|  |  |  |  |
| --- | --- | --- | --- |
| **SAP Material Description** | PECAN CARAMEL ROLL | **Document Type** | ZFGCOPACK |

|  |  |  |  |
| --- | --- | --- | --- |
| **Sub Category** | ZBRKFST | **SAP System ID** | 000000033481 |
| **Status** | Released | **Approved** | 04/25/2018 |
| **Created By** |  | **SAP Valid Dates** | 04/25/2018-12/31/9999 |
|  |  | **ECN#** | 62446 |

|  |  |
| --- | --- |
| **Description** | **Identifier** |
| **Product's Common Name** | 61323 Pecan Caramel Roll |
| **Plant identifier for Date Code** | 7X |
| **SAP Material Description** | 61323 PECAN CARAMEL ROLL |
| **Shopping Guide #** | 879 |
| **Home Service Product** | HS |

**[Vendor**

| **SAP Vendor #** | **SAP Vendor Name** | **SAP Goods Supplier #** | **SAP Goods Supplier Name** | **Regulatory Number** | **Regulatory body** |
| --- | --- | --- | --- | --- | --- |
| **]** |  | 0000389832 | LONE STAR BAKERY INC-(PLANT #2) | XXXXXX3844 | FDA Registration Number |

**Description**

Schwan's Pecan Caramel Roll is a microwavable fully cooked 4.75 oz portion of sweet, nutty, caramel flavored breakfast roll. Each sell unit consists of 6 - 4.75 oz. rolls with 12 sell units per master case.

**Ingredient Statement**

INGREDIENTS: ENRICHED FLOUR (BLEACHED WHEAT FLOUR, MALTED BARLEY FLOUR, NIACIN, REDUCED IRON, THIAMINE MONONITRATE, RIBOFLAVIN, FOLIC ACID), DOUGH CONCENTRATE (ENRICHED FLOUR [WHEAT FLOUR, NIACIN, IRON, THIAMINE MONONITRATE, RIBOFLAVIN, FOLIC ACID], DEXTROSE, SOYBEAN OIL, SALT, LEAVENING [SODIUM ACID PYROPHOSPHATE, BAKING SODA], CONTAINS 2% OR LESS OF ASCORBIC ACID, BETA CAROTENE [COLOR], CITRIC ACID, DATEM, EGGS, ENZYMES, MONO & DIGLYCERIDES, SOY FLOUR, WHEY), WATER, HEAVY CREAM (CREAM, CARRAGEENAN, MONO & DIGLYCERIDES, CELLULOSE GUM, POLYSORBATE 80, DEXTROSE), SUGAR, POWDERED SUGAR, PECANS, WHOLE EGGS, CONTAINS 2% OR LESS OF ACTIVE DRY YEAST (YEAST, SORBITAN MONOSTEARATE, ASCORBIC ACID), CINNAMON, DRIED EGG WHITES, MODIFIED FOOD STARCH, GRAPE JUICE, RICE SYRUP, CARROT FIBER, MARGARINE (PALM OIL, WATER, SALT, VEGETABLE MONO AND DIGLYCERIDES, NATURAL BUTTER FLAVOR, CITRIC ACID [PRESERVATIVE], BETA CAROTENE [COLOR], VITAMIN A PALMITATE ADDED), MOLASSES, NATURAL FLAVORS, NONFAT DRY MILK, PALM OIL, SALT, SOYBEAN OIL, WHEAT FLOUR.

**Allergen**

|  |  |
| --- | --- |
| **Allergen Information** | **Comment** |
| Milk or its Derivatives | Contains |
| Eggs or its Derivatives | Contains |
| Wheat or its Derivatives | Contains |
| Soy or its Derivatives | Contains |
| Tree Nuts or Derivatives | Contains |

**Sensitivity**

|  |  |
| --- | --- |
| **Sensitivity** | **Comment** |
| Sulfites | Contains |
| Autolyzed Yeast/ Yeast Extracts | Contains |
| Tocopherols (Vitamin E) | Contains |
| Cinnamon | Contains |

**CAN Allergen**

|  |  |
| --- | --- |
| **CAN Allergen** | **Comment** |
| CAN Gluten (Wheat, Oats, Barley, Rye, Triticale) | Contains |

