CLEANING AND SANITATION IN MEAT PLANTS

Periodic cleaning and sanitation\(^1\), which includes disinfection of meat plant premises and equipment, is an integral part of Good Hygienic Practice (GHP, see page 341). Cleaning and sanitation can even be considered as one of the most important activities in the meat plant, as these measures provide the necessary environment for proper meat handling and processing.

Efficient meat plant cleaning and sanitation is often neglected as it requires extra work and the positive effects are not immediately visible. However, failures in meat plant hygiene can cause high financial losses in the long run. Unhygienic conditions in a meat plant result in

- unattractive, tasteless products
- spoilage of valuable food and/or
- food-borne diseases

Proper cleaning and sanitation is becoming increasingly important in modern meat processing as more perishable and hygienically sensitive meat products come on the market, particularly convenience foods such as prepacked portioned chilled meat, vacuum-packed sliced sausage and ham products, meat products in controlled atmosphere packages etc. The microbial load of such products must be low to guarantee adequate shelf life and to avoid spoilage during distribution.

How to carry out meat plant cleaning and sanitation

a) General

Preconditions for efficient cleaning and sanitation are:

- Premises and equipment must be “cleaning-friendly” (see page 364), which means
  - easy and practicable access to all contaminated areas,
  - smooth surfaces and adequate materials for building structures and equipment to be cleaned.
- Proven methods for meat plant cleaning and sanitation must be available.
- Personnel must be regularly instructed and trained in cleaning and sanitation methods.

\(^1\) The term “sanitation” usually refers to disinfection and pest control.
Cleaning is the removal of dirt and organic substances, such as fat and protein particles from surfaces of walls, floors, tools and equipment. Through the cleaning procedures, high numbers of microorganisms (90% and more) present on the mentioned objects will be removed. However, many microorganisms stick very firmly to surfaces, in particular in tiny almost invisible layers of organic materials, so called biofilms, and will not entirely be removed even by profound cleaning but persist and continue multiplying.

Inactivation of those microorganisms requires antimicrobial treatments, carried out in food industries through hot water or steam or through the application of disinfectants. Disinfectants are chemical substances, which kill microorganisms but should not affect human health through hazardous residues and not cause corrosion of equipment. The application of disinfectants is called disinfection. The term sanitation refers to the inactivation of microorganisms through disinfectants, but also includes combating pests such as insects and rodents through chemical substances (insecticides and rodenticides).

When starting cleaning and disinfection/sanitation measures all food products must be removed from the area because:

- Physical cleaning with pressurized water may stir up dirt or produce contaminated water droplets (aerosol), which could contaminate meat present in such rooms.
- Chemical cleaning/disinfection may produce toxic residues when in contact with remaining meat or meat products. The same applies to insecticides and rodenticides for pest control.

Cleaning and disinfection procedures in the meat industries are complex processes depending on the surfaces to be treated and the kind of contamination to be removed. Selection of suitable chemicals for cleaning or for disinfection may require special knowledge. All these factors can make correct cleaning and disinfection a difficult task for the personnel involved. However, staff must be made aware that efficient cleaning and disinfection is of utmost importance for product quality and safety.

**b) Cleaning techniques**

The first step in floor and equipment cleaning is to physically remove scrap, i.e. coarse solid particles, with a dry brush or broom and shovel. This is usually referred to as “dry cleaning”. Using large amounts of water to remove this material would be extremely wasteful and eventually cause drains to clog and waste water treatment facilities to become overloaded.
More profound clean-up procedures require water in sufficient quantities. **Manual cleaning** using brushes or scrapers is widely applied in small-scale operations although labour and time-intensive (Fig. 488). A cleaning method commonly used in the meat industries is **high pressure cleaning**. The pressurized water is applied by high pressure units and special spraying lances. The pressure should be between 30-70 bar and the spraying nozzle ≤15cm from the surface to be cleaned. Otherwise the pressure being applied decreases rapidly. If hot water is used, the temperature should be 55°C at the nozzle in order to achieve sufficiently high temperatures at the surfaces, in particular for fat removal (Fig. 489).

![Fig. 488: Manual cleaning of working tables with brushes](image1)

![Fig. 489: Cleaning of wall with pressurized water - care must be taken not to contaminate equipment](image2)

**High pressure water** is efficient for surface cleaning after dry-cleaning of scrap. It serves for the removal of remaining small solid parts, blood and dirt from the entire floors and walls of processing sections as well as for the removal of meat and fat particles and layers of protein from tools and equipment. As hot water has a much better cleaning effect than cold water, hot water should be available for this purpose.

Cleaning with equipment producing a **pressurized steam/water-mix** is even more efficient as impact temperatures of approx. 100°C can be achieved. The disadvantage of this method is the intense fog and aerosol formation, which may not only cause unwanted microbial spreading by water droplets (aerosol) but also affect installations and equipment through high humidity and excessive condensation. For these reasons a steam/water-mix is not suitable for meat processing facilities and cold or hot pressurized water cleaning is preferred.

The removal of loose dirt and meat/fat residues by water does not mean that the cleaning was complete. Sticky or encrusted layers of fat or
protein will still exist and must be removed. For this purpose **chemical cleaning solutions** can be very effective.

Application can be by hand using brushes or scrapers for dismantled equipment or in general for smaller surfaces to be cleaned. Mechanical cleaning with high pressure equipment together with cleaning solutions is used for larger floor and wall areas as well as working tables, containers and equipment.

Traditional cleaning substances for manual use are **alkalines**, such as sodium carbonates (Na$_2$CO$_3$, washing soda). These substances are efficient in dissolving proteins and fats, but may cause corrosion in tools and equipment, if their pH is 11 and above.

Commercially available cleaning agents in modern cleaning practices are complex compositions of either **alkaline, acid or neutral** chemical substances. In order to improve their dirt loosening properties, surface-active agents, also called **surfactants** or **detergents** are added. Detergents decrease the superficial tension of water. Water can then penetrate into the small spaces between dirt particles and surfaces (Fig. 490), where those particles are attached, thus facilitating their removal. For fat removal by pressurized hot water, cleaning detergents are important as they keep the fat dissolved and prevent fats settling down after the water temperature has decreased. Detergents may have additional cleaning components such as chlorine, silicate or phosphate. It is important that manufacturers indicate the type of the substance, either alkaline, acidic or neutral on the product label.

**Alkaline cleaning agents:**
Generally suitable for removing organic dirt, protein residues and fat.

![Fig. 490: Effect of detergents (surfactants): Decrease of surface tension of water droplets and impact angle (below), dirt particles are easier loosened and removed from surface.](image-url)
**Acid cleaning agents:**
Used particularly for removal of encrusted residues of dirt or protein or of inorganic deposits (“scaling”) such as waterstone, milkstone, lime etc.

**Neutral cleaning agents:**
Have much less effect than alkaline or acid cleaning agents, but have mild impact on skin and materials and are useful for manual cleaning of smooth surfaces without encrusted dirt.

In practice alkaline and acid cleaning substances should be used **alternatively**. The alkaline agent should be the substance used for routine cleaning, but every few days an acid substance should be employed instead in order to remove encrusted residues, scaling etc.

Cleaning substances together with the suspended dirt particles and fat must be rinsed off using potable water.

A relatively new cleaning method for the food industry, in particular the larger-scale plants, is **foam cleaning** (Fig. 491). Water foam containing detergents and other cleaning agents is sprayed on wetted walls, floors and surfaces of equipment. The foam does not immediately run off but clings to the surfaces. This allows a longer term contact on the surfaces to be cleaned. After a sufficient impact period (min. 15 minutes) the foam is washed down with water (water hose or low-pressure water spray). As no high pressure water spraying is needed for washing off the foam, the spreading of water droplets (aerosol) in the room to be cleaned is minimized.

### c) Disinfection techniques

Cleaning reduces a substantial amount of microorganisms (Fig. 492b) but it does not have the potential to completely eliminate all surface contamination. Persistent microorganisms will continue to grow in number by using remaining protein as nutrients and pose a further risk to the foods to be processed.
The elimination of microorganisms is achieved through **disinfection**\(^1\), either by using hot water (or better steam) or chemical disinfectants (Fig. 492c). **Chemical disinfectants** are preferred for most applications in the meat industries as they are easy to use and do not involve the risk of accidents or other negative side effects such as damage to equipment by generating high humidity or water condensation, which may occur when using steam.

![Image of impression plate samples](Fig. 492: Effect of cleaning and disinfection on the number of bacteria)

**Fig. 492: Effect of cleaning and disinfection on the number of bacteria**
Image of impression plate samples (see page 332) taken from a meat container (plastic)

1) Disinfection in the food sector does not aim at the complete absence of microorganisms (such as sterilization of surgical instruments in hospitals), but the number of microorganisms must be substantially reduced by the process.
Best disinfection results are achieved when chemical disinfection is preceded by intensive dry/wet cleaning (see page 370, b). Disinfection without precleaning is not fully efficient as many microorganisms remain embedded in encrusted dirt, protein and fat, which cannot be properly dissolved by disinfection chemicals. Therefore microorganisms remain protected against the disinfection chemicals. Moreover, remaining protein may inactivate chemical disinfectants.

Adequate rinsing with water after cleaning and prior to disinfection is also indispensable, as chemical disinfectants may be neutralized by remaining cleaning substances. All this has to be taken into account, otherwise the disinfection procedures may be inefficient and a waste of money.

A compromise on this issue is proposed by the chemical industry by offering so called combined disinfection/cleaning agents. They are made on the basis of quaternary ammonium compounds, which have surfactant and disinfectant properties. The combined method should be considered only in cases of very little dirt contamination.

It is very important that disinfection chemicals are strictly used according to the specifications given by the suppliers. Lower concentrations and shorter impact periods than prescribed will considerably reduce the efficacy of disinfection or make it totally inefficient. Surfaces should be dried after cleaning and rinsing before starting disinfection. This is important, as the concentration of the disinfection solution would be lowered with remaining water on the surfaces and possibly ineffective when becoming too highly diluted.

The application of chemical disinfectants is done with stationary or mobile spraying devices. In medium or small scale meat plants, mobile spraying devices are sufficient (Fig. 493). The disinfectant is applied by means of spraying lances and manual or electrical pumps. One important rule is, that the disinfectant solution must be applied from top to bottom, i.e., first upper parts of walls, then lower parts of walls and the floor last. The same applies to equipment.

Fig. 493: Disinfection of walls by using portable spray equipment. For operator’s protection gloves and facemask are recommended.
Hot disinfectant solutions (up to 50°C) are more effective than cold ones. After application, the disinfectant solution must remain for a certain period of time on the surfaces to be disinfected as indicated in the user instructions, normally for 30 minutes. Thereafter removal of the chemicals through rinsing with potable water is needed.

d) Disinfectants for the meat industry

Disinfectants should be effective and rapidly acting in killing microorganisms (Fig. 494). It should be noted that disinfectants do not sterilize the surfaces treated, absolute germ-free surfaces cannot be achieved, but disinfectants should kill all pathogens. The chemical composition of disinfectants vary depending on the specific target (slaughterhouse, meat processing, easily accessible open processing lines or closed food pipeline systems) and on chemical formulations by the individual disinfectant manufacturer. Modern disinfectants are mostly mixtures of different chemical substances. Combinations of disinfection chemicals achieve a synergistic effect and result in the elimination of a broader spectrum of microorganisms. The exact compositions are sometimes not fully revealed by the manufacturers. In principle the following groups of substances are used:

1. Chlorine containing compounds
   a) Na - or Ca-hypochlorite (Na/Ca O Cl)
   b) Gaseous chlorine (Cl₂)
      (Hypochlorous acid is the effective substance used preferably for disinfection of water)

   Effective against a wide range of bacteria, penetrates cell walls, but has a corrod঱ing effect on equipment

2. Aldehydes (used in animal production, e.g. Formaldehyde)
   Phenoles / Kresols (used in medicine, households
   Alcohols (used in medicine, e.g. skin)
   Alkalines (pH 10 or higher) (e.g. NaOH, used in animal production)
   Acids (some organic acids used in food industries)

   Destruction of microorganisms, may be corrosive

3. Quaternary ammonium compounds (QUATS)
   Amphotensids
      (used in food industries, as not corrosive)
   Low efficiency on spores

   Effect on cell walls, not corrosive, odourless, additional cleaning properties (surfactant)
4. Oxygen releasing substances
   Peroxide compounds (H₂O₂)
   Per-acetic acid
   (use in food industries)

   Penetrate into cells, good effect on all microorganisms incl. spores and virus, odourless, may be corrosive in concentrations >1%

Fig. 494: Effect of some chemical disinfectants on microorganisms

The following commercially available disinfectant is an example for an efficient combination of components:
- organic acids
- surfactants (= surface active agents)
- peroxide compounds

The organic acids, apart from their sanitizing effect, decrease the pH as some disinfectants are more efficient at lower pH. The surfactants assist in penetrating organic material. The peroxide compounds have the direct antimicrobial effect by coagulation and denaturation of proteins (virus) and penetration through cell walls causing cell destruction (bacteria).
The available types of chemical disinfectants act differently on certain groups of bacteria and under certain pH-ranges. In order to achieve a maximum disinfection effect, it is recommended to alternate periodically the type of the chemical disinfectant applied. Utilization of suitable alternative substances will inactivate bacteria, which were possibly surviving the previous sanitation process. This procedure will also help to counteract the development of resistant bacteria in the meat plant (see “Cleaning and sanitation plan”, table 22).

**e) Cleaning and disinfection (sanitation) schemes**

Meat industry staff must be made fully aware of the need for proper cleaning. Cleaning should be treated as an integral part of the production process. It should be done carefully and not just superficially or in a rush at the end of the production process.

While daily cleaning or even cleaning several times a day is an absolute necessity, it has to be decided according to type and product lines or activity of each individual meat plant, where and at which time intervals disinfection measures should be applied.

Frequency of disinfection depends on need requirements:

- **Several daily disinfections** (by hot water or chemicals) are necessary for hand tools, meat saws and cutting boards.
- **Daily disinfection** is useful for dismantled equipment such as parts of grinders, fillers, stuffers, etc.
- **Disinfection once a week** is recommended for other equipment and floors and walls of processing and chilling rooms.

**Cleaning and disinfection plans**

For all rooms and all equipment used for meat processing or meat storage, specific **cleaning and disinfection plans** should be established.

