

Product Specification

Name of Product	KETTLE ® Veg Chips, Lightly Salted
Legal Title	Parsnip, Sweet Potato and Beetroot Chips, Lightly Salted
Category	Kettle Domestic
Pack Sizes	40g, 100g, 125g
Country of Manufacture	The Netherlands

Pack design examples



40g pack



125g pack

INGREDIENTS:

Select Vegetables in Variable Proportions (Parsnips, Sweet Potatoes, Beetroot), Sunflower Oil, Sea Salt.

Gluten-Free.

These chips are suitable for Vegans.



Packaged in a protective atmosphere.

Sorry this packaging is currently not recyclable.



Nutrition	
Typical Values	Per 100g
Energy kJ	2137
Energy kcal	514
Fat	32.9g
of which saturates	2.4g
Carbohydrate	44.1g
of which sugars	21.3g
Fibre	10.1g
Protein	5.3g
Salt	1.0g

Each 40g Serving Contains:

Energy:	Fat:	Saturates:	Sugar:	Salt:
855 kJ/206 kcal	13.2 g	1.0 g	8.5 g	0.4 g
10%	19%	5%	9%	7%

Each 25g Serving Contains:

Energy:	Fat:	Saturates:	Sugar:	Salt:
534 kJ/129 kcal	8.2 g	0.6 g	5.3 g	0.25 g
6%	12%	3%	6%	4%

Of your reference intake

Typical values per 100g: Energy 2137 kJ/ 514 kcal



Dietary	
Allergens	
Recipe Contains	Yes/No
Celery	No
Cereals containing Gluten (Wheat, Rye, Oats, Barley, Spelt, Kamut)	No
Crustaceans	No
Egg	No
Fish	No
Lupin	No
Milk	No
Molluscs	No
Mustards	No
Nuts namely: Almond, Walnut, Hazelnut, Cashew, Brazil nut, Pistachio nut, Macadamia nut, Queensland nut.	No
Peanuts	No
Sesame Seeds	No
Soybeans	No
Sulphur Dioxide	No
Additives/Ingredients	
Recipe Contains	Yes/No
Artificial Colours	No
Artificial Flavours	No
Added MSG	No
Artificial Preservatives	No
Genetically Modified Ingredients	No
Garlic	No
Added Sugar	No
Yeast	No
Meat	No

Suitable For	Yes/No
Suitable for Vegetarians	Yes
Suitable for Vegans	Yes
Suitable for Ova-Lacto Vegetarians	Yes
Kosher Certified	No
Halaal Certified	No
Organic	No
Fair Trade	No
Suitable for Coeliacs	Yes



Microbiological		
Test	Target	Report
Total Viable Count	<1,000/g	>10,000/g
Enterobacteriaceae	<10/g	>100/g
Escherichia coli	<10/g	>10/g
Salmonella	Absent in 25g	Present in 25g
Yeasts	<100/g	>1,000/g
Moulds	<100/g	>1,000/g

Shelf Life:

Kettle® Vegetable Chips have desired 20 Week Shelf Life.
Guaranteed 12 Weeks Shelf Life from Manufacture.
Minimum Shelf Life into Depot: 9 Weeks.

Product is coded from Saturday following the week of production.

Storage: Store in a cool dry place away from bright light.

Additional Information

Products manufactured for Kettle Foods comply with all relevant EU legislation.
Systems are in place to satisfy the defence of "all reasonable precautions and all due diligence".
A documented Quality Management System is in operation.
Yellow Chips BV is accredited under the British Retail Consortium Global Standards protocol.

KM Sijbesma
QESH Manager

02.12.2019



Pack Format	18 x 40g	8 x 100g	8 x 125g				
FG Code	FG001938	FG002603	FG002223				
Case Barcode	05017764 600174	05017764 600303	05017764 701437				
Bag Barcode	5017764 600167	5017764 600280	5017764 701420				
CASE INFO							
Depth	289mm	290mm	290mm				
Width	385mm	324mm	324mm				
Height	175mm	225mm	225mm				
Tare Weight	274g	275g	275g				
Net Weight	720g	800g	1.000kg				
Gross Weight	1.399kg	1.129kg	1.332kg				
Cases per Pallet	110	96	96				
Layers per Pallet	11	8	8				
Cases per Layer	10	12	12				
BAG INFO							
Depth	50mm	65mm	65mm				
Width	115mm	180mm	193mm				
Height	180mm	300mm	285mm				
Tare Weight	4g	6.75g	7.1g				
Gross Weight	44g	106.75g	132.1g				

