

Canned mushrooms- Specification

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Canned mushrooms- Specification

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PREFACE

This Kenya Standard was developed by the Technical Committee on Processed Fruits and Vegetables under the guidance of the Standards Projects Committee, and it is in accordance with the procedures of the Kenya Bureau of Standards.

Mushrooms are nutritious vegetable products which can be cultivated on waste by-product. At least one local firm in the country is showing a lot of interest in mushroom cultivation while several other firms are involved in mushroom canning. Canned mushroom which is gaining prominence in this country has a good opening in the world market as an export item with a high potential.

Canned mushrooms have been associated with numerous incidences of food poisoning. This is partly due to the inclusion of toxic cultivars in canned mushrooms and also due to improper processing and canning techniques. There have also been a few reported cases of cans full of brine with only a few pieces of mushrooms.

This standard is therefore intended to help eliminate such health and economic hazards as well as establish hygienic conditions for mushroom processing. It is also intended to promote this important sector of agro-industry and also ensure that mushrooms canned locally are of internationally acceptable quality.

During the preparation of this standard, the following publications were referred to, and the assistance derived from them is acknowledged with thanks.

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|---------------------------------------|---|--|
| CAC/RS 38-1970 | - | Recommended general standard for edible fungi and fungus products. |
| CAC/RS 55-1972 | - | Recommended international standard for canned mushrooms. |
| Codex Standard for certain Vegetables | | (CODEX STAN 297-2009) |

KENYA STANDARD

Canned mushrooms- Specification**1. SCOPE**

This Kenya Standard specifies requirements and methods of test for canned mushrooms, the product prepared from fresh mushrooms of the cultivated varieties (cultivars) of the genus *Agaricus* (*Psalliota*), including *A. bisporus*, packed in juice exuding from the mushrooms or other suitable media and processed by heat in an appropriate manner, so as to prevent spoilage.

2. Normative references

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

AOAC 968.30 (Codex General Method for processed fruits and vegetables)
 AOAC 971.33 (Codex General Method for processed fruits and vegetables)
 KS EAS 38, labeling of prepackaged foods
 KS EAS 39, Code of practice for hygiene in the food and drink manufacturing industry
 KS EAS 12, Drinking (Potable) water- Specification
 KS EAS 803; Nutrition labeling – Requirements
 KS EAS 804:2013 Claims on foods – Requirements
 KS EAS 805; Use of Nutrition and health claims
 Codex Stan 195, General Standard for Food Additives
 Codex Stan 193, General Standard for contaminants
 KS 38, Plantation (mill) white sugar — Specification
 KS 344; Honey- Specification
 KS EAS 5, Refined white sugar — Specification
 KS ISO 4833-1; Microbiology of the food chain -- Horizontal method for the enumeration of microorganisms -- Part 1: Colony count at 30 degrees C by the pour plate technique
 KS ISO 6888-1; Microbiology of food and animal feeding stuffs -- Horizontal method for the enumeration of coagulase-positive staphylococci (*Staphylococcus aureus* and other species) -- Part 1: Technique using Baird-Parker agar medium
 KS ISO 16649-1; Microbiology of food and animal feeding stuffs -- Horizontal method for the enumeration of beta-glucuronidase-positive *Escherichia coli* -- Part 1: Colony-count technique at 44 degrees C using membranes and 5-bromo-4-chloro-3-indolyl beta-D-glucuronide
 KS ISO 762; Fruit and vegetable products -- Determination of mineral impurities content
 KS ISO 7251, Microbiology of food and animal feeding stuffs - Horizontal method for the detection and enumeration of presumptive *Escherichia coli* - Most probable number technique
 KS ISO 763, Fruits and vegetable products - Determination of ash insoluble in hydrochloric acid
 KS ISO 2448, Fruit and vegetable products - Determination of ethanol content
 KS ISO 2172, Fruit juice - Determination of soluble solids content - Pykometric method
 KS ISO 2173, Fruit and vegetable products - Determination of soluble solids - Refractometric method
 KS ISO 5522, Fruits, vegetables and derived products - Determination of total *sulphur dioxide content*

3. DESCRIPTION

- 3.1 The fresh mushrooms shall be in good condition and after cleaning and trimming shall be sound.
- 3.2 Heat treatment is strongly recommended after the material has been sealed in the container.

