e.g. wheat, spelt, rye, barley, oats etc)	No	No	No	
Crustaceans (e.g. prawns, crab, lobster, crayfish)	No	No	No	
Egg	No	Yes	No	
Fish	No	No	No	
Peanuts	No	No	No	
Nuts; namely almond, hazelnut, walnut, cashew, pecan nut, Brazil nut, pistachio nut, macadamia nut	No	No	No	
Soya	No	Yes	No	
Milk (including lactose)	No	Yes	No	
Mustard	No	No	No	
Sesame	No	No	No	
Sulphur dioxide / sulphites, where added and at a level above 10ppb in the finished product.	No	Yes	No	
Lupin	No	No	No	
Molluscs (e.g. mussels, clams, oysters, scallops, snails and squid)	No	No	No	
Celery	No	No	No	

**5.2 Contains**

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INGREDIENT	PRESENT IN PRODUCT (Yes/No)	PRESENT ON SITE (Yes/No)	CONTAMINATION RISK PRESENT (Yes/No)	DETAILS
Maize	No	Yes	No	
Additives (declared additives or processing aids)	No	Yes	No	
Antioxidants	No	No	No	
Natural Colourings	No	No	No	
Artificial Colourings (incl. NI)	No	No	No	
Natural Flavourings	No	Yes	No	
Artificial Flavourings (incl. NI)	No	No	No	
Flavour Enhancers	No	No	No	
Preservatives	No	Yes	No	
Sweeteners	No	No	No	
Alcohol (abv %)	No	Yes	No	

**5.3 Other Considerations**

	Yes / No	Details if Yes
Is the product packaged in Modified Atmosphere?	No	
Is this product treated using ionising radiation?	No	
Does this product contain Genetically Modified Ingredients?	No	
Is this product a possible source of phenylalanine?	No	
Is this product a possible source of histamines?	No	
Does the product contain hydrogenated fats?	No	
Does the product contain palm oil?	No	

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**6.0 SUITABILITY DATA**

	Yes / No	Declared	Details
Suitable for Vegetarians	Yes	No	
Suitable for Vegans	No	No	Honey is derived from bees.
Halal Certified	No	No	
Kosher Certified	Yes	Yes	
Suitable for Coeliacs	Yes	No	Naturally gluten free however not tested for it
Organic Certified	No	No	

**7.0 PACKAGING**

**7.1 Packaging details**

Packaging Item / Level	Specification	Dimension (mm)	Material	Weight (g)	% Recycled Content	Recyclable (Yes/No)
Squeezy bottle	PET Bottle – flat beehive shaped. Clear colour	H 128 x W 78	70% PET 30% PCR	17.5 +/- 1.5g	30	Yes
Cap	Screw on, flip top cap with tamper evidence within cap. Plastic.  Tamper evidence inside cap – sealed at the neck of the bottle	H 19.7 x D 33.4	PP	3.98 +/- 0.2g	0	Yes
Label	Front and back self-adhesive labels. Pre-printed, paper / laminate material. 5+ colours	64 x 50	Paper label	0.46	0	Yes
Tray	Rowse specially printed.	79 x 276 x 30	Cardboard	22	97	Yes
Outer Case Label	Self-adhesive white label for trays	H 76 x W 102 Thickness 125microns	Self-adhesive	1	0	Yes
Shrink-wrap	Shrink wrap for trays	350mm x 30um	LPDE	25	30	Yes

**7.2 Packaging details**


Units per outer	6
Outers per layer	53
Layers per pallet	6
Cases per pallet	318

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**8.0 FINISHED PRODUCT STANDARDS**

**8.1 Organoleptic Evaluation**

	Acceptable	Unacceptable
<b>Appearance</b>	<ul style="list-style-type: none"> <li>• Fill should be clean and level</li> <li>• Air bubbles may be present in the shoulder of the bucket, which may look like slight foaming. The ring should be no more than 1cm thick.</li> <li>• Minimal small air bubbles or no larger bubbles present in body of the product.</li> <li>• The product is a viscous pourable liquid.</li> <li>• Free from foreign bodies</li> </ul> 	<ul style="list-style-type: none"> <li>• Low fill level.</li> <li>• Excessive air bubbles</li> <li>• Product is very thick and not pourable.</li> <li>• Moisture reject &gt;20.0%</li> </ul>
<b>Colour</b>	<ul style="list-style-type: none"> <li>• Glossy appearance.</li> <li>• Colour Lovibond accept 30 - 50mm pfund</li> </ul>	<ul style="list-style-type: none"> <li>• Very pale or dark in colour, or very cloudy</li> <li>• Colour Lovibond reject &lt;30 - &gt;50mm pfund</li> </ul>
<b>Texture</b>	<ul style="list-style-type: none"> <li>• The honey is a viscous pourable liquid.</li> <li>• Dissolves easily in the mouth.</li> <li>• Not tacky or sticky in the mouth.</li> <li>• Generally smooth and not grainy.</li> <li>• Crystallisation may occur over life.</li> </ul>	<ul style="list-style-type: none"> <li>• Larger sugar crystals in mouthfeel</li> <li>• Fully crystallized</li> </ul>
<b>Aroma</b>	<ul style="list-style-type: none"> <li>• Typical honey aroma</li> <li>• No off odours present</li> </ul>	<ul style="list-style-type: none"> <li>• Non honey aroma</li> <li>• Off odors present.</li> </ul>
<b>Flavour</b>	<ul style="list-style-type: none"> <li>• Sweet, mild flavour typical of honey with delicate fruity &amp; floral notes.</li> <li>• Acidity should not dominate but may be present in the aftertaste.</li> <li>• No off, fermented or bitter flavours to be present.</li> </ul>	<ul style="list-style-type: none"> <li>• Tastes burnt or distinct strong caramel flavour.</li> <li>• Excessive acidic notes dominate.</li> <li>• Off, fermented or bitter flavours present.</li> </ul>

