



## Code of Labelling/Raw Materials (IRMA/CoL)

In Europe, the purchasers of fruit juice concentrates, purees etc. have complained for a long time that no international standards exist regarding the design and content of the labels on drums, etc. The situation is very complex, and confusing and causes many problems concerning the control of incoming goods at the bottlers and blending stations. Unintentionally, this has resulted in the incorrect utilisation of raw materials. The resulting issues have had to be followed-up by SGF/IRMA.

The SGF therefore decided to look for a “pro-active” and “problem avoiding” approach and set up a working group, which has elaborated the “Code of Labelling, Raw Materials” (IRMA/CoL). This “Code” has become a mandatory component of the rules of the control system. It is in the interests of all raw material producers and users that the Code is implemented.

## **1.0 INTRODUCTION**

- 1.1 All the various labels, designed by manufacturers, have the same objective. They all seek to inform the user. Each manufacturer hopes the information they are providing to their customer is clear and simple to understand. In the event of a problem they expect the user to provide them with all the correct data to enable any particular delivery to be identified.
- 1.2 Unfortunately the situation is not so simple when seen from the user's point of view. A large production facility can be faced with a bewildering array of different label designs, each with their own style of lot number, batch number, product number, date code, factory number etc.
- 1.3 The information that should be recorded for traceability purposes is often not clear.
- 1.4 Another common example of ambiguous information that appears on labels is the field "date". Is it the date the material was produced or blended? Is it the date the material was filled or dispatched? Is it a use by or best before date? On some labels it is specified, on others it is not.
- 1.5 Is the label itself fit for purpose? Does it fall off in the freezer? If it gets wet does it become illegible? Are parts of the label hand written?
- 1.6 Clarity of information is also important for documentation. For example, if several documents accompany a raw material delivery, which of the documents' many numbers are important for traceability purposes?

## **2.0 PURPOSE**

- 2.1 The purpose of this code is to specify and standardise all the important aspects of labelling:
  - sizes of labels
  - clarity and sizes of the lettering
  - minimum quantity of information that should be provided
  - suitable and unambiguous field names
  - water resistance
  - resistance to removal during transit and storage, especially at low temperatures
  - where and how they should be attached
- 2.2 It is also concerned with the "field names" used in the documentation that accompanies the delivery. Goods delivered in bulk are often not labelled as such but rely heavily on the accompanying paperwork for their identity and traceability

## **3.0 SCOPE**

- 3.1 This code of practice is applicable to labelling and documentation used to identify raw materials within the fruit juice industry.  
Specifically:
  - (a) the label that is attached directly to the primary container of the raw material; the label that is the source of information to the final end user – i.e. the person who is opening the drum , bottle or case etc.
  - (b) documentation that accompanies raw material deliveries

## 4.0 **FIELDS**

4.1 As a minimum, all of the following 11 fields must be present on ONE label

**Produced By**  
**Product**  
**Additives**  
**Product Code**  
**Brix**  
**either Ratio or Acidity**  
**Country of Origin**  
**Traceability Data**  
**Storage**  
**Fill Date – d/m/y**  
**Net Weight or Net Contents**

4.2 The fields must be identified using only these specified field names.

4.3 All the fields must contain information. If, for example, a product does not have a product code, the "Product Code" field should contain the words NOT APPLICABLE or N/A . It should not be left blank

4.4 The label is not restricted to the fields detailed above, additional fields may be incorporated as necessary. E.g. USE BY and GROSS WT.

4.5 **Produced By:** The name of the company that produced or blended the product. It should not be the name of an agent or other 3rd party acting on behalf of the producer.

4.6 **Product:** A full description of the product is required This will be

- the legal name, where one exists, or
- the name agreed between the buyer and the seller, or
- the name usually associated with that product.

Attachment 1 contains details of recommended words, Any number of words from each of the 5 columns can be used e. g.