3.1 Product definition

Mushroom (*Agaricus* spp)1 stands for the product prepared from mushrooms conforming with the characteristics

of any suitable cultivated varieties (cultivars) of the genus *Agaricus* (*Psalliota*), which mushrooms shall be in good condition and after cleaning and trimming shall be sound.

3.2 Colour Type

3.2.1 White or cream.

3.2.2 Brown.

3.3 Styles and Sizing

3.3.1 Buttons - Whole mushrooms, with attached stems not exceeding 5 mm in length, measured from the bottom of the veil.

3.3.2 Sliced Buttons - Buttons cut into slices 2 mm or 6 mm thick, of which not less than 50% are cut parallel to the axis of the mushroom.

3.3.3 Whole - Whole mushrooms, with attached stems cut to a length not exceeding the diameter of the cap, measured from the bottom of the veil.

3.3.4 Sliced or Sliced Whole - Mushrooms cut into slices 2 mm or greater mm thick, of which not less than 50% are cut with regular thickness, parallel to the axis of the mushroom.

3.3.5 Random Sliced - Mushrooms cut into slices of varying thickness and in which the slices may deviate materially from cuts approximately parallel to the axis of the mushroom.

3.3.6 Quarters - Mushrooms cut into four approximately even parts.

3.3.7 Stems and Pieces (Cut) - Pieces of caps and stems of irregular sizes and shapes.

3.3.8 Grilling - Selected open-veiled mushrooms not exceeding 40 mm in diameter, with attached stems not exceeding the diameter of the cap, measured from the bottom of the veil scar.

5. Essential composition and quality factors

5.1. Composition

5.1.1 Other Permitted Ingredients

As appropriate for the respective packing media

- (1) Juice exuding from the mushrooms.
- (2) Water, salt, spices, seasonings, soyabean sauce, vinegar, wine. (3) Vinegar;
- (4) Sucrose, invert sugar syrup, dextrose, glucose syrup, dried glucose syrup.
- (5) Butter or other edible animal or vegetable fats or oils, including olive oil; milk, milk powder, or cream. If butter is added, it must amount to not less than 3% m/m of the final product.
- (6) Starches - natural (native), physically or enzymatically modified - only when butter or other edible animal or vegetable fats or oils are ingredients.
- (7) Wheat or corn flour.
- (8) Packing media may contain ingredients subject to labelling requirements of Section 8 and may include, but is not limited to:

5.2.4 Packing Media

5.2.4.1 Basic Ingredients

Water, and if necessary salt

The potable water used shall comply with the requirements of KS EAS 12

5.2.4.2 Other permitted ingredients

Packing media may contain ingredients subject to labelling requirements of Section 8 and may include, but is not limited to:

5.2.4.2.1 Sugars and Sweetening Agents

Sucrose, glucose (dextrose anhydrous) or fructose with less than 2 % moisture may be added only to products intended for sale to the consumer or for catering purposes.

5.2.4.2.2 Honey

The quality of honey used shall comply with KS 05-344, Specification for honey.

5.2.4.2.3 Tomato puree.

5.2.4.2.4 Regular or concentrated fruit juice;

5.2.4.2.5 Vinegar;

5.2.4.2.6 Spices and aromatic herbs/plants or extracts thereof, seasoning Salt and spices and aromatic herbs (and their natural extracts) may be added to

5.2.4.2.7 Juice exuding from the mushrooms.

5.2.4.2.8 Butter or butter sauce. CODEX STAN 297-2009

5.4.2.7 Oil

5.1.2.8 Cream sauce.

5.1.2.9 Wine

5.1.2.10 Sauce other than a butter or cream sauce

5.1.2.11 **Vinegar.**

5.1.2.12 Nutrients

For the purpose of product fortification, essential nutrients such as vitamins and minerals may be added to products. Such additions shall comply with national legislation established for this purpose.