In table 22, an example is given for disinfection of meat processing equipment, in this case for a meat grinder. This type of equipment is an integral part of almost every meat processing line. Meat grinders require particular careful and frequent cleaning and sanitation, as the output product **minced meat** is hygienically very sensitive.
### Table 22: Cleaning and disinfection plan (example)

**Equipment:** Meat grinder

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**Agent A:** Alkaline cleaning substance  
**Agent B:** Acid cleaning substance  
**Agent C:** Disinfectant  
**Agent D:** Disinfectant chemically different from C and supplementing impact of C
ANNEX I

RECIPES FOR PROCESSED MEAT PRODUCTS

Fresh meat products

Boerwors / South African BBQ sausage 383
Longganisa / Philippine BBQ sausage 384
Merguez / French BBQ sausage 385
Chorizo Criollo / Latin American BBQ sausage 386
Salchicha Madrillena / Spanish BBQ sausage 387
Bratwurst / German BBQ sausage 388
Thuringian BBQ sausage 389
Beef Burger (premium) 390
Juicy burger (premium, Philippines) 391
Juicy burger (extended, Philippines) 392
Chicken nuggets (Asian small-scale) 393

Raw-fermented sausages

Chorizo / medium-term ripened raw sausage 394
Mutton salami / medium-term ripened raw sausage 395
Summer sausage / quick-cured raw sausage 396
Cervelat sausage / quick-cured raw sausage 397
Salami sausage (meat grinder only) 398
Salami sausage (meat grinder – bowl cutter) 399

Raw-cooked meat products

Frankfurters (mixed product) 400
Vienna sausages (premium) 401
Chicken viennas (premium) 402
Beef frankfurters (pure beef) 403
Lyoner / fine ham sausage 404
Coarse ham sausage 405
White sausage / Veal sausage 406
Krakow sausage 407
Buffalo sausage 408
Mortadella (with slaughter by-products) 409
Beef frankfurters (moderately extended) 410
Beef hotdog (substantially extended) 411
Chicken hotdog (substantially extended)  412  
Breakfast sausage (moderately extended)  413  
Meat loaves / meat balls  414

**Precooked-cooked products**

Corned beef (traditional method, South America)  415  
Corned beef (premium, Philippines)  416  
Corned beef (substantially extended, Philippines)  417  
Fine liver sausage / Liver pate  418  
Coarse liver sausage  419  
Blood sausage (Central European)  420  
Blodkorporv (extended blood sausage, Sweden)  421

**Cured meat cuts**

Cooked ham (entire muscle pieces, standard)  422  
Raw fermented hams  423  
Pork bacon  423  
Beef bacon  423

**Indigenous meat products**

Lup-cheong / Chinese dry pork sausage  424  
Naem (Nham) / fermented pro sausage (SA-Asia)  425  
Isaan sausage / herb sausage (quick-cured)  426  
Isaan sausage / herb sausage (fresh)  427  
List of other products with details in chapters  428

**Please note:**

The term NITRITE CURING SALT used in some of the recipes refers to a standard mixture of common salt with the curing agent sodium nitrite. The premix consists of 99.5% salt and 0.5% nitrite.
FRESH MEAT PRODUCTS

BOERWORS / South African BBQ sausage
(Fresh sausage type, coarse mixture)

INGREDIENTS

Raw materials: (calculated for 10 kg batch)
90.00 % Beef trimmings without tendons 9.000 kg

Extenders:
4.00 % Rusk (baked and crushed wheat flour 0.400 kg
3.00 % Water, potable 0.300 kg
3.00 % Vinegar 0.300 kg

Additives:
(per kg of raw materials) (total for 10 kg)
18.00 g Common salt (refined) 180.00 g

Seasonings:
(per kg of raw materials) (total for 10 kg)
2.00 g White pepper, ground 20.00 g
1.50 g Coriander, ground 15.00 g
0.50 g Thyme 5.00 g

PROCESSING

CUT Fresh meat trimmings into small pieces
SOAK Rusk in added potable water
MIX Meat trimmings, rusk, vinegar and seasonings
GRIND Mixture 3 mm
STUFF Into natural sheep casings (26-28 mm)
PORTION Link into sausages of desired size (60-100 g)
STORE Below +4°C, shelf life < 4 days
PREPARE Fry in a frying pan or roast on a grill
**LONGGANISA / Philippine BBQ Sausage**
*(Fresh sausage type, coarse mixture)*

**INGREDIENTS**

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<thead>
<tr>
<th>Raw materials:</th>
<th>(calculated for 10 kg batch)</th>
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<tbody>
<tr>
<td>60.00 % Pork trimmings, fresh</td>
<td>6.000 kg</td>
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<tr>
<td>40.00 % Pork belly without rind</td>
<td>4.000 kg</td>
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| Extenders: | --- |

**Additives:**

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<thead>
<tr>
<th>(per kg of raw materials)</th>
<th>(total for 10 kg)</th>
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<tr>
<td>7.00 g Nitrite curing salt</td>
<td>70.00 g</td>
</tr>
<tr>
<td>7.00 g Common salt (refined)</td>
<td>70.00 g</td>
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<tr>
<td>2.50 g Phosphate</td>
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**Seasonings:**

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<tr>
<td>50.00 g Sugar (refined)</td>
<td>500.00 g</td>
</tr>
<tr>
<td>20.00 g Pineapple juice</td>
<td>200.00 g</td>
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<tr>
<td>10.00 g Anisado wine</td>
<td>100.00 g</td>
</tr>
<tr>
<td>20.00 g Garlic, fresh</td>
<td>200.00 g</td>
</tr>
<tr>
<td>5.00 g Black pepper, ground</td>
<td>50.00 g</td>
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**PROCESSING**

- **CUT** Fresh meats into small pieces
- **MIX** Fresh meats, additives, seasonings
- **GRIND** Meat/seasonings mixture 5 mm
- **MIX** All ground materials thoroughly
- **STUFF** Into natural sheep casings (22-24 mm)
- **PORTION** Link to sausages of desired size (60-100 g)
- **STORE** Below +4°C, shelf life < 4 days
- **PREPARE** Fry in a frying pan or roast on a grill

**CHICKEN LONGGANISA** see page 191
**MERGUEZ / French BBQ Sausage**

*(Fresh sausage type, coarse mixture)*

**INGREDIENTS**

Raw materials: (calculated for 10 kg batch)

<table>
<thead>
<tr>
<th>Percentage</th>
<th>Ingredient</th>
<th>Quantity</th>
</tr>
</thead>
<tbody>
<tr>
<td>40.00 %</td>
<td>Beef meat trimmings</td>
<td>4.000 kg</td>
</tr>
<tr>
<td>35.00 %</td>
<td>Mutton meat trimmings</td>
<td>3.500 kg</td>
</tr>
<tr>
<td>10.00 %</td>
<td>Beef muscle and brisket fat</td>
<td>1.000 kg</td>
</tr>
<tr>
<td>5.00 %</td>
<td>Mutton fats</td>
<td>0.500 kg</td>
</tr>
<tr>
<td>5.00 %</td>
<td>Green pepper, fresh</td>
<td>0.500 kg</td>
</tr>
<tr>
<td>5.00 %</td>
<td>Onions, fresh</td>
<td>0.500 kg</td>
</tr>
</tbody>
</table>

Extenders: ---

Additives:

(per kg of raw materials) (total for 10 kg)

<table>
<thead>
<tr>
<th>Quantity</th>
<th>Ingredient</th>
</tr>
</thead>
<tbody>
<tr>
<td>150.00 g</td>
<td>Common salt (refined)</td>
</tr>
</tbody>
</table>

Seasonings:

(per kg of raw materials) (total for 10 kg)

<table>
<thead>
<tr>
<th>Quantity</th>
<th>Ingredient</th>
</tr>
</thead>
<tbody>
<tr>
<td>20.00 g</td>
<td>Black pepper, ground</td>
</tr>
<tr>
<td>10.00 g</td>
<td>Chilli, ground</td>
</tr>
<tr>
<td>50.00 g</td>
<td>Garlic, fresh</td>
</tr>
</tbody>
</table>

**PROCESSING**

**CUT**

Fresh meats and fats into small pieces

**GRIND**

Meat and onions 13 mm, muscle and brisket fat 5 mm

**MIX**

Ground meat and fat with seasonings

**GRIND**

Meat/seasonings mixture 5 mm

**STUFF**

Into natural sheep casings (22-24 mm)

**PORTION**

Link to sausages of desired size (60-100 g)

**STORE**

Below +4°C, shelf life < 4 days

**PREPARE**

Fry in a frying pan or roast on a grill
**CHORIZO CRIOLLO / Latin American BBQ sausage**
*(Fresh sausage type, coarse mixture)*

**INGREDIENTS**

**Raw materials:** (calculated for 10 kg batch)

<table>
<thead>
<tr>
<th>Percentage</th>
<th>Ingredient</th>
<th>Quantity</th>
</tr>
</thead>
<tbody>
<tr>
<td>75.00 %</td>
<td>Pork meat trimmings</td>
<td>7.500 kg</td>
</tr>
<tr>
<td>20.00 %</td>
<td>Beef meat trimmings</td>
<td>2.000 kg</td>
</tr>
<tr>
<td>5.00 %</td>
<td>Pork back fat</td>
<td>0.500 kg</td>
</tr>
</tbody>
</table>

Extenders: ---

Additives:

(per kg of raw materials) (total for 10 kg)

<table>
<thead>
<tr>
<th>Ingredient</th>
<th>Quantity</th>
</tr>
</thead>
<tbody>
<tr>
<td>Common salt (refined)</td>
<td>160.00 g</td>
</tr>
</tbody>
</table>

Seasonings:

(per kg of raw materials) (total for 10 kg)

<table>
<thead>
<tr>
<th>Ingredient</th>
<th>Quantity</th>
</tr>
</thead>
<tbody>
<tr>
<td>Pepper, ground</td>
<td>40.00 g</td>
</tr>
<tr>
<td>Pepper, broken corns</td>
<td>30.00 g</td>
</tr>
<tr>
<td>Red wine</td>
<td>30.00 g</td>
</tr>
<tr>
<td>Cane sugar</td>
<td>10.00 g</td>
</tr>
<tr>
<td>Garlic, fresh</td>
<td>10.00 g</td>
</tr>
</tbody>
</table>

**PROCESSING**

**CUT**
Fresh meat trimmings into small pieces

**MIX**
Meat trimmings, additives and seasonings

**GRIND**
Mixture 5 mm

**STUFF**
Into natural hog casings (24-26 mm)

**PORTION**
Link to sausages of desired size (60-100 g)

**STORE**
Below +4°C, shelf life < 4 days

**PREPARE**
Fry in a frying pan or roast on a grill
**SALCHICHA MADRILENA / Spanish BBQ sausage**  
(*Fresh sausage type, coarse mixture*)

**INGREDIENTS**

**Raw materials:** (calculated for 10 kg batch)
- 50.00 % Pork meat without tendons, lean 5.000 kg
- 50.00 % Pork belly without rind, fresh 5.000 kg

**Extenders:** ---

**Additives:**  
(per kg of raw materials) (total for 10 kg)
- 18.00 g Common salt (refined) 180.00 g

**Seasonings:**  
(per kg of raw materials) (total for 10 kg)
- 10.00 g Paprika, sweet-red 100.00 g
- 3.00 g Red pepper 30.00 g
- 3.00 g Marjoram 30.00 g
- 0.50 g Garlic, fresh 5.00 g

**PROCESSING**

**CUT**  
Fresh meat trimmings into small pieces

**MIX**  
Meat trimmings and seasonings

**GRIND**  
Mixture 3 mm

**STUFF**  
Into natural sheep casings (20-24 mm)

**PORTION**  
Link to sausages of desired size (60-100 g)

**STORE**  
Below +4°C, shelf life < 4 days

**PREPARE**  
Fry in a frying pan or roast on a grill
**BRATWURST / German BBQ sausage**  
(Fresh sausage type, coarse meat mixture)

**INGREDIENTS**

**Raw materials:**  
(calculated for 10 kg batch)  
50.00 % Pork trimmings, lean, fresh  5.000 kg  
30.00 % Pork belly without skin, fresh  3.000 kg  
20.00 % Beef trimmings, lean  2.000 kg  

**Extenders:**  
---

**Additives:**  
(per kg of raw materials)  
(total for 10 kg)  
15.00 g Common salt (refined)  150.00 g  
1.50 g Phosphate, plain (>pH 7.3)  15.00 g  

**Seasonings:**  
(per kg of raw materials)  
(total for 10 kg)  
50.00 g Onions, fresh  500.00 g  
2.00 g White pepper, ground  20.00 g  
0.30 g Ginger, ground  3.00 g  
0.30 g Cardamom, ground  3.00 g  
0.20 g Nutmeg, ground  2.00 g  

**PROCESSING**  

**CUT**  
Pork meats and onions in small pieces  
**GRIND**  
Beef trimmings 3 mm  
**MIX**  
Fresh pork meat, onions, ground beef, seasonings  
**GRIND**  
Meat/onion/seasonings mixture 5 mm  
**MIX**  
All ground materials thoroughly  
**STUFF**  
Into natural pork casings (26-28 mm)  
**PORTION**  
Link to sausages of desired size (60-100 g)  
**STORE**  
Below +4°C, shelf life < 2 days  
**PREPARE**  
Fry in a frying pan or roast on a grill
THURINGIAN BBQ SAUSAGE
(Fresh sausage type, coarse meat with binder, water added)

INGREDIENTS

Raw materials:  (calculated for 10 kg batch)
50.00 %  Pork trimmings, lean, fresh  5.000 kg
30.00 %  Pork belly without skin, fresh  3.000 kg
15.00 %  Beef trimmings, lean     1.500 kg
5.00 %   Ice (potable water) 0.500 kg

Extenders:  ---

Additives:  (per kg of raw materials)  (total for 10 kg)
15.00 g  Common salt (refined)      150.00 g
1.50 g   Phosphate, plain (>pH 7.3) 15.00 g

Seasonings:  (per kg of raw materials)  (total for 10 kg)
50.00 g  Onions, fresh  500.00 g
2.00 g   White pepper, ground 20.00 g
0.30 g   Ginger, ground 3.00 g
0.30 g   Cardamom, ground 3.00 g
0.20 g   Nutmeg, ground 2.00 g

PROCESSING

GRIND  Beef trimmings and onions 3 mm
CHOP   Ground beef with ice and all additives
       Until a fine lean batter is achieved
CUT    Pork meat and belly in small pieces
MIX    Fresh pork meat, onions, ground beef, seasonings
GRIND  Meat/onion/seasonings mixture 5 mm
MIX    All ground materials and fine beef batter thoroughly
STUFF Into natural sheep casings (22-24 mm)
PORTION Link to sausages of desired size (60-100 g)
STORE  Below +4°C, shelf life < 2 days
PREPARE Fry in a frying pan or roast on a grill
**BEEFBURGER** (traditional recipe, premium)**
(Fresh processed meat product, coarse mixture)

**INGREDIENTS**

**Raw materials:** (calculated for 5 kg batch)

100.00 % Lean beef meat, low connective tissue 5.000 kg

**Extenders:** ---

**Additives:**
(per kg of raw materials) (total for 5 kg)

12.00 g Common salt 60.00 g

**Seasoning:**
(per kg of raw materials) (total for 5 kg)

5.00 g Black pepper ground 25.00 g

**PROCESSING**

**CUT**
Lean beef meat into small pieces

**MIX**
lean beef meat, additives and seasoning

**GRIND**
Mixture 3mm

**SHAPE**
Into patties (50-100 g per patty) in paperlyne

**PACK**
In P.E. bag and seal

**STORE**
In freezer at -18°C

**PREPARE**
Fry in shallow oil or grill on charcoal

**CHICKEN BURGERS** see page 191, 202

**LOW-COST BURGERS** see page 201
**JUICY BURGER** (Beef/pork mixture, premium, Philippines)  
(*Fresh processed meat product, coarse mixture*)

### INGREDIENTS

**Raw materials:** (calculated for 5 kg batch)

<table>
<thead>
<tr>
<th>Ingredient</th>
<th>Percentage</th>
<th>Amount</th>
</tr>
</thead>
<tbody>
<tr>
<td>Beef lean, ground</td>
<td>40.00 %</td>
<td>2.000 kg</td>
</tr>
<tr>
<td>Pork lean, ground</td>
<td>45.00 %</td>
<td>2.250 kg</td>
</tr>
<tr>
<td>Pork back fat</td>
<td>10.00 %</td>
<td>0.500 kg</td>
</tr>
<tr>
<td>Potable water</td>
<td>5.00 %</td>
<td>0.250 kg</td>
</tr>
</tbody>
</table>

**Extenders:** ---

**Additives:**

(per kg of raw materials) (total for 5 kg)

<table>
<thead>
<tr>
<th>Ingredient</th>
<th>Amount</th>
</tr>
</thead>
<tbody>
<tr>
<td>Common salt</td>
<td>12.00 g</td>
</tr>
<tr>
<td>Phosphate</td>
<td>2.00 g</td>
</tr>
</tbody>
</table>

**Seasoning:**

(per kg of raw materials) (total for 5 kg)

