



Vita-Pakt
CITRUS PRODUCTS CO.
TECHNICAL BULLETIN
PRODUCT NO. 909

VITA-PAKT MANDARIN JUICE CONCENTRATE

Description

Vita-Pakt Product No. 909, Mandarin Juice Concentrate is made from the juice of fresh mandarin oranges. The juice is run through an evaporator which removes the water from the juice until concentrated to 60% ± 1.0% soluble solids. Add 5.25 volumes of water to 1 volume of concentrate to reconstitute to a natural single-strength juice.

Ingredients

Mandarin Juice Concentrate.

Specifications:

Product		Microbiological Specifications cfu/g	
Brix (corrected)	60° ± 1.0°	TPC	≤5000
Acid	4.8 ± 1.6% w/w	Yeast	≤900
B/A Ratio	9.5 – 19.0 max	Mold	≤100
pH	3.5 ± 0.5	Total Coliform	<100
Pulp (fine)	8% ± 4% v/v	E. coli	<10
Weight	10.7 lbs./gal (avg.)		

Shipping and Storage

0° F (- 17.8° C) or below. Product should be used as soon as possible after thawing.

Shelf Life

For best quality, use within two years.

Packaging

5 U.S. gallons (18.9 liters) in an HDPE pail.

Weight: 53.6 pounds (24.3 Kg) net
56.1 pounds (25.4 Kg) gross

52 U.S. gallons (197 liters) in open-head steel drum with polyethylene liner.

Weight: 558 pounds (253 Kg) net
608 pounds (276 Kg) gross

4500 U. S. gallons available in tankers (average)*

* Weight will vary based on actual Brix° value

525 E. Lindmore Street Lindsay California 93247/ Telephone Number: 559-562-6008

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NUTRITION FACTS

PRODUCT NO. 909
VITA-PAKT MANDARIN JUICE CONCENTRATE

Average Values per 100 grams

Calories	224	
Calories from Fat	8	
Moisture	42.71 g	
Ash	2.33 g	
Total Fat	0.92 g	
Saturated Fat	0.30 g	
Trans Fatty Acids	0 g	
Cholesterol	0 mg	
Sodium	59.70 mg	
Potassium	397 mg	
Total Carbohydrate	50.63 g	
Dietary Fiber	0.77 g	
Sugars	49.50 g	
Added Sugars	0 g	
Protein	3.41 g	
Vitamin A	167	I.U.
Vitamin C	177	mg
Vitamin D	0	mcg
Calcium	85	mg
Iron	0.80	mg

These are calculated values based on published data and actual analysis. As these values are subject to geographic and environmental factors affecting the fruit being harvested, they can vary over a rather broad spectrum.



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ALLERGEN AND SENSITIVITY AGENTS INFORMATION

Vita-Pakt Product No. 909, Mandarin Juice Concentrate

Allergen	Present in Product	Present in Products Manufactured on Same Line	Present in Same Manufacturing Plant
Egg/Egg Products • Egg whites, albumen, lysozyme etc.	No	No	No
Fish • All species	No	No	No
Milk/Milk Products • Caseinates, NFDM, cheese, whey, lactose, butter, etc.	No	No	No
Peanut Products • All types (e. g. butter, oil, arachis, etc.)	No	No	No
Shellfish Crustaceans • Shrimp, crab, lobster, prawns, crayfish, etc.	No	No	No
Soybean/Soy Products • Tofu, miso, soy lecithin, soy flour, soy grits, soy isolate, hydrolyzed soy protein, etc.	No	No	No
Tree Nuts • All types (e.g., walnuts, almonds, cashews, pecans, hazelnuts, Brazil nuts, pistachios, pine nuts, macadamia, ginkgo nut, coconut, etc.)	No	No	No
Wheat/Related Grains • Wheat gluten, wheat flour, germ, farina, malt, etc.	No	No	No

International Allergens & Sensitizing Agents	Present in Product	Present in Products Manufactured on Same Line	Present in Same Manufacturing Plant
Added Diacetyl	No	No	No
Alternative Sweeteners • Aspartame, fructose, Sorbitol, Stevia, Sucralose, etc.	No	No	No