NOTE: any optional ingredients added are subject to ingredient labelling requirements (see Clause 10)

5.2 Quality Criteria

5.2.1 Colour, *Flavour and Texture*

Canned vegetables shall have normal colour, flavor, odour and texture characteristics of the product,

5.2.1.1 Colour

5.2.1.1.1 The mushroom portion of the product shall have normal colour characteristics of the variety of the canned mushrooms. Canned mushrooms of special types and containing special permitted ingredients shall be considered of characteristic colour when there is no abnormal discolouration for the respective ingredients used.

5.2.1.1.2 The liquid medium in water, brine and/or juice exuding from the mushrooms shall be either clear or slightly turbid and yellow to light brown in colour.

5.2.1.1.3 Texture

The mushrooms in water, brine, and/or juice exuding from the mushrooms shall be firm and substantially intact.

5.2.2 Uniformity

For styles in general, 10%, by count, of the units for the respective style may exceed the specified stem length or size.

5.2.3 Defects and Allowances

Canned vegetables should be substantially free from defects. Certain common defects should not be present in amounts greater than the limitations fixed in the table 1 below

Defects	Definition	Tolerances
(a) Spotted mushrooms	a mushroom is spotted when it presents a dark brown to brown spot diameter upper to 3 mm or when it is very speckled (more than 10 spots).	5% by weight
(b) Traces of casing material	mushroom or piece of mushroom on which remains a part of root and/or soil and/or grit, or any other extraneous matter, whether of mineral or organic origin, of more than 2 mm in diameter attached or not to the mushroom.	5% by weight of affected product
(c) Open mushroom for "buttons" and "whole mushrooms":	a mushroom is opened if small strips are visible on at least half of the circumference and if the distance between the cap and the stem is up to 4 mm.	10% by count
(d) Broken mushroom or pieces of mushroom or mushrooms with detached caps or stems for "buttons", "whole mushrooms" and "grilling mushrooms"	mushroom which is missing at least the quarter of the cap, caps and only stems.	10% by weight

5.2.3.1 Classification of "Defectives"

A container that fails to meet one or more of the applicable quality requirements, as set out in Section

5.2 (except those based on sample averages), should be considered as a "defective".

5.2.3.2 Lot Acceptance

A lot should be considered as meeting the applicable quality requirements referred to in Section 3.2 when:

- (1) for those requirements which are not based on averages, the number of "defectives", as defined in Section 3.3, does not exceed the acceptance number (c) of the appropriate sampling plan with an AQL of 6.5; and
- (2) The requirements of Section 3.2, which are based on sample averages, are complied with.

6. FOOD ADDITIVES

- 6.1 Thickeners, emulsifiers and stabilizers used in accordance with Table 3 of the *General Standard for Food Additives* (CODEX STAN 192-1995) for Food Category 04.2.2.4 are acceptable for use in canned mushrooms in sauce only.

6.2 Only the colour listed below is permitted for use in canned mushroom in sauce.

INS No.	Name of the Food Additive	Maximum Level
150a	Caramel I – plain caramel	GMP
150c	Caramel III – ammonia caramel	50,000 mg/kg
150d	Caramel IV - sulfite ammonia caramel	50,000 mg/kg

6.3 Flavour enhancers used in accordance with Table 3 of the *General Standard for Food Additives* (CODEX STAN 192-1995) for Food Category 04.2.2.4 are acceptable for use in canned mushrooms.

7. Contaminants

The products covered by this Standard shall comply with the maximum levels of the *General Standard for Contaminants and Toxins in Food and Feed* (CODEX STAN 193-1995).