Bag Materials	100g and 125g packs: 30 matt OPP/ 30 met OPP 40g packs: PP MAT 20/PP MET 30
----------------------	--

Transit Materials	Corrugated Board Case Chep Pallet (Height 14.4cm, Weight 25kg) Polyethylene Pallet Shrink Wrap (+/-300g)
--------------------------	--



Product Breakdown

Component Name	% Weight	Supplier	Country of Origin
Parsnips	22% approx.	Various suppliers	Netherlands, UK
Sweet Potatoes	22% approx.	Various suppliers	Spain, Israel, Honduras, Egypt, USA, Nicaragua
Beetroot	22% approx.	Various suppliers	Netherlands, Spain
Sunflower Oil	33% approx.	Various Suppliers	France, Spain, Roman, Italy, Ukraine, Argentina, Russia, Moldovia
Sea Salt	1% approx.	Zoutman Industrie Belgium	Australia, Bonaire

*Please note source of vegetables will vary by season/harvest. This list is regularly reviewed.

**Vegetable Varieties used**

Parsnips, Sweet Potatoes and Beetroot.

Raw Material Information

Description	RM Code	Specification link
Seasoning		
Sea Salt	4200	
Film - Primary Packaging		
40g	30480	
100g	30489	
125g	30249	
Cases		
40g	31064	
100g x 8	31150	
125g x 8	31065	

Vegetable intake

According incoming goods inspection based on best practice

Inspection

Intrinsic foreign e.g. stalk and blemished/defect to be removed during production

Colour Standards for Individual Vegetables



BEETROOT: PASS



BEETROOT: OVERCOOKED- FAIL



SWEET POTATO: PASS



SWEET POTATO: OVERCOOKED- FAIL



PARSNIP: PASS



PARSNIP: OVERCOOKED- FAIL



Guideline Cooking Parameters

Slice thickness: Parsnip & Sweet potato 1,6mm (+/-0,2 mm), Beetroot 2.2mm (+/- 0.3 mm)

but may vary based on a number of factors.

Start temperature: 145 - 160 deg C

Picking and Inspection Checks

Defect Checks: continues during production (visual checks)

Frequency of Metal detection check: Start and end of shift

Metal detection test puck sizes: Ferrous 2.0mm, - Non Ferrous 2.5mm, - Stainless steel 3.0mm

Defects

Maximum permissible defects based on 1000g product at picking line		
Classification	Specification Defects	Definition
Intrinsic Foreign Materials - will cause consumer complaint		
Vegetable Stalk	Absent	
Congeaed Oil		
Major Defects - may cause consumer dissatisfaction per 8 bags- one outer box		
Large Bruise	≤ 4	Pale grey bruise ≥0.8cm2
Soft Chips		Individual soft chip
Large Blemish		Black or very dark area ≥0.8cm2
Burnt Chip		Individual chip which in RED range
Double fry/oily chip		Chip which is entirely oily
Minor Defects - may cause consumer dissatisfaction at high levels per 8 bags- one outer box		
Crumpled	≤8	Predominantly crumpled < 16mm
Exceeds colour		Individual very pale/white crisp
Dark Area		Dark area on chip >2.5cm2
Breakage		Crumbs <16mm



Seasoning Checks

Salt Analysis: Start of run and then hourly

Added salt analysis in production: Min: 0.70%- Target: 1.0%- Max: 1.3%

Packaging Checks:

Check of Oxygen level in Bag using OXYBABY O2 Gas Analyser: Bags are checked once every shift.

The norm is <10.