**Special Diets**

|  |  |
| --- | --- |
| **Special Diets** | **Comment** |
| Vegetarian | Yes |

**Certification**

|  |  |
| --- | --- |
| **Certification** | **Comment** |

**Composition**

| **Ingredient/Component** | **Target** | **Min** | **Max** | **UOM** |
| --- | --- | --- | --- | --- |
| Enriched Flour |  |  |  | % |
| Bleached Wheat Flour |  |  |  | % |
| Malted Barley Flour |  |  |  | % |
| Niacin |  |  |  | % |
| Reduced Iron |  |  |  | % |
| Thiamine Mononitrate |  |  |  | % |
| Riboflavin |  |  |  | % |
| Folic Acid |  |  |  | % |
| Dough Concentrate |  |  |  | % |
| Iron |  |  |  | % |
| Dextrose |  |  |  | % |
| Soybean Oil |  |  |  | % |
| Salt |  |  |  | % |
| Leavening |  |  |  | % |
| Sodium Acid Pyrophosphate |  |  |  | % |
| Baking Soda |  |  |  | % |
| Ascorbic Acid |  |  |  | % |
| Beta Carotene |  |  |  | % |
| Color |  |  |  | % |
| Citric Acid |  |  |  | % |
| Datem |  |  |  | % |
| Eggs |  |  |  | % |
| Enzymes |  |  |  | % |
| Mono and Diglycerides |  |  |  | % |
| Soy Flour |  |  |  | % |
| Whey |  |  |  | % |
| Water |  |  |  | % |
| Heavy Cream |  |  |  | % |
| Cream |  |  |  | % |
| Carrageenan |  |  |  | % |
| Cellulose Gum |  |  |  | % |
| Polysorbate 80 |  |  |  | % |
| Sugar |  |  |  | % |
| Powdered Sugar |  |  |  | % |
| Pecans |  |  |  | % |
| Whole Eggs |  |  |  | % |
| Active Dry Yeast |  |  |  | % |
| Yeast |  |  |  | % |
| Sorbitan Monostearate |  |  |  | % |
| Cinnamon |  |  |  | % |
| Dried Egg Whites |  |  |  | % |
| Modified Food Starch |  |  |  | % |
| Grape Juice |  |  |  | % |
| Rice Syrup |  |  |  | % |
| Carrot Fiber |  |  |  | % |
| Margarine |  |  |  | % |
| Palm Oil |  |  |  | % |
| Vegetable Mono and Diglycerides |  |  |  | % |
| Natural Butter Flavor |  |  |  | % |
| Preservatives |  |  |  | % |
| Vitamin A Palmitate |  |  |  | % |
| Molasses |  |  |  | % |
| Natural Flavors |  |  |  | % |
| Nonfat Dry Milk |  |  |  | % |

**Marketing Sections**

|  |  |
| --- | --- |
| **PACKAGES**  **PACKAGE** |  |
| **Brand** | SCHWAN'S® |
| **Brand Family** |  |
|  |  |
| **GLOBAL DATA SYNC** |  |
| **UNIQUE PRODUCT IDENTIFIERS** |  |
| **SCC-14 (Master Case)** | 00072180613233 |
| **UPC-12 (Pack/Sell Unit)** | 061323 |
| **UPC-12 (Piece/IW Sell Unit)** |  |
| **Variable Weight** | No |
|  |  |
| **OTHER PRODUCT INFORMATION** |  |
| **Country Of Origin** | United States |
|  |  |

**Preparation Instructions**

|  |  |
| --- | --- |
| **Prep Method/Oven Selection** | **Steps** |
| Microwave: (1100 Watts) | **Prepare from FROZEN state.**  **Appliances may vary, adjust accordingly.**  **MICROWAVE (1100 Watts):**  1. Remove 1 roll from carton and wrapper. Leave in tray.  2. Microwave on high for 1 minute.  3. Turn tray over onto a dish and spread caramel from tray onto roll.  4. Let stand 1 minute.  **FOR FOOD SAFETY AND QUALITY, FOLLOW THESE HEATING INSTRUCTIONS. THIS PRODUCT MUST BE HEATED TO AN INTERNAL TEMPERATURE OF 145°F PRIOR TO EATING.** |

**Storage/Shipping/Shelf Life**

| **Property** | **Attribute** | **Target** | **Min** | **Max** | **UOM** | **Note** |
| --- | --- | --- | --- | --- | --- | --- |
| Age | Receiving |  |  | 90 | Day(s) | Product must have a minimum of 90 days shelf life remaining at the time of receipt in the Marshall DC. |
| Weight | Label | 28.5 | 28.5 | 30 | Ounce(s) |  |
|  | Gross Case | 27.5 | 26.5 | 28.5 | Pounds |  |
|  | Net Case | 21.38 | 21.38 | 22.23 | Pounds |  |
|  | M/C Tare Weight | 2 |  |  | Pounds |  |
| Temperature | Shipping | -10 |  | 0 | °F |  |
|  | Storage | -10 |  | 0 | °F |  |
| Shelf Life | Frozen Use By |  |  | 180 | Day(s) |  |

