SILK FOODS CEYLON

TECHNICAL PRODUCT SPECIFICATION

Company Information

Manufacturer	Silk Foods Ceylon (Pvt) Ltd
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Document Information

Document No.	SFC/SPEC/FR-LSDH/2026/01
Product Name	Lemon Slices Dehydrated
Version	2026 V1.1
Date of Issue	30 April 2025
Revision	2026 V1.1
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Operation	Manufacturing — full in-house process per the QA-approved Process Flow Master Document

1. Product Description

Lemon Slices Dehydrated is produced from sound, ripe *Citrus limon (L.) Osbeck* fruit of Sri Lankan origin. Fruit is selected at optimal ripeness, washed, peeled, de-seeded where applicable, cut into uniform pieces, and dehydrated using controlled hot-air drying to reduce moisture content while preserving natural colour, flavour and nutritional profile. No preservatives, artificial colours, flavours or added sugars are used. The finished product is a semi-soft, chewy piece with characteristic colour and natural sweetness. Suitable for direct consumption or as a food ingredient.

2. Intended Use

Lemon Slices Dehydrated (*Citrus limon (L.) Osbeck*) is intended as a ready-to-eat snack and as an ingredient for breakfast cereals, granola, trail mixes, baked goods, yogurt toppings, and confectionery. Suitable for general population including children above 3 years of age. Suitable for vegetarian, vegan and plant-based diets. Certified organic where indicated, compliant with EU Regulation (EC) 2018/848 and USDA NOP standards.

3. Ingredient Declaration

100 % Lemon Slices Dehydrated (*Citrus limon (L.) Osbeck*)

4. Allergen Declaration

Free from all 14 major allergens declared under EU Regulation 1169/2011 (cereals containing gluten, crustaceans, eggs, fish, peanuts, soybeans, milk, tree nuts, celery, mustard, sesame, sulphur dioxide / sulphites at >10 mg/kg, lupin, molluscs). Manufactured in a facility that also processes coconut products — cross-contact possible.

5. Nutritional Information (Per 100 g)

Nutrient	Amount per 100 g
energy (kcal)	280
energy (kJ)	1170
carbohydrate (g)	72
of which total sugars (g)	5
dietary fibre (g)	11
protein (g)	1.5
total fat (g)	0.3
of which saturated fa (g)	0.1
trans fatty acids (g)	0
sodium (mg)	5

6. Physical Specifications (Sensory / Organoleptic)

Parameter	Specification
Appearance	Semi-soft, chewy dehydrated pieces, uniform size, free from foreign matter
Colour	Pale yellow dried slices
Odour	Bright citrus
Taste	Tart, characteristic
Texture	Semi-soft, chewy, non-sticky
Piece Size	8 – 12 mm (L × W × H) typical for cubes; product-specific for slices/strips
Foreign Matter	Absent

7. Chemical Specifications

Parameter	Specification	Method
Moisture (%)	≤ 14.0 %	ISO 939:2021
Water Activity (aw)	≤ 0.60	ISO 21807:2004
pH (at 25 °C)	3.5 – 5.5	AOAC 981.12
Total Ash (%)	≤ 4.0 %	ISO 928:1997
Sulphur Dioxide (SO_2)	< 10 ppm (no added sulphites)	AOAC 990.28
Pesticide Residues	Compliant with EU 396/2005	Multi-residue GC-MS/MS + LC-MS/MS (QuEChERS, EN 15662)

8. Microbiological Criteria

Parameter	Limit	Method
Total Plate Count	≤ 1×10^4 CFU/g (Industry standard)	ISO 4833-1:2013 (Amd 1:2022)
Yeast & Mould	< 100 CFU/g (Codex)	ISO 21527-2:2008
Escherichia coli	Absent / g (EU 2073/2005)	ISO 7251:2005 (Amd 1:2023)
Total Coliforms	< 10 MPN/g (Industry standard)	ISO 4832:2006
Salmonella spp.	Absent / 25 g (EU 2073/2005)	ISO 6579-1:2017 / Amd 1:2020
Staphylococcus aureus	Absent / g (EU 2073/2005)	ISO 6888-1:2021 (Amd 1:2023)
Listeria monocytogenes	Absent / 25 g (EU 2073/2005)	ISO 11290-1:2017
Bacillus cereus	≤ 1×10^2 CFU/g (EU 2073/2005 (process hygiene))	ISO 7932:2004 (Amd 1:2020)

9. Heavy Metal Limits

Parameter	Limit	Method
Lead (Pb)	≤ 0.1 mg/kg (EU 2023/915 (dried fruit))	ICP-MS per AOAC 999.10 / EPA 6020B
Cadmium (Cd)	≤ 0.05 mg/kg (EU 2023/915 (fruit))	ICP-MS per AOAC 999.10 / EPA 6020B
Arsenic (As)	≤ 0.3 mg/kg (Codex CXS 193-1995)	ICP-MS per AOAC 999.10 / EPA 6020B
Mercury (Hg)	≤ 0.02 mg/kg (Codex CXS 193-1995)	CV-AAS per AOAC 977.15 / EPA 7473

10. Mycotoxin Limits

Parameter	Limit	Method
Aflatoxin B1	≤ 2 µg/kg (EU 1881/2006 (dried fruit, indirect))	HPLC-FLD per AOAC 991.31
Ochratoxin A	≤ 8 µg/kg (EU 1881/2006 (dried fruit — vine fruit; conservative))	HPLC-FLD per AOAC 2000.03
Aflatoxin Total	≤ 4 µg/kg (EU 1881/2006 (dried fruit))	HPLC-FLD per AOAC 991.31

11. Pesticide Residues

Parameter	Limit	Method
Total Pesticide Residue (multi-residue scan)	Within EU Regulation (EC) 396/2005 MRL limits	Multi-residue GC-MS/MS + LC-MS/MS (QuEChERS, EN 15662)

12. Shelf Life & Storage

Shelf Life: 12 months from date of manufacture under recommended storage conditions.

After Opening: Consume within 4 weeks of opening; reseal tightly between uses.

Storage Conditions:

- Store in a cool, dry place at ambient temperature (15–25 °C), relative humidity below 65 %.
- Protect from direct sunlight, heat sources, moisture, strong odours and pests.
- Handle using clean, dry, and appropriate utensils to prevent contamination.
- Once opened, reseal tightly and consume within a reasonable period.

13. Packaging

Primary Packaging: Food-grade heat-sealed multi-layer laminated pouches (PET / ALU / LLDPE) or stand-up zip-lock pouches.

Bulk / Secondary Packaging: 5 kg / 10 kg / 20 kg corrugated cartons sealed with tape, or kraft paper bags with inner polyethylene liner. Printed box-board cartons for retail packs.

Coding: Batch number and date printed for full traceability.

14. Compliance & Standards

Products comply with Sri Lanka Food Act No. 26 of 1980 + Regulations 2026, EU Regulation (EC) 1881/2006 (heavy metal contaminants), EU Regulation (EC) 2073/2005 (microbiological criteria), EU Regulation (EC) 396/2005 (pesticide MRLs), EU Regulation 1169/2011 (Food Information to Consumers), and applicable Codex Alimentarius standards. Products are manufactured under BRCGS, FSSC 22000, HACCP, ISO 22000 and GMP-certified facilities.

Authorization

Report Prepared By	Manager Quality Assurance / R&D
Report Approved By	Factory Manager
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