7.1 Pesticide residues

The products covered by this Standard shall comply with the maximum residue limits for pesticides established by the Codex Alimentarius Commission.

7.2 Heavy Metal Contaminants

The products covered by the provisions of this standard shall conform to those maximum limits for Heavy metals contaminants established by the Codex Alimentarius Commission for these products in table 5 below

TABLE 5- Contaminants

CONTAMINANTS		MAXIMUM LEVEL	Method of Test
Arsenic	(As)	0.2 mg/kg	AOAC 942.17
Lead	(Pb)	0.3 mg/kg	AOAC 972.25 / KS ISO 6733
Copper	(Cu)	5.0 mg/kg	AOAC 999.10
Zinc	(Zn)	5.0 mg/kg	AOAC972.25 / KS ISO 5738
Iron	(Fe)	15 mg/kg	AOAC 999.10
Tin	(Sn)	250 mg/kg	AOAC 999.10
Mercury	(Hg)	0.01	AOAC 999.10
Cadmium	(cd)	0.05 mg/kg	AOAC 999.11/ KS ISO 6732

7.3 Other contaminants

The products covered by the provisions of this standard shall conform to those maximum levels for contaminants established by the Codex Alimentarius Commission for these products

8. Hygiene

8.1

It is recommended that the products covered by the provisions of this Standard be prepared and handled in accordance with the appropriate sections of the *General Principles of Food Hygiene* (CAC/RCP 1-1969), *Code of Hygienic Practice for Low and Acidified Low-Acid Canned Foods* (CAC/RCP 23-1979) and other relevant Codex texts such as codes of hygienic practice and codes of practice.

8.2 The products shall conform to microbiological criteria in Table 6 and those provided in KS 2455; Food Safety - general standard

Table 6 - Microbiological limits for canned Mushrooms

<u>SL No.</u>	<u>Microorganism</u>	<u>Limit</u>	<u>Method of Test</u>
i.	Total plate count, cfu/g, max	50	KS ISO 4833
ii.	Escherichia coli, (cfu/g), max	Absent	KS ISO 7251
iii.	Staphylococcus aureas, (cfu/25g)	Absent	KS ISO 6888-1
iv.	Shigella, cfu/25g	Absent	KS ISO4833
v.	Salmonella. CfU/25g	Absent	KS ISO 6579
vi.	Colostridium botulinum, cfu/25g	Absent	KS ISO 4833
vii.	Vibrio cholera, cfu/25g	Absent	KS ISO 4833
viii.	Moulds (cfu/25g), max	Absent	KS ISO 7954

9.3 WEIGHTS AND MEASURES

9.1 Fill of Container

9.1.1 Minimum Fill

The container should be well filled with the product (including packing medium) which should occupy not less than 90% (minus any necessary head space according to good manufacturing practices) of the water capacity of the container. The water capacity of the container is the volume of distilled water at 20°C which the sealed container will hold when completely filled. This provision does not apply to vacuum packaged vegetables. This shall be carried out in accordance to CAC/RM 46-1972 (Codex General Method for processed fruits and vegetables) and ISO 90.1:1999

9.1.2 Classification of “Defectives”

A container that fails to meet the requirement for minimum fill of Section 7.1.1 should be considered as a “defective”.

9.1.3 Lot Acceptance

A lot should be considered as meeting the requirement of Section 7.1.1 when the number of “defectives”, as defined in Section 7.1.2, does not exceed the acceptance number (c) of the appropriate sampling plan with an AQL of 6.5.

9.1.4 Minimum Drained Weight

7.1.4.1 The drained weight of the product should be not less than the percentages indicated in the corresponding Annexes, calculated on the basis of the weight of distilled water at 20°C which the sealed container will hold when completely filled.

