

- metering, 245
- pawl pumps, 305
- positive displacement piston pumps, 306
- progressive cavity (mono) pumps, 305
- screw pumps, 304
- sliding vane pumps, 303
- purchasing, 456, 662, 669
- purple beans, 40, 187, 533 *see also* cut test
- pyrazines, 105, 194–198, 201
- pyridines, 196
- pyrometer, 360, 565
- pyrrols, 196
- quality control/assurance, 532, 584, 594, 651
- quantitative ingredients declaration (QUID), 692
- quinones, 23
- radiation, 52, 367, 395
- radio frequency identification (RFID), 557
- raffinose, 73
- Rainforest Alliance, 19, 32, 489
- raisins, 332, 434, 437
- rancidity, 108, 550–551, 553, 622, 644
- Readco Kurimoto, 409
- rebaudioside, 519
- recall, 598, 608, 611, 614
- recipes
 - chocolate and non-chocolate coatings & tablets, 492
 - lauric coatings, 175
 - milk crumb, 136
 - non-lauric coatings, 179
 - supercoatings, 174
- reducing sugars, 114, 195, 537
- refinement, 8
- refiner-conche, 81, 121, 142, 544 *see also* Hamburg Dresdner Maschinenfabriken
- refining, 544 *see also* rolls, refiner
- refining, two-stage, 65, 77, 231, 232
- regulations *see also* legislation
 - international standards for chocolate manufacture, 675–676
 - serving size/portion control, 648
- relative humidity
 - chocolate, 177, 308
 - cocoa, 30, 69
 - conche, 243, 261
 - measurement, 570
 - milk crumb, 149–150
 - mould conditioning, 372
 - panning, 443, 445
 - probiotic bacteria, 98
 - sugar, 76–77, 80
- relaxation times (in NMR), 295, 588
- release lacquer, 643–644
- rennet, 105
- Republic of Ireland, 711
- resistant polysaccharide (resistant oligosaccharide), 85
- retail, 61, 467, 470–472, 532, 630, 658, 668
- retronasal flavour release, 208
- rework, 417, 450–455, 582, 603, 612, 615
- Reynolds number, 329
- rheology, 220, 230, 234, 269, 282 *see also* viscosity
- riboflavin, 114, 523
- Richard Frisse GmbH, 251, 256, 257, 262
- Rittinger's Law, 219
- road tankers, 308
- roast *see* roasting
- roasted, 186, 189, 190, 194
- roaster, 56–59, 194, 537, 539
- roaster-drum, 56, 57
- roasting
 - artisan chocolate manufacture, 463, 495
 - cocoa bean blending, 42
 - cocoa beans, 54–58, 193, 537–539, 564
 - cocoa liquor/cocoa mass, 193, 409
 - cocoa nib, 54–58, 193, 539
 - flavour development, 195–200
 - Salmonella* control, 35, 56, 610
- Robinson test, 552
- robotic packing, 425
- rodents, 611
- Rodolph Lindt, 251, 252
- roll coverage, 230, 576, 578, 580
- roller dried milk powder, 366, 375, 384, 391, 396
- roller, licking, 366, 374, 384, 391, 398
- roller refiners, 52, 228, 544, 576
- roll refiner-2 roll, 6, 77, 218, 231
- roll refiner-5 roll, 228–230, 244, 245, 569, 575
- roll refining
 - CBR coatings, 179
 - chocolate with high cocoa solids content, 205, 231
 - milk powder, 226
 - no-added sugar chocolate, 97, 232
 - sugar, 79, 80, 203

- rolls, refiner, 52, 228, 544, 576
- rotary conches, 251
- Rowntree, 135, 418, 655, 659
- Royal Duyvis Wiener, 255, 260–266, 269
- RUMBA, 267–268
- Russia, 493, 655, 660, 690, 696
- saccharose, 72
- Sacher Torte, 502
- safety
 - allergen hazards, 614, 617
 - cocoa, 35–37, 41, 599
 - Food Safety Management systems, 598
 - Food Safety Modernization Act, US FDA requirements, 533
 - foreign matter, 582, 600
 - HACCP, 468–469, 599
 - microbiological safety of chocolate
 - products, 611
 - packaging, 646, 651
 - shelf life, 550
- Salatrim, 181, 729
- Salmonella*
 - cocoa powder, 68–69, 542
 - control of water and cleaning
 - processes, 612
 - food poisoning outbreaks & chocolate, 608
 - in other ingredients, 611
 - personal hygiene and pest management, 611
 - raw cocoa beans, 35, 608
 - roasting cocoa beans, 56, 59, 610
 - survival in chocolate, 69, 607, 610
- sal oil, 166–169
- salt, 496, 693
- Samoa, 10
- Sanchez cocoa, 188
- sand, 69, 231, 535, 539
- Savy Jeanjean et Cie, 383
- scraped-surface heat exchanger, 147, 328, 336, 339
- sealants, 444, 607, 652
- sealing, 442–445, 552, 623, 631, 643–644
- seasonal, 118, 469, 626, 628, 663
- seeding, 317–318, 326, 341–348
- SeedMaster, 343–352
- seed tempering, 317, 349, 476
- sensors
 - 3-D sensors for imaging surfaces, 559
 - pressure sensors, 569
 - production monitoring, 575, 580
 - RFID sensors, use with chocolate
 - moulds, 557
 - temperature sensors, 564–565
- sensory effects in chocolate of
 - grinding above the glass transition
 - temperature, 227
 - lactose, 114
 - particle size, 206, 208, 237
 - stale milk powder, 206
 - sugars and bulk sweeteners, 93
- sensory evaluation
 - chocolate & cocoa products, 509–519
 - cocoa beans, 42, 197
 - sugars and bulk sweeteners, 92
- shakers, 358, 377, 418
- shea oil, 165–166
- shear
 - in conche design & development, 251–271
 - elongational shear, 247–248
 - in generation of cooked flavour in conches, 247, 250
 - shear mixing, 245–247
 - shear thinning, 277
- shear rate
 - conche design implications, 246
 - definition, 245, 276
 - laminar and turbulent flow, 300
 - measurement, 278–288
 - moulding and depositing chocolate, 278
 - particle size distribution, 234
 - PGPR, 234
 - tempering, 324, 326, 328–329
 - viscosity of molten chocolate, 277
- shear stress
 - definition, 276, 299
 - regimes, 234
 - tempering, 325, 329, 339
 - yield value, 277–278, 289–296
- sheen, 397, 640
- shelf life
 - artisanal chocolates, 465
 - best before labelling, 693
 - cocoa butter, 65, 541
 - cocoa powder, 69
 - dairy ingredients, 115
 - definition, 550
 - determination, 553
 - inclusions in chocolate, 462
 - milk chocolate, 206