

# PHILIPPINE NATIONAL STANDARD

PNS/BFAD 19:2008  
ICS 67.020

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**Recommended code of practice for the processing  
and handling of flour sticks (Pancit canton)**



**BUREAU OF PRODUCT STANDARDS**

<b>Contents</b>	<b>Page</b>
1 Scope .....	1
2 Definition of terms .....	1
3 Ingredients and packaging material requirements .....	3
4 Hygiene .....	4
5 Preparation and processing .....	7
6 Labeling .....	6
7 Quality assurance .....	7
8 Storage and transport of finished product .....	8
9 Laboratory control procedure .....	8
10 End product specifications .....	8

**Table**

1 Food additives for flour sticks or “pancit canton” as per BFAD Bureau Circular No. 016 s. 2006. Updated List of Food Additives .....	4
A.1 Standard values for bacteriological quality .....	9
A.2 Standard value for biological organisms for drinking water .....	9
A.3 Standard values for physical and chemical quality: aesthetic quality .....	9

**Annexes**

A Standard Parameters and Values for Drinking Water .....	9
B Standard for Iodized Salt .....	10
C Determination of Net Weight .....	13
D Codex Alimentarius Sampling plans for prepackaged foods (AQL 6.5) .....	14

**Foreword**

The Philippine National Standards for Flour Sticks (Pancit Canton) and Recommended Code of Practice for the Processing and Handling of Flour Sticks (Pancit Canton) are product standards being developed by the Commodity Working Group (CWG) composed of representatives from Department of Trade and Industry-Bureau of Product Standards (DTI-BPS), Department of Health-Bureau of Food and Drugs (DOH-BFAD), Department of Science and Technology (DOST) Testing Laboratory (Industrial Technology Development Institute-Standards and Testing Division (ITDI-STD) and Pancit Canton processors (Jeverps, Florence, Sodeska, Fitrite, Filchoice, Gem Food, Recipe Foods), with Food Processing Division (FPD-ITDI) as Secretariat.

The CWG analyzed commercial samples of the product. They visited different Pancit Canton Plants such as Florence Foods Corporation and the Festive Foods, both in Novaliches, Quezon City, 888 Food Products in Bulacan, Bulacan and Jeverps Food Products in Parañaque City. The draft Standard and Recommended Code of Practice was reviewed by the Food Standards Technical Committee (FSTC), before these were submitted to the BFAD for public consultation.

Posting at the BFAD website, [www.bfad.gov.ph](http://www.bfad.gov.ph), of the draft standard and recommended code of practice was made to solicit comments and suggestions from different stakeholders. Public consultation workshop was conducted in Metro Manila where the product is commonly produced.

The final drafts were forwarded to the Bureau of Agriculture and Fisheries Product Standards-Department of Agriculture (BAFPS-DA) for notification by the World Trade Organization Secretariat.

The final copy was submitted to the Bureau of Product Standards-Department of Trade and Industry (BPS-DTI) for adoption.

This Standard was developed not only to serve as guide for the assurance of safety and quality but also to make the products more competitive in the local and world market.

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**Recommended code of practice for the processing and handling  
of flour sticks (Pancit canton)**

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**1 Scope**

This Code of Practice is a set of recommended procedures that shall be adopted by processors, of fried flour sticks or "*pancit canton*", to enable their products to conform to the **Standards for Flour Sticks or "*Pancit Canton*" (PNS 18:2008)**.

This code provides a guide in the production, storage and handling of flour sticks or "*pancit canton*" necessary to maintain their quality from the receipt of ingredients in production up to the point of consumer purchase.

**2 Definition of terms**

For the purpose of this Code, the following definitions shall apply:

**2.1****antioxidant**

is a food additive that prolongs the shelf life of food by preventing/delaying the deterioration of its fat content that can result in the development of rancidity, other off-flavors and discoloration

**2.2****container**

means any form of packaging material, which completely or partially encloses the food (including wrappers). A container may enclose the food as a or types of prepackaged food when such is presented for sale to the consumer

**2.3****current good manufacturing practices (cGMP)**

a quality assurance system aimed at ensuring that products are consistently manufactured, packed or repacked or held to a quality appropriate for the intended use. It is concerned with both manufacturing and quality control procedures

