

# Heygates Ltd Flour Specification



<b>Product Name</b>	<b>Customer Name</b>	<b>Cust Ref</b>
<b>TM065 PLAIN</b>	<b>Bradleys</b>	<b>HAR150</b>

**Description Of Flour**

A smooth free flowing white flour that shall be free from hard lumps or foreign matter. The flour shall be free from any off taints or odours shall have a neutral cereal taste.

## 2020 Harvest

**Flour Analysis**

Method	Range	Method
NIR PROTEIN (Dumas N x 5.7 as is)	9.5    10.5	HEY 014
NIR MOISTURE (90 MINS @130C)	Max    14.0	HEY 014
FALLING NUMBER	Min    250	HEY 06
NIR FLOUR COLOUR GRADE	Max    0.5	HEY 014

\*Uncontrolled Copy



\*The product analysis data is obtained using historical data and could be subject to change at harvest

<b>Shelf Life &amp; Storage</b>	365 Days	FLOUR IS A RAW INGREDIENT AND MUST BE COOKED OR BAKED BEFORE EATING
	Flour should be stored in cool, well ventilated and pest-free areas away from direct sunlight.	

<b>Ingredients</b>	We reserve the right to source wheat from the global market to ensure consistent quality	<b>Countries of origin</b>
	Wheat	UK, GER, POL, FRA, SWE, CAN, USA
	Calcium Carbonate (E170), Iron, Niacin, Thiamine	UK, USA, IND, CHN, SWE
<b>Stat Adds</b>	UK and NI Bread and Flour Regulations 1998	

<b>Issue Date</b>	22-Jan-21	<b>Spec ID</b> TL026	<b>Prepared By</b>
		<b>Version</b> 10/12/2020	ATV - Anne Taylor-Vissers

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<b>HQ Address</b>		<b>The below sites are approved to supply</b>	
Add 1	Heygates Ltd	<b>Flour name:</b>	TM065 PLAIN
Add 2	Bugbrooke Flour Mills	<b>To:</b>	Bradleys
Add 3	Bugbrooke		
Add 4	Northants NN7 3QH		
Sales & Technical	Mervin Poole		
Quality Manager	David Bailey		
<b>Export Declarations</b>			
Heygates EORI No.	GB119291076	Goods are of UK Origin	
Product commodity code	11010015		
<b>Approved Sites For The Supply Of This Product</b>			
	T		B
Add 1	Heygates Ltd, Tring	Add 1	Heygates Ltd, Bugbrooke
Add 2	New Mill	Add 2	Bugbrooke Flour Mills
Add 3	Tring	Add 3	Bugbrooke
Add 4	Herts HP23 4JN	Add 4	Northants NN7 3QH
Tel No.	01442 823311	Tel No.	01604 830381
Fax No.	01442 890283	Fax No.	01604 831865
Grade	<b>A</b>	Grade	<b>A</b>
Scope	The milling of white, wholemeal and brown wheat flours and co products, for retail (1.5kg flour bags) and industrial (sack-packed and bulk tanker) supply. Cert No. ESP 21707.	Scope	The milling of wheat flours including heat treated flour, blended bread mixes and other wheat derived products, including co-products, for industrial supply (sack packed and bulk tanker). Cert No. ESP 23255.
<b>BRC validation</b>	 <b>Directory</b>	<b>Site Code</b>	1220543
		<b>BRC validation</b>	 <b>Directory</b>
		(pls click icon)	<b>Site Code</b>
			1127834

<b>Food Safety Controls - Critical Control Points</b>			
Final Sieve Size	1 mm	Frequency of Inspection	Weekly
Frequency of overtail Checks	Daily	<b>The flour will be free from foreign bodies</b>	
Blow Line Metal Detection	1.0Fe, 1.0Nfe, 2.0SS		
Bag Metal Detection	2.5Fe, Nfe, 3.0 SS		

<b>Packaging</b>			
Size of bag	6x1.5Kg	Bag Dim.	115x75x310x60mm
		Primary Packaging	N/A
		Pallet Configuration	
Weight	1 x 80gsm (per bag)	Secondary Packaging	N/A
		No. per layer	N/A
		No. layers	N/A