<table>
<thead>
<tr>
<th>Ingredient</th>
<th>Amount</th>
</tr>
</thead>
<tbody>
<tr>
<td>Sugar, refined</td>
<td>10.00 g</td>
</tr>
<tr>
<td>Garlic, chopped</td>
<td>11.00 g</td>
</tr>
<tr>
<td>Black pepper ground</td>
<td>5.00 g</td>
</tr>
<tr>
<td>Monosodium glutamate (MSG)</td>
<td>1.50 g</td>
</tr>
<tr>
<td>Celery powder</td>
<td>1.00 g</td>
</tr>
<tr>
<td>Onion, chopped</td>
<td>130.00 g</td>
</tr>
<tr>
<td>Wheat flour</td>
<td>30.00 g</td>
</tr>
<tr>
<td>Eggs, fresh</td>
<td>2 pcs</td>
</tr>
</tbody>
</table>

**PROCESSING**

**CUT**  
Lean meat and pork back fat into small pieces

**MIX**  
Lean meat, back fat, additives and seasoning

**GRIND**  
Mixture 3mm

**FORM**  
Into patties (50 g per patty) in paperlyne

**PACK**  
In PE bag and seal

**STORE**  
In freezer at -18°C

**PREPARE**  
Fry in shallow oil or grill on charcoal
**JUICY BURGER** (Beef/pork mixture, extended, Philippines)
*(Fresh processed meat product, coarse mixture)*

**INGREDIENTS**

**Raw materials:** (calculated for 5 kg batch)

- 25.00% Beef lean, ground 1.250 kg
- 25.00% Pork lean, ground 1.250 kg
- 20.00% Pork back fat, ground 1.000 kg

**Extenders:** (total for 5 kg)

- 8.00% TVP (textured vegetable protein) 0.400 kg
- 21.50% Water for hydration 1.075 kg
- 0.50% ISP (isolated soy protein) 0.025 kg

**Additives:**
(per kg of raw materials) (total for 5 kg)

- 12.00 g Common salt 60.00 g
- 2.00 g Phosphate 10.00 g
- 50.00 g Potable water 250.00 g

**Seasonings:**
(per kg of raw materials) (total for 5 kg)

- 10.00 g Sugar, refined 50.00 g
- 1.00 g Celery powder 5.00 g
- 5.00 g Black pepper ground 25.00 g
- 100.00 g Onion, chopped 500.00 g
- 30.00 g All purpose flour 150.00 g
- 10.00 g Garlic, chopped 50.00 g
- 2 pcs Eggs, fresh 10 pcs

**PROCESSING**

**HYDRATE**
TVP and ISP with potable water

**CUT**
Lean meat and pork back fat into small pieces

**GRIND**
Pork back fat and lean meat 3mm

**MIX**
Meat and fat with hydrated TVP/ISP, additives, seasonings

**FORM**
Into patties (50 g) in paperlyne

**PACK**
In P.E. bag and seal bags

**STORE**
In freezer at -18°C

**PREPARE**
Fry in shallow oil or grill on charcoal
CHICKEN NUGGETS / Asian small-scale product  
(Fresh processed meat product, coarse mixture)

**INGREDIENTS**

**Raw materials:**  
(calculated for 5 kg batch)

- 95.00 % Chicken meat, boneless: 4.750 kg
- 5.00 % Chicken skin (from breast): 0.250 kg

**Additives:**  
(per kg of raw materials)  
(total for 5 kg)

- 12.00 g Common salt: 60.00 g
- 3.00 g Phosphate: 15.00 g
- 50.00 g Potable water (chilled): 250.00 g

**Seasonings:**  
(per kg of raw materials)  
(total for 5 kg)

- 10.00 g Sugar (refined): 50.00 g
- 20.00 g Garlic fresh, chopped: 100.00 g
- 6.00 g White pepper, ground: 30.00 g
- 1.00 g Monosodium glutamate (MSG): 5.00 g

**PROCESSING**

**GRIND**  
Chilled chicken skin 3mm  
Chilled chicken meat, 5 mm

**MIX**  
Ground raw materials, additives and seasonings

**MOULD**  
Mixture in a rectangular tray, 10-15 mm thick

**FREEZE**  
At -7°C to facilitate cutting into nuggets

**CUT**  
Into desired size (e.g. 20x30 mm)

**ROLL**  
In breading or in bread crumbs

**STORE**  
Packed and deep-frozen at -18°C

**PREPARE**  
Deep-fry at +180°C until golden brown
RAW-FERMENTED SAUSAGES

CHORIZO / Medium-term ripened raw sausage
(Raw-fermented sausage type, coarse mixture)

INGREDIENTS

Raw materials: (calculated for 10 kg batch)
50.00 % Pork meat without tendons, lean 5.000 kg
50.00 % Pork belly without rind, fresh 5.000 kg

Extenders: ---

Additives:
(per kg of raw materials) (total for 10 kg)
28.00 g Common salt (refined) 280.00 g
0.50 g Sugar 5.00 g
0.50 g GdL (glucono-delta-lactone) 5.00 g

Seasonings:
(per kg of raw materials) (total for 10 kg)
5.00 g Paprika, sweet, red 50.00 g
1.50 g Chilli, ground 15.00 g

PROCESSING

CUT Meat and belly into small pieces, keep at -4°C
MIX Raw materials, additives and seasonings
GRIND Mixture 8 mm
STUFF Into natural sheep casings (28-32 mm)
PORTION Link into sausages of desired size (100-200 g)
RIPEN For 7 days at +18-22°C (weight loss 25-30 %)
SMOKE Cold smoke (<+22°C) for 6 hrs. on day 2/5
(weight loss 30-35 %)
STORE In a dry and cool place (below + 25°C)
**MUTTON SALAMI / Medium-term ripened raw sausage**  
*(Raw-fermented sausage type, coarse mixture)*

**INGREDIENTS**

**Raw materials:** (calculated for 10 kg batch)
- 80.00 % Mutton meat without tendons, fresh 8.000 kg
- 20.00 % Beef fat, fresh 2.000 kg

**Extenders:** ---

**Additives:**
*(per kg of raw materials) (total for 10 kg)*
- 22.00 g Nitrite curing salt 220.00 g

**Seasonings:**
*(per kg of raw materials) (total for 10 kg)*
- 2.00 g Black pepper, ground 20.00 g
- 1.00 g White pepper corns 10.00 g
- 0.50 g Cardamom, ground 5.00 g
- 1.00 g Fresh garlic 10.00 g

**PROCESSING**

**CUT**  
Meat and fat into small pieces and keep at –4°C

**MIX**  
Frozen meat and fat pieces and seasonings

**GRIND**  
Meat/seasonings mixture 5 mm

**STUFF**  
Natural sheep or beef casings (28-34 mm)

**PORTION**  
Link into sausages of desired size (60-100 g)

**RIPIEN**  
3-5 days at +20°C

**SMOKE**  
Cold smoke (<+22°C) for 6 hrs. on day 2/5  
(weight loss 30-35 %)

**STORE**  
In a dry and cool place (below + 25°C)
**SUMMER SAUSAGE / Quick-cured raw sausage**
*(Semi-dry, raw-fermented sausage type, coarse mixture)*

*Meat grinder use only*

**INGREDIENTS**

**Raw materials:** (calculated for 10 kg batch)

- 30.00% Pork meat, lean 3.000 kg
- 30.00% Beef trimmings, lean 3.000 kg
- 20.00% Pork belly without skin 2.000 kg
- 20.00% Pork back fat 2.000 kg

**Extenders:** ---

**Additives:**

(per kg of raw materials) (total for 10 kg)

- 28.00 g Nitrite curing salt 280.00 g
- 1.00 g Starter cultures (e.g. Staphylococcus) 10.00 g
- 3.00 g GdL (glucono-delta-lactone) 3.00 g

**Seasonings:**

(per kg of raw materials) (total for 10 kg)

- 3.00 g White pepper, ground 30.00 g
- 2.00 g Mustard seeds 20.00 g
- 1.00 g Coriander, ground 10.00 g
- 0.50 g Pimento 5.00 g

**PROCESSING**

(meat grinder only)

**CUT**

Pork meat into small pieces and keep below −4°C
Back fat into dices (10-20 mm), keep below −4°C

**GRIND**

Lean beef trimmings 3 mm

**MIX**

Raw materials, additives and seasonings

**GRIND**

Mixture 5 mm

**STUFF**

Beef middles (35-45 mm)
Fibrous/collage casings (50-60 mm)

**RIPEN**

At <+24-26°C for 4-7 days

**SMOKE**

Cold smoke (<+22°C) on days 2, 4 and 6
(weight loss approx. 25-30%)

**KEEP**

In a dry and cool place
CERVELAT SAUSAGE / Quick-cured raw sausage
(Semi-dry, raw-fermented sausage type, fine particles)
Meat grinder/ bowl cutter combined use

INGREDIENTS

Raw materials: (calculated for 10 kg batch)
40.00 % Pork meat, lean 4.000 kg
30.00 % Beef trimmings, lean 3.000 kg
30.00 % Pork back fat 3.000 kg

Extenders: ---

Additives: (per kg of raw materials)
(total for 10 kg)
28.00 g Nitrite curing salt 280.00 g
1.00 g Starter cultures (e.g. Staphylococcus) 10.00 g
3.00 g GdL (glucono-delta-lactone) 3.00 g

Seasonings: (per kg of raw materials)
(total for 10 kg)
3.00 g White pepper, ground 30.00 g
1.00 g Coriander, ground 10.00 g

PROCESSING

CUT
Pork meat into small pieces, keep below –12°C
50% beef meat into pieces, keep below –12°C
Back fat into dices (10-20 mm), keep below –12°C

GRIND
Remaining lean beef 2 mm, keep chilled

CHOP
At high speed the frozen lean pork, beef, back fat
including starter cultures and seasonings
(until fine particle size is achieved)

ADD
At slow speed the ground beef trimmings and
 distribute thoroughly, now add the curing salt and
 continue chopping (final temperature -4-6°C)

STUFF
Beef bungs or fibrous/collagen casings (60-75 mm)

RIPIEN
At <+24-26°C for 4 days, at +22°C for 5 days

SMOKE
Cold smoke (<+22°C) on days 2, 5 and 8
(weight loss approx. 30-35%)

KEEP
In a dry and cool place
**SALAMI SAUSAGE / Long-term ripened raw sausage**
*(Raw-fermented sausage type, coarse mixture)*

*Meat grinder use only*

**INGREDIENTS**

**Raw materials:** (calculated for 10 kg batch)

<table>
<thead>
<tr>
<th>Ingredient</th>
<th>Percentage</th>
<th>Quantity</th>
</tr>
</thead>
<tbody>
<tr>
<td>Pork meat, lean</td>
<td>35.00 %</td>
<td>3.500 kg</td>
</tr>
<tr>
<td>Beef trimmings, lean</td>
<td>35.00 %</td>
<td>3.500 kg</td>
</tr>
<tr>
<td>Pork back fat</td>
<td>30.00 %</td>
<td>3.000 kg</td>
</tr>
</tbody>
</table>

**Extenders:** ---

**Additives:**

<table>
<thead>
<tr>
<th>Component</th>
<th>Amount (per kg of raw materials)</th>
<th>Total (for 10 kg)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Nitrite curing salt</td>
<td>28.00 g</td>
<td>280.00 g</td>
</tr>
<tr>
<td>Starter cultures (mixtures)</td>
<td>1.00 g</td>
<td>10.00 g</td>
</tr>
<tr>
<td>Sugar (lactose-glucose)</td>
<td>3.00 g</td>
<td>3.00 g</td>
</tr>
</tbody>
</table>

**Seasonings:**

<table>
<thead>
<tr>
<th>Component</th>
<th>Amount (per kg of raw materials)</th>
<th>Total (for 10 kg)</th>
</tr>
</thead>
<tbody>
<tr>
<td>White pepper, ground</td>
<td>3.00 g</td>
<td>30.00 g</td>
</tr>
<tr>
<td>Mustard seeds</td>
<td>2.00 g</td>
<td>20.00 g</td>
</tr>
<tr>
<td>Coriander, ground</td>
<td>1.00 g</td>
<td>10.00 g</td>
</tr>
<tr>
<td>Pimento</td>
<td>0.50 g</td>
<td>5.00 g</td>
</tr>
</tbody>
</table>

**PROCESSING**

**CUT**

Pork meat into small pieces and keep below –4°C
Back fat into dices (10-20 mm), keep below –4°C

**GRIND**

Lean beef trimmings 3 mm

**MIX**

Raw materials, additives and seasonings

**GRIND**

Mixture 5 mm

**STUFF**

Beef middles (35-45 mm)
Fibrous/collage casings (55-75 mm)

**PORTION**

Link, tie/clip and hang (400-2000 g)

**REDDEN**

6 days at +20-25°C (lower temperature from day 4)

**RIPEN**

At <+14°C for 10 days

**SMOKE**

Cold smoke (<+22°C) on days 2, 4 and 6
(weight loss 30-40%)

**KEEP**

In a dry and cool place
**SALAMI SAUSAGE / Long-term ripened raw sausage**  
*(Raw-fermented sausage type, coarse mixture)*  
*Meat grinder / bowl cutter combined use*

**INGREDIENTS**

**Raw materials:** (calculated for 10 kg batch)

<table>
<thead>
<tr>
<th>%</th>
<th>Material</th>
<th>Quantity</th>
</tr>
</thead>
<tbody>
<tr>
<td>35.00 %</td>
<td>Pork meat, lean</td>
<td>3.500 kg</td>
</tr>
<tr>
<td>35.00 %</td>
<td>Beef trimmings, lean</td>
<td>3.500 kg</td>
</tr>
<tr>
<td>30.00 %</td>
<td>Pork back fat</td>
<td>3.000 kg</td>
</tr>
</tbody>
</table>

**Extenders:** ---

**Additives:**
(per kg of raw materials) (total for 10 kg)

<table>
<thead>
<tr>
<th>g</th>
<th>Additive</th>
<th>Quantity</th>
</tr>
</thead>
<tbody>
<tr>
<td>28.00</td>
<td>Nitrite curing salt</td>
<td>280.00 g</td>
</tr>
<tr>
<td>1.00</td>
<td>Starter cultures (mixtures)</td>
<td>10.00 g</td>
</tr>
<tr>
<td>3.00</td>
<td>Sugar (lactose-glucose)</td>
<td>3.00 g</td>
</tr>
</tbody>
</table>

**Seasonings:**
(per kg of raw materials) (total for 10 kg)

<table>
<thead>
<tr>
<th>g</th>
<th>Seasoning</th>
<th>Quantity</th>
</tr>
</thead>
<tbody>
<tr>
<td>3.00</td>
<td>White pepper, ground</td>
<td>30.00 g</td>
</tr>
<tr>
<td>2.00</td>
<td>Mustard seeds</td>
<td>20.00 g</td>
</tr>
<tr>
<td>1.00</td>
<td>Coriander, ground</td>
<td>10.00 g</td>
</tr>
<tr>
<td>0.50</td>
<td>Pimento</td>
<td>5.00 g</td>
</tr>
</tbody>
</table>

**PROCESSING**

**CUT**

Pork meat into small pieces and keep below –10°C  
Back fat into dices (20 mm), keep below –12°C

**GRIND**

Lean beef trimmings 3 mm, keep chilled (0°C)

**CHOP**

At medium speed the lean pork meat, back fat  
including starter cultures and seasonings  
(until fat displays desired particle size)

**ADD**

At slow speed the ground beef trimmings and  
distribute thoroughly, now add the curing salt and  
continue chopping (final temperature -4°/-6°C)

**STUFF**

Fibrous/collagen casings (55-75 mm)

**REDDEN – RIPEN – SMOKE - STORE**
RAW-COOKED MEAT PRODUCTS

FRANKFURTERS (mixed beef/pork product)
(Raw-cooked sausage type, finely chopped batter)

INGREDIENTS

Raw materials: (calculated for a 30 kg batch)