*The finished product weight average must meet or exceed the stated label weight, at the end of the production shift or production run, whichever comes first.*

**Sensory**

|  |  |
| --- | --- |
| **Flavor** | Sweet roll with a nutty caramel flavor. |
| **Color** | Golden Brown. |
| **Texture** | Bread like with creamy and crunchy toppings. |
| **Appearance** | Round spiraled golden brown caramel rolls with medium brown caramel and brown pecans. |

**Critical Product Characteristics**

| **Attribute** | **Target** | **Min** | **Max** | **UOM** | **Test Methods** | **Note** |
| --- | --- | --- | --- | --- | --- | --- |
| Defects Allowed |  |  |  |  |  | Caramel boil out, visible flour, roll placement, pecan distribution, under baked dough, smear on outer edge of tray and dough grease spots. |
| Foreign Material |  |  |  |  |  | No hair, wood, glass, plastic, paper or anything the customer would not expect in the product. |
| Heat Processing |  | 190 |  | °F |  | Product is fully cooked. Product must meet a minimum temperature of 190 F. |

**General Product Characteristics**

| **Attribute** | **Target** | **Min** | **Max** | **UOM** | **Test Methods** | **Note** |
| --- | --- | --- | --- | --- | --- | --- |
| Weight - Sauce | 48 | 47.75 | 48.5 | gram(s) |  | Caramel |
| Weight | 105 | 104.5 | 105.5 | gram(s) |  | Roll and smear |
| Weight | 4 | 3.75 | 4.5 | gram(s) |  | Pecans |
| Weight - Piece | 4.75 | 4.75 | 4.94 | Ounce(s) |  | Pecan Caramel Roll |
| Diameter | 3.75 | 3.62 | 3.87 | Inch(es) |  |  |
| Count |  | 6 |  | Per Carton |  | Rolls |
| Count - Shipping Cases | 36 |  |  | Per Pallet |  | 6 tie X 6 high |
| Count - Units | 12 |  |  | Per Case |  |  |
| Count - Piece | 72 |  |  | Per Case |  |  |
| Pallet Tie - Shipping (\*Required) | 6 |  |  |  |  |  |
| Pallet High - Shipping (\*Required) | 6 |  |  |  |  |  |
| Enzyme Source |  |  |  |  |  | Microbial |
| Sulfites | .024 |  |  | ppm |  |  |

**Relevant Procedures**

No changes to the product can occur without the prior consent of The Schwan Food Company.

**Process Steps:**

1. After mixed, dough is dumped into the hopper and ran on the line. Rework of dough held to 10% and traceability of rework is documented.

2. Smear is applied and spread out.

3. Rows of product are cut into rolls.

4. Caramel weighed out and dispensed into tray.

5. Nuts weighed and dispensed into tray.

6. The rolls are dropped into tray on top of caramel and pecans.

7. Trays are transferred to the spiral proofer.

8. Trays exit spiral and are transferred to oven.

9. Trays exit oven and transfer to the spiral cooling belt.

10. Trays exit cooling belt, transfer into RTE area and go into spiral freezer.

11. Once frozen, trays are overwrapped with dated film and placed 6 trays per sell unit.

12. Sell units are closed and dated and placed 12 units per master case.

13. Master cases are sealed with tape, check weighed, metal detected, and palletized.

**Note:**

1. Process flow charts are attached for the smear, caramel sauce and the finished product.

**Product Weights:**

1. Weigh the product in the sales unit to ensure product meets or exceeds label weight.

2. Weigh each component, recording the weights and checking them against the target, range and minimum.

3. If deficiencies are found, record on the product review sheet.

**Product Review Procedure**

**Product Cutting:**

Frequency of Cook Off: Two times/production shift.

1. Pecan Caramel Rolls must be prepared to minimum cook time, following the cooking instructions on the sell unit.

2. After cooking, remove product from oven and check the temperature.

a. Fully cooked product must reach a temperature of 165º F.

b. Record temperature on the Sensory Review Sheet, if minimum temperature is not met, cook product until it reaches the minimum temperature, recording the amount of additional time needed to reach the minimum temperature.

3. Let product stand and cool for 2 minutes.

4. Cut product and review for characteristics listed in the sensory section of the Schwan's Specification.

5. If deficiencies are found, record on the product review sheet.

**Reporting:**

1. Food safety or product quality issues should be communicated to Schwan's Purchasing or QA representative so that appropriate actions/adjustments can be made.