**8.2 Quality Analysis**

Test	Frequency	Method	Accept	Reject
HMF at time of packing	Every Batch	Spectrophotometer	≤ 40 mg/kg	>40 mg/kg
Colour	Every Batch	Lovibond Comparator	30 – 50 mmpfund	<30 / >50 mmpfund
Moisture	Every Batch	Refractometer	≤ 20 %	>20 %

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**8.3 Veterinary Residues**

Test	Target	Reject	Method	Frequency
Chloramphenicol	0-0.3 ppb	>0.3 ppb	VETRES02	Routine sampling of honey by batch verification
Streptomycin	0-10 ppb	>10 ppb	VETRES05	Routine sampling of honey by batch verification
Tetracycline's	0-10 ppb	>10 ppb	VETRES11	Routine sampling of honey by batch verification
Sulphonamides	0-5 ppb	>5 ppb	VETRES03	Routine sampling of honey by batch verification
Nitrofurans	0-0.5 ppb	>0.5 ppb	VETRES08	Routine sampling of honey by batch verification
Macrolides	0-2 ppb	>2 ppb	VETRES09	Routine sampling of honey by batch verification
Nitroimidazoles	0-1 ppb	>1 ppb	Imid.P - tested for Chinese Honey only	Routine sampling of honey by batch verification
Trimethoprim	0-5 ppb	>5ppb	VETRES09 - tested for Chinese Honey only	Routine sampling of honey by batch verification

All honey is sampled for Veterinary Residues/Antibiotic testing by an accredited, independent laboratory in accordance with the European Union and United Kingdom regulations. Antibiotic residue testing is based on risk assessment. Rowse may alter the testing suite due to changes within the risk assessment. Evidence of homogenisation is provided prior to delivery; all homogenised loads are sampled as per guideline of the square root +1 of the number of barrels in a container. If it is not homogenised sampling is done on a risk assessment basis.

**8.4 Other Contaminants**

Pesticide testing is completed annually by the Honey Association and results are all within the tolerances set in Regulation (EC) 396 2005, foods which do not have an MRL for any particular pesticide there is a general MRL of 0.01mg/kg.

**8.5 Microbiological Analysis**

Test	Method	Frequency	Units	Target	Reject
TVC	TP4100	Quarterly	Cfu/g	<10000	>10000
Yeast	TP4109	Quarterly	Cfu/g	<1000	>1000
Mould	TP4109	Quarterly	Cfu/g	<1000	>1000

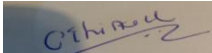
**8.6 Other**

<b>Certificate of Conformance:</b>	An annual certificate of conformance can be supplied by email upon request.
<b>Laboratory Details:</b>	Internal: CLAS Accredited External: UKAS Accredited

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**9.0 AUTHORISATION**

NAME	SIGNATURE	POSITION	DATE
Caroline Thirkell		Specifications Technologist	23/06/2022

**REFERENCE**

**The honey supplied in this product complies to the following documents.**

Honey (England) Regulations 2015

EC Directive 2001/110/EC relating to honey with Directive 2014/63/EU amendments

EC Directive 2008/772/EC on the approval of residue monitoring plans submitted by third countries in accordance with Council Directive 96/23/EC

Commission Regulations (EU) No 37/2010 on pharmacologically active substances and their classification regarding maximum residue limits in foodstuffs of animal origin

CODEX Standard for Honey 12-1981

**CRYSTALLISATION OF HONEY**

Honey is a natural product completely free of additives of any kind. As such, its constituent parts are variable according to the floral and geographic origin of the plants visited by the bees. Approximately 80% of honey is invert sugar in various forms. The two main ones are fructose and glucose. As a general rule, those honeys which are high in glucose will crystallise readily, perhaps within a matter of weeks and sometimes, exceptionally quickly, even before the honey is extracted from the comb. Conversely, honeys which are high in fructose will stay liquid for a greater length of time and in some cases indefinitely. The main bulk of honeys will re - crystallise naturally within about six months.

When honey sets some of the glucose comes out of the solution and forms crystals. The process can be accelerated by keeping the honey at the optimum temperature for crystallisation and by starting off with a nucleus of crystals on which further crystals can grow. Other matter, such as pollen, can also act in the same way and cause the precipitation of crystals to be accelerated. The process can be reversed by warming the honey, thus melting the crystals, but they will usually form again within a short period of time. It always follows that a honey with very little pollen in it will stay liquid for a longer period of time.

It is important to realise that honey which crystallises naturally does so more slowly and the formation of the crystals is less controlled and results in a coarse texture. There is nothing wrong with the honey, it is perfectly edible, and the only difference between it and smooth spreadable set honey is that the latter has been crystallised under strictly controlled temperature conditions.

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**THE STORAGE OF HONEY**

Honey is formed from nectar which is converted by the bee into a concentrated solution containing many sugars, but in the main glucose and fructose.

All honey should be stored in a clean warehouse away from strong odours and out of direct sunlight.

*Clear Honey*

Clear honey should be stored at 20°C (68F) on average, but no higher than 24°C (75F) or lower than 15°C (59F). Lower temperatures will hasten the appearance of glucose crystals which, although harmless, detract from the appearance of the product.

**SUMMARY OF SPECIFICATION CHANGES**

SPEC VERSION NO	DATE	SUMMARY OF AMENDS
3	01.12.2016	Specification transfer into the new template.
4	05.03.2019	Update to colour limits. Countries of origins updated.
5	13.08.2021	New 30% rPET bottle
6	22/06/2022	COOL & Contacts Updated, % recycled content of shrink wrap updated.

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