<table>
<thead>
<tr>
<th>%</th>
<th>Ingredient</th>
<th>Quantity</th>
</tr>
</thead>
<tbody>
<tr>
<td>30.00</td>
<td>Pork meat trimmings, lean</td>
<td>9.000 kg</td>
</tr>
<tr>
<td>20.00</td>
<td>Beef meat trimmings, lean</td>
<td>6.000 kg</td>
</tr>
<tr>
<td>25.00</td>
<td>Fatty pork tissues</td>
<td>7.500 kg</td>
</tr>
<tr>
<td>25.00</td>
<td>Ice (drinking water)</td>
<td>7.500 kg</td>
</tr>
</tbody>
</table>

Additives: (per kg raw materials) (total for 30 kg)

<table>
<thead>
<tr>
<th>g</th>
<th>Additive</th>
<th>Quantity</th>
</tr>
</thead>
<tbody>
<tr>
<td>18.00</td>
<td>Nitrite curing salt</td>
<td>540.00 g</td>
</tr>
<tr>
<td>3.00</td>
<td>Phosphate (pH &gt;7.3)</td>
<td>90.00 g</td>
</tr>
<tr>
<td>0.30</td>
<td>Ascorbic acid</td>
<td>9.00 g</td>
</tr>
</tbody>
</table>

Seasonings: (per kg raw materials) (total for 30 kg)

<table>
<thead>
<tr>
<th>g</th>
<th>Seasoning</th>
<th>Quantity</th>
</tr>
</thead>
<tbody>
<tr>
<td>3.00</td>
<td>White pepper, ground</td>
<td>90.00 g</td>
</tr>
<tr>
<td>1.00</td>
<td>Nutmeg, ground</td>
<td>30.00 g</td>
</tr>
<tr>
<td>0.50</td>
<td>Cardamom, ground</td>
<td>15.00 g</td>
</tr>
<tr>
<td>0.20</td>
<td>Coriander, ground</td>
<td>6.00 g</td>
</tr>
</tbody>
</table>

PROCESSING

<table>
<thead>
<tr>
<th>Step</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>GRIND</td>
<td>Meats and fats separately 3 mm</td>
</tr>
<tr>
<td>CHILL</td>
<td>Meats and fats over night at &lt; +4°C</td>
</tr>
<tr>
<td>CHOP</td>
<td>Ground meat, ice and additives for 10-15 rounds</td>
</tr>
<tr>
<td></td>
<td>Add fats and seasonings and chop until +12°C</td>
</tr>
<tr>
<td>STUFF</td>
<td>Sheep casings (24/26 mm) or pig casings (26/28 mm)</td>
</tr>
<tr>
<td>LINK</td>
<td>To desired length and twist</td>
</tr>
<tr>
<td>SMOKE</td>
<td>At +65°C for 40 min.</td>
</tr>
<tr>
<td>COOK</td>
<td>In water or steam +76°C for &gt; 30 min.</td>
</tr>
<tr>
<td></td>
<td>(core temperature &gt; +72°C for all products)</td>
</tr>
<tr>
<td>COOL</td>
<td>Under cold shower or in water until &lt;+20°C</td>
</tr>
<tr>
<td>STORE</td>
<td>In chiller below +4°C, shelf life &lt; 14 days</td>
</tr>
</tbody>
</table>
**VIENNA SAUSAGES** (premium quality, mixed beef/pork product)  
*(Raw-cooked sausage type, finely chopped batter)*

**INGREDIENTS**

**Raw materials:** (calculated for a 30 kg batch)

<table>
<thead>
<tr>
<th>Percentage</th>
<th>Description</th>
<th>Quantity</th>
</tr>
</thead>
<tbody>
<tr>
<td>40.00 %</td>
<td>Pork meat trimmings, lean</td>
<td>12.000 kg</td>
</tr>
<tr>
<td>16.00 %</td>
<td>Beef meat trimmings, lean</td>
<td>4.800 kg</td>
</tr>
<tr>
<td>22.00 %</td>
<td>Fatty pork tissues</td>
<td>6.600 kg</td>
</tr>
<tr>
<td>22.00 %</td>
<td>Ice (drinking water)</td>
<td>6.600 kg</td>
</tr>
</tbody>
</table>

**Extenders:** ---

**Additives:**

(per kg raw materials)  
(total for 30 kg)

<table>
<thead>
<tr>
<th>Amount</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>18.00 g</td>
<td>Nitrite curing salt</td>
</tr>
<tr>
<td>3.00 g</td>
<td>Phosphate (pH &gt;7.3)</td>
</tr>
<tr>
<td>0.30 g</td>
<td>Ascorbic acid</td>
</tr>
</tbody>
</table>

**Seasonings:**

(per kg raw materials)  
(total for 30 kg)

<table>
<thead>
<tr>
<th>Amount</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>3.00 g</td>
<td>White pepper, ground</td>
</tr>
<tr>
<td>1.00 g</td>
<td>Nutmeg, ground</td>
</tr>
<tr>
<td>0.50 g</td>
<td>Cardamom, ground</td>
</tr>
<tr>
<td>0.20 g</td>
<td>Coriander, ground</td>
</tr>
</tbody>
</table>

**PROCESSING**

**GRIND**  
Meats and fats separately 3 mm

**CHILL**  
Meats and fats over night at < +4°C

**CHOP**  
Ground meat, ice and additives for 10-15 rounds  
Add fats and seasonings and chop until +12°C

**STUFF**  
Sheep casings (20/22 mm)

**LINK**  
To desired length and twist

**SMOKE**  
At +65°C for 40 min.

**COOK**  
In water or steam +76°C for > 30 min.  
(core temperature > +72°C for all products)

**COOL**  
Under cold shower or in water until <+20°C

**STORE**  
In chiller below +4°C, shelf life < 14 days
**CHICKEN VIENNAS** (premium quality, pure poultry product)  
*(Raw-cooked sausage type, finely chopped batter)*

**INGREDIENTS**

**Raw materials:**  
(calculated for a 30 kg batch)

<table>
<thead>
<tr>
<th>Percentage</th>
<th>Description</th>
<th>Quantity</th>
</tr>
</thead>
<tbody>
<tr>
<td>50.00 %</td>
<td>Chicken meat trimmings, lean</td>
<td>15.000 kg</td>
</tr>
<tr>
<td>10.00 %</td>
<td>Vegetable oil</td>
<td>3.000 kg</td>
</tr>
<tr>
<td>20.00 %</td>
<td>Chicken fat emulsion (1:6:6)</td>
<td>6.000 kg</td>
</tr>
<tr>
<td>20.00 %</td>
<td>Ice (drinking water)</td>
<td>6.000 kg</td>
</tr>
</tbody>
</table>

**Extenders:**  
---

**Additives:**  
(per kg raw materials and extenders)  
(total for 30 kg)

<table>
<thead>
<tr>
<th>Quantity</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>10.00 g</td>
<td>Nitrite curing salt</td>
</tr>
<tr>
<td>2.00 g</td>
<td>Phosphate</td>
</tr>
<tr>
<td>0.10 g</td>
<td>Sodium erythorbate</td>
</tr>
<tr>
<td>1.00 g</td>
<td>Food colouring (liquid)</td>
</tr>
<tr>
<td>300.00 g</td>
<td>(total for 30 kg)</td>
</tr>
<tr>
<td>60.00 g</td>
<td></td>
</tr>
<tr>
<td>3.00 g</td>
<td></td>
</tr>
<tr>
<td>30.00 g</td>
<td></td>
</tr>
</tbody>
</table>

**Seasonings:**  
(per kg raw materials and extenders)  
(total for 30 kg)

<table>
<thead>
<tr>
<th>Quantity</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>2.00 g</td>
<td>White pepper, ground</td>
</tr>
<tr>
<td>0.30 g</td>
<td>Nutmeg, ground</td>
</tr>
<tr>
<td>0.60 g</td>
<td>Garlic powder</td>
</tr>
<tr>
<td>60.00 g</td>
<td>(total for 30 kg)</td>
</tr>
<tr>
<td>9.00 g</td>
<td></td>
</tr>
<tr>
<td>18.00 g</td>
<td></td>
</tr>
</tbody>
</table>

**PROCESSING**

**GRIND**  
Meat trimmings 3 mm

**EMULSIFY**  
Chicken skin/fats, chill emulsions at < 0°C

**CHILL**  
Meat trimmings and vegetable oil over night

**CHOP**  
Meats, ice, extenders and additives for 10-15 rounds  
Add fat emulsion and seasonings and chop until +12°C

**STUFF**  
Into sheep or collagen casings, 20-22 mm and link

**SMOKE**  
Dry for 30 min. at +45°C, smoke at +65°C for 30 min.

**COOK**  
In water or steam at +75°C for 20 min.

**COOL**  
under cold shower or in water, vacuum pack and chill

**STORE**  
< +4 C, shelf life less than 10 days

* Part of the lean chicken meat is often replaced by other poultry meats, mostly turkey, to improve texture, colour and binding; subject to availability.
**BEEF FRANKFURTERS** (pure beef product)  
*(Raw-cooked sausage type, finely chopped batter)*

**INGREDIENTS**

**Raw materials:** (calculated for a 30 kg batch)

<table>
<thead>
<tr>
<th>Percentage</th>
<th>Ingredient</th>
<th>Quantity</th>
</tr>
</thead>
<tbody>
<tr>
<td>40.00 %</td>
<td>Beef meat trimmings, lean</td>
<td>12.000 kg</td>
</tr>
<tr>
<td>20.00 %</td>
<td>Beef meat trimming, fatty</td>
<td>6.000 kg</td>
</tr>
<tr>
<td>15.00 %</td>
<td>Vegetable oil</td>
<td>4.500 kg</td>
</tr>
<tr>
<td>25.00 %</td>
<td>Ice (drinking water)</td>
<td>7.500 kg</td>
</tr>
</tbody>
</table>

**Extenders:** ---

**Additives:**

(per kg raw materials) (total for 30 kg)

<table>
<thead>
<tr>
<th>Grams</th>
<th>Ingredient</th>
<th>Quantity</th>
</tr>
</thead>
<tbody>
<tr>
<td>18.00 g</td>
<td>Nitrite curing salt</td>
<td>540.00 g</td>
</tr>
<tr>
<td>3.00 g</td>
<td>Phosphate (pH &gt;7.3)</td>
<td>90.00 g</td>
</tr>
<tr>
<td>0.30 g</td>
<td>Ascorbic acid</td>
<td>9.00 g</td>
</tr>
</tbody>
</table>

**Seasonings:**

(per kg raw materials) (total for 30 kg)

<table>
<thead>
<tr>
<th>Grams</th>
<th>Ingredient</th>
<th>Quantity</th>
</tr>
</thead>
<tbody>
<tr>
<td>3.00 g</td>
<td>White pepper, ground</td>
<td>90.00 g</td>
</tr>
<tr>
<td>1.00 g</td>
<td>Nutmeg, ground</td>
<td>30.00 g</td>
</tr>
<tr>
<td>0.50 g</td>
<td>Cardamom, ground</td>
<td>15.00 g</td>
</tr>
<tr>
<td>0.20 g</td>
<td>Coriander, ground</td>
<td>6.00 g</td>
</tr>
</tbody>
</table>

**PROCESSING**

**GRIND**  
Beef meats 3 mm

**CHILL**  
Meats and vegetable oil over night at < +4°C

**CHOP**  
Ground meats, ice and additives for 25 rounds  
Add vegetable oil and seasonings, chop until +12°C

**STUFF**  
In sheep or collagen casings, 24/26 mm

**LINK**  
To desired length and twist

**SMOKE**  
At +65°C for 40 min.

**COOK**  
In water or steam +76°C for > 30 min.  
(core temperature > +72°C)

**COOL**  
Under cold shower or in water until <+20°C

**STORE**  
In chiller below +4°C, shelf life < 14 days
**LYONER / Fine ham sausage**  
*(Raw-cooked sausage type, finely chopped batter)*

### INGREDIENTS

**Raw materials:**  
(calculated for 30 kg medium batch)

<table>
<thead>
<tr>
<th>Percentage</th>
<th>Ingredient</th>
<th>Quantity</th>
</tr>
</thead>
<tbody>
<tr>
<td>40.00 %</td>
<td>Pork meat trimmings, lean</td>
<td>12.000 kg</td>
</tr>
<tr>
<td>15.00 %</td>
<td>Beef meat trimmings, lean</td>
<td>4.500 kg</td>
</tr>
<tr>
<td>22.50 %</td>
<td>Fatty pork tissues</td>
<td>6.750 kg</td>
</tr>
<tr>
<td>22.50 %</td>
<td>Ice (potable water)</td>
<td>6.750 kg</td>
</tr>
</tbody>
</table>

**Extenders:**  
---

**Additives:**  
(per kg raw materials)  
(total for 30 kg)

<table>
<thead>
<tr>
<th>Quantity</th>
<th>Ingredient</th>
</tr>
</thead>
<tbody>
<tr>
<td>18.00 g</td>
<td>Nitrite curing salt</td>
</tr>
<tr>
<td>3.00 g</td>
<td>Phosphate (pH &gt;7.3)</td>
</tr>
<tr>
<td>0.30 g</td>
<td>Ascorbic acid</td>
</tr>
</tbody>
</table>

**Seasonings:**  
(per kg raw materials)  
(total for 30 kg)

<table>
<thead>
<tr>
<th>Quantity</th>
<th>Ingredient</th>
</tr>
</thead>
<tbody>
<tr>
<td>2.00 g</td>
<td>White pepper, ground</td>
</tr>
<tr>
<td>0.50 g</td>
<td>Nutmeg, ground</td>
</tr>
<tr>
<td>0.50 g</td>
<td>Mace, ground</td>
</tr>
<tr>
<td>0.30 g</td>
<td>Cardamom, ground</td>
</tr>
</tbody>
</table>

### PROCESSING

**GRIND**  
Meats and fats separately 3 mm

**CHILL**  
Meats and fats overnight at < +4°C

**CHOP**  
Ground meat, ice and additives for 10-15 rounds  
Add fats and seasonings and chop until +12°C

**STUFF**  
Plastic casings, 60 mm  or  Cattle rounds, 40 mm

**SMOKE**  
N/A  
at +65°C for 40 min.

**COOK**  
At +76°C for 75 min.  
at +76°C for 40 min.  
(core temperature > +72°C for both casing formats)

**COOL**  
Under cold shower or in water until <+20°C

**STORE**  
In chiller below +4°C, shelf life < 14 days
**COARSE HAM SAUSAGE**
*(Raw-cooked sausage type, finely chopped batter with coarse meats)*

**INGREDIENTS**

<table>
<thead>
<tr>
<th>Raw materials: (calculated for 30 kg batch)</th>
</tr>
</thead>
<tbody>
<tr>
<td>50.00 % Lyoner sausage mix (raw batter)</td>
</tr>
<tr>
<td>15.000 kg</td>
</tr>
<tr>
<td>40.00 % Pork meat, lean, no tendons</td>
</tr>
<tr>
<td>12.000 kg</td>
</tr>
<tr>
<td>10.00 % Pork belly without skin (50/50)</td>
</tr>
<tr>
<td>3.000 kg</td>
</tr>
</tbody>
</table>

**Extenders:** ---

**Additives:** (per kg pork meat and belly – 15 kg) (total for 15 kg)

| Nitrite curing salt | 270.00 g |
| Phosphate           | 45.00 g  |

**Seasonings:** (per kg pork meat and belly – 15 kg) (total for 15 kg)

| White pepper, ground | 30.00 g  |
| Mace, ground         | 7.50 g   |
| Coriander, ground    | 7.50 g   |
| Ginger, ground       | 7.50 g   |

**PROCESSING**

**CUT**

pork meat and belly in small pieces

**MIX**
pork meat, belly, salt and spices

**GRIND**
Mixture 8-13 mm and store over night in cold room

**MIX**
Lyoner batter and ground mixture

**STUFF**
Plastic casings, 60 mm or cattle rounds, 40 mm

**SMOKE**
N/A at +65°C for 60 min.

**COOK**
At +75°C for 75 min. at +76°C for 40 min.
(core temperature > +72°C for both casing formats)

**COOL**
Under cold shower or in water, drain and air-dry

**STORE**
In chiller below +4°C, shelf life < 14 days
**WHITE SAUSAGE / Veal Sausage** (Bavaria)
*(Raw-cooked sausage type, finely chopped batter)*