2. Review deficiencies with the appropriate vendor, production and customer personnel.

3. A copy of the product review should be sent to the fax number listed on the specification along with the Certificate of

Analysis.

**Date Code Requirement**

|  |  |  |
| --- | --- | --- |
| **Pkg Type** | **Date Code Type** | **Date Code Requirements** |
| Piece/ IW Sell Unit | Closed - Julian (Mfg) | Tray - 7XYDDDTT:TT Supplier ID (7X), year digit of production, three digit Julian date of production, followed by time |
| Piece/ IW Sell Unit | Closed - Julian (Mfg) | Film - 7XYDDD Supplier ID (7X), year digit of production, three digit Julian date of production |
| Pack/Sell Unit | Closed - Julian (Mfg) | Sales Unit: Supplier ID (7X), year digit of production, three digit Julian date of production, followed by case count 7X YJJJ CCCC Example: 7X 5032 0001 |
| Master Case | Closed - Julian (Mfg) | Master Case: On long sides Supplier ID (7X), year digit of production, three digit Julian date of production, followed by case count 7X YJJJ CCCC Example: 7X 5032 0001  On short sides 3 digit rotation code see below |

**[**A standardized 10 digit date code must be printed on each master case and sales unit.

Digits one and two represent the supplier ID; digit three represents the year of production; digits four through six represents the Julian Date; digits seven through ten are open digits for the supplier to use as they see fit.

**All sales units and master cases must be marked with a legible date code.**

**Misprinted date codes must not be re-coded.**

**Metal Detection**

| **Type of Detection** | **Ferrous** | **Non Ferrous** | **Stainless** | **Note** |
| --- | --- | --- | --- | --- |
| Metal | 1.5 MM | 2 MM | 3 MM | All products must be passed through a working metal detector. Metal detectors must be calibrated and verified to sensitivities listed above. A metal detection test is performed hourly and recorded. If MD is found not functional product is placed on hold to the last good check and re-run through the metal detector. |

**Inventory Management**

*ALL Bill of Lading (BOL) Shipping documents must include the amount of product shipping, per date code, per product number.*

*ALL trailers must be sealed in accordance with Schwan's Policy.*

**Microbiological Risk**

| **Risk Category** | **Requirements** | **Location** |
| --- | --- | --- |
| **]**3-Medium Low | No CoA required |  |

**Microbiological**

| **Property** | **Sample Configuration** | **Sampling Size** | **n** | **c** | **m** | **M** | **COA** | **CoC** | **Test Methods** | **Note** |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| Coliform | INDIVIDUAL | 25 g | 5 | 3 | 100 | 1,000 | No |  | AOAC APPROVED METHOD OR EQUIV. |  |
| E. Coli | INDIVIDUAL | 25 g | 5 | 0 | 10 |  | No |  | AOAC APPROVED METHOD OR EQUIV. |  |
| S. aureus (coag+) | INDIVIDUAL | 25 g | 5 | 3 | 100 | 1,000 | No |  | AOAC Approved Method or Equiv. Viable counts > m require confirmation for Neg. Enterotoxin (25 gm sample) |  |

*Zero (0) - lower limit of detections, depending on the method for E.Coli*

*n - number of samples to be examined*

*c - maximum allowable number of sample units yielding unsatisfactory test results between m and M in a 3-class plan*

*m - A microbiological limit which separates good quality from marginally acceptable quality in a 3-class plan or, separates good quality from defective quality in a 2-class plan*

*M - maximum number of bacteria per gram in any one sample which causes the rejection of the lot number under consideration*

*Product is produced under an appropriate HACCP plan, which is maintained on site at the manufacturing facility.*

**Method of Packaging**

1. Individual baked pecan caramel rolls will exit the spiral freezer and be conveyed to a horizontal wrapper.

2. Each trayed roll is heat seal and date code applied.

3. 6 wrapped rolls are packed into a corrugated carton. Each carton is date coded and seal shut.

4. 12 cartons are packed into a corrugated master case. Each case is taped close, date coded, RC coded and passes through a working metal detector.

5. 36 cases will be placed on a Grade A 40X48" pallet.

