

No. : FS/84 Issue date : 25/10/2022 Revision : 02 Revision date : 03/02/2023 Page : 1 of 8	PT CHAROEN POKPHAND INDONESIA SAUSAGE PROCESSING PLANT  PRODUCT SPECIFICATIONS	PRODUCT NAME  HIESTA READY TO GO SAUSAGE ORIGINAL
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**A. PRODUCTION FLOW CHART**

**AGING MEAT PRODUCTION FLOW CHART**

```

      graph TD
        MEAT --> TUMBLING
        TUMBLING --> AGING
      
```

**SAUSAGE PRODUCTION FLOW CHART**

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      graph TD
        FORMULA --> CHOPPING_I[CHOPPING I]
        CHOPPING_I --> CHOPPING_II[CHOPPING II]
        CHOPPING_II --> CHOPPING_III[CHOPPING III]
        CHOPPING_III --> CHOPPING_IV[CHOPPING IV]
        CHOPPING_IV --> STUFFING
        STUFFING --> COOKING
        COOKING --> COOLING[COOLING DOWN  
IN COOLINGDOWN ROOM]
        COOLING --> PLASTIC_FILLING[PLASTIC FILLING]
        PLASTIC_FILLING --> DETECTING_METAL[DETECTING OF METAL]
        DETECTING_METAL --> SORTASI
        SORTASI --> READY[READY TO BE TRANSFER  
TO RETORT PLANT]
      
```

**Meat Temperature** : 0 - 5 °C  
**Aging meat formula** : Lihat Section B (FORMULATION PAGE 2)

Drum on : 15 - 30 menit  
 Drum off : 0 menit  
 Drum speed : 21 RPM  
 Total time : 15 - 30 menit  
 Vacuum : 0 in Hg (non vacuum)  
 Suhu pusat produk : maks 10 °C

4-12 hour in chill room (room temp. 0-5°C) covered with plastic

**Meat Temperature** : 0 - 5 °C  
**Lihat Section B (FORMULATION PAGE 2)**

CIKANDE	
Merk bowl cutter	CATO
Bowl Speed	3
Speed knife	1500 rpm
Time (minute)	2

CIKANDE	
Merk bowl cutter	CATO
Bowl Speed	3
Speed knife	3000 rpm
Time (minute)	5

CIKANDE	
Merk bowl cutter	CATO
Bowl Speed	3
Speed knife	1500 rpm
Time (second)	30

CIKANDE	
Merk bowl cutter	CATO
Bowl Speed	3
Speed knife	1500 rpm
Suhu adonan	14 - 16°C
Time (second)	30

STUFFER	
Berat mentah per 3 piece:	209 - 212 gram
Panjang per piece:	120 - 130 mm
Type casing:	Collagen 24 mm

SMOKEHOUSE FESSMAN				
Condition	Temp. (°C)	Time (minute)	RH (%)	Ct. Product (°C)
Drying I	50	10	20	-
Cooking	77-78	-	100	75-76
Drying IV	70	2	20	-

Suhu ruang cooling down : 6 - 7 °C  
 Core Temp. : maksimum 13°C  
 WIP produk (posisi produk tertutup plastik)  
 Waktu cooling 25 - 35 menit

**PVDC top dan bottom thermo**

Jumlah pc sosis/pack	1	pc
Target weight/pc	65	gram
Nett weight/pack	65 - 66	gram
Gross weight/pack	67 - 68	gram

**METAL DETECTOR**

Specimen	Size (mm)
SUS 316	2,5
Fe	1,5
Non Fe	2,0

Bocor  
 Seal Lipat  
 Mengembung  
 Kode Produksi dan Best before tidak sesuai (BB 6 bulan)

WIP dari packing ke transfer maks 4 jam

Keterangan :  
 Revisi 01 : 15/12/2022 : Update parameter mesin  
 Revisi 02 : 02/02/2023 : Update flow chart proses

R&D	TERKENDALI
CIKande	Controlled Copy No.14

RD 10/04

No. : FS/84 Issue date : 25/10/2022 Revision : 04 Revision date : 03/01/2023 Page : 2 of 8	PT CHAROEN POKPHAND INDONESIA SAUSAGE PROCESSING PLANT RETORT PROCESSING PLANT PRODUCT SPECIFICATIONS	PRODUCT NAME FIESTA READY TO GO SAUSAGE ORIGINAL