**INGREDIENTS**

Raw materials: (calculated for 30 kg batch)

<table>
<thead>
<tr>
<th>Ingredient</th>
<th>Percentage</th>
<th>Quantity</th>
</tr>
</thead>
<tbody>
<tr>
<td>Veal trimmings</td>
<td>30.00 %</td>
<td>9.000 kg</td>
</tr>
<tr>
<td>Pork trimmings</td>
<td>20.00 %</td>
<td>6.000 kg</td>
</tr>
<tr>
<td>Pork fat, soft fatty tissue</td>
<td>25.00 %</td>
<td>7.500 kg</td>
</tr>
<tr>
<td>Ice (drinking water)</td>
<td>25.00 %</td>
<td>7.500 kg</td>
</tr>
</tbody>
</table>

Extenders: ---

Additives: (per kg raw materials) (total for 30 kg)

<table>
<thead>
<tr>
<th>Additive</th>
<th>Quantity</th>
</tr>
</thead>
<tbody>
<tr>
<td>Common salt</td>
<td>540.00 g</td>
</tr>
<tr>
<td>Phosphate</td>
<td>90.00 g</td>
</tr>
</tbody>
</table>

Seasonings: (per kg raw materials) (total for 30 kg)

<table>
<thead>
<tr>
<th>Seasoning</th>
<th>Quantity</th>
</tr>
</thead>
<tbody>
<tr>
<td>White pepper, ground</td>
<td>30.00 g</td>
</tr>
<tr>
<td>Ginger, ground</td>
<td>15.00 g</td>
</tr>
<tr>
<td>Mace, ground</td>
<td>15.00 g</td>
</tr>
<tr>
<td>Lemon skin</td>
<td>15.00 g</td>
</tr>
<tr>
<td>Parsley leaves, fresh</td>
<td>30.00 g</td>
</tr>
<tr>
<td>Onions, fresh</td>
<td>3 pieces</td>
</tr>
</tbody>
</table>

**PROCESSING**

**CUT**
Meats and fatty tissues in small pieces

**CHILL**
Meats and fats over night at < +4°C

**GRIND**
Meats and fats separately 3 mm

**CHOP**
Ground meat, ice and ingredients for 10 rounds. Add fats and seasonings and chop until +12°C

**STUFF**
In hog casings 26/28 mm

**COOK**
In water at +74°C for 40 min.

**COOL**
Under cold shower or in cold water

**PREPARE**
Traditionally eaten immediately after production
Heated in simmering water

**STORE**
Optional: In chiller below +4°C, shelf life < 5 days
KRAKOW SAUSAGE (Polish traditional product)*
(Raw-cooked sausage type, finely chopped batter with coarse meats)

**INGREDIENTS**

**Raw materials:** (calculated for 30 kg batch)
- 10.00 % Beef trimmings, high collagen content 3.000 kg
- 10.00 % Pork trimmings, high collagen content 3.000 kg
- 10.00 % Ice (potable water) 3.000 kg
- 50.00 % Pork meat, lean, no tendons 15.000 kg
- 20.00 % Pork belly without skin 6.000 kg

**Extenders:** ---

**Additives:**
(per kg raw materials) (total for 30 kg)
- 18.00 g Nitrite curing salt 540.00 g
- 3.00 g Phosphate 90.00 g

**Seasonings:**
(per kg pork meat and belly – 15 kg) (total for 30 kg)
- 2.00 g Black pepper, ground 60.00 g
- 0.20 g Cardamom, ground 6.00 g
- 0.50 g Mace, ground 15.00 g

**PROCESSING**

**CUT** Lean pork meat and belly in small pieces
**MIX** Lean meat, belly, remaining additives, seasonings
**GRIND** Mixture 13 mm and store over night in cold room
**GRIND** Beef and pork trimmings 3 mm
**CHOP** Ground trimmings with ice, and 30% additives
In bowl cutter until a fine lean batter is achieved
**MIX** Fine lean batter and chilled ground mixture
**STUFF** Into fibrous or collagen casings 60-75 mm
**SMOKE** Hot at +65°C for 60 min.
**COOK** At +75°C for 75-90 min. (core temp. > +72°C)
**COOL** Under cold shower or in water, drain and air-dry
**SMOKE** Cold at +18-22°C the following day
**STORE** In cold room below +12°C

* Due to continuing moisture loss, the product can become semi-dry and display a reasonable shelf-life at cooler temperatures
BUFFALO SAUSAGE (non-pork product)
(Raw-cooked sausage type, finely chopped batter with coarse meats)

INGREDIENTS

Raw materials: (calculated for 30 kg batch)
45.00 % Lean buffalo meat 13.500 kg
35.00 % Buffalo trimmings (30 % fat) 10.500 kg
10.00 % Buffalo brisket fat or beef hump fat 3.000 kg
10.00 % Ice (drinking water) 3.000 kg

Extenders: ---

Additives: (per kg of material) (total for 30 kg)
18.00 g Nitrite curing salt 540.00 g
3.00 g Phosphate 90.00 g
0.30 g Ascorbic Acid 9.00 g

Seasonings: (per kg of material) (total for 30 kg)
3.0 g White pepper, ground 30.00 g
1.0 g Nutmeg, ground 10.00 g
0.5 g Coriander, ground 5.00 g
0.5 g Chilli, ground 5.00 g
2.0 g Garlic, fresh 20.00 g

PROCESSING

GRIND Lean buffalo meat 3 mm, trimmings 5 mm, fats 13 mm
Store overnight in cold room

CHOP Lean buffalo meat, ice, additives, spices until fine batter
Add fat and distribute in slow gear evenly
Add trimmings and distribute in slow gear evenly

STUFF Into plastic casings into tin plate cans
Diameter 75 mm size 73/110

COOK At +75°C for 90 min. at +121°C for 120 min.
(core temp +72°C) (core temp +114°C, F-value 12)

COOL Under cold shower or in cold water, drain and air-dry

STORE In cold rooms below +4°C below +40°C
Shelf life < 14 days shelf life 1 year as
fully sterilized cans
MORTADELLA (with slaughter by-products, Italy)
(Raw-cooked sausage type, finely chopped batter)

INGREDIENTS

Raw materials: (calculated for 30 kg batch)
30.00 % Beef trimmings  9.000 kg  
20.00 % Pork/beef (gullet, skirt, cheeks)  6.000 kg  
15.00 % Fatty tissues  4.500 kg  
10.00 % Soft by-products (lung, spleen, etc.)  3.000 kg  
15.00 % Ice (potable water)  4.500 kg  

Extenders:  (calculated for 30 kg batch)
10.00 % Wheat flour  3.000 kg  

Additives:
(per kg raw materials)  (total for 30 kg)
18.00 g Nitrite curing salt  540.00 g  
3.00 g Phosphate  90.00 g  
0.30 g Ascorbic acid  9.00 g  

Seasonings:
(per kg raw materials)  (total for 30 kg)
2.50 g White pepper, ground  75.00 g  
1.00 g Nutmeg, ground  30.00 g  
0.50 g Cardamom, ground  15.00 g  
0.50 g Coriander, ground  15.00 g  
0.20 g Cloves, ground  6.00 g  
0.20 g Fresh garlic  6.00 g  

PROCESSING*

CUT  Meat, fats and by-products in small pieces
GRIND  Meat, fats and by-products separately 3 mm
CHOP  Meat, by-products, ice and additives for 10 to 15 rounds
   Add fatty tissue, seasonings and chop until +12°C
STUFF  Into plastic casings diameter 120-240 mm
COOK  At +80°C for > 150-280 min. (core temp. >+72°C)
COOL  Under cold shower or in cold water, drain and air-dry
STORE  In cold room below +4°C, shelf life < 14 days

* Sometimes small back fat cubes (5 mm) and pistachio are added
### BEEF FRANKFURTERS (moderately extended)
*(Raw-cooked sausage type, finely chopped batter)*

#### INGREDIENTS

**Raw materials:** (calculated for a 30 kg batch)

<table>
<thead>
<tr>
<th>Percentage</th>
<th>Ingredient</th>
<th>Quantity</th>
</tr>
</thead>
<tbody>
<tr>
<td>33.00 %</td>
<td>Beef meat trimmings, lean</td>
<td>9.900 kg</td>
</tr>
<tr>
<td>20.00 %</td>
<td>Beef trimmings, fatty</td>
<td>6.000 kg</td>
</tr>
<tr>
<td>20.00 %</td>
<td>Vegetable oil</td>
<td>6.000 kg</td>
</tr>
<tr>
<td>25.00 %</td>
<td>Ice (drinking water)</td>
<td>7.500 kg</td>
</tr>
</tbody>
</table>

**Extenders:** (calculated for a 30 kg batch)

<table>
<thead>
<tr>
<th>Percentage</th>
<th>Ingredient</th>
<th>Quantity</th>
</tr>
</thead>
<tbody>
<tr>
<td>2.00 %</td>
<td>Wheat flour</td>
<td>0.600 kg</td>
</tr>
</tbody>
</table>

**Additives:**

(Per kg raw materials and extenders) (total for 30 kg)

<table>
<thead>
<tr>
<th>Quantity</th>
<th>Ingredient</th>
</tr>
</thead>
<tbody>
<tr>
<td>18.00 g</td>
<td>Nitrite curing salt</td>
</tr>
<tr>
<td>3.00 g</td>
<td>Phosphate (pH &gt; 7.3)</td>
</tr>
<tr>
<td>0.30 g</td>
<td>Ascorbic acid</td>
</tr>
</tbody>
</table>

**Seasonings:**

(Per kg raw materials) (total for 30 kg)

<table>
<thead>
<tr>
<th>Quantity</th>
<th>Ingredient</th>
</tr>
</thead>
<tbody>
<tr>
<td>3.00 g</td>
<td>White pepper, ground</td>
</tr>
<tr>
<td>1.00 g</td>
<td>Nutmeg, ground</td>
</tr>
<tr>
<td>0.50 g</td>
<td>Cardamom, ground</td>
</tr>
<tr>
<td>0.20 g</td>
<td>Coriander, ground</td>
</tr>
<tr>
<td>0.50 g</td>
<td>Garlic, fresh</td>
</tr>
</tbody>
</table>

#### PROCESSING

**GRIND**  
Meat and fatty trimmings separately 3 mm

**CHILL**  
Meats, fats and vegetable oil over night at < +4°C

**CHOP**  
Ground meats, ice and additives for 15-20 rounds  
Add slowly vegetable oil, seasonings; chop until +12°C

**STUFF**  
Sheep or collagen casings, 20-24 mm

**LINK**  
To desired length and twist (60-100 g)

**SMOKE**  
At +65°C for 40 min.

**COOK**  
In water or steam +76°C for > 30 min.  
(core temperature > +72°C)

**COOL**  
Under cold shower or in water until <+20°C

**STORE**  
In chiller below +4°C, shelf life < 14 days
**BEEF HOTDOG** (substantially extended)
*(Raw-cooked sausage type, finely chopped batter)* (see also page 204)

**INGREDIENTS**

**Raw materials:** (calculated for a 30 kg batch)

- 35.00% Beef meat trimmings, lean: 10.500 kg
- 14.00% Fat emulsion (1:6:6): 4.200 kg
- 20.00% Ice (drinking water): 6.000 kg

**Extenders:** (calculated for a 30 kg batch)

- 18.00% Water for hydration of TVP (1:3): 5.400 kg
- 6.00% TVP (Textured Vegetable Protein): 1.800 kg
- 0.50% ISP (Isolated Soya Protein): 0.150 kg
- 5.00% Potato starch: 1.500 kg
- 1.50% Skimmed milk: 0.450 kg

**Additives:**

- (per kg raw materials and extenders) (total for 30 kg)
  - 10.00 g Nitrite curing salt: 300.00 g
  - 2.00 g Phosphate: 60.00 g
  - 2.00 g Carrageenan: 60.00 g
  - 0.10 g Sodium erythorbate: 3.00 g

**Seasonings:**

- (per kg raw materials and extenders) (total for 30 kg)
  - 2.00 g White pepper, ground: 60.00 g
  - 0.30 g Nutmeg, ground: 9.00 g
  - 0.60 g Garlic powder: 18.00 g
  - 0.35 g Paprika: 10.50 g
  - 0.35 g Mustard seeds, ground: 10.50 g

**PROCESSING**

- **GRIND** Meat trimmings 3 mm and chill over night
- **EMULSIFY** ISP, water and vegetable oil, chill emulsion at < 0°C
- **HYDRATE** TVP by mixing with cold water 1:3
- **CHOP** Meats, ice, extenders and additives for 10-15 rounds
  Add fat emulsion and seasonings and chop until +12°C
- **STUFF** Into peeling casings diameter 20-22 mm and link
- **SMOKE** Dry for 30 min. at +45°C, smoke at +65°C for 30 min.
- **COOK** In water or steam at +75°C for 20 min.
- **COOL** under cold shower or in water, vacuum pack and chill
- **STORE** < +4°C, shelf life less than 14 days
**CHICKEN HOTDOG** (substantially extended)
*(Raw-cooked sausage type, finely chopped batter)*

**INGREDIENTS**

**Raw materials:** (calculated for 30 kg batch)

- 20.00% Chicken meat trimmings, lean 6.000 kg
- 20.00% Chicken MDM 6.000 kg
- 20.00% Chicken fat emulsion (1:6:6) 6.000 kg
- 18.00% Ice (drinking water) 5.400 kg

**Extenders:**

- 12.00% Water for hydration of TVP (1:3) 3.600 kg
- 4.00% TVP (Textured Vegetable Protein) 1.200 kg
- 0.50% ISP (Isolated Soya Protein) 0.150 kg
- 4.00% Potato starch 1.200 kg
- 1.50% Skimmed milk 0.450 kg

**Additives:**

(per kg raw materials and extenders) (total for 30 kg)

- 10.00 g Nitrite curing salt 300.00 g
- 2.00 g Phosphate 60.00 g
- 0.10 g Sodium erythorbate 3.00 g
- 1.00 g Food colouring (liquid) 30.00 g

**Seasonings:**

(per kg raw materials and extenders) (total for 30 kg)

- 2.00 g White pepper, ground 60.00 g
- 0.30 g Nutmeg, ground 9.00 g
- 0.60 g Garlic powder 18.00 g

**PROCESSING**

- **GRIND**  Meat trimmings 3 mm and chill over night
- **EMULSIFY** Vegetable oil and chicken fats, chill emulsions at < 0°C
- **HYDRATE** TVP by mixing with cold water 1:3
- **CHOP** Meats, ice, extenders and additives for 10-15 rounds
  Add fat emulsion and seasonings and chop until +12°C
- **STUFF** Into peeling casings diameter 20-22 mm and link
- **SMOKE** Dry for 30 min. at +45°C, smoke at +65°C for 30 min.
- **COOK** In water or steam at +75°C for 20 min.
- **COOL** Under cold shower or in water, vacuum pack and chill
- **STORE** <4°C, SHELF LIFE LESS THAN 10 DAYS
BREAKFAST SAUSAGE (moderately extended)
(Raw-cooked sausage type, finely chopped batter)

INGREDIENTS

Raw materials: (calculated for 30 kg batch)
- 30.00 % Beef meat trimmings, lean 9.000 kg
- 20.00 % Pork meat trimmings, lean 6.000 kg
- 20.00 % Fatty pork tissues 6.000 kg
- 18.00 % Ice (potable water) 5.400 kg

Extenders:
- 6.00 % Wheat flour 1.800 kg
- 4.00 % Rusk (baked and crushed flour) 1.200 kg
- 2.00 % Corn starch 0.600 kg

Additives: (per kg raw materials) (total for 30 kg)
- 16.0 g Common salt 480.00 g
- 3.0 g Phosphate 90.00 g
- 0.3 g Ascorbic acid 9.00 g
- 0.5 g MSG (mono sodium glutamate) 15.00 g

Seasonings: (per kg raw materials) (total for 30 kg)
- 2.0 g White pepper, ground 60.00 g
- 0.3 g Nutmeg, ground 9.00 g
- 0.3 g Mace, ground 9.00 g
- 0.2 g Coriander, ground 6.00 g
- 0.2 g Ginger, ground 6.00 g

PROCESSING

CUT Meat trimmings and fatty tissues in small pieces
CHILL Meat trimmings and fats over night
GRIND Meat trimmings and fats separately 3 mm
CHOP Meat mince, fats, ice, spices and additives to +12°C
STUFF Into collagen casings 26-28 mm, link 50 g
PACK 10-20 pieces (0.5-1.0 kg) in plastic pouches
STORE In deep-freezer below –18°C, shelf life 3 to 6 months
Stored raw frozen, heat-treated only prior to consumption
MEAT LOAVES

The common formulations for raw-cooked sausages can be used in principle for the fabrication of product mixes for meat loaves. There are meat loaves entirely composed of finely chopped batter and varieties consisting of fine batter mixed with coarse meat materials (usually ground 5-12 mm). Meat loaves are subject to intensive heat treatment when they are baked in ovens at +150°C, resulting in some weight loss (water evaporation). Usually the salt content is slightly reduced (from 18g to 16g calculated per kg of total raw materials).