7.1.4.1.2 *Canned mushrooms in water; brine, and/or exuded juices; vinegar; wine and oil packs.*

The drained weight of the product shall be not less than 53% of the weight of distilled water at 20°C which the sealed container will hold when completely filled.

7.1.4.1.3 *Canned mushrooms in sauce packs*

The drained mushroom portion, after washing off the sauce or liquid, shall be not less than 27.5% of the total product weight.

9.1.5 Packaging

The products covered by the provisions of this standard shall be packaged in clean food grade packaging material to protect the product from contamination. The packaging materials and process shall not contaminate the product or otherwise affect its technological, nutritional or sensory quality.

10. Labelling

In addition to the Standard for the Labelling of Pre-packaged Foods (KS EAS 38), the following specific provisions apply:

10.1 Name of the product

10.1.1 The following styles shall be included as part of the name or in close proximity to the name: "Buttons", "Sliced Buttons", "Whole", "Sliced" or "Sliced Whole", "Random Sliced", "Quarters", "Stems and Pieces (Cut)", "Grilling", as appropriate

10.1.2 A declaration of any special sauce which characterizes the product, e.g. "With X" or "In X" when appropriate. If the declaration is "With (or "In") Butter Sauce", the fat used shall only be butter fat

10.1.6 When the vegetables are sized, the size (or sizes when sizes are mixed), as defined in the corresponding Annexes, may be declared as part of the name or in close proximity to the name of the product.

10.1.7. The name of the product shall include the indication of the packing medium as set out in Section 5.2.4. For canned vegetables packaged in accordance with Section 3.1.2 (b) the words "vacuum packaged" shall be affixed to the commercial designation of the product or in close proximity.

10.1.8. Other styles - If the product is produced in accordance with the other styles provision (Section 3.2.1), the label should contain in close proximity to the name of the product such additional words or phrases that will avoid misleading or confusing the consumer.

10.1.9 If an added ingredient, as defined in Sections 3.1.2 and 3.1.3, alters the flavour characteristic of the product, the name of the food shall be accompanied by the term "flavoured with X" or "X flavoured" as appropriate.

10.2 Additional Requirements

10.2.1 Drain weight declaration content- Canned vegetables must be labelled with a declaration of "Drained weight content __%. 10.1.2.6 Ingredient declaration

10.2.2 Nutrition declaration - Any added essential nutrients declaration should be labelled in accordance with the Guidelines on Nutrition Labelling (CAC/GL 2-1985), General Guidelines on Claims (CAC/GL 1-1979) and the CAC/GL 23-1997; Guidelines for Use of Nutrition and Health Claims

10.2.3 mushrooms containing spices and/or aromatic herbs

Where tomato juice contains spices and/or aromatic herbs in accordance with Section 3.1.2(f), the term "spiced" and/or the common name of the aromatic herb shall appear on the label near the name of the juice.

10.2 Non-retail containers

Information for non-retail containers not destined to final consumers shall be given either on the container or in accompanying documents, except that the name of the product, lot identification, net contents and the name and address of the manufacturer, packer, distributor or importer, as well as storage instructions, shall appear on the container, except that for tankers the information may appear exclusively in the accompanying documents.

However, lot identification, and the name and address of the manufacturer, packer, distributor or importer may be replaced by an identification mark, provided that such a mark is clearly identifiable with the accompanying documents.

- 10.3 **List of Ingredients** — a complete list of ingredients including added syrup shall be declared on the label in descending order of proportion.
- 10.4 **Net Contents** — the net contents shall be declared by volume in metric units (*Systeme Internationale*).
- 10.5 **Name or business name and Address** of the manufacturer, packager, distributor, importer, exporter or vendor of the product, whichever may apply, shall be declared.
- 10.6 **Instructions for use shall be declared**
- 10.7 **Storage conditions or conditions for use**
- 10.8 **Lot Identification** — each container shall be embossed or otherwise permanently marked in code or in clear identity the producing factory and the lot.
- 10.9 **Place/country of origin**
- 10.8 **Date of expiry**
- 10.9 **irradiation status, where applicable**
11. **Methods of sampling and test**

The products covered by the provisions of this standard shall be tested using appropriate standard methods declared in this standard. Other test may be performed as per the methods given in the latest AOAC/ Codex/ ISO and other internationally recognized methods. Sampling shall be as described in the Standard, in the corresponding Annexes

DETERMINATION OF WATER CAPACITY OF CONTAINERS (CAC/RM 46-1972)

1. SCOPE

This method applies to glass containers.