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**A. PRODUCTION FLOW CHART**

**RETORT PLANT**

**LAYERING**

1 Trolley /maksimum 7 tray. 1 Tray isi 300-330 pcs sosis  
 1 mesin Pasteurizing (Retort) 4 trolley maks 600 kg  
 Sosis ditata dengan aturan p x l = 50-55 x 6 pcs sosis

l = 6 pcs sosis



p = 50-55 pcs sosis

**PASTEURIZING**

Initial Temperature : 10 ± 2 °C  
 Tekanan Steam : 0.59 - 0.78 Mpa  
 Tekanan Air : 0.20 - 0.25 Mpa

RETORT MACHINE			
Application Steps	Time (Mnt)	Temp.(°C)	Pressure (Mpa)
1. Water Injection	1'	85 °C	0.049
2. Up Temperature	4'	90 °C	0.049
3. Pasteurisasi	29'	90 °C	0.049
4. Hot Water Recycling	2'	-	0.049
5. Cooling Water Injection	3'	-	0.049
6. Cooling Constant Temp.	10'	-	0.049
7. Raw cooling water	-	-	-
8. Pressure Discharge	-	-	-

Parameter sensori produk setelah keluar dari Chamber Machine

Sortasi : Lepas vacuum dan Pecah Seal

Chill or frozen condition

**READY TO BE TRANSFER TO SAUSAGE PLANT**

**SAUSAGE PLANT FREEZING**

Ct ≤ (- 18 °C)

**BOX PACKING**




Inner box		
Contains	: 12	pcs sausage
Nett weight	: 804 - 816	gram/inner box
Gross weight	: 846 - 858	gram/inner box
Outer box		
Contains	: 6	Inner boxes
Nett weight	: 5.076 - 5.148	gram/inner box
Gross weight	: 5.445 - 5.517	gram/inner box

Temp. : (- 18 °C)  
 Best before 6 months from production date

**FROZEN STORAGING**

Keterangan :  
 Revisi 01 15/12/2022 Update parameter mesin  
 Revisi 02 02/02/2023 Update flow chart proses  
 Revisi 03 16/02/2023 Update kapasitas per chamber dan proses pasteurisasi  
 Revisi 04 01/03/2023 Update jenis sortasi setelah proses pasteurisasi dan proses pasteurisasi

R&D TERKENDALI  
 CPM Cikande Controlled Copy No. 7

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No. : FS/84 Issue date : 20/10/2022 Revision : 00 Rev. Date : - Page : 3 of 8	PT CHAROEN POKPHAND INDONESIA SAUSAGE PROCESSING PLANT  PRODUCT SPECIFICATIONS	PRODUCT NAME :  FIESTA READY TO GO SAUSAGE ORIGINAL
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**B. FORMULASI**

**1. Komposisi Raw Material**

**Formula**

**AGING MEAT**

SBL minced 8 mm	96,000	Kg
Water	2,880	Kg
Ice	6,720	Kg
N 80RTG A (x 12 bag)	1,176	Kg
<b>Total</b>	<b>106,776</b>	<b>Kg</b>

Note : waktu tumbling 15-30 menit untuk 96kg SBL minced (6x formula aging meat)  
 Jadi 1x tumbling bisa untuk 3x chopping (1x chopping butuh 2 bag premix)

**Komposisi - 1** (chopping I)

Beef C185 minced	22,600	Kg
SBB minced	40,800	Kg
Skin minced	30,000	Kg
Emulsi skin	8,200	Kg
Ice	13,160	Kg
Bawang merah minced	0,800	Kg
N 80RTG B (x 2 bag)	2,556	Kg
A 80RTG C (x 2 bag)	6,340	Kg

**Komposisi - 2** (chopping II)

Tapioka starch (TSN)	4,800	Kg
Ice	15,000	Kg
Blackpepper broken/coarse/pecah	0,180	Kg
Parsley flake	0,200	Kg

**Komposisi - 3** (chopping III)

SBL Aging meat	16,000	Kg
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**Komposisi - 4** (chopping IV)




N O 80BRAT (x 2 bag)	0,560	Kg
AR A (Purasal S)	0,840	Kg
AR E (Purac FCC88)	0,060	Kg
<b>TOTAL</b>	<b>162,096</b>	<b>Kg</b>

Note premix :