Common recipes used for the fabrication of meat loaves are frankfurters (page 400) and coarse ham sausage (page 405), with the above mentioned adjustment on salt content.

MEAT BALLS

Raw-cooked meat mixes are used for the material, from which meat balls are shaped. These mixes are mainly fabricated without curing substances but with common salt, as for the majority of such products a grey colour is required. Formulations usually have high contents of lean meat (fat and water contents significantly reduced) to make these products firm-elastic. The salt content is reduced to 10-12g per kilo and often herbs are added.

Especially in Asia, there are several varieties of low-cost meat balls on the market. These meat balls are used as street food and in fast food outlets. One common formulation is shown below:

**Raw materials:** (calculated for 10 kg batch)

<table>
<thead>
<tr>
<th>Percentage</th>
<th>Description</th>
<th>Quantity</th>
</tr>
</thead>
<tbody>
<tr>
<td>40.00 %</td>
<td>Pork meat trimmings, lean</td>
<td>4.000 kg</td>
</tr>
<tr>
<td>20.00 %</td>
<td>TVP (re-hydrated 1:3)</td>
<td>2.000 kg</td>
</tr>
<tr>
<td>10.00 %</td>
<td>Wheat flour</td>
<td>1.000 kg</td>
</tr>
<tr>
<td>10.00 %</td>
<td>Ice (potable water)</td>
<td>1.000 kg</td>
</tr>
<tr>
<td>15.00 %</td>
<td>Fatty pork tissues</td>
<td>1.500 kg</td>
</tr>
<tr>
<td>5.00 %</td>
<td>Potato or corn starch</td>
<td>0.500 kg</td>
</tr>
</tbody>
</table>

**Additives and spices:** (per kg raw materials)

<table>
<thead>
<tr>
<th>Quantity</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>10.0 g</td>
<td>Common salt</td>
</tr>
<tr>
<td>2.0 g</td>
<td>Phosphate</td>
</tr>
<tr>
<td>2.0 g</td>
<td>White pepper, ground</td>
</tr>
<tr>
<td>0.2 g</td>
<td>Coriander, ground</td>
</tr>
<tr>
<td>0.2 g</td>
<td>Ginger, ground</td>
</tr>
</tbody>
</table>

60.00 g
PRECOOKED-COOKED PRODUCTS

CORNED BEEF (traditional method, South America)
(Precooked-cooked meat product, coarse mixture)

The described procedure is a small-scale processing method. Industrial processing method see page 169.

INGREDIENTS

Raw materials: (calculated for 10 kg batch)
80.00 %  Beef meat pieces, lean  8.000 kg
20.00 %  Beef meat trimmings    2.000 kg

Curing brine (10 litres):
(per litre brine) (total for 10 kg)
22.00 g  Nitrite curing salt  220.00 g
  2.00 g  Sugar          20.00 g

PROCESSING

CUT  Beef meat in uniform big stripes
CURE Meat for 4 days in curing brine at +10°C
COOK Beef meat stripes at +82°C *
CHECK Meat for tendons, remove if necessary
GRIND Cooked meat through kidney plate, reverse knife
STUFF Into typical cans (compact properly) and seal
COOK Sterilise cans to F-value 12-14
COOL On air or in water
STORE at ambient temperature

* Cooking loss around 30-35 %, often small layer of cooked fats is added on top.
CORNED BEEF (premium quality, spiced variety, Philippines)  
(Precooked-cooked meat product, coarse mixture)

Similar variations are common also on the Pacific islands. The corned beef is prepared with onions, garlic and often potato pieces and consumed hot together with cooked/steamed rice.

**INGREDIENTS**

**Raw Materials:** (calculated for 10 kg batch)
- 50.00 % Beef meat and brisket)  5.000 kg
- 50.00 % Buffalo meat trimmings, lean  5.000 kg

**Curing brine:** (2.500 kg brine, 10% salt solution)
- 88.86 % Potable water  2.224.00 g
- 10.00 % Nitrite curing salt  250.00 g
- 1.00 % Sugar, refined  25.00 g
- 1.50 % Phosphate (soluble)  37.50 g
- 0.04 % Sodium erythorbate  1.00 g

**Seasonings:**
- (per kg raw materials)  (total for 10 kg)
  - 1.50 g Ground black pepper  15.00 g
  - 2.00 g Chopped garlic, fresh  20.00 g
  - 0.05 g Bay leaf  0.50 g
  - 3.00 g Oregano powder  30.00 g

**PROCESSING**

**CUT**  
Fresh/ chilled meats into 50 mm cubes

**BRINE**  
Mix cold water (+4°C) with ingredients, start with phosphate (soluble), thereafter nitrite curing salt, thereafter sugar, sodium erythorbate (see page 180)

**CURE**  
Meat in a clean container submerged in brine at +4 for 1 day

**WASH**  
Cured meat once with potable water

**COOK**  
Meat with seasonings in pressure cooker for 1 hour

**FLAKE**  
Meat pieces and remix with broth (7:3)

**STUFF**  
Into cans and sterilize at +110°C to F-value 12

**STORE**  
At ambient temperature
CORNED BEEF (substantially extended, spicy, Philippines)
(Precooked-cooked meat product, coarse mixture) (see also page 212)

INGREDIENTS

Raw Materials: (calculated for 10 kg batch)
25.00 % Beef meat and brisket) 2.500 kg
50.00 % Buffalo meat trimmings, lean 5.000 kg

Extenders: (calculated for 10 kg batch)
10.00 % Pork skin 1.000 kg
10.00 % Potable water (for re-hydration) 1.000 kg
5.00 % TVP (textured vegetable protein) 0.500 kg
0.50 % Carrageenan 0.050 kg

Curing brine: (2.500 kg brine, 10% salt solution)
88.86 % Potable water 2.224.00 g
10.00 % Nitrite curing salt 250.00 g
5.00 % Sugar, refined 125.00 g
0.10 % Sodium erythorbate 2.50 g

Seasonings: (per kg raw materials ) (total for 10 kg)
2.00 g Ground black pepper 20.00 g
2.00 g Chopped garlic, fresh 20.00 g
3.00 g Oregano powder 30.00 g
1.00 g Ginger, ground 10.00 g
1.00 g MSG (mono sodium glutamate) 10.00 g

PROCESSING

CUT Fresh/ chilled meats into 50 mm cubes
BRINE Mix brine components, start with phosphate (soluble), nitrite curing salt, sugar, sodium erythorbate
CURE Meat in a clean container submerged in brine at +4°C for 1 day
RE-HYDRATE TVP with potable water allocation
COOK Meat, pork skin with seasonings for 1 hour
FLAKE Meat, grind pork skin, remix with broth (7:3)
STUFF Into plastic bags (250, 500 g) and seal
STORE In deep-freezer, cook prior to consumption
FINE LIVER SAUSAGE / LIVER PATE
(Precooked-cooked sausage type, finely chopped batter)

INGREDIENTS

Raw materials: (calculated for 30 kg batch)

35.00 % Pork liver, raw 10.500 kg
50.00 % Pork belly, pre-cooked 15.000 kg
(fresh weight 19.5 kg, cooking loss 4.500 kg)
15.00 % Meat soup (“broth”) 4.500 kg
(compensation for cooking loss)

Extenders: ---

Additives: (per kg materials) (total for 30 kg)
15.00 g Nitrite curing salt 450.00 g

Seasonings: (per kg materials) (total for 30 kg)
2.00 g White pepper, ground 60.00 g
0.50 g Ginger, ground 15.00 g
0.30 g Cardamom, ground 9.00 g
0.30 g Mace, ground 9.00 g
0.50 g Vanilla sugar 15.00 g
1.00 g Honey 30.00 g
30.00 g Onions, slightly fried in lard 900.00 g

PROCESSING

CHOP Fresh, chilled pork liver with nitrite curing salt at high
speed until fine and creamy texture is achieved (bubbles)

CHILL Chopped liver over night at < +4°C

PRE-COOK Pork belly at +85°C, grind 13 mm

CHOP Hot ground pork belly, onions and hot broth at high
speed

ADD Below +45°C add cold cured liver, spices and honey
Complete chopping until +24°C

STUFF Into plastic casings, diameter 60 mm

COOK At +82°C for 75 min. to a core temperature > +72°C

COOL Under cold shower or in cold water, drain and air-dry

STORE In cold room below +4°C, shelf life < 14 days
COARSE LIVER SAUSAGE
(Precooked-cooked sausage type, coarse materials)

INGREDIENTS

Raw materials: (calculated for 10 kg batch)
- 15.00 % Pork liver and kidneys, raw 1.500 kg
- 35.00 % Meat and pork belly, pre-cooked 3.500 kg
- 15.00 % Fatty tissues, pre-cooked 1.500 kg
- 15.00 % Pig head meat, pre-cooked 1.500 kg
- 10.00 % Meat soup (broth) 1.000 kg
  (compensation for cooking loss)

Extenders:
- 5.00 % Wheat flour 0.500 kg
- 5.00 % Bread crumbs (old bread or bread rolls) 0.500 kg

Additives:
(per kg materials) (total for 10 kg)
- 16.00 g Common salt (refined) 160.00 g

Seasonings:
(per kg materials) (total for 10 kg)
- 50.00 g Onions, slightly fried in lard 500.00 g
- 2.00 g White pepper, ground 20.00 g
- 1.50 g Marjoram 15.00 g
- 0.30 g Ginger, ground 3.00 g
- 0.30 g Cardamom, ground 3.00 g
- 0.20 g Pimento (allspice), ground 2.00 g

PROCESSING

PRE-COOK  Meat trimmings, fatty tissues, pig heads
DE-BONE  Pig heads (beware of teeth, hard tissue)
MIX  Cooked materials, fresh liver, seasoning and additives
GRIND  Mixed materials 3 mm, mix again
STUFF  Into hog casings 26-30 mm, caps, middles
COOK  At +84°C to a core temperature > +72°C
COOL  Under cold shower or in cold water, drain and air-dry
SMOKE  Cold smoke < +20°C over night
STORE  In chiller below +4°C, shelf life < 14 days
**BLOOD SAUSAGE / Central European product**  
*(Precooked-cooked sausage type, coarse mixture)*

**INGREDIENTS**

**Raw materials:** (calculated for 10 kg batch)

<table>
<thead>
<tr>
<th>%</th>
<th>Ingredient</th>
<th>Quantity</th>
</tr>
</thead>
<tbody>
<tr>
<td>20.00</td>
<td>Pig blood, raw</td>
<td>2.000 kg</td>
</tr>
<tr>
<td>25.00</td>
<td>Pork head-meat, pre-cooked</td>
<td>2.500 kg</td>
</tr>
<tr>
<td>25.00</td>
<td>Pork belly, pre-cooked</td>
<td>2.500 kg</td>
</tr>
<tr>
<td>20.00</td>
<td>Pork skin, pre-cooked</td>
<td>2.000 kg</td>
</tr>
<tr>
<td>5.00</td>
<td>Meat soup (broth)</td>
<td>0.500 kg</td>
</tr>
<tr>
<td>5.00</td>
<td>Onions, raw</td>
<td>0.500 kg</td>
</tr>
</tbody>
</table>

**Extenders:** ---

**Additives:**

(per kg materials)  
(total for 10 kg)

| g   | Nitrite curing salt | 160.00 g |

**Seasonings:**

(per kg materials)  
(total for 10 kg)

<table>
<thead>
<tr>
<th>g</th>
<th>White pepper, ground</th>
<th>25.00 g</th>
</tr>
</thead>
<tbody>
<tr>
<td>1.00</td>
<td>Cloves, ground</td>
<td>10.00 g</td>
</tr>
<tr>
<td>0.70</td>
<td>Marjoram</td>
<td>7.00 g</td>
</tr>
<tr>
<td>0.50</td>
<td>Pimento (allspice), ground</td>
<td>5.00 g</td>
</tr>
<tr>
<td>0.30</td>
<td>Nutmeg, ground</td>
<td>3.00 g</td>
</tr>
</tbody>
</table>

**PROCESSING**

**COOK**  
Pig heads, pork skin and pork belly

**DE-BONE**  
Cooked pig heads (beware of teeth)

**CUT**  
Cooked hot pork skin and onion into dices or stripes

**GRIND**  
Cooked hot pork skin, onions and broth 3 mm

**MIX**

a) fat and meat dices with salt and spices

b) spiced dices with ground pork skin and add blood

**STUFF**  
Into pork intestines of desired size

**COOK**  
At +82°C to a core temperature of +75°C

**COOL**  
On air and transfer to cold room for 24 hours

**SMOKE**  
Cold smoke at < +22°C over night

**STORE**  
In cold room at < +4°C, shelf life < 21 days
**BLODKORV/ Extended Blood Sausage** (Sweden)  
*(Precooked-cooked sausage type, coarse mixture)*

**INGREDIENTS**

**Raw materials:** (calculated for 10 kg batch)

<table>
<thead>
<tr>
<th>Percentage</th>
<th>Ingredient</th>
<th>Quantity</th>
</tr>
</thead>
<tbody>
<tr>
<td>35.00 %</td>
<td>Pig blood, raw</td>
<td>3.500 kg</td>
</tr>
<tr>
<td>10.00 %</td>
<td>Pork lard</td>
<td>1.000 kg</td>
</tr>
<tr>
<td>10.00 %</td>
<td>Pork backfat, blanched</td>
<td>1.000 kg</td>
</tr>
<tr>
<td>10.00 %</td>
<td>Meat soup (broth)</td>
<td>1.000 kg</td>
</tr>
</tbody>
</table>

**Extenders:** (calculated for 10 kg batch)

<table>
<thead>
<tr>
<th>Percentage</th>
<th>Ingredient</th>
<th>Quantity</th>
</tr>
</thead>
<tbody>
<tr>
<td>25.00 %</td>
<td>Wheat flour</td>
<td>2.500 kg</td>
</tr>
<tr>
<td>10.00 %</td>
<td>Sugar</td>
<td>1.000 kg</td>
</tr>
</tbody>
</table>

**Additives:**

(per kg materials)  
(total for 10 kg)

<table>
<thead>
<tr>
<th>Quantity</th>
<th>Ingredient</th>
</tr>
</thead>
<tbody>
<tr>
<td>160.00 g</td>
<td>Common salt</td>
</tr>
</tbody>
</table>

**Seasonings:**

(per kg materials)  
(total for 10 kg)

<table>
<thead>
<tr>
<th>Quantity</th>
<th>Ingredient</th>
</tr>
</thead>
<tbody>
<tr>
<td>10.00 g</td>
<td>Cloves, ground</td>
</tr>
<tr>
<td>10.00 g</td>
<td>Cinnamon</td>
</tr>
<tr>
<td>10.00 g</td>
<td>Raisins</td>
</tr>
</tbody>
</table>

**PROCESSING**

**MIX**  
Blood, sugar, salt and seasonings

**CUT**  
Pork back fat into dices 5-8 mm

**BLANCH**  
Pork back fat dices (scalding)

**MIX**  
Wheat flour, lard, dices into heated meat soup  
Add the blood mix also

**STUFF**  
Into medium size beef middles

**COOK**  
At +85°C to a core temperature of +75°C

**COOL**  
On air and transfer to cold room for 24 hours

**SMOKE**  
Cold smoke at < +22°C over night and air-dry

**STORE**  
In cold room at < +4°C
CURED MEAT CUTS

COOKED HAM / Entire muscle pieces formed together

Raw materials:
20.000 kg Pork topsides (meat piece from hind leg),
all connective tissue and fats removed from surface,
pH-value 5.7 or higher.