<b>Microbiological</b>		<b>Mean Figs from industry survey</b>	<b>Mean Figs from industry survey</b>
Aerobic Total Viable Count		31999 cfu/g	Presumptive Bacillus cereus
Yeasts & Moulds		2041 cfu/g	Listeria spp (count)
Presumptive Coliforms		1414 cfu/g	Salmonella
Presumptive Escherichia coli		0 cfu/g	Frequency of tests
<b>Micro Analysis</b>	We consider the product to be low risk microbiologically. The product should pass through a validated heat treating process i.e. cooking before final consumption.		Post harvest
	FLOUR IS A RAW INGREDIENT AND MUST BE COOKED OR BAKED BEFORE EATING		
<b>Mycotoxin / Pesticide Residue Tests</b>		All wheat and wheat derivatives meet current EU legislation	
	<b>Test</b>	<b>Frequency of Test</b>	
<b>Wheat</b>	Ochratoxin A; DONs; ZONs	Annually at Harvest then risk assessed basis following this.	
	Pesticide Residue	HGCA Project	
		Typical results available on request	

**Food Allergen Information**

The following list of known allergens is based on the statutory instrument 2008: No.1188. the Food labelling (Declaration of Allergens)(England) regulations 2008 - Amended March 2011

	Q1	Q2	Q3
Cereals containing gluten	<b>YES</b>	<b>YES</b>	N/A
Crustaceans	NO	NO	NO
Eggs	NO	NO	NO
Fish	NO	NO	NO
Peanuts	NO	NO	NO
Soyabeans	NO	NO	<b>YES</b>
Milk	NO	NO	NO
Nuts (i.e. almonds, hazelnuts)	NO	NO	NO
Celery	NO	NO	NO
Mustard	NO	NO	NO
Sesame	NO	NO	NO
Sulphur dioxide & sulph <sup>^</sup> >10	NO	NO	NO
Lupin	NO	NO	NO
Molluscs	NO	NO	NO

Q1: Is the allergen declared on the packaging label

Q2: Is this allergen used within the same production facility

Q3: Is there a risk of adventitious cross contamination

*Adventitious cross-contamination can occur in the wheat transport chain. Transportation (vessels, trains, road haulage), ports, storage and conveying systems may carry other combinable crops when they are not used for wheat. Best practice controls are in place to reduce any adventitious contamination within the supply chain. Heygates employ the services of a port superintendent to check previous loads and inspect samples of incoming wheat at the port. Wheat is tested and cleaned when it enters the mill to minimise the inclusion of any adventitious cross contamination. However, the supply chain is not segregated.*

**Nutritional Information (per 100g)****Typical**

https://www.gov.uk/government/publications/composition-of-foods-integrated-dataset-cofid

Source - McCance & Widdowson's

Water (g)	11.6	Magnesium (mg)	23.0
Total Nitrogen (g)	1.6	Phosphorus (mg)	114.0
Protein (g)	9.1	Iron (mg)	1.9
Fat (g)	1.4	Copper (mg)	0.2
Av Carbohydrate (g)	80.9	Zinc (mg)	0.7
Energy (kcal)	352.0	Chloride (mg)	143.0
Energy (KJ)	1501.0	Manganese (mg)	23.0
Starch (g)	80.3	Selenium (ug)	3.0
Total Sugars (g)	0.6	Iodine (ug)	TR
Gluc (g)	TR	Retinol (ug)	0.0
Fruct (g)	TR	Carotene (ug)	0.0
Sucr (g)	0.5	Vitamin D (ug)	0.0
Saturates (g)	0.4	Vitamin E (mg)	0.6
Malt (g)	0.1	Thiamine B1 (mg)	0.3
Lact (g)	0.0	Riboflavin B2 (g)	0.1
Dietary Fibre (g)	3.4	Niacin (mg)	1.7
Satd (g)	0.4	Tryptophan/60 (mg)	2.0
Mono-unsatd	0.2	Vitamin B6 (mg)	0.2
Poly-unsatd (g)	0.2	Vitamin (B12 (ug)	0.0
Trans (g)	TR	Folates (ug)	16.0
Cholest-erol (mg)	0.0	Pantothenate (mg)	0.4
Sodium (mg)	2.0	Biotin (ug)	2.0
Potassium (mg)	175.0	Vit C (mg)	0.0
Calcium (mg)	96.0		

**Suitable For**

Vegetarian	Yes
Vegans	Yes
Coeliacs	<b>No</b>
Kosher	Certified
Halal	Yes

**Pest Control**

No. of routine visits	26
No. of technical insp	4

**Scope of pest Control:**

Rodents & moth plus 24hr call out

**Contractor:** Check Pest Control, Reading, Berkshire.

## Heygates Food Safety Policies

### Genetic Modification

At this time no genetically modified wheat has been authorised in the EU for commercial cultivation, nor for import into the EU. NABIM (The National Association of British and Irish Millers) continue to monitor the developments in the areas of labelling and patenting of agricultural food products derived from GMO's and keep its members informed of any developments. Regulations (EC) 1139/98 and 49/2000, and the new regulations (EC) 1829/2003 and 1830/2003 on the compulsory labelling in foodstuffs of products derived from GMO's, do not apply and additional specific labelling is not required.