1. Huruf "N" : Premix Menandakan Premix tidak mengandung bahan Allergen  
 2. Huruf "A" : Premix Menandakan premix mengandung bahan Allergen

\*Tanpa Revisi

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RD 10/04

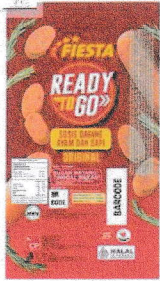

No. : FS/84 Issue date : 25/10/2022 Revision : 01 Rev. Date : 15/12/2022 Page : 4 of 8	PT CHAROEN POKPHAND INDONESIA SAUSAGE PROCESSING PLANT  PRODUCT SPECIFICATION	PRODUCT NAME :  FIESTA READY TO GO SAUSAGE ORIGINAL
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**C. PACKAGING**

**1. Plastic PVDC**




READY TO GO 6SG :

- Material : PL BOTTOM RTG TRANSPARANT PP/PVDC/PA CO-EX  
PL TOP RTG FIESTA SOSIS ORIGINAL 6SG PP/PVDC/PE 7C
- Dimensi : 423mm x 600m x 120 mc (bottom)  
400mm x 600m x 90 mc piilch 300mm (top)
- Stamp :
  - Kode daerah/Lokasi Produksi**
    - SRG : Plant CPI Food Cikande, Serang
    - LBP : Plant CPI Food Medan, Deli serdang (Lubuk Pakam)
    - SOR : Plant CPI Food Bandung, Sororang
    - SLT : Plant CPI Food Salatiga
    - SDA : Plant CPI Food Berbek, Sidoarjo
    - MJK : Plant CPI Food Ngoro, Mojokerto
    - TAB : Plant CPI Food Bali, Tabanan
    - SGN : Plant CPI Food Sragen, Jawa Tengah
    - MJL : Plant CPI Food Majalengka
    - MKS : Plant CPI Food Mkasar
    - PLG : Plant CPI Palembang
    - PWT : Plant CPI Food Banyumas
    - KWG : Plant CPI Food Karawang
    - BDW : Plant CPI Food Bondowoso
    - PML : Plant CPI Food pemaalng
  - Kode Produksi : YMDD L NN XZ P**
    - Y : Tahun Produksi (A : 2010, B : 2011, dst)
    - M : Bulan Produksi (A : Jan, B : Feb., Dst)
    - DD : Tanggal produksi
    - L : Lokasi 0 = Eksternal ; 1 = Cikande ; 2 = Surabaya ; 3 = Salatiga ;  
5 = Bali ; 6 = Medan ; 7 = Sidoarjo (Bebek) ; 8 = Bandung ;  
9 = Karawang ; O = Cikande SH2 ; A = Banyumas ;  
B = Palembang ; C = Makassar ; D = Majalengka ;  
E = Sragen ; F = Bondowoso ; G = Pemaalng ; H = Madiun
    - NN : No urut Adonan (01 - 99)
    - X : Grup Produksi
    - Z : Grup Packing
    - P : Procces Type
  - Best before : DD MM YYYY**  
**6 months setelah tanggal produksi**
    - Dua digit pertama : Tanggal Best before
    - Dua digit kedua : Bulan Best before
    - empat digit ketiga : Tahun Best before
  - Contain Allergen : soybean, milk, egg  
May Contain Allergen : Peanut, Fish, Celery, Crustaceans, Sesame, wheat
  - Barcode : 8993207 223131
  - Lay out packaging dan QR Code

R&D TERKENDALI  
 CPI Cikande Controlled Copy No. 14

Keterangan :  
 Revisi 01 15/12/2022 Penambahan keterangan dimensi dan material packaging  
 \*Tanpa Revisi

Prepared by :	Acknowledge by :	Approved by :
		
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No. : FS/84	PT CHAROEN POKPHAND INDONESIA	PRODUCT NAME :
Issue date : 25/10/2022	SAUSAGE PROCESSING PLANT	FIESTA READY TO GO
Revision : 02		SAUSAGE ORIGINAL
Rev. Date : 01/03/2023		
Page : 5 of 8	PRODUCT SPECIFICATION	

## C. PACKAGING

### 2. INNER BOX

READY TO GO 65G : IC RTG FIESTA SOSIS ORIGINAL 65GX12 PCS

∞ Material : Ivory 350GSM 6C Laminating Glossy