**2.4****deep frying**

is cooking in hot oil that is enough to keep the food entirely immersed

**2.5****food**

any substance, whether processed, semi-processed or raw, which is intended for human consumption, and includes drink, chewing gum and any substance which has been used in the manufacture, preparation or treatment of "food" but does not include cosmetics or tobacco or substances used only as drugs

**2.6**

**food additive**

refers to any substance the intended use of which results or may reasonably be expected to result, or indirectly, in its becoming a component or otherwise affecting the characteristics of any food (including any substance intended for use in producing, manufacturing, packing, processing, preparing, treating, packaging, transporting, or holding food; and including any source of radiation intended for any such use), if such substance is generally recognized, among experts qualified by scientific training and experience to evaluate its safety, as having been adequately shown through scientific procedures to be safe under the conditions of the intended use (R.A. No. 3720)

**2.7**

**food standard**

is a regulatory guideline that defines the identity of a given food product (i.e. its name and the ingredients used for its preparation) and specifies the minimum quality factors and, when necessary, the required fill of the container. It may also include specific labeling requirements other than or in addition to the labeling requirements generally applicable to all prepackaged foods

**2.8**

**hazard analysis and critical control points (HACCP)**

is a preventive food quality management system, which identifies, evaluates and controls the hazards significant to food safety specific to a product. (Source: Administrative Order No. 2005-0018 Subject: Philippine National Standards on Ethnic Food Products)

**2.9**

**ingredient**

any substance including food additive, used as a component in the manufacture or preparation of a food and present in the final product in its original or modified form

**2.10**

**label**

includes any tag, brand, mark, pictorial, or other descriptive script, written, printed, marked, embossed or impressed on, or attached to the container

**2.11**

**labeling**

means any written, printed or graphic matter (1) upon any article or any of its container or wrappers and/or (2) accompanying the packaged food

**2.12**

**lot**

food produced during a period of time and under more or less the same manufacturing conditions indicated by a specific code

**2.13**

**moisture content**

the percentage weight of water in relation to the dry weight of the product

**2.14**

**packaging**

is the process of packing in a protective container, as part of the production cycle, applied to a bulk product to obtain the finished product. It consists of any material, including painted material, employed in the packaging of a product including any outer packaging used for

transportation and distribution. Packaging materials may either be primary or secondary depending on whether they are or not in direct contact with the food product itself

## 2.15

### **processed food**

shall refer to foods that have been subjected to some degree of processing (e.g. milling, drying, freezing, concentration and canning, etc), which partially or completely change the physico-chemical and/or sensory characteristics of the raw material

## 2.16

### **potable water**

water fit for human consumption and in which potability has been determined by health authorities cited in the Philippine National Standards for drinking water (PNS 991:1993 Agricultural and Other Food Products – Bottled Drinking Water Specifications)

## **3 Ingredients and packaging material requirements**

### **3.1 Ingredients**

#### **3.1.1 Basic ingredients**

- a. Wheat flour - fortified, prepackaged wheat flour, fit for human consumption as per **RA 8976 or the Philippine Food Fortification Act of 2000**. It shall be free from abnormal color, flavor, odor and living insects, and free from foreign matters and filth, including dead insects in amounts which may represent a hazard to human health.
- b. Potable water - water fit for human consumption and potability determined by health authorities cited in **Philippine National Standards for Drinking Water** or the **A.O. No. 18A s.1993** (Regulation on Bottled Drinking Water). (Annex A).
- c. Salt. - food grade quality salt that meets the purity requirements of standards for iodized salt as per **R.A. No. 8172 or An Act Promoting Salt Iodization Nationwide and for Related Purposes**. It shall be refined or unrefined solar evaporated salt in the form of white, coarse or fine crystals without any dirt or other foreign matter. It shall contain the prescribed level of iodine and purity (as sodium chloride) of at least 97% (Annex B).
- d. Cooking oil - shall be edible, refined and fortified vegetable oil as per **RA 8976 or the Philippine Food Fortification Act of 2000**.

#### **3.1.2 Optional ingredients**

All other ingredients used shall be of food grade quality and conform to all applicable standards, which may include, but not limited to the following: a) other flours and starches; b) fresh eggs or egg powder; c) fresh or powdered fruits and vegetables; and d) seasonings and condiments.