Brine composition:
7.000 kg Potable water
1.800 kg Crushed ice
1.200 kg Nitrite curing salt
0.200 kg Phosphate (soluble)
0.100 kg Sugar
0.100 kg Carrageenan
0.020 kg Sodium ascorbate

PROCESSING:
Meat is chilled (+4°C) prior to brine injection
Brine is prepared and chilled (supported by adding of crushed ice)
   Without tumbler:
      Inject 20% curing brine in the meat (based on fresh meat
      weight)
      Submerge injected meat pieces in remaining brine
      Keep in chiller for 48 hours
   With tumbler:
      Inject 20% curing brine in the meat (based on fresh meat
      weight)
      Transfer injected meat pieces to tumbler
      Tumble under refrigeration for 12 hours
      5-8 rpm, 5 minutes rotation / 20 minutes resting, +2°C
Transfer meat pieces into ham moulds and apply firm pressure with
cover
Allow for resting phase of 5 hours in chiller
Cook at +75°C to core temperature of +70°C (use Delta-t cooking if
possible)
Cool under running water, transfer to chiller over night
Remove hams from ham moulds and vacuum-pack final product
RAW FERMENTED HAMS
Production principles see page 172

PORK BACON

Raw materials:
20.000 kg Pork belly (meat/fat ratio 60/40)
Rib bones and soft bones are removed
Skin left on or also removed

Brine composition:
8.800 kg Ice water
1.200 kg Nitrite curing salt
0.200 kg Phosphate (soluble)
0.100 kg Sugar
0.020 kg Sodium ascorbate

PROCESSING:
Belly is trimmed and chilled (+4°C) prior to brine injection
Brine is prepared and chilled
20% curing brine are injected in the meat (based on fresh meat weight)
Injected bellies are submerged in remaining brine
Keep in chiller for 36-48 hours
Bellies are hung and hot-smoked
After hot-smoking, cool down at ambient temperature and transfer to chiller over night
Slice 2-4 mm and vacuum-pack

BEEF BACON

Raw materials:
20.000 kg Beef silverside tip or brisket (meat 60-80%)
Bones and soft bones are removed
10 mm layer of body fat is left on silverside tip

Brine composition:
8.800 kg Ice water
1.200 kg Nitrite curing salt
0.200 kg Phosphate (soluble)
0.100 kg Sugar
0.020 kg Sodium ascorbate

PROCESSING:
See “pork bacon” above.
INGENIOUS MEAT PRODUCTS

LUP-CHEONG / Chinese dry pork sausage
(Dried sausage type, coarse mixture) (see also page 214)

INGREDIENTS

Raw materials: (calculated for 10 kg batch)
60.00 % Lean pork meat (90/10)  6.000 kg
40.00 % Pork belly without skin (60/40)  4.000 kg

Extenders: ---

Additives:
(per kg raw materials) (total for 10 kg)
15.00 g Common salt (refined)  150.00 g
15.00 g Sugar (saccharose)  150.00 g

Seasonings:
(per kg raw materials) (total for 10 kg)
10.00 g Soy sauce  100.00 g
2.00 g Rice wine  20.00 g
1.00 g Ginger, ground  10.00 g
0.50 g Cinnamon, ground  5.00 g

PROCESSING

CUT Meat and belly into small pieces, keep at –2°C
MIX Raw materials, additives and seasonings
GRIND Mixture 5 mm
STUFF Natural pig casings (26 mm)
PORTION Link into sausages of desired size (60-100 g)
DRY (SMOKE) +60°C for 24-48 hrs., another 48 hours +45-50°C
KEEP In a dry and cool place (if possible vacuum packed)
NAEM (also Nham) / Fermented Pork Product (SE-Asia)
(Fermented sausage type, coarse mixture) (see also page 217)

INGREDIENTS

Raw Materials:  (calculated for 10 kg batch)
60.00 % Pork meat, lean  6.000 kg
20.00 % Pork skin  2.000 kg

Extenders:  (calculated for 10 kg batch)
20.00 % Rice, medium quality, cooked  2.000 kg

Additives:
(per kg raw materials) (total for 10 kg)
23.00 g Nitrite curing salt  230.00 g
1.00 g MSG (mono sodium glutamate)  10.00 g

Seasonings:
(per kg raw materials) (total for 10 kg)
15.00 g Chilli, fresh  150.00 g
2.00 g Sugar  20.00 g
80.00 g Fresh garlic  800.00 g

PROCESSING

PRECOOK  Rice (cook in water or steam)
Pork skin in boiling water

CUT  Lean pork meat in smaller pieces
Cooked pork skin in small stripes

GRIND  Pork meat, seasonings and garlic 3 mm

MIX  Mixture with cooked rice and pork skin

PORTION  Wrap small quantities in banana leaves (traditional) or stuff in perforated plastic casings (35 mm)

FERMENT  At room temperature (+25-30°C) for 2-4 days

STORE  Under refrigeration, shelf-life 2 weeks

CONSUME  As snack or use as ingredient to meals
ISAAN SAUSAGE / Herb Sausage (Thailand, recipe 1)
(Quick-cured sausage type, coarse mixture)

INGREDIENTS

Raw Materials: (calculated for 10 kg batch)
- 80.00 % Pork belly without skin, fresh  8.000 kg
- 10.00 % Potable water  1.000 kg

Extenders:
- 10.00 % Rice, medium quality  1.000 kg

Additives:
(per kg raw materials) (total for 10 kg)
- 12.00 g Common salt  120.00 g
- 2.00 g Erythorbate  20.00 g

Seasonings:
(per kg raw materials) (total for 10 kg)
- 6.00 g White pepper, ground  60.00 g
- 1.00 g Sugar  10.00 g
- 20.00 g Fresh garlic  200.00 g
- 1.00 g MSG (mono sodium glutamate)  10.00 g

PROCESSING

CUT  Pork meat in small pieces
SOAK  Rice in water
GRIND  Pork meat, seasonings and garlic 5 mm
MIX  Pork meat, garlic, seasoning and rice
STUFF  Into natural pork casings (26-28mm)
CURE  At room temperature (+37°C) for 2 days
STORE  Under refrigeration, shelf-life 2 weeks
PREPARE  Roast on charcoal or gas grill
**ISAAN SAUSAGE / Herb Sausage (Thailand, recipe 2)**
*(Fresh sausage type, coarse mixture) (see also page 216)*

**INGREDIENTS**

**Raw Materials:** (calculated for 10 kg batch)

<table>
<thead>
<tr>
<th>Percentage</th>
<th>Ingredient</th>
<th>Quantity</th>
</tr>
</thead>
<tbody>
<tr>
<td>80.00 %</td>
<td>Pork meat trimmings, lean</td>
<td>8.000 kg</td>
</tr>
<tr>
<td>20.00 %</td>
<td>Pork belly and back fat</td>
<td>2.000 kg</td>
</tr>
</tbody>
</table>

**Extenders:** ---

**Additives:**

(per kg raw materials) (total for 10 kg)

<table>
<thead>
<tr>
<th>Amount</th>
<th>Ingredient</th>
</tr>
</thead>
<tbody>
<tr>
<td>10.00 g</td>
<td>Common salt</td>
</tr>
<tr>
<td>2.00 g</td>
<td>Erythorbate</td>
</tr>
</tbody>
</table>

**Seasonings:**

(per kg raw materials) (total for 10 kg)

<table>
<thead>
<tr>
<th>Amount</th>
<th>Ingredient</th>
</tr>
</thead>
<tbody>
<tr>
<td>1.00 g</td>
<td>Chilli paste</td>
</tr>
<tr>
<td>1.50 g</td>
<td>Soy sauce</td>
</tr>
<tr>
<td>1.00 g</td>
<td>Shrimp paste</td>
</tr>
<tr>
<td>1.00 g</td>
<td>Lemon grass</td>
</tr>
<tr>
<td>10.00 g</td>
<td>Fresh garlic</td>
</tr>
<tr>
<td>1.00 g</td>
<td>MSG (mono sodium glutamate)</td>
</tr>
</tbody>
</table>

**PROCESSING**

**CUT** Pork meat and belly fat trimmings in small pieces

**MIX** Pork meat, fats, additives and seasoning

**GRIND** Mixture 5 mm

**STUFF** Into natural pork casings (26-28mm)

**STORE** Under refrigeration, self-life <2 days

**PREPARE** Roast on charcoal or gas grill
RICE SAUSAGE (Asian cereal sausage) see page 78

KEBAB see page 106

LOW-COST FRESH SAUSAGES see page 113

TRADITIONAL BLOOD SAUSAGES see page 163

CHICKEN PRODUCTS
  a) Coated/breaded products see page 189
  b) Chicken burger see page 191

MOO-YOH (Asian flour sausage) see page 197

SPLEEN-LIVER SAUSAGE (Asian offal sausage) see page 216

FLOSSY SHREDDED PORK see page 217

SALAME (South-American, raw-fermented) see page 219

MORCILLA (South-American blood sausage) see page 219

SIMPLE DRIED MEAT (without additives) see page 233

CHARQUE (South-American dried meat) see page 236

BILTONG (South-African dried meat) see page 237

PASTIRMA (Middle-East dried meat) see page 238

JERKY (North-American dried meat) see page 239

KILISHI (African dried and processed meat) see page 241
ANNEX II

GLOSSARY

Acceptance test
The acceptance test is a type of sensory examination. Acceptance testing is used during product development to test the market potential of a new product ready to be launched.

Acid
An acid is a substance which decreases pH into the acid range (< pH 7.0) when dissolved in water. Acids can be inorganic (e.g. hydrochloric acid, HCl) or organic (e.g. citric acid) compounds.

Acidification
This term relates to the capability of microorganisms of forming acid when carbohydrates are degraded. Such acid can be of the desirable type for meat products, such as lactic acid but also undesirable such as acetic acid.

Actin
Actin belongs to the so-called contractile proteins (and myosin) of the myofibrils of the meat musculature. The protein actin accounts for approximately 20 percent of the muscular protein.

Actomyosin
Actomyosin is created by an association of actin with myosin, resulting under the influence of ATP in muscle contraction. Their dissociation results in muscular relaxation (in live animals).

Additives
The term additives as refers to food products (and meat products) manufacturing is defined as comprising all such materials or substances not classified as actual foods (“food by itself”).

Agar-agar
Agar-agar is a swelling substance of plant origin. Extracted from red algae (Rhodophyta) and other algae, it is used as a gelatinizing/thickening agent in food manufacturing.

Air humidity, relative
The relative humidity of air (r.h.) is the ratio of water vapour contained in air of a certain temperature to the maximum water vapour content expressed in percent.
Air-dried
The term air-dried refers to non-smoked raw/uncooked meat products and sausages which, as the word implies, have been simply dried on air.

Airtight
When a container is described as closed airtight, the meaning is that materials used are impermeable to oxygen and therefore suitable for extending the shelf-life of enclosed products.

Alginate
Alginites are the salts of alginic acid (sodium alginate). They are obtained from marine algae through extraction and form highly viscous solutions in water. Contrary to products such as agar-agar or carrageenan, alginates do not gelatinate and are used as thickener in mayonnaises and gravies.

Antibacterial
Processes or substances defined as antibacterial are capable of inhibiting the growth or multiplication of bacteria or effecting outright kill of bacteria.

Antioxidants
Antioxidants are substances capable of slowing down oxidation, thereby postponing the occurrence of taste or colour alteration (e.g. rancidity).

Artificial casings
The use of artificial sausage casings made of cellulose, collagen, textile fibres or plastics is firmly established in meat processing. The advantages of artificial casings are their attractive designs, easy stocking and uniform calibre.

Ascorbic acid
Ascorbic acid (Vitamin C) or its salt (sodium ascorbate) is used in meat processing as cure accelerator to enforce the curing colour development. The reaction of ascorbic acid is fast and further accelerated by increasing temperatures. This makes it an ideal component in quick-cured and heat treated products. Sodium ascorbate reacts slower and is therefore mainly used in raw-fermented products.

ATP
ATP (adenosine triphosphate) is a chemical compound occurring in almost all cells of the living body. ATP plays a role in the processes of muscular contraction and relaxation. ATP is also useful in the manufacturing of raw-cooked meat product.
**Autoclave**
Autoclaves, also called retorts, are large pressure cookers achieving temperatures above +100°C and used for sterilization of meat products filled into hermetically sealed containers (cans, glass jars, flexible pouches, etc). Autoclaves can be designed as still or rotating autoclaves.

**$a_w$-value**
The $a_w$-value is an important measure used in meat processing. The $a_w$-value describes the water activity, meaning the free water in the product. High $a_w$-values present good conditions for microorganisms, lower $a_w$-values inhibit activities of such microorganisms. Bacteria require $a_w$-values around and above 0.9, yeasts and moulds only need $a_w$-values above 0.6.

**Bacteria**
Bacteria are monacellular microorganisms of various shape and size. Bacteria are present everywhere, in soil, water, air, the intestinal tract, on all kinds of surfaces, etc. Some bacteria can cause food spoilage or food poisoning, other strains of bacteria are used in food products manufacturing (starter cultures used in raw-fermented sausage making, production of yogurt and cheese).

**Benzpyrene (3,4-Benzpyrene)**
Benzpyrene is a condensating aromatic hydrocarbon and a carcinogenic substance. 3,4 benzpyrene is generated during the burning or smoldering of wood when the smoldering temperatures are relatively high. However, smoked meat products remain far below the content of 1 ppm benzpyrene, which is considered the risk level.

**Binder**
The term binder is used for substances of animal or plant origin, which have a significant high level of protein that serves for both water and fat binding. Such substances include high-protein soy, wheat and milk products, such as isolated soy protein, wheat gluten or milk caseinate.

**Biological value**
This is the method of measuring protein quality. Protein is used in the cells of the human and animal organisms. The more protein is retained in the organism the higher is the level of utilization of the particular protein provided through food/feed and the higher is its biological value. The biological value is the ratio of protein consumed to the amount of protein retained in the organism and not excreted as urine or faecal matter. Isolated whey and egg protein are amongst the products with the highest biological value and serve as measurement (biological value of isolated whey = 100). Biological value of other foods: whole eggs 94, cow milk
Blood plasma
Blood plasma is the yellowish liquid obtained by centrifuging blood and contains 7-8% protein. This liquid is either stored frozen or spray-dried and stored as powder. It is used in finely-chopped raw-cooked (frankfurter type) sausages to increase the protein content and improve water binding.

Blood sausage
Blood sausages belong to the group of precooked-cooked products. In these products fresh blood (10-20%) is mixed with precooked animal tissues, cereals, vegetables, salt and spices. The final mixture is stuffed and heat treated again.

Boiling point
This term refers to the temperature at which a liquid changes over into gaseous state.