∞ Dimensi : 140 x 90 x 145 mm

∞ Stamp : ∞ Kode daerah/Lokasi Produksi

SRG : Plant CPI Food Cikande, Serang  
LBP : Plant CPI Food Medan, Deli serdang (Lubuk Pakam)  
SOR : Plant CPI Food Bandung, Soreang  
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BDW : Plant CPI Food Bondowoso  
PML : Plant CPI Food pemalang



∞ Kode Produksi : YMDD L NN XZ P

Y : Tahun Produksi (A : 2010, B : 2011, dst)  
M : Bulan Produksi (A : Jan, B : Feb., Dst)  
DD : Tanggal produksi  
L : Lokasi 0 = Eksternal ; 1 = Cikande ; 2 = Surabaya ; 3 = Salatiga ;  
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NN : No urut Adonan (01 - 99)  
X : Grup Produksi  
Z : Grup Packing  
P : Proses Type

∞ Best before : DD MM YYYY

6 months setelah tanggal produksi

Dua digit pertama : Tanggal Best before  
Dua digit kedua : Bulan Best before  
empat digit ketiga : Tahun Best before

∞ Barcode : 8993207 230016

∞ Lay out



Keterangan :

Revisi 01 15/12/2022 Penambahan keterangan dimensi dan material inner carton  
Revisi 02 01/03/2023 Penambahan barcode pada inner box

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**C. PACKAGING**

**2. CARTON BOX**

READY TO GO 65G : MC FIESTA RTG ISI 6 BOX

∞ Material : K150/M125X3/K150 BC/F GLUE 1C

∞ Dimensi : 435 x 195 x 150mm

∞ Printing : **FIESTA RTG SAUSAGE 65 G**

∞ Stamp : ∞ **Kode daerah/Lokasi Produksi**

SRG : Plant CPI Food Cikande, Serang  
LBP : Plant CPI Food Medan, Deli serdang (Lubuk Pakam)  
SOR : Plant CPI Food Bandung, Soreang  
SLT : Plant CPI Food Salatiga  
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BDW : Plant CPI Food Bondowoso  
PML : Plant CPI Food pemalang

∞ **Kode Produksi : YMDD L NN XZ P**


Y : Tahun Produksi (A : 2010, B : 2011, dst)  
M : Bulan Produksi (A : Jan, B : Feb., Dst)  
DD : Tanggal produksi  
L : Lokasi 0 = Eksternal ; 1 = Cikande ; 2 = Surabaya ; 3 = Salatiga ;  
5 = Bali ; 6 = Medan ; 7 = Sidoarjo (Bebek) ; 8 = Bandung ;  
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E = Sragen ; F = Bondowoso ; G = Pemalang ; H = Madiun  
NN : No urut Adonan (01 - 99)  
X : Grup Produksi  
Z : Grup Packing  
P : Proses Type

∞ **Best before : DD MM YYYY**




**6 months setelah tanggal produksi**

Dua digit pertama : Tanggal Best before  
Dua digit kedua : Bulan Best before  
empat digit ketiga : Tahun Best before

∞ Lay out



Keterangan :  
Revisi 01 15/12/2022 Penambahan keterangan dimensi dan material inner carton  
\*Tanpa Revisi

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D. STANDAR PRODUK

1. Standar Kimia

Kadar air : 59 - 68 %

pH : 6 - 6.6

Aw : 0.91 - 0.92

Salt content : 1.1 - 1.9 %

2. Standar Mikrobiologi

ALT : max 1,0 x 10<sup>4</sup> CFU/g

Enterobacteriaceae : max 1,0 x 10<sup>1</sup> koloni/g


Salmonella : negatif/25 g

Staph. aureus : max 1,0 x 10<sup>2</sup> koloni/g

3. Allergent : Soybean, egg dan milk


4. Standar bentuk

a. Bentuk OK






Bentuk lurus, tidak bengkok,  
panjang sesuai standar yang ditetapkan (12-13 cm) .