6. Full pallet will then be moved into holding storage freezer.

**Sales Unit:**

1. Check bag seals - visually inspect.

2. Check date code placement and clarity, all characters must be easily read.

3. Check to make sure that none of the graphics or printing is cut off or covered.

4. If deficiencies are found, record on the product review sheet.

Packaging BOM:

1 - Master Case - NA

12 - Die Cut Corrugate Cartons - 2026878

72 - Printed over wrap film - 2026882

**Packaging Properties**

|  |  |  |
| --- | --- | --- |
| **[Packaging Properties for:]** | **[Packaging Marked Recyclable]** | **[Packaging Marked Returnable]** |
| Sell Unit (if UPC Coded) | Yes | No |
| Piece (if UPC Coded) | No | No |

**Master Case Dimensions**

|  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- |
| **Property** | **Attribute** | **Target** | **Min** | **Max** | **UOM** |
| Length | Outside Dimension | 20.9375 |  |  | Inch(es) |
| Width | Outside Dimension | 15.3125 |  |  | Inch(es) |
| Height | Outside Dimension | 13.25 |  |  | Inch(es) |
| M/C Cube | Outside Dimension | 2.458 |  |  | Cubic Feet |
|  |  |  |  |  |  |

**Sell Unit Dimensions**

|  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- |
| **Property** | **Attribute** | **Target** | **Min** | **Max** | **UOM** |
| Height - Sell Unit | Outside Dimension | 4 |  |  | Inch(es) |
| Depth - Sell Unit | Outside Dimension | 14.75 |  |  | Inch(es) |
| Width - Sell Unit | Outside Dimension | 5.0625 |  |  | Inch(es) |

**Nutrition Facts Panel**

|  |  |
| --- | --- |
| **Fact Panel For** | Pecan Caramel Roll |
| **Serving Size** | 1 roll (134g) |
| **Servings per Container** | 6 |
| **Calories** | 470 |
| **Calories from Fat** |  |
| **Total Fat** | 21 g |
| **% DV Total Fat** | 27 % |
| **Saturated Fat** | 8 g |
| **% DV Sat. Fat** | 40 % |
| **Trans Fat** | 0 g |
| **Polyunsaturated Fat** |  |
| **Monounsaturated Fat** |  |
| **Cholesterol** | 45 mg |
| **% DV Chol.** | 15 % |
| **Sodium** | 420 mg |
| **% DV Sodium** | 18 % |
| **Total Carb** | 66 g |
| **% DV Tot. Carbo** | 24 % |
| **Dietary Fiber** | 2 g |
| **% DV Dietary Fiber** | 7 % |
| **Total Sugars** | 33 g |
| **Added Sugars** | 33 g |
| **% DV Added Sugars** | 66 % |
| **Sugar Alcohol** |  |
| **Protein** | 7 g |
| **% DV Protein** |  |
| **Vitamin D** | 0 MCG |
| **% DV Vitamin D** | 0 % |
| **Calcium** | 53 mg |
| **% DV Calcium** | 4 % |
| **Iron** | 2 mg |
| **% DV Iron** | 10 % |
| **Potassium** | 150 mg |
| **% DV Potassium** | 4 % |
| **Vitamin A** |  |
| **% DV Vitamin A** |  |
| **Vitamin C** |  |
| **% DV Vitamin C** |  |
| **Food Choices: Carb Choices** | 4 |
| **Food Choices: Lean Protein** | 1 |
| **Food Choices: Fat** | 3 1/2 |
|  |  |

**General Info Attachment**

|  |  |
| --- | --- |
| Graphics (ZPG) | 61323 PECAN CARAMEL ROLL Carton 11-8-17 ZPG 10000000000012756 000 05 |
| Graphics (ZPG) | 61323 MC 2-12-15 ZPL 10000000000034007 000 02 |
| Graphics (ZPG) | 61323 PECAN CARAMEL ROLL FILM 11-14-17 ZPG 10000000000056313 000 02 |
| Pictures (ZPS) | 61323 Target Pic 4-9-15 ZPS 10000000000053743 000 02 |
| Process Visuals (ZPV) | # 879 Pecan Caramel Rolls ZPV 10000000000063040 000 01 |
| Allergen Sheet (ZAS) | 61323 PECAN CARAMEL ROLL 4-2-18 ZAS 10000000000055410 000 03 |

**Packaging – Packaging Attachments**

|  |  |
| --- | --- |
| Pallet Pattern (ZPP) | 61323 PP 6-23-11 ZPP 10000000000033949 000 01 |

**Preparation Instructions - Cooking Instruction Validation**

|  |  |
| --- | --- |
| ZCI | # 879 Pecan Caramel Rolls Validate ZCI 10000000000063041 000 01 |
| ZCI | # 879 Pecan Caramel Rolls Verify ZCI 10000000000063042 000 01 |