- frozen concentrated orange juice
- concentrated, clear apple juice plus aroma

The description does not have to contain a word (or words) from each of the columns but all the words used should be in column order. E.g. frozen s/s blackcurrant juice NOT blackcurrant juice frozen s/s

If more than one fruit is present then the word "mix" should form part of the description

4.7 **Additives:** Any material, added to the product, which is specified as an additive in the "Council directive 89/107/EEC and 95/2/EC on food additives: Council Directive 94/35/EC on colours in foods: 88/388/EEC on flavourings in foods: 94/36/EC on sweeteners in foods and any subsequent amendments there of. Any other added materials e.g. sugar ,salt, vitamin C, lemon juice

This field is to be used to identify additions to authentic fruit juices – as defined in the AIJN Code of Practice. It is not applicable to products such as compounds and bases. i.e. it is not meant to record a list of ingredients in these types of products

- 4.8 **Product Code:** Recommendation: Any combination of letters and /or numbers, devised by the processor, to define the product.
- 4.9 **Brix:** The data in this field should include either the word “**corrected**” or “**uncorrected**” as appropriate.
- 4.10 **Ratio or Acidity:** The field should be labelled with either the word “ratio” or “ acidity”, whichever is appropriate for the fruit in question. It is recommended to include fields for ratio and acidity. If an acidity value is quoted, both the units and how the acidity is being expressed must be included.  
 e.g. 15.0 g/l as anhydrous citric acid (ACA)  
 4.3 g/kg as citric acid monohydrate (CAM)  
 5.9 g/l as malic, as tartaric etc
- 4.11 **Country of Origin:** The name of the country where the product was manufactured  
 Oranges processed into juice concentrate in Brazil but drummed in Holland would be “Country of Origin – Brazil”  
 If the product is a blend from more than one country the word “Blend” will be used
- 4.12 **Traceability Data:** Any combination of letters and/or number(s) that identifies the specific product and batch. In the event of a problem, the data in this field will constitute all the information that the producer requires from the user to fully trace the specific product. The traceability data – Batch number, Lot number etc must agree with the delivery documentation.
- 4.13 **Storage:** The conditions under which the item should be stored, unopened, for optimum preservation
- 4.14 **Fill Date – d/m/y:**The date on which the material was placed into the container. The date should be in the following type of open format - day / month / year
- 4.15 **Net Weight or Net Contents:** This field must include the units of measure , kg, l etc

## 5.0 **LABEL PROPERTIES**

- 5.1 Minimum dimensions: 125 x 80 mm (strong recommendation)  
 Maximum dimensions: A5, 148 X 210mm
- 5.2 The following are recommendations:  
 The material should be freeze –stable and not weaken appreciably when wet  
 The combination of ink and the material used should be scratch, water and UV resistant  
 The adhesive should be permanent and deep-freeze stable  
 The adhesive should have good ageing characteristics and be UV resistant

## 6.0 **LETTERING**

- 6.1 All of the data in the 11 obligatory fields must be printed, none of it can be hand written
- 6.2 The size and quality of the lettering should enable all the information to be read easily, even in poor light.  
 Recommendations:  
 a) “minimum size of the letters for the fields and the data is “Legible”. E. g. “Legible” is the minimum

- b) the font in which the label is printed be clear and easily read e.g. Arial
- c) the printing should be dark against a bright background and be of good quality

6.3 All the printing should remain legible, without running or blotting, when the label is wet.

## **7.0 LABELLING**

7.1 The label should be applied to the side of the container, not the lid, in a position where it is least likely to become damaged or defaced in transit and handling. Recommendation: Particularly for drums, a 2<sup>nd</sup> duplicate label should be applied at a position 180 degrees to the first. This ensures that at least one of the labels can be seen (and bar code scanned) whatever the orientation of a group of drums on a pallet.

7.2 Additional labels should NEVER be placed inside the container. They pose a considerable contamination risk to the contents, especially if automatic drum emptying systems are employed

7.3 All labels should be adhered firmly to the primary container and retain their adhesion under both chill, freezer and/or damp conditions. If labels are applied to outer packing then further labelling is required on the primary container. If not, when the outer packaging is removed at the point of use the identity and traceability of the individual items is lost.