#### **3.1.3 Food additives**

Food additives when used shall be in accordance with the regulations established by the Bureau of Food and Drugs (BFAD) (Bureau Circular No. 016 s.2006. Updated List of Food Additives) and/or the Codex Alimentarius Commission. The food additives listed in Table 1, but not limited to, may be used for the manufacture of Flour Sticks or "*Pancit Canton*"

**Table 1 – Food additives for flour sticks or “pancit canton” as per BFAD Bureau Circular No. 016 s. 2006. (Updated List of Food Additives)\***

<b>Food additive</b>	<b>Max. use level</b>
<b>a. Acidity regulator</b>	
Sodium hydroxide **	GMP
<b>b. Antioxidant</b>	
Butylated hydroxyanisole (BHA)***	100mg/kg
Butylated hydroxytoluene (BHT)***	200 mg/kg
Tocopherol*	GMP
<b>c. Color</b>	
FD&C Yellow # 5 (Tartrazine) **	300 mg/kg
FD&C Yellow # 6 (Sunset yellow) ***	300 mg/kg
<b>d. Flour treatment agent</b>	
Phosphates (as sodium or potassium phosphates)***	2,200 mg/kg
<b>e. Raising agent/stabilizer</b>	
Sodium carbonate***	2,600 mg/kg
Potassium carbonate***	2,600 mg/kg
* Based on the Food Category System: ** 06.2 - Flours and starches *** 06.4.2 - Pre-cooked or dried pastas and noodles and like products	

All other food additives not included in the above list shall be allowed as carry-over, provided they are approved by the BFAD regulation and shall be in accordance to Section 5.2 of the “Principle Relating to the Carry-Over of Food Additives into Foods” (CAC/Vol.. 1 1991).

### 3.2 Packaging materials

The packaging materials should be appropriate for the product to be packed and for the expected conditions of handling during distribution and storage. These should provide the products adequate protection from contamination and should be sufficiently durable to withstand mechanical, chemical and thermal stresses encountered during processing and normal distribution. All packaging materials must be clean and free from defects that may affect the product or package integrity. These shall be stored in a clean and sanitary manner.

## 4 Hygiene

It is recommended that the product covered by the provisions of this code of practice be prepared and handled in accordance with the appropriate sections of the **Recommended International Code of Practice – General Principles of Food Hygiene (CAC/RCP 1 – 1969, Rev 4 (2003))** and/or the **BFAD A.O. No. 153 s. 2004 - Guidelines, Current Good Manufacturing Practices in Manufacturing, Packing, Repacking or Holding Food**, covering the plant facilities and operations requirement including the construction and layout of processing plant, hygienic facilities, equipment, utensils and working surfaces.

## 5 Preparation and processing

The production of Flour Sticks or “*Pancit Canton*” products is described from the receipt of raw materials up to the packing operations. The production process should be supervised by competent personnel with adequate technical training, experience and expertise.

### 5.1 Preparation of ingredients

#### 5.1.1 General requirements.

All ingredients must be of food grade quality and assured in suitable condition before use. Whenever applicable, certificates of analyses (COA) from ingredient suppliers shall be secured to confirm their suitability for processing. No ingredients, which have indications of deterioration, decomposition or contamination to an extent which renders them unfit for human consumption, shall be used for processing. Stored stocks of ingredients should be used on a first in–first out (FIFO) or first-to-expire first-out (FEFO) basis.

All ingredients not conforming to 3.1 (Ingredient requirements) shall be rejected.

#### 5.1.2 Receipt of basic ingredients

All basic ingredients must be carefully inspected before use and must meet the following quality requirements:

- a. Wheat flour shall be pre-packaged flour which is free from any abnormal color, flavor, odor, insect infestation, and extraneous matters or filth, including insect parts, in amounts which may present a hazard to human health;
- b. Potable water shall be obtained only from reliable sources, with adequate supply at all times. It should be clear and, free from any objectionable color, odor or taste;
- c. Salt shall be pre-packaged iodized refined or unrefined salt in the form of coarse or fine white crystals without any dirt, sand or other foreign matter; and
- d. Cooking oil shall be refined, edible, clear, pale yellow to water white and, free from any rancid odor and flavor.

#### 5.1.3 Receipt of optional ingredients

All optional ingredients shall be inspected before use. They must be packaged properly and free from any signs of quality deterioration, decomposition or contamination like excessive discoloration, mold growth, insect infestation, caking and presence of foreign matters.