### Nut Policy

Heygates Ltd do not process any nut or seed products at any of our flour production facilities. Flour is produced in a sealed system and conveyed by means of an enclosed pneumatic pipe to bulk storage where it can either be discharged into dedicated bulk flour tankers or packed into flour sacks.

## COSHH

**1: Product:** TM065 PLAIN

**Details below are for wheat flour - the worse case scenario**

### **2: Composition/Information on Ingredients**

Wheat Flour is produced by milling cleaned wheat grain or endosperm of cleaned wheat grain. Flour is mainly used in the manufacture of bread, biscuits, confectionery, other foodstuffs and for various industrial purposes.

### **3: Hazards Identification**

This product is not classified as hazardous to health according to EC directive.

	8hr TWA	STEL
MEL(maximum exposure limit)	10mg/m <sup>3</sup>	30mg/m <sup>3</sup>

In normal use wheat flour does not present a serious health risk and ingestion has no adverse effects. To comply with the Control of Substances Hazardous to Health Regulations and the assigned MEL, and for general health reasons outlined below, it is necessary to reduce so far as reasonably practicable personal exposure to any dust through enclosure, ventilation and the provision and use of personal protective equipment.

### **4: First Aid Measures**

**Inhalation:** Flour dust may cause asthmatic reactions in a small proportion of susceptible employees. Remove affected person from area of exposure preferably into fresh air. Anyone who has asthmatic symptoms from an exposure to dust should seek medical advice. The symptoms normally disappear if the sufferer avoids further exposure.

**Eyes:** Flour dust may cause discomfort and the eyes should be washed with running water. Medical advice should be sought if the discomfort persists.

**Skin:** Flour can have a drying effect on the skin. For hygiene reasons it should be cleaned from broken skin to reduce risk of infection. There should be no adverse response from exposure to skin. It is only very rarely, if ever, the cause of dermatitis (see 8. Exposure and Controls below).

### **5: Fire Fighting Measures**

Extinguish with Water(Red) or Foam (Cream).

Extinguish with Powder(Blue) should there be an electrical risk or electrical fire, when water and foam should not be used.

Extinguish with Foam(Cream) or Powder if burning liquids are involved.

Use of CO<sub>2</sub> (Black), particularly large trolley-mounted extinguishers, may incur risk of generating an ignitable dust cloud.

## 6: Accidental Releases

Flour should be swept up, do not allow to enter drainage system, do not hose down. Vacuum cleaners must be spark free and earthed. Vacuuming is the preferred method of cleaning. Brushes should preferably be of the type with coloured nylon bristles. Compressed air is not suitable for cleaning jobs. It is dangerous and it spreads the problem to areas which are harder to clean and possibly into unexpected sources of ignition.

## 7: Handling and Storage

In bulk, flour should be stored at ambient temperatures in dry bins. Bagged flour should be stored in cool, dry conditions. Flour is usually supplied either by bulk tanker or in paper bags. Static Electricity: The pneumatic intake of flour from bulk tankers can give rise to static electricity. Accordingly it is essential for blowlines to be earthed; suitable earthing points must be provided at the discharge point. Manual Handling: All manual handling operations, including those involving flour bags, should be the subject of risk assessment appropriate to the environment and the physical characteristics of the handlers.

## 8: Exposure and Controls

Dust formation should be minimised during handling to prevent inhalation and skin contact. Overalls and dust respirators are recommended when handling loose materials. Spillages should be removed without delay to maintain hygiene standards and to minimise the level of dust in the atmosphere. Vacuum cleaning should be used wherever possible. It is unusual for contact with clean flour dust to cause dermatitis however high standards of personal hygiene should be maintained to avoid the possibility of dermatitis or product contamination.