(CONTINUED ON NEXT PAGE)

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ALLERGEN AND SENSITIVITY AGENTS INFORMATION

Vita-Pakt Product No. 909, Mandarin Juice Concentrate

International Allergens & Sensitizing Agents	Present in Product	Present in Products Manufactured on Same Line	Present in Same Manufacturing Plant
Anti-Oxidants <ul style="list-style-type: none"> • BHA, BHT, TBHQ, etc. 	No	No	No
Celery	No	No	No
Chocolate/Chocolate Derivatives	No	No	No
Colors <ul style="list-style-type: none"> • Annatto, apo-carotenal, beet powder, caramel, carmine, cochineal, FD&C, paprika, tartrazine, turmeric, etc. 	No	No	No
Gluten <ul style="list-style-type: none"> • Barley, malt, oats, rye, etc. 	No	No	No
Grains <ul style="list-style-type: none"> • Barley, corn, oats, rice, etc. 	No	No	No
Hydrolyzed Vegetable Protein	No	No	No
Lupin/Lupine	No	No	No
Monosodium Glutamate (MSG) <ul style="list-style-type: none"> • Autolyzed yeast/yeast extracts, Glutamic acid 	No	No	No
Mustard	No	No	No
Seeds/Seed Derivatives <ul style="list-style-type: none"> • All types (e.g., caraway, celery seed, cottonseed, mustard, poppy, safflower, sesame, sunflower, etc.) 	No	No	No
Sesame	No	No	No
Shellfish Molluscan <ul style="list-style-type: none"> • Clams, mussels, oyster, scallops, etc. 	No	No	No
Sulfites/Sulfur Dioxide <ul style="list-style-type: none"> • Sodium bisulfite, sodium metabisulfite, sodium sulfite, potassium bisulfite, potassium metabisulfite, potassium sulfite, etc. 	No	No	No

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LABEL – Pails:



LABEL – Drums:



PERCENT RANGE OF INGREDIENTS

Vita-Pakt Product #909, Mandarin Juice Concentrate - 60° Brix

<u>Ingredient</u>	<u>%wt/wt</u>
Mandarin Juice Concentrate	100



TECHNICAL BULLETIN
GENERAL RECOMMENDATION TABLE FOR
PRODUCT THAWING AND HANDLING

Thaw Procedure Table

Thawing Temperature	Thaw Time	Packaging	Residence Time (after thaw)	Total Time
≤ 41 °F	5 – 7 Days	Pails	3 – 5 Days	8 – 12 Days
≤ 41 °F	7 – 10 Days	Drums	3 – 5 Days	10 – 15 Days
Circulating Bath < 70 °F	< 4 hours	Pails	Use Immediately	-
Microwave	-	Small Packages	Use Immediately	-

Temperature Effect Table on Finished Products Shelf Stability Once Thawed

Storage Temperature	Shelf Stability	Thaw Time (pails)	Total Time Stable	Recommended Handling*
45 °F	4.0 Days	5.0 Days	9.0 Days	Not Recommended
41 °F	7.0 Days	7.0 Days	14.0 Days	
40 °F	8.0 Days	8.0 Days	16.0 Days	
35 °F	19.0 Days	20.0 Days	39.0 Days	
30 °F	124.0 Days	N/A	124.0 Days	
25 °F	6 months	N/A	6 months	
14 °F	1 Year	N/A	1 Year	
0 °F	2 Years	N/A	2 Years	

Additional Comments: Typical thaw for products is generally 1 day for every 5 lbs. of product by weight. For peel products, the time to thaw decreases if the product is packed in syrup or juice.

*Recommended refreezing after thaw within 3 – 5 days to preserve stability. Refreeze in airtight containers, allowing expansion for single strength products. Food must be kept out Danger Zone of 40 °F – 140 °F whenever possible. Food takes longer to thaw at lower temperatures. Some areas of cold storage may be warmer or cooler depending on location from heat exchanger and doors.

Shelf stability is generally reduced to 50% of remaining shelf when product is refrozen.