### 5.2 Processing operations

#### 5.2.1 General requirements

The manufacture of flour sticks or “*pancit canton*” shall use standardized formulation and processes required to achieve the finished product quality as prescribed in Section 4.2 of the Standards for Flour Sticks or “*Pancit Canton*”. Any modifications introduced must be tested and validated prior to adoption in the commercial process.

#### 5.2.2 Processing operation requirements

- a. Weighing/measuring of ingredients. All ingredients shall be properly weighed separately using appropriately and regularly calibrated weighing scales.

- b. Mixing of ingredients. Pre-weighed basic and optional ingredients are mixed in an appropriate mechanical mixer until a dough is produced. Manual mixing may also be employed provided that the proper consistency of the dough is achieved.
- c. Sheeting/pressing. The dough is repeatedly passed thru a roller press to form a noodle sheets of desired texture and thickness.
- d. Slitting and cutting. The noodle sheets are passed into cutting rolls or slitters to form into strands, which are then cut into proper lengths by a cutter.
- e. Blanching/cooking. The noodle strands are blanched in boiling water for a specified period. The cooking water is maintained at constant temperature and monitored with a suitable thermometer or temperature recorder, preferably installed in the cooker. The volume of boiling water in the cooker should be kept sufficient to allow uniform cooking of the noodle strands.
- f. Washing and cooling. Immediately after cooking, the cooked noodle strands are washed and cooled in a water bath or running water.
- g. Weighing and molding. The cooled noodle strands are weighed and transferred into the noodle molder baskets. The weight of the strands filled into each molder approximates the desired final weight of the product. The shape of the molder may be square or round depending on the desired shape of the product. The molder baskets must preferably be made of stainless steel.
- h. Deep frying. The molded noodle strands are deep fried in hot cooking oil maintained at the optimum frying temperature. The frying process should start before the oil reaches the smoke point. The fryer should be equipped with a calibrated thermometer to monitor the oil temperature. A suitable antioxidant may be added to the frying oil to retard the onset of rancidity.
- i. Cooling. The fried noodles are immediately cooled to room temperature (28-30°C) while the excess oil is allowed to drip. It is important to cool the noodles quickly to prevent oxidation of the oil and onset of rancidity.
- j. Packing. The noodles are individually or bulk packed in appropriate packaging films or preformed bags. The weight of each package shall not be less than 95% of the declared net weight. During manual packing, care should be observed to prevent breakage of the fried noodles. Individually packed noodles are transferred in bulk packaging materials such as shipping cartons and plastic bags.

### **5.3 Coding of packed products**

Coding of packed products in sealed containers shall be made with indelible markers with information details of production, date, batch code, product code, the product line in which product is packed and other information necessary for product traceability. Whenever the container does not permit the code to be embossed or inked, the label shall be legibly perforated or otherwise marked, and securely affixed to the product package.

### **5.4 Post-process container handling**

Care must be exercised in the handling and distribution of packed retail or bulk packaged flour sticks or "*pancit canton*" so as to prevent mechanical damage like breakage of noodle strands.

## **6 Labeling**

All processed products shall be inspected before labeling and casing. All containers of packaged products shall be properly labeled. The label shall conform to current BFAD labeling requirements and shall contain the following information:

- a. The name of the product. The name of the product shall be "Flour Sticks" or "Pancit Canton". Other common names like "Wheat Flour Sticks", "Wheat Noodles", "Wheat



Flour Noodles”, “C(K)anton Noodles” or “*Panc(s)it* C(K)anton Noodles” may also be used, provided it is accepted in the country of distribution.

- b. The name and the address of the manufacturer, packer, distributor, importer, exporter or vendor of the food.
- c. The complete list of ingredients and food additives used in the preparation of the product in descending order of proportion.
- d. The net content by weight in the metric system. Other systems of measurement required by importing countries shall appear in parenthesis after the metric system units.
- e. The words “Best/Consume Before”/“Use by date” indicating end of period at which the product shall retain its optimum quality attributes at defined storage conditions.
- f. Lot identification marked in code identifying product lot.
- g. The words “Product of the Philippines” or the country of origin if imported.
- h. Additional requirements  
A pictorial representation of the product on the label should not mislead the consumer with respect to the product so illustrated

### **6.1 Labeling of non-retail, bulk containers**

The name of the product, lot identification code and the name and address of the manufacturer or packer shall appear in the container. However, the name and address of the manufacturer may be replaced by identification marks provided that such mark is clearly identified with accompanying documents.

