SILK FOODS CEYLON

MANUFACTURING PROCESS

ISO 5807 Notation · BRCGS · FSSC 22000 · HACCP · ISO 22000 · GMP

Company Information

Manufacturer	Silk Foods Ceylon (Pvt) Ltd
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Document Information

Document No.	SFC/MFG/FR-PINTBC/2026/01
Process	Pineapple Dehydrated TBC Manufacturing Process (Raw Material → Packed Product)
Product	Pineapple Dehydrated TBC
Operation Type	Manufacturing — full in-house process per the QA-approved Process Flow Master Document
Standard	BRCGS, FSSC 22000, HACCP, ISO 22000, GMP
Date of Issue	31 March 2025
Revision	2026 V1.1
Revision Date	31 March 2025
Prepared By	Production & QA Team — Silk Foods Ceylon (Pvt) Ltd

Approved Process Flow

RM Receiving → Washing → Cutting/Slicing → Drying (≤60°C) → Moisture Check → Milling → Sieving → Magnetic separator → Packing → Labeling

Source: Process Flow Master Document (QA-approved)

Process Flow Steps — 10 Steps (ISO 5807 Notation)

#	Shape	Process Step	Description / Critical Limit	CCP?	Notes
1	TERMINAL	RM Receiving	—	—	
2	PROCESS	Washing	—	—	

3	PROCESS	Cutting/Slicing	—	—	
4	CCP	Drying (≤60°C)	—	✓ CCP	
5	DECISION	Moisture Check	—	—	
6	PROCESS	Milling	—	—	
7	PROCESS	Sieving	—	—	
8	CCP	Magnetic separator	—	✓ CCP	
9	PROCESS	Packing	—	—	
10	TERMINAL	Labeling	—	—	

Critical Control Points (CCPs) — Critical Limits

CCP	CCP 1 — Drying / Moisture Verification
Critical Limit	Tray dryer 55–60 °C, max 6 hours, IF moisture is found above the product spec at receipt. Final moisture to meet product-specific limit (see SPEC).
Monitoring	Continuous tray-dryer temperature log (chart recorder); final moisture test by ISO 939:2021 / AOAC 934.06 on each batch; supplier COA moisture verified on receipt.
Corrective Action	If moisture exceeds spec after one drying cycle: extend drying time by 2-hour increments. If still above spec after 3 cycles: quarantine batch and consult QA Manager.
Verification	QA Manager weekly review of temperature charts; annual third-party calibration of moisture analyser and chart recorder.
Records	Drying Log (DL-01), Moisture Test Record (MT-01), Calibration Certificate

CCP	CCP 2 — Magnet Separation (Ferrous Foreign-Matter Removal)
Critical Limit	Product passes over / through a high-intensity permanent magnet separator (≥ 8,000 Gauss / ≥ 0.8 Tesla surface flux). All ferrous foreign matter retained on the magnet. Magnet present, clean and correctly positioned before each batch.
Monitoring	Magnet presence, cleanliness and position checked at the start of every batch and at end of shift; any captured material recorded; surface flux (Gauss) verified at the scheduled calibration interval.
Corrective Action	If the magnet is found displaced, fouled or below required flux: stop the line, isolate all product since the last verified check, re-pass the affected product over the magnet, investigate the source and document the non-conformance.
Verification	QA Manager weekly review of the magnet-separation log; annual third-party flux-density (Gauss) calibration certificate.
Records	Magnet Separation Log (MG-01), Annual Gauss Calibration Certificate

ISO 5807 Shape Legend

- TERMINAL (oval) — Start / End point — begins or ends the process
- PROCESS (rectangle) — Operation or action step

- DECISION (diamond) — Quality checkpoint — Go / No-Go gate
- CCP (red highlight) — Critical Control Point — must monitor and record
- DOCUMENT (parallelogram) — Record creation — batch record, QC form

Authorization

Report Prepared By	Production Manager / QA Manager
Report Approved By	Factory Manager
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