Approved by: Vita-Pakt Technical and Quality Assurance

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MATERIAL SAFETY DATA SHEET

I. PRODUCT IDENTIFICATION

Trade Name:	Mandarin Juice Concentrate
Formula:	N/A
Chemical or Common Name:	Mandarin Juice Concentrate
CAS Number:	N/A

II. TYPICAL PHYSICAL AND CHEMICAL CHARACTERISTICS

Appearance and Odor: Orange viscous liquid with odor characteristic of mandarin.

Boiling Point (@ 760 mm Hg):	N/A
Vapor Pressure (Torr @ 25° C):	N/A
Vapor Density (Air = 1):	N/A
Specific Gravity (@ 25/25° C, H ₂ O = 1):	N/A
Solubility in Water:	Complete

III. FIRE, EXPLOSION AND REACTIVITY HAZARD DATA

Flash Point (Tag Closed Cup):	N/A
Ignition Temperature:	N/A
Flammable Limits	
(Percent by Volume):	Lower: N/A
	Upper: N/A
Fire Extinguishing Media:	N/A
Special Fire Fighting Procedures:	None
Unusual Fire and Explosion Hazards:	None
Hazardous Products of Combustion:	None
Stability Considerations:	Stable
Incompatibility With:	N/A
Hazardous Polymerization:	None
Hazardous Decomposition Products:	None
Conditions to Avoid:	None

IV. HEALTH HAZARD DATA

OSHA Permissible Exposure Limit:	Not Listed
ACGIH Threshold Limit Value:	Not Listed
Carcinogenicity:	N/A
Effects of Overexposure:	May cause skin irritation in sensitive individuals.
Primary Route(s) of Exposure:	Skin or eye contact


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MATERIAL SAFETY DATA SHEET

IV. HEALTH HAZARD DATA (cont'd.....)

Emergency First Aid Procedures:	Wash thoroughly with soap and water, thoroughly flush eyes.
Medical Conditions General Recognized As Being Aggravated By Exposure:	None

V. SPILL OR LEAK PROCEDURES

Steps to Be Taken in Case Material Is Released or Spilled:	Contain with absorbent material or rinse into drain.
Waste Disposal Method:	If local ordinances permit, flush into sewer system.

VI. PERSONAL PROTECTION, HANDLING AND STORAGE INFORMATION

Personal Protective Equipment:	Adequate work clothes. For sensitive individuals, gloves may be required.
Appropriate Hygienic Practice:	Wash with soap and water after handling.
Ventilation:	N/A
Restrictions:	N/A
Handling and Storage Precautions:	For maximum shelf-life, store frozen.

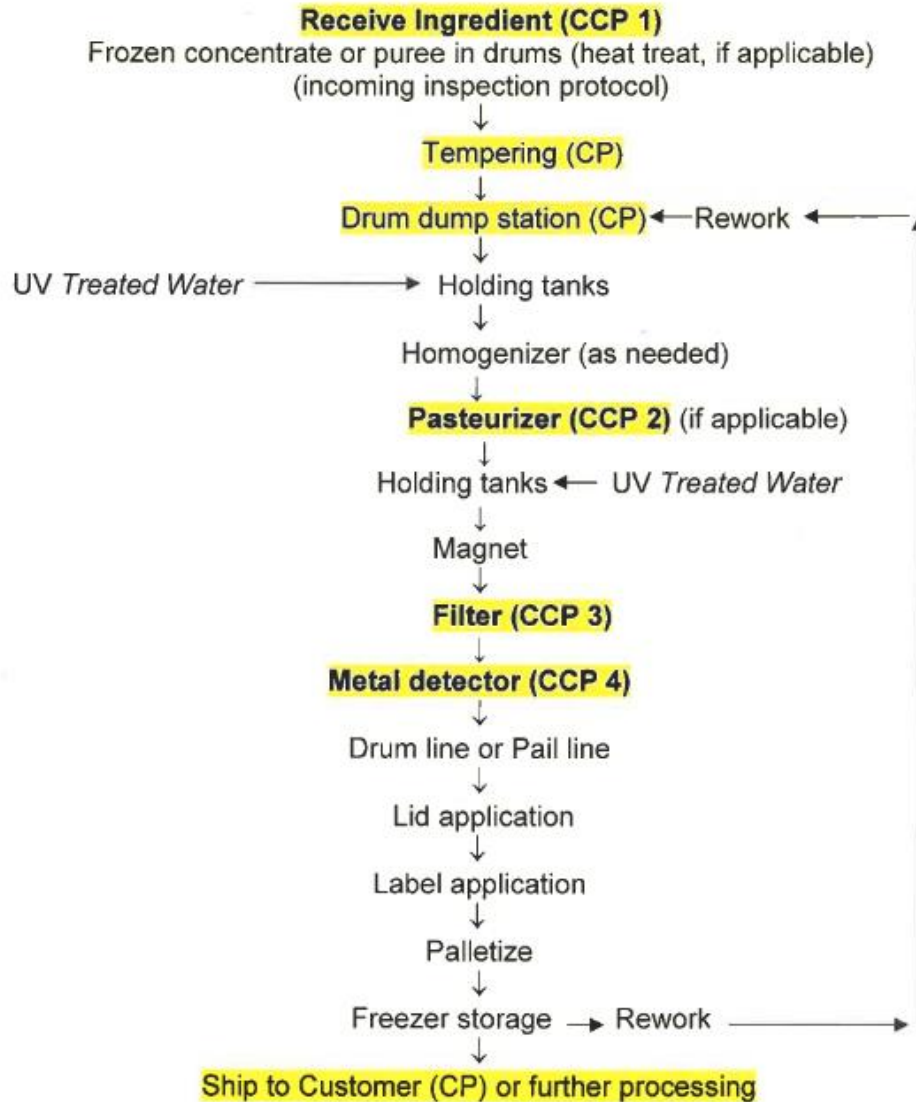
For further questions, contact Paul Gottschall at (559) 562-6008.