## **7 Quality assurance**

### **7.1 Inspection of finished products**

All processed products shall be inspected and should pass the quality criteria prescribed in Section 4 of the Standards for Flour Sticks or “*Pancit Canton*” and the number of defectives, as defined in Section 5, in the lot examined must not exceed the acceptable number based on the appropriate sampling plan ((FAO/WHO Codex Alimentarius Sampling Plans for Prepackaged Foods - CAC/RM 42-1969, Codex Alimentarius Volume 13, 1994).

### **7.2 Record keeping**

Permanent and legible dated records of production batches, code marks and other pertinent details shall be kept concerning each load. Such records are essential as a check on processing operations.

Written records of all package examinations shall specify the code lot and the date of package inspections, the measurements obtained and all the corrective actions taken.

Records identifying initial distribution of the finished product to facilitate, if necessary, the segregation of specific food lots that may have been contaminated or otherwise unfit for intended use, shall be kept and maintained.

All process deviations involving failure to satisfy the minimum requirements of the process shall be recorded detailing those deviations and the actions taken

### **7.3 Hazard analysis and critical control points (HACCP)**

Appropriate HACCP plan must be developed for the product. Prior to the development of HACCP plan, establishments shall have developed, documented and implemented prerequisite programs based on BFAD's Current Good Manufacturing Practices (cGMP) and Hygiene Control. Guidelines for the Application of the Hazard Analysis Critical Control Point (HACCP) System (CAC/GL 18-1993) present the recommended sequence and document formats for the application of the HACCP systems.

## **8 Storage and transport of finished product**

Storage and transport conditions of the finished product shall be such that the integrity of the product container, and the safety and quality of the product are not adversely affected.

Cases and cartons must be thoroughly dry. They must be of proper size so that the containers fit snugly and are not subject to damage from movement within the case. They must be strong enough to withstand normal transport and distribution conditions.

Extreme temperature fluctuations, during storage and transport of the product must be avoided to prevent product deterioration.

## **9 Laboratory control procedures**

Each food processing establishment shall have access to laboratory analyses and control of both the processes used and the finished products. All food ingredients and food products declared unfit for human consumption by the laboratory shall be rejected.

Representative samples for each lot or batch shall be randomly taken to assess the safety and quality of the product.

The Microbiological laboratory shall be separated from the processing area. No pathogens shall be handled within the premises of the manufacturing plant.

Laboratory procedures for quality control of the processes and the product must follow recognized or standard methods for easy interpretation and recognition of the results.

## **10 End product specifications**

Appropriate methods shall be used for sampling analysis and determinations of Flour Sticks or "*Pancit Canton*" to meet the following specifications:

- a. To the extent possible in good manufacturing practices, the products shall be free from any objectionable characteristics;
- b. The product shall not contain any toxic substances originating from microorganisms and chemicals;
- c. The product shall be free from chemical pollutants in amounts which may represent hazard to health; and
- d. The product shall comply with the requirements set forth by the Bureau of Food and Drugs and the Codex Alimentarius Commission on Pesticide Residues and Food Additives.

**Annex A**  
**Standard parameters and values for drinking water**

**Table A.1 – Standard values for bacteriological quality**

Source and mode of supply	Bacteria	Standard value (no./100mL)
a. All drinking water supplies under all circumstances (Level I, II, III bottled water and emergency water supplies)	<i>E.coli</i> or thermotolerant (fecal) coliform bacteria	0
b. Treated water entering the distribution system	<i>E.coli</i> or thermotolerant (fecal) coliform bacteria	0
c. Treated water in the distribution system	<i>E.coli</i> or thermotolerant (fecal) coliform bacteria	0
	Total coliforms	Must not be detectable in any 100 mL sample. In cas of large quantities where sufficient samples were examined, it must not be present in 95% of samples taken throughout any 12-month period.