Boning
This term refers to the removing of bones from carcass parts of slaughter animals. It is often also called deboning.

Botulism
The term botulism describes a bacterial food poisoning caused by the botulinus toxin, which is discharged into the food by Clostridium botulinum. Botulism can occur in preserved meat, vegetable and fish products.

Bowl cutter
The bowl cutter is the most frequently used meat chopping equipment designed to produce very small lean meat and fat particles. Bowl cutters consist of a horizontally revolving bowl and a set of curved sharp knives rotating vertically on a horizontal axle at a high speed. Another name is bowl chopper.

Brine
The term brine describes a water/salt solution used for curing meat products.

Burger
Originally, burgers were made from beef (preferably lean cow meat), but in recent years also chicken and mutton burgers were introduced. Other animal tissues such as fats or connective tissue/tendons can also be part of the mixture, with quantities depending on the type and quality of the
products. Burgers are formed usually to disc-like shape with diameters of 80-150 mm and 5-20 mm height. Burgers are stored frozen and individually pan-fried before consumption.

**Calibre**
In meat processing, the term calibre refers to the diameter of casings and sausages.

**Canning**
This term refers to the filling of food into cans followed by hermetically sealing of the containers and heat treatment.

**Carbohydrates**
These are organic substances formed by the elements carbon, hydrogen and oxygen. Sugars such as saccharose and dextrose are the best known carbohydrates, but also dextrines, starches, cellulose and pectines belong to this group.

**Carcass**
The term carcass refers to the body of a slaughter animal (without internal organs) consisting of meat, fats, bones and connective tissues.

**Carrageenan**
Carrageenan is a polysaccharide produced by red algae and obtained by water extraction. It has good gelling properties.

**Casings**
Casings are defined as soft cylindrical containers used to be filled with sausage mix. Casings can be of natural origin or industrially manufactured (artificial). Natural casings are obtained by special treatment of animal intestines derived from slaughtering. Manufactured artificial casings are made of cellulose, collagen or synthetic materials.

**Cellulose**
Cellulose is the substantial framework of plant cell walls. Because it is not attacked by digestive juices, it serves as dietary fiber in human nutrition. Cellulose also serves as material for paper, packaging films and foils and artificial casings. It belongs to the group of polysaccharides.

**Cereal sausages**
For this product group sizeable quantities of various non-meat ingredients such as breadcrumbs, rice, potatoes, cassava, etc are incorporated into the basic mixture of pre-cooked lower value animal parts. Also liver or blood may be added thus making those cereal sausages either part of the liver or blood sausage variety. The term cereal refers to grain crops and other field crops.
Coarse
Coarse describes a degree of comminution, in this context not very finely comminuted.

Cold smoking
Cold smoking is the application of smoke to meat products at temperatures below 24°C. It is mainly used for raw-fermented sausages and raw hams.

Collagen
Collagen is an important component of connective tissue found in tendons, skin, bones and cartilage. Due to its high water holding capacity it is used as binding agent in blood sausages and gelatines. It serves also for the manufacture of artificial casings.

Colloid mill
Also known as emulsifier, this equipment is used for very fine cutting or comminution of sausage batters.

Common salt
Common salt (sodium chloride) is the sodium salt of hydrochloric acid (HCl) and is one of the most important aiding substances (additives) in meat processing. Common salt facilitates the extraction of protein (actin, myosin) and contributes to the taste.

Conduction
This term refers to the means of transmission of heat in food products consisting mainly of solids.

Connective tissue
Connective tissue consists of connective tissue proteins i.e. collagen, elastin and is found in many body parts, with particularly high quantities in tendons, skins and cartilages.

Convection
This term refers to the means of transmission of heat in food products which consist to a great extend of liquids.

Corned beef
The classical Corned beef was a by-product of meat extract production. Before refrigeration was available, the only way to utilize surplus beef from Latin-America and other regions of the Southern hemisphere for shipment to Europe was to produce meat extract. Originally a by-product, the cooked beef, which still has a high protein content, is filled into cans and heat sterilized. The result is Corned beef.
**Core temperature**
In meat processing, this term refers to the temperature achieved in the critical thermal point of products where it takes longest for the temperature to change.

**Curing**
Curing is the method used to achieve the desired red colour in processed meat products. The products are salted with a mixture of common salt (sodium chloride NaCl) and the curing agent sodium nitrite (NaNO₂). Sodium nitrite facilitates formation of a red curing colour and typical aroma/flavour.

**Deep-freezing**
This term refers to storage temperatures of -18°C and below and is ideally suited for long-term storage of meat and meat products.

**Detergents**
Detergents are substances used in cleaning and capable of relaxing the surface tension of water to enhance the cleaning effect. Most common are anion detergents (soaps), cation detergents (invert soaps) and non-ionogenic detergents.

**DFD meat**
The term DFD refers to “dark, firm, dry”. Meat showing DFD properties can be identified by a pH-value above 6.2.

**Erythorbate**
Cure accelerator with similar effect as sodium ascorbate.

**F-value**
The F-value is a unit of measure for the heating effect obtained in heat-treated products. The letter “F” in F-value is derived from Fahrenheit (temperature scale used in the US). Preservation by cooking/sterilization of processed products following the F-value concept is far more reliable than orientation by core temperatures alone. Computation of the F-value and cooking according to F-value is based on inhibition or elimination of microorganisms and maintaining as far as possible the sensory quality of products.

**Fat**
Fat is defined as a substance under the category of triglycerides. It exists in various forms and is used in sausage production.

**Fermentation**
Fermentation is the breakdown of organic substances by fermentative microorganisms. During fermentation, carbohydrates are partly reduced
to acids or other substances (extraction of alcohol from sugar). In meat processing, fermentation occurs in raw sausage and raw ham production.

**Flavour**
This term is used in sensory evaluation and refers to a combination of taste and odour.

**Freezing point**
The term refers to the temperature at which a substance changes from liquid to solid. This temperature varies from substance to substance. Water freezes at 0°C, if salt is added the water/salt solution freezes at a much lower temperature. The freezing point of lean meat is at -1.5°C.

**Fresh processed meat products**
The characteristic of this group is that all meat and non-meat ingredients are added fresh (raw), either refrigerated or non-refrigerated, but not cooked. Most of the fresh meat mixes are filled in casings, which defines such products as sausages. If other portioning is customary, the products are known as patties, kebab, or burgers. Only prior to consumption the products are heat treated (frying, cooking) and usually consumed hot.

**Friction smoke**
A specific technique employed in smoke generation. Smoke is produced by pressing a wood log onto a rotating wheel. This causes friction and frictional heat so that the log smoulders and smoke is generated.

**GdL**
GdL stands for Glucono-delta-lactone and is obtained from dextrose. In watery solution, GdL changes rapidly into gluconic acid. The prime area of GdL application is the manufacturing of fast cured raw-fermented sausages.

**Gelatine**
Gelatine is made of collagen containing materials such as bones, cartilage and skins (rinds, hides). Gelatine is a high-molecular protein which swells in cold water and which forms viscous solutions in warm water. Upon cooling, a solid gel is obtained.

**Grind**
Grinding or mincing are terms used in meat processing, when bigger meat pieces are broken down in size by use of specialized equipment.

**Grinder**
The grinder is a machine used to force meat or meat trimmings by means of a feeding worm (auger, feeding screw) under pressure inside a
horizontally mounted cylinder (barrel, feeding worm housing). At the end of the barrel the meat is broken down in size by a cutting system consisting of star shaped knives (cutters) rotating with the feeding worm and perforated cutting discs (grinding plates).

**Guar gum**
Guar gum is a hydrocolloid obtained from the seeds of a leguminose plant and used as thickener in soups, gravies and sauces.

**Halal**
Refers in the narrower sense to Muslim dietary laws. An important feature as far as meat and poultry are concerned, is the slaughtering according to Halal rules which in practice mostly excludes prestunning of slaughter animals. Pork and pork based products are prohibited and pork-based food operations such as pig slaughtering or pork processing must be absent where processing of Halal meat and meat products takes place.

**Hemoglobin**
Hemoglobin is the red pigment of blood.

**High hydrostatic pressure treatment**
Method of food preservation where microbial reduction is achieved through application of high pressure (in the range of 3000 bar) on the food product.

**Hot smoke**
Hot smoking is the form of smoking which involves high temperatures (>50-70°C) and is mainly used for frankfurter-type sausages.

**Hot-boning**
This term describes the process of separating meat and bones from freshly slaughtered unchilled animal carcasses.

**Hurdle concept**
The hurdle concept serves as a system of estimating and influencing the shelf life of meat and processed meat products. In this concept several individual measures (hurdles) are combined to prevent microorganisms from growing/multiplying such as temperature, humidity, water content, pH-value, salt concentration, presence of preserving substances, etc.

**Hydroxyproline**
An amino acid, which in meat exclusively occurs in the connective tissue and which is therefore used as a parameter in connective tissue protein determination.
**Hygrometer**
Such a device is used to determine the relative air humidity. Hygrometers are available as simple hair hygrometer models and electronic aspiration psychrometers.

**Intermediate moisture food**
The term Intermediate Moisture Food characterizes processed products, which have a low $a_w$-value and possess great storage stability.

**Irradiation**
In the food sector irradiation by ionizing high energy gamma rays, x-rays, or in some cases by high energy of electron sources, is used in some countries (where such treatments are legal) for reducing or eliminating microbial contamination in food, control parasite such as trichinae in meat or insect in grains and sanitize packing material prior to food packaging or treat drinking water.

**Kidney fat**
Also known as kidney tallow, this term describes the layer of fat where the kidneys are embedded.

**Lactic acid**
Lactic acid belongs to the so called food grade acids as do citric acid and acetic acid, and are used to lower the pH-values.

**Lactobacilli**
Lactobacilli are gram positive microorganisms which have the ability to form acids from carbohydrates. They are used as starter cultures in raw-fermented sausage production.

**Liquid smoke**
Liquid smoke is obtained by condensation of natural smoke in liquids and used in meat processing by being sprayed into smoking chambers where it will condensate on the surfaces of the products or by directly adding to meat mixes.

**Liver sausage**
Liver sausage belongs to the group of precooked-cooked sausages and is composed of precooked meat trimmings and fatty tissues and liver (10-20%). The liver (mainly added raw) provides not only the name for this sausage type but also contributes to its unique flavour and taste. In general two types of liver sausages are produced, the coarse-mixed type and the fine-emulsified type.
**Meat inspection**
Each slaughtered animal should undergo official meat inspection after slaughtering to ensure that only meat fit for human consumption enters into the sales and distribution chain. Respective national regulations must be observed.

**Meat products**
Meat products are such food products which are exclusively or predominantly composed of meat.

**Microorganism**
The term microorganisms is used collectively for all live organisms which in their cellular form cannot be detected upon visual inspection. The term microorganisms refers to bacteria, yeasts and moulds. All these microorganisms are of great importance in meat processing.

**Moulds**
Moulds are microorganisms which may be desirable or undesirable in meat processing. They can cause a multitude of damages on surfaces of meat products, split proteins and break casings by digesting cellulosic. Taste and colour deviations can also occur. But some moulds are also helpful by forming a protective and flavour providing layer on the surface of air-dried raw sausages.

**Mono sodium glutamate (MSG)**
MSG is used in larger quantities as a flavour and taste enhancer in meat products and cooked foods especially in Asia. The use of MSG is often questioned as it can cause allergies and health problems.

**Myofibrils**
Myofibrils belong to the structural elements of a muscle and form the content matter of the muscular fiber or muscle cell, enclosed by the sarcolemma. They develop from the filaments of the myofibrillar proteins actin and myosin.

**Myoglobin**
Myoglobin is a proteinaceous substance in muscular meat responsible for oxygen transport in the live muscle and for the colour of fresh lean meat, but also for the curing-red colour in processed meat products after its reaction with nitrite. In this case, the myoglobin connects with the degradation product NO of the nitrite resulting in nitrosomyoglobin.

**Myosin**
Myosin filaments represent approx. 40% of muscular proteins. As a result of association with actin they form the so called actomyosin,
responsible for muscular contraction. A dissociation of these two muscle proteins brings about muscular relaxation.

**Nitrite**
Nitrite (sodium nitrite) is used for curing of meat and meat products such as raw-cooked sausages, cooked hams, raw hams, raw-fermented sausages and other products. Nitrite (NaNO₂), or rather nitrogen oxide (NO), which is formed from nitrite in an acid environment, combines with myoglobin to form nitrosomyoglobin and results in the red curing colour of the meat. Nitrosomyoglobin is heat stable i.e. when the meat is heat treated the bright red colour remains. In larger quantities, which, however, are not needed in meat curing, sodium nitrite has toxic effects.

**Nutritive value**
The nutritive value of a meat product is determined by its content levels of proteins, carbohydrates, fats and other nutrient such as mineral salts and vitamins (see also Biological value).

**Organic non-fat**
In simple analyses of meat products, only the fat, water and mineral contents are determined by extraction and drying respectively. The remaining constituents are described as organic non-fat (ONF), which can contain proteins and remains of carbohydrates. Minerals as inorganic compounds occur in very small quantities and can be determined by burning the sample in a furnace.

**Organoleptic test**
Organoleptic tests are sensory tests based on perceptions registered by the human senses, such as smell, taste, sight or touch. The testing involves colour development and retention, firmness, consistency, odour, flavour, taste and appearance.

**Pasteurisation**
Pasteurisation refers to the heat treatment at temperatures of up to 100°C, mostly in the temperature range of 60 to 85°C. Pasteurized products still contain a certain amount of viable ("living") microorganisms. Their growth in the stored product can only be prevented under low temperatures. Products must therefore be kept under refrigeration (0°-5°C).

**Perforated disc (grinder plate)**
Perforated discs with holes of varying diameter are used with grinders as a mechanical gate through which meat being cut or comminuted can pass. By selecting the diameter of the holes in these perforated discs, the final particle size is determined.
**pH-value**
The pH-values range from 1.0 to 14.0 with its neutral point at pH 7.0. The acidic range is below 7.0, the alkaline range above 7.0. In meat processing, the pH-values range from 4.0 to 7.0.

**Phosphates**
Phosphates have a wide application in meat processing. They directly increase the water-holding capacity of muscle meat by raising the pH-value as their own pH is above 7.0 and also stabilize the texture of meat products by increasing protein solubility in connection with salt. The most common phosphates in meat processing are Sodium tri-polyphosphate STPP (pH 9.8) and Sodium di-phosphate SDP (pH 7.3). The usual dose is 0.05 %.

**Precooked-cooked meat products**
These products can be manufactured from a variety of animal tissues. The animal tissues used are precooked before processing. Only liver (for liver sausage) and blood (for blood sausage) are added uncooked (raw) to the mixture. Precooked-cooked sausages can only be cut or sliced when cold. According to the ingredients used, five types of precooked-cooked sausage products can be distinguished: liver sausage, blood sausage, cooked gelatinous meat mixes, cereal sausage and corned beef.

**Presalting**
The method of pre-salting meat as an initial step in meat processing was common in former times to increase storage properties and facilitate extraction of protein from fresh and ground raw meat materials. Presalting is not widely used in modern meat processing, as it delays production and may cause hygienic risks.

**Preservation**
The term preservation refers to all measures taken to extend the shelf life of meat and meat products. Those measures can be both physical as well as chemical methods. The most common are heating, cooling, freezing, drying, smoking, lowering of pH-value and the addition of salt and nitrite.

**Protein**
Proteins consist of large molecules of amino acids. Many of them are soluble, have the ability to swell in water and denaturate upon heating. Particular use is made of such protein properties in meat products manufacturing. Proteins are the most important constituents of meat and meat products.
**PSE meat**
The term PSE refers to “pale, soft, exudative” and characterizes meat which shows poor water-binding capacity due to a non-normal fast drop of the pH after slaughter.

**Rancidity**
Rancidity is the result of enzymatic or autