



Associated Milk Producers, Inc.
 Cheese Package & Process Division
 301 Brook Street • PO Box 240
 Portage, Wisconsin 53901

**PASTEURIZED PROCESS
 SWISS CHEESE
 160 slice**

Prepared by: Nick Voss
 Revised: 09/15/2009

Approved by: Don Weideman
 Supersedes: 02/11/2008

Regulations/General:

This product shall comply with all current requirements of the Code of Federal Regulations, Food and Drugs, 21CFR133, Cheese and Related Cheese Products and 21CFR110 Good Manufacturing Practice (GMP's).

Packaging/Temperature:

This product shall be wrapped in a polypropylene film and heat sealed. Product shall be shipped and stored at a temperature of 35-40° F

Shelf Life/Coding:

Open freshness date – 180 days from date of pack
 Sell by – MMM DD YY, line, blend, shift (variations occur due to customer requirements)
 Shelf life – based on unopened product, continuously maintained at 35-40° F

Chemical/Physical & Microbiological:^{1,2}

CHEMICAL/PHYSICAL	
%Moisture ^{15.110}	≤ 44
%Fat on Dry Basis (F.D.B). ^{15.080}	≥ 43
pH. ^{15.020}	5.3 – 6.0
%Salt ^{15.050}	1.6 – 2.1
Color NCI (Nat'l Cheese Institute)	1-2
Melt (at 400° F for 5 minutes)	≥ 3

MICROBIOLOGICAL	
Yeast/Mold ^{8.110}	< 1000 cfu/g
Coliform ^{7.020 & 7.070}	< 100 cfu/g
*E. coli ^{7.020 & 7.050}	Negative (to test)
*Coag.+ Staph ^{5.050}	Negative (to test)
*Salmonella/Listeria ^{5.020-5.040}	Negative (to test)

1- Methods: APHA – Standard Methods for the Examination of Dairy Products – 17th Ed.
 2- Typical Analysis
 *- Not routinely performed on cheese made for the commodity market.

Physical:

This product shall possess a clean, nutty Swiss-like flavor, medium-firm body and not break or stick to other slices when peeled.

Loaf/Slice Characteristics:

STYLE	LOAF 3 # (1362g) 5 # (2270g)					SLICE (approximate)				
	L"	x	W"	x	H"	Wt	L"	x	W"	Wt
Pullman	12	x	3.25	x	3.5	5#	3	x	3	.5oz / 14g

INGREDIENTS: SWISS CHEESE (MILK, CHEESE CULTURES, SALT, CALCIUM CHLORIDE, ENZYMES), WATER, CREAM, SODIUM CITRATE, COLOR ADDED, ENZYME MODIFIED CHEESE, SALT, SORBIC ACID (ADDED AS PRESERVATIVE), SOY LECITHIN (NON-STICKING AGENT)

NUTRITION FACTS

Serving Size: 2 slices (28g)
 Servings per package: 80

Amount per serving		% Daily Value*
Calories	100	Calories from Fat 70
Total Fat	8g	12%
Saturated Fat	5g	24%
Trans Fat	0g	
Cholesterol	25mg	8%
Sodium	420mg	18%
Total Carbohydrate	2g	1%
Dietary Fiber	0g	0%
Sugars	1g	
Protein	5g	

Vitamin A 8% • Vitamin C 0%
 Calcium 15% • Iron 0%

*Percent Daily Values are based on a 2,000 calorie diet. Your daily values may be higher or lower depending on your caloric needs.

	Calories:	2,000	2,500
Total Fat	Less than	65g	80g
Sat Fat	Less than	20g	25g
Cholesterol	Less than	300mg	300mg
Sodium	Less than	2,400mg	2,400mg
Total Carbohydrate		300g	375g
Dietary Fiber		25g	30g

Calories per gram:
 Fat 9 • Carbohydrate 4 • Protein 4

Allergens: milk, soy lecithin

Kosher: No