## 9: Physical and Chemical Properties

White free flowing powder.  
Particle Size  
Will vary with flour type. E.g., in white flour a large majority of particles will be smaller than 150 microns, 50% of particles being smaller than 50 microns. For fine cake flours, about 50% of particles will be below 25 microns. In wholemeal flour, some particles will be greater than 300 microns.  
Specific Heat  
0.42 J/gm C.  
Explosive Concentrations  
Above 50g/m<sup>2</sup>. (Upper explosive limit concentrations are not well defined for combustible dusts.)  
Ignition Temperatures  
A cloud of flour in air can be ignited by surfaces at temperatures of about 400°C. Layers of flour on a hot surface can smoulder at around 200°C, leading to flame and ignition.  
Kst Values  
Comprehensive tests on flours indicate a range between 74 and 120 bar m/s, depending on the flour type, particle size and moisture content. (The limit for the least severe class of explosible dusts, St1, is 200 bar m/s and this figure is often used for determining suitable vent size.) Density Usually between 450 and 560 kg/m<sup>3</sup>.

## 10. Fire and Dust Explosion Hazards

Like most organic materials, flour dust is flammable. Although not especially combustible, in certain conditions flour can form dust clouds which, if ignited, can lead to a dust explosion. The following precautions should therefore be taken:

- Adequate extraction facilities should be provided in all areas subject to dust,
- Care should be taken to prevent the formation of dust clouds in storage and conveying plant,
- Potential sources of ignition should be avoided,
- Silos and appropriate equipment, including blowlines, should be earthed to prevent ignition by electrostatic discharge,
- Adequate explosion prevention or protection should be fitted to silos and other appropriate equipment,
- Smoking must be prohibited near storage and handling areas,
- Build-up of dust on beams and ledges – representing a potential dust cloud if dislodged - should be prevented,
- Electrical equipment should be of the type suitable for flammable dusts

Further advice on this matter is contained in the technical data below and in "The Prevention of Dust Explosions in Flour Mills and Bulk Flour Containers", available from NABIM.

### **11. Toxicological Information**

This product is non-toxic.

Ingestion: Safe for human ingestion.

Inhalation: Repeated exposure may cause sensitisation and asthma (see 8. Exposure and control)

Eye: May cause discomfort as a foreign body/matter.

Skin: Slight drying of skin. May cause dermatitis in rare cases

### **12. Ecological Information**

None available at this time

### **13. Disposal Considerations**

Dispose of according to national and local regulations.

### **14. Transport Considerations**

This product is not classified as dangerous goods.

### **15. Regulatory Information**

The product is produced so as to comply with the prevailing requirements of the Food Safety Act and the Bread and Flour Regulations.

EH 40 Risk Phrases: none

EH 40 Safety Phases: none

### **16. Other Information**

Under COSHH Regulations the user is under a legal obligation to carry out suitable and sufficient assessment of the health and safety risks which this material may present.

Reference should be made to:

Occupational Exposure Limits EH40/current year

Preventing Asthma at Work L55

Handling of Combustible Dusts HSE 103

The information provided in this Material Safety Data Sheet is correct to the best of our knowledge, information and belief at the date of issue below. The information is for guidance in safe handling, use, storage, transportation, disposal and release and is not in itself a warranty or quality specification. The information relates only to the products identified. This Material Safety Data Sheet may not be valid for such product used in combination with other substances or processes which must be assessed separately.

# HACCP - Process Flow Diagram

Process	Status	Checks / Monitoring
<b>Wheat Intake</b>	<b>PRE REQ</b> - pesticide, moisture, taint & infestation	All wheat is sampled and positively released
<b>Wheat Storage</b>		
<b>Wheat Conditioning</b>	<b>CP</b> - micro hazard from mains water	Water tested for micro content every year
<b>Wheat Cleaning</b>		
<b>Milling</b>		Daily detector tests and rejects sampled
<b>Metal Detector</b>	<b>CCP</b> - metal contamination	1.0Fe, 1.0Nfe, 2.0SS
<b>Final Sieve</b>	<b>CCP</b> - foreign body contamination	Sieve integrity and overtail checks
<b>Storage</b>		
<b>Packing</b>		2 hrly bag metal detector checks
<b>Bag Metal Dec</b>	<b>CCP</b> - metal contamination	2.5Fe, Nfe, 3.0 SS
<b>Palletisation &amp; Despatch</b>		
<b>Bulk Outloading</b>		
<b>Despatch</b>	<b>CP</b> - Tanker hygiene	Tanker cleaning schedule