7.4 All the information, both obligatory and additional, should be on one label not some on one label and some elsewhere e.g. on a 2<sup>nd</sup> label or stencilled directly onto the drum.

7.5 If 2<sup>nd</sup> hand drums are being used, any old label(s) must be completely removed

## **8.0 DOCUMENTATION**

8.1 On all documents, where applicable, the field names, itemised in section 4 above should be used.

Examples:

All the information required for traceability purposes should be grouped in one place under the heading "Traceability Data" The name of the product on the drum should be identical to the one on the paperwork. The term "Product Code" should be used, not Product ID. or Product Ref.

## **9.0 BAR CODING**

9.1 The inclusion of a bar code on the label is recommended but not obligatory. Once the standardised label has become established then it is expected that the inclusion of a bar code will be obligatory.

## Attachment 1

### RECOMMENDED WORDING

1 STORAGE	2 STRENGTH	3 DESCRIPTI ON	4 FRUIT	5 ADDITIONAL DESCRIPTION
ASEPTIC	COMMinute(d)	Any number	Any number	Any number
CANNED	CONCEntrate(d)	%	%	%
CHILLED	S/S	Fruit variety	Fruit Type	AROMA
FROZEN	NFC	Colour	Vegetable	BASE
PRESERVED			Type	
		ACID		CELLS
		BRIX		JUICE
		BULK		LIGHT
		CLEAR		MIX
		CLOUDY		NECTAR
		DAIRY		PASTE
		DARK		PECTIN
		DECOLOURISED		PLUS
		DEIONISED		PUREE
		DEODOURISED		WESOS
		FOLD		
		HIGH		
		LOW		
		ORGANIC		
		PREMIUM		
		RATIO		
		SOUR		
		SPECIAL		
		STANDARD		
		SUMMER		

#### Notes

Any number of words from each of the 5 columns can be used e.g.

The description does not have to contain a word (or words) from each column but all words used must be in "column" order

If more than one "fruit" is used then the word "mix " must form part of the description

## Attachment 2

EXAMPLE 1

Produced By: <b>Fruity Juice Ltd.</b>	
Product: <b>Aseptic S/S NFC cloudy apple juice</b>	
Additives: <b>Vitamin C</b>	
Product Code: <b>FJ-659874</b>	
Acidity: <b>3.5 g/l as malic</b>	Brix: <b>11.4 uncorr.</b>
Country of origin: <b>Various</b>	
Traceability Data: <b>Lot 65 B54698 17/3/01</b>	
Storage <b>Chill, 0 to 5 C</b>	
Fill Date: d / m / y <b>17-Mrz-01</b>	
Net Weight: <b>180kg</b>	

### Attachment 3

EXAMPLE 2

Produced By: <b>Citrus Sunshine Inc.</b>	
Product: <b>Frozen Conc. Orange Juice plus Cells</b>	
Additives: <b>3% cells</b>	
Product Code: <b>CSI 5698/3</b>	
Ratio: <b>15 to 16</b>	Brix: <b>64 min corr.</b>
Country of origin: <b>South Brazil</b>	
Traceability Data: <b>6508792</b>	
Storage <b>-10 C max</b>	
Fill Date: d / m / y <b>17-Mrz-01</b>	Use By: m / y <b>03 - 07</b>
Net Weight: <b>260 kg</b>	Gross Weight: <b>285 kg</b>

## Attachment 4

EXAMPLE 3

Produced By: <b>The Citric Acid Company</b>	
Product: <b>Citric Acid Monohydrate</b>	
Additives: <b>None</b>	
Product Code: <b>CC 456</b>	
Acidity: <b>99.8 min as ACA</b>	Brix: <b>N/A</b>
Country of origin: <b>China</b>	
Traceability Data: <b>Batch 69 Lot 5</b>	
Storage <b>Dry, ambient</b>	
Fill Date: d / m / y <b>17-Mrz-99</b>	
Net Weight: <b>25kg</b>	