**Table A.2 – Standard value for biological organisms for drinking water**

Constituent	Permissible limit
Total count/ml	10

**Table A.3 – Standard values for physical and chemical quality: aesthetic quality**

Constituent maximum or characteristics	Level (mg/L)
Taste	Unobjectionable
Odor	Unobjectionable
Color	5 TCU
Turbidity	5 NTU
Aluminum	0.2
Chloride	250
Copper	1
Hardness	300 (as CaCO <sub>3</sub> )
Hydrogen sulfide	0.05
Iron	1
Manganese	0.5
pH	6.5 – 8.5
Sodium	200
Sulfate	250
Total dissolved solids	500
Zinc	5

(Sec.2 Philippine National Standards for Drinking Water, Department of Health, Manila.)

## Annex B

### Standard for iodized salt

#### B.1 Scope

This standard applies to iodized salt used as condiment or an ingredient in the preparation of food in households, food service and food manufacturing establishments.

#### B.2 Description

Iodized salt is food grade salt that contains the prescribed level of iodine. It shall be produced refined or unrefined (crude) salt obtained from underground rock salt deposits or by evaporation of seawater or natural brine. The finished product shall be in the form of solid crystal or powder, white in color, without visible spots of clay, sand, gravel or other foreign matter.

#### B.3 Iodization process

**B.3.1** Salt may be iodized with potassium iodate ( $KIO_3$ ) or potassium iodide (KI) by means of any of the following methods:

- a) dry mixing of salt in powdered form;
- b) dip feeding or spray mixing if salt is in crystal form; and
- c) submersion of ice crystals in iodated brine.

#### B.4 Essential composition and quality factors

To ensure the stability of iodine, salt to be iodized must conform with the following quality requirements:

Moisture, minimum	4 % for refined salt 7 % for unrefined salt
NaCl minimum	97 % dry basis
Calcium and magnesium, maximum	2 %
Water insolubles, maximum	0.2 %
Heavy metal contaminants	
Arsenic as As	0.5 mg/kg
Cadmium as Cd	0.5 mg/kg
Lead as Pb	2.0 mg/kg
Mercury as Hg	0.1 mg/kg

##### B.4.1 Naturally present secondary products and contaminants in raw salt

Notwithstanding the purity requirements in section 4.1. the raw salt may contain naturally secondary product, which are present in varying amounts depending on the origin and method of production of salt, and which are composed mainly of calcium, potassium, magnesium and sodium sulphates, carbonates, bromides and of calcium, potassium chlorides as well as natural contaminant may also be present in amounts varying with the origin and method of production of the salt.

**B.5 Labelling**

**B.5.1** Iodized salt for commercial distribution shall carry appropriate labelling in accordance with BFAD rules and regulations on labelling of prepackaged foods. Specifically, the following information shall be declared in every container of iodized salt whether in bulk or retail package.

**B.5.1.1** For locally produced iodized salt

- a) The name of the product, "IODIZED SALT", printed in bold capital letters
- b) Name and address of manufacturer
- c) Net weight
- d) Iodine compound used
- e) Chemical additives, e.g. anti-caking agents, emulsifiers
- f) Open date marking, e.g. "Best Before" or "Consume Before" Date
- g) Lot identification code (replacers must use □anufacturer's lot i.d code)
- h) Storage Instruction: STORE IN COOL DRY PLACE

**B.5.1.2** For imported Iodized salt

- a) same as 5.1.1 (a), (c) to (h)
- b) Name and address of Importer/Local Distributor
- c) Country of Origin

**B.5.2 Labelling of non-retail containers**

In the case of non-reail containers of at least 25 kg of iodized salt, the labelling information required in sections 5.1.1. (b), (d)or in 5.1.2 (b) may not be declared if such bulk packages are intended for delivery to distributors of food manufacturers/institutional users, providedd every shipment or delivery is accompanied by a document containing all information in 5.1.1. or 5.1.2.

**B.5.3 Iodine levels based on WHO recommendation**

In order to meet national needs, the prescribes levels of iodized salt be indicated below:

	Type of container	Packages
Sampling point	Bulk (>2 kg)	Retail (<2 kg)
Production site	70-150 g/kg	60-100 mg/kg
Port of entry*	70-150 mg/kg	60-100 mg/kg
Retail site	> 50 mg/kg	> 40 mg/kg
* For imported iodized salt, also at importer's/distributor warehouse		

**B.6 Food additives**

**B.6.1** All additives used, including KIO and KI, and shall be of food grade quality and shall conform to the specifications prescribed by JECFA of the Food Chemicals Codex.