2. DEFINITION

The water capacity of a container is the volume of distilled water at 20°C which the sealed container will hold when completely filled.

3. PROCEDURE

3.1 Select a container which is undamaged in all respects.

3.2 Wash, dry and weigh the empty container.

3.3 Fill the container with distilled water at 20°C to the level of the top thereof, and weigh the container thus filled.

4. CALCULATION AND EXPRESSION OF RESULTS

Subtract the weight found in 3.2 from the weight found in 3.3. The difference shall be considered to be the weight of water required to fill the container. Results are expressed as ml of water.

Sampling Plans

The appropriate inspection level is selected as follows:

Inspection level I - Normal Sampling

Inspection level II - Disputes, (Codex referee purposes sample size), enforcement or need for better lot estimate

SAMPLING PLAN 1 (Inspection Level I, AQL = 6.5)

NET WEIGHT IS EQUAL TO OR LESS THAN 1 KG (2.2 LB)		
Lot Size (N)	Sample Size (n)	Acceptance Number (c)
4,800 or less	6	1
4,801 - 24,000	13	2
24,001 - 48,000	21	3
48,001 - 84,000	29	4
84,001 - 144,000	38	5
144,001 - 240,000	48	6
more than 240,000	60	7
NET WEIGHT IS GREATER THAN 1 KG (2.2 LB) BUT NOT MORE THAN 4.5 KG (10 LB)		
Lot Size (N)	Sample Size (n)	Acceptance Number (c)
2,400 or less	6	1
2,401 - 15,000	13	2
15,001 - 24,000	21	3
24,001 - 42,000	29	4
42,001 - 72,000	38	5
72,001 - 120,000	48	6
more than 120,000	60	7
NET WEIGHT GREATER THAN 4.5 KG (10 LB)		
Lot Size (N)	Sample Size (n)	Acceptance Number (c)
600 or less	6	1
601 - 2,000	13	2
2,001 - 7,200	21	3
7,201 - 15,000	29	4
15,001 - 24,000	38	5
24,001 - 42,000	48	6
more than 42,000	60	7

SAMPLING PLAN (Inspection Level II, AQL = 6.5)

NET WEIGHT IS EQUAL TO OR LESS THAN 1 KG (2.2 LB)		
Lot Size (N)	Sample Size (n)	Acceptance Number (c)
4,800 or less	13	2
4,801 - 24,000	21	3
24,001 - 48,000	29	4
48,001 - 84,000	38	5
84,001 - 144,000	48	6
144,001 - 240,000	60	7
more than 240,000	72	8
NET WEIGHT IS GREATER THAN 1 KG (2.2 LB) BUT NOT MORE THAN 4.5 KG (10 LB)		
Lot Size (N)	Sample Size (n)	Acceptance Number (c)
2,400 or less	13	2
2,401 - 15,000	21	3
15,001 - 24,000	29	4
24,001 - 42,000	38	5
42,001 - 72,000	48	6
72,001 - 120,000	60	7
more than 120,000	72	8
NET WEIGHT GREATER THAN 4.5 KG (10 LB)		
Lot Size (N)	Sample Size (n)	Acceptance Number (c)
600 or less	13	2
601 - 2,000	21	3
2,001 - 7,200	29	4
7,201 - 15,000	38	5
15,001 - 24,000	48	6
24,001 - 42,000	60	7
more than 42,000	72	8

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