Legal Weight Checks: every half hour

Checkweigher and Weight Control Table

Pack Size	Tare	T1	T2	H
125g	7.1g	120.5g	116g	128.5g
100g	6.75g	95.5g	91.0g	104.5g
40g	4g	35.5g	32.8g	45g

Pack Coding

Correct coding

Date and traceability coding must be full and legible

Coding fully within date code box

Best Before: Numeric Best Before and Production Code

DD MM YYYY

Example Code: 07/08/2019
 10:13 B207 XXXXX

Code explanation: 07/08/2019 - Best Before Date
 10:13 - time of packaging
 B - Packaging Line
 207 - day packed in Julian code
 XXXXX - unique order number

Case Coding

Best Before DD MM YYYY Time and Order number



Final Pack Defect Check

Start up, start of shift or after any changeover

Major Defect	Description
Incorrect Film	Incorrect brand or flavour or pack size or language(s) i.e. domestic/international
No/Incorrect Date Code	Date code is missing from the pack or is incorrect
No/Incorrect Production Code	Production code is missing from the pack or is incorrect
Date Code illegible	Date code is illegible and cannot be read or not complete
Production Code illegible	Production Code is illegible and cannot be read or not complete
Underweight	Pack under filled (T2 value or below)
Overweight	Pack over filled (H value)
Oversize Pack	Anything larger than a single pack
Poor Seal (air escaping)	Seal has a pleat (film doubled over)/crease/is obstructed allowing air to escape
Major Back Seal overlay	Overlay from top layer of film is too narrow (less than 1/3 of the seal overlay) compared to the overlay from bottom layer of film or is not enough to cover bottom layer of film so silver line can be seen
Seal Misalignment	Seals misaligned and the pack is twisted
Film Print Misalignment	The print on the front and rear of the pack is misaligned or twisted
Major Bag Length Misalignment	Top and Bottom registration misaligned by >3mm i.e. the print is out of vertical alignment by >3mm
Major Film Print Defect	Print registration is misaligned and not true i.e. colours or text misaligned

Minor Defect	Description
Date Code position	Position of date code is not within the date code box
Poor Seal (no air escaping)	Seal has a small pleat (film doubled over)/small crease but air not escaping
Crease in back seal	Where the back seal is creased but air not escaping
Minor Back Seal overlay	Overlay from top layer of film is too wide (between 2/3 and 1/3 approx.) compared to overlay from bottom layer of film
Minor Bag Length Misalignment	Top and Bottom registration misaligned by ≤ 3 mm i.e. the print is out of vertical alignment by ≤ 3 mm
Minor Film Print Defect	Lines or runs in film print
Film Damage	Score marks on pack

Minor defects must be corrected immediately but adjustments can be made whilst line is running.



Typical Product Appearance

Whole Pack



Whole Pieces



Broken Pieces





Organoleptic Key Attributes

	Green	Amber	Red
	Target (score 3)	Acceptable but action required (score 2)	Reject (score 1)
Appearance	Mainly whole pieces, with some folded. Within colour standard and with breakage $\leq 10\%$ before transit and 22% post transit) (breakage = pieces $\leq 16\text{mm}$) Because of the crispiness a more broad colour aspect is accepted.	Mainly whole pieces, some folded and with breakage $\leq 12\%$ before transit and 22% post transit (breakage= pieces $\leq 16\text{mm}$). Product at the extreme of the colour standard.	Predominantly pieces not whole crisps, and/or predominantly crumpled. Or exceeds colour or breakage specification, more than $>15\%$ before transit and $>22\%$ post transit) (breakage = pieces $\leq 16\text{mm}$)
Odour	Fresh slightly sweet fried vegetable aroma	Strong sunflower oil Slight caramelised	Stale/old/off Burnt/bitter Old oil/rancid Raw/starchy/green/overcooked veg Unpleasant/foreign/taint



Organoleptic Key Attributes - continued

	Green	Amber	Red
	Target (score 3)	Acceptable but action required (score 2)	Reject (score 1)
Flavour	Typical of fried parsnip, sweet potato and beetroot chips. Slightly sweet but not burnt, caramelized or rancid. Pleasant taste of Sea Salt	Sea Salt flavour slightly over or under seasoning.	Excessively Sea Salt of no Sea Salt. Stale/old/off Burnt/bitter Old oil/rancid Unpleasant/ foreign/ taint
Texture	Crisp fracturing initial crunch, remaining crisp during second and third bite. Not dull chewy or toothpacking.	Seasoning: moderately/highly granular Veg: Crisp single initial bite but slightly dull texture during chewing which takes longer than typical to breakdown. Not soft chewy or tooth packing.	Seasoning: particulates or clumps Veg: Soft crisps, dull chewy texture and very toothpacking.