**B.6.1.1** Anti-caking agents Maximum level in the final product

B.6.1.1.1. Coating agents; Carbonate, )

calcium/magnesium, magnesium oxide;	)	20 g/kg singly or in combination
Phosphate, tricalcium; Silicon dioxide, amorphous;	)	
Silicates, calcium , magnesium, sodium alumino or	)	
soddim or sodium calcium alumino	)	
	)	
B.6.1.1.2. Coating hydrophobic agents, aluminum,	)	10 mg/kg singly or in combination, expressed as {Fe(CN)}
calcium, magnesium, potassium or sodium salts of	)	
myristic, palmitic or stearic acid	)	
	)	
	)	
B.6.1.1.3 Crystal modifiers: ferrocyanide, calcium,	)	10 mg/kg
potassium combination or sodium	)	
	)	
	)	
	)	
<b>B.6.1.2. Emulsifiers</b>		10 mg/kg
Polysorbate 80		
<b>B.6.1.3 Processing Aid</b>	)	10 mg of residue/kg
Dimethylpolysiloxane	)	

**B.7 Packaging**

All iodized salt shall be packed in woven propylene bags, clean andd unused jute bags, or other non-porous material with a lining of high density polyethylene to ensure the retention of appropriate iodine level at the time of consumption.

**B.8 Storage, transport and display at retail**

In order to minimize avoidable losses of iodine, iodized salt shall not be exposed to any of the following conditions during storage, transport and display at retail outlets:

- a) direct sunlight or near source of strong light
- b) high temperature and humidity
- c) contamination with moisture, e.g. ran, flood, etc.
- d) contamination with dust or filth from the environment

Reference: Republic Act No. 8172: An Act Promoting Salt Iodization Nationwide and for Related Purposes and Its Implementing Rules and Regulations. Published by the National Nutrition Council, 1996.

**Annex C**  
**Determination of net weight**

**C.1 Apparatus**

Weighing balance (sensitivity: 0.10 gram).

**C.2 Procedure**

**C.2.1** Weigh the sample unit on its original sample packed container. This is the gross weight.

**C.2.2** Open and transfer the contents of each individual package. Wash the empty package and blot dry.

**C.2.3** Weigh out the washed empty package. This is the weight of the packaging material.

**C.2.4** Subtract the weight of the empty package from the gross weight. The resulting figure is the net weight of the individual package (net weight = gross weight – weight of packaging).

**C.2.5** Average the results from all package of a sample representing a lot. Report result as the average net weight of the product.

## Annex D

**Codex Alimentarius Sampling plans for prepackaged foods (AQL 6.5)  
(CAC/RM 42-1969)**

**Sampling plan no. 1 – Normal operations  
Inspection level 1, AQL 6.5)**

**1. Net weight: ≤ 1 kg**

Lot size (N)	Sample size	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
94,001 – 144,000	48	6
144,001 – 240,000	84	9
More than 240,000	126	13

**2. Net weight: >1 kg ≥ 4.5 kg**

Lot size (N)	Sample size	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	48	6
72,001 – 120,000	84	9
More than 120,000	126	12

**3. Net weight > 4.5kg**

Lot size (N)	Sample size	Acceptance number (C)
600 or less	1	1
601 – 2,000	13	2
2,001 – 7,200	21	3
7,201 – 15,000	29	4
15,001 – 24,000	48	6
24,001 – 42,000	84	9
More than 42,000	126	13



**Sampling plan 2 - In case of disputes  
Inspection level 2, AQL 6.5)**

**1. Net weight:  $\geq 1$  kg**

Lot size (N)	Sample size	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	48	6
94,001 – 144,000	84	9
144,001 – 240,000	126	13
More than 240,000	200	19

**2. Net weight:  $>1$  kg  $\geq 4.5$  kg**

Lot size (N)	Sample size	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	48	6
42,001 – 72,000	84	9
72,001 – 120,000	126	13
More than 120,000	200	19

**3. Net weight  $> 4.5$  kg**

Lot size (N)	Sample size	Acceptance number (C)
600 or less	13	2
601 – 2,000	21	3
2,001 – 7,200	29	4
7,201 – 15,000	48	6
15,001 – 24,000	84	9
24,001 – 42,000	126	13
More than 42,000	200	19

Source: Codex Alimentarius Sampling Plans for Prepackaged Foods - CAC/RM 42-1969, Codex Alimentarius Volume 13.

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.

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**B P S**

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