b. Bentuk Toleransi


















Kondisi ujung sosis yang masih OK dengan syarat sebagai berikut :  
1. bagian ujung sosis yang casingnya terbuka maks 2x1 cm  
2. casing terbuka bukan karena adanya bagian sosis yang terpotong (tercongel)

Keterangan :  
Revisi 01 14/03/2023 Penambahan standar ujung sosis dengan kategori toleransi OK  
Standar kimia update

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RD 10/04

No. : FS/84 Issue date : 25/10/2022 Revision : 01 Rev. Date : 15/03/2023 Page : 8 of 8	PT CHAROEN POKPHAND INDONESIA SAUSAGE PROCESSING PLANT  PRODUCT SPECIFICATION	PRODUCT NAME  FIESTA READY TO GO SAUSAGE ORIGINAL															
<div>4. Standar bentuk</div> <div>b. Bentuk Toleransi</div> <div><div></div><div><div>R&amp;D</div><div>TERKENDALI</div><div>CPI Cikande</div><div>Controlled Copy No. 14</div></div></div> <div>Bentuk lurus, panjang sesuai dengan standar (12-13 cm), sedikit melengkung di bagian ujung sosis akibat menempel pada stick pada saat proses pencetakan.</div> <div>c. Bentuk Riject</div> <div><div></div><div></div></div> <div><div>Bentuk lurus, panjang tidak sesuai standar yang ditetapkan (&lt;12 cm atau &gt;13cm)</div><div>Sosis gagal twisting</div></div> <div><div></div><div></div></div> <div><div>Sosis tidak terpotong sempurna</div><div>Bentuk bengkok, panjang kurang dari standar (&lt;12 cm) Bentuk bengkok, panjang lebih dari standar (&gt;13 cm)</div></div> <div></div> <div>Kondisi ujung sosis yang tidak OK/riject dengan syarat sebagai berikut : 1. bagian ujung sosis yang casingnya terbuka lebih dari 2x1 cm 2. casing terbuka karena adanya bagian sosis yang terpotong (tercongkel)</div> <div>Keterangan : Revisi 01      15/03/2023      Penambahan standar ujung sosis dengan kategori toleransi OK</div> <table><tr><td>Prepared by :</td><td>Acknowledge by :</td><td>Approved by :</td></tr><tr><td></td><td></td><td></td></tr><tr><td>Agatha Dewi. C</td><td>Ria Wijayanti</td><td>Cynthia Dewi Adikara</td></tr><tr><td>PD Spv.</td><td>PD Manager</td><td>HEAD PDQC-R&amp;D</td></tr><tr><td>Date : 15/03/2023</td><td>Date : 15/03/2023</td><td>Date : 15/03/2023</td></tr></table>			Prepared by :	Acknowledge by :	Approved by :				Agatha Dewi. C	Ria Wijayanti	Cynthia Dewi Adikara	PD Spv.	PD Manager	HEAD PDQC-R&D	Date : 15/03/2023	Date : 15/03/2023	Date : 15/03/2023
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