



**TECHNICAL BULLETIN**

PRODUCT NO. 105  
VITA-PAKT ORANGE JUICE CONCENTRATE - 63° BRIX

Description

Product No. 105, Orange Juice Concentrate, is manufactured from selected sweet oranges, *Citrus sinensis* L. Osbeck (family Rutaceae) blended from various growing areas. Specified quantities of orange oil and aqueous orange essence have been returned to the concentrate to provide a fresh juice flavor. This product reconstitutes to 11.8° Brix when 5.65 gallons of water area added to one gallon of concentrate.

Ingredients

Concentrated Orange Juice

Specifications

Product		Microbiological Specifications cfu/g	
Brix (corrected)	63° ± 1.0°	TPC	≤5000
pH	3.40 – 4.00	Yeast	≤900
B/A Ratio	16.5 ± 1.5	Mold	≤100
Pulp (fine)	8.0% ± 4% v/v	Total Coliform	<100
Oil	0.015 ± 0.002%v/v	E. coli	<10
Weight*	10.8 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 liter) fill in an HDPE pail.

Weight: 54.4 pounds (24.7 kg) net  
56.9 pounds (25.9 kg) gross

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

Weight: 565 pounds (256 kg) net  
615 pounds (280 kg) gross

203 EAST BADILLO ST P. O. BOX 309 COVINA, CALIFORNIA 91723 (626) 332-1101 FAX (626) 722-0113

Issued: September 14, 2021 JR  
Supersedes: July 31, 2018 EV



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## TECHNICAL BULLETIN NUTRITION FACTS

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Average Values per 100 grams

Calories	240
Calories from Fat	0
Moisture	37
Ash	2
Total Fat, g	0
Saturated Fat, g	0
Trans Fatty Acids, g	0
Cholesterol, mg	0
Sodium, mg	5
Potassium, mg	1050
Total Carbohydrate, g	57
Dietary Fiber, g	1
Sugars, g	56
Added Sugars, g	0
Protein, g	4
Vitamin A, I.U.	410
Vitamin C, mg	200
Vitamin D, mcg	0
Calcium, mg	50
Iron, mg	0.54

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.



**TECHNICAL BULLETIN**  
**ALLERGEN AND SENSITIVITY AGENTS INFORMATION**

PRODUCT NO. 105

VITA-PAKT ORANGE JUICE CONCENTRATE - 63° BRIX

Allergen	Present in Product	Present in Products Manufactured on Same Line	Present in Same Manufacturing Plant
<b>Egg/Egg Products</b> <ul style="list-style-type: none"> <li>• Egg whites, albumen, lysozyme etc.</li> </ul>	No	No	No
<b>Fish</b> <ul style="list-style-type: none"> <li>• All species</li> </ul>	No	No	No
<b>Milk/Milk Products</b> <ul style="list-style-type: none"> <li>• Caseinates, NFDM, cheese, whey, lactose, butter, etc.</li> </ul>	No	No	No
<b>Peanut Products</b> <ul style="list-style-type: none"> <li>• All types (e. g. butter, oil, arachis, etc.)</li> </ul>	No	No	No
<b>Shellfish Crustaceans</b> <ul style="list-style-type: none"> <li>• Shrimp, crab, lobster, prawns, crayfish, etc.</li> </ul>	No	No	No
<b>Soybean/Soy Products</b> <ul style="list-style-type: none"> <li>• Tofu, miso, soy lecithin, soy flour, soy grits, soy isolate, hydrolyzed soy protein, etc.</li> </ul>	No	No	No
<b>Tree Nuts</b> <ul style="list-style-type: none"> <li>• All types (e.g., walnuts, almonds, cashews, pecans, hazelnuts, Brazil nuts, pistachios, pine nuts, macadamia, ginkgo nut, coconut, etc.)</li> </ul>	No	No	No
<b>Wheat/Related Grains</b> <ul style="list-style-type: none"> <li>• Wheat gluten, wheat flour, germ, farina, malt, etc.</li> </ul>	No	No	No

International Allergens & Sensitizing Agents	Present in Product	Present in Products Manufactured on Same Line	Present in Same Manufacturing Plant
<b>Added Diacetyl</b>	No	No	No
<b>Alternative Sweeteners</b> <ul style="list-style-type: none"> <li>• Aspartame, fructose, Sorbitol, Stevia, Sucralose, etc.</li> </ul>	No	No	No

**(CONTINUED ON NEXT PAGE)**

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**ALLERGEN AND SENSITIVITY AGENTS INFORMATION**

PRODUCT NO. 105

VITA-PAKT ORANGE JUICE CONCENTRATE - 63° BRX

<b>International Allergens &amp; Sensitizing Agents</b>	<b>Present in Product</b>	<b>Present in Products Manufactured on Same Line</b>	<b>Present in Same Manufacturing Plant</b>
<b>Anti-Oxidants</b> • BHA, BHT, TBHQ, etc.	No	No	No
<b>Celery</b>	No	No	No
<b>Chocolate/Chocolate Derivatives</b>	No	No	No
<b>Colors</b> • Annatto, apo-carotenal, beet powder, caramel, carmine, cochineal, FD&C, paprika, tartrazine, turmeric, etc.	No	No	No
<b>Gluten</b> • Barley, malt, oats, rye, etc.	No	No	No
<b>Grains</b> • Barley, corn, oats, rice, etc.	No	No	No
<b>Hydrolyzed Vegetable Protein</b>	No	No	No
<b>Lupin/Lupine</b>	No	No	No
<b>Monosodium Glutamate (MSG)</b> • Autolyzed yeast/yeast extracts, Glutamic acid	No	No	No
<b>Mustard</b>	No	No	No
<b>Seeds/Seed Derivatives</b> • All types (e.g., caraway, celery seed, cottonseed, mustard, poppy, safflower, sesame, sunflower, etc.)	No	No	No
<b>Sesame</b>	No	No	No
<b>Shellfish Molluscan</b> • Clams, mussels, oyster, scallops, etc.	No	No	No
<b>Sulfites/Sulfur Dioxide</b> • Sodium bisulfite, sodium metabisulfite, sodium sulfite, potassium bisulfite, potassium metabisulfite, potassium sulfite, etc.	No	No	No

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**Vita-Pakt®**  
CITRUS PRODUCTS CO.  
TECHNICAL BULLETIN

LABEL

Drums:





## PERCENT RANGE OF INGREDIENTS

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



**TECHNICAL BULLETIN**

**GENERAL RECOMMENDATION TABLE FOR  
PRODUCT THAWING AND HANDLING**

**Thaw Procedure Table**

<b>Thawing Temperature</b>	<b>Thaw Time</b>	<b>Packaging</b>	<b>Residence Time (after thaw)</b>	<b>Total Time</b>
≤ 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**

<b>Storage Temperature</b>	<b>Shelf Stability</b>	<b>Thaw Time (pails)</b>	<b>Total Time Stable</b>	<b>Recommended Handling*</b>
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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**TECHNICAL BULLETIN  
SAFETY DATA SHEET**

**I. PRODUCT IDENTIFICATION**

Trade Name:	Orange Juice Concentrate
Formula:	N/A
Chemical and Common Name:	Orange Juice Concentrate
CAS Number:	N/A

**II. TYPICAL PHYSICAL AND CHEMICAL CHARACTERISTICS**

Appearance and Odor: Viscous orange liquid with odor characteristic of orange.

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 <sub>2</sub> 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:	Acute: May cause slight skin irritation in sensitive individuals.
	Chronic: May cause slight skin irritation in sensitive individuals.
Primary Route(s) of Exposure:	Skin or eye contact.



**TECHNICAL BULLETIN  
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:	Dispose in compliance with federal, state, and local regulations.

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.
Ventilation:	N/A
Restrictions:	N/A
Handling and Storage Precautions:	Proper lifting techniques are recommended. Store at 0° F. or below for best quality.

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

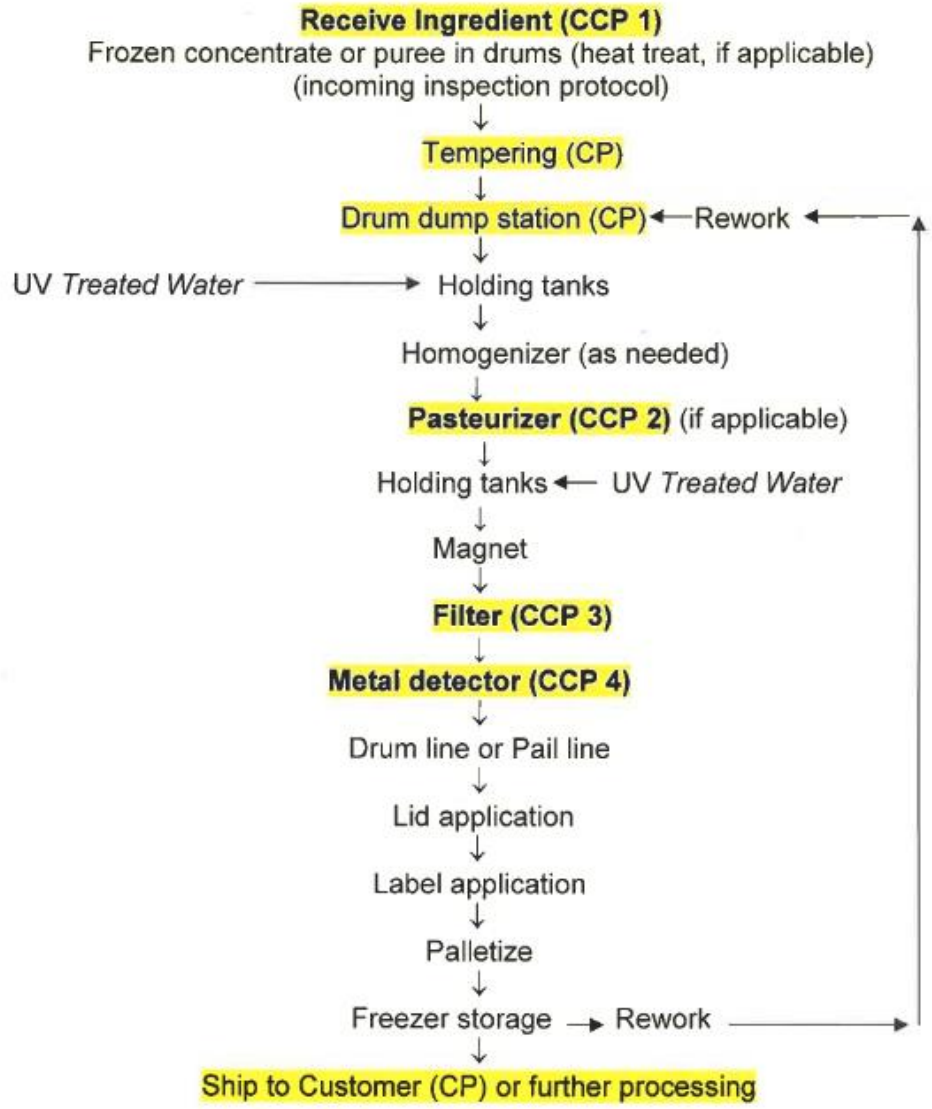
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**HACCP FLOW CHART FOR**

**PROCESSING OF CONCENTRATE FROM DRUMS OR TANKER TO PACKAGING**



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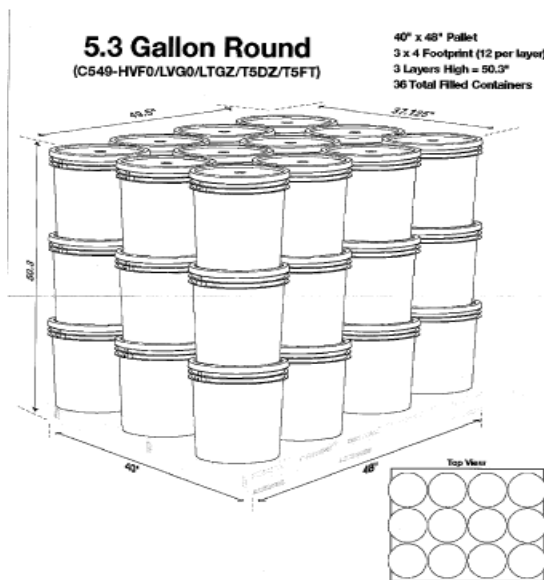
**PALLET REQUIREMENTS AND CONFIGURATIONS**

**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.