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VITA-PAKT
HACCP FLOW CHART FOR
PROCESSING OF CONCENTRATE FROM DRUMS OR TANKER TO PACKAGING



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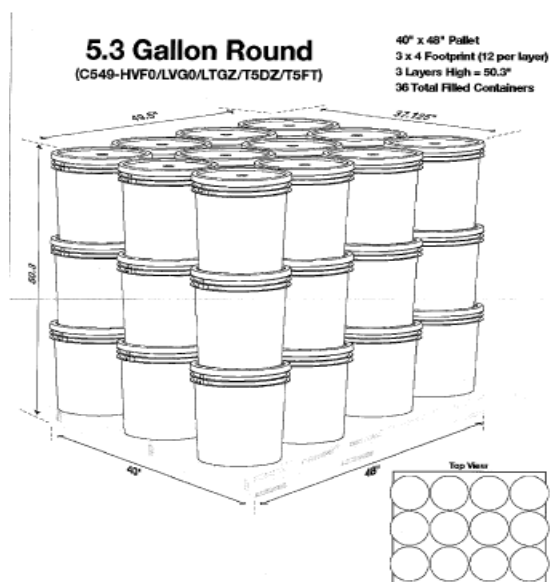
TECHNICAL BULLETIN PALLET REQUIREMENTS AND CONFIGURATIONS

GMA #1 required for all shipments

Most 48" x 40" pallets are manufactured as "Grocery Manufacturer's Association" or GMA pallets.

- Stringers are 1 3/8" x 3 1/2" x 48".
- Stringers have two notches in the side to allow for forklift entry. This makes it a 4way pallet.
- Pallet boards are 5/8" thick.
- Top of pallet has a 5/8" x 5 1/2" x 40" board on each end, and five 5/8" x 3 1/2" x 40" boards in the center.
- Bottom of pallet has a 5/8" x 5 1/2" x 40" board on each end, and three 5/8" x 3 1/2" x 40" boards positioned between the notches.
- Alternate acceptable construction for GMA pallet is six 5/8" x 5 1/2" x 40" board on top, and four 5/8" x 5 1/2" x 40" boards on the bottom.

Pallet Configurations



ISPM Requirement:

All pallets shall be - **Heat Treated (HT)**: Wood packaging material should be heated in a schedule that achieves a minimum core temperature of 56°C for a minimum of 30 minutes. The American Lumber Standards Committee administers the U.S. certification program for heat treatment. Each pallet must be marked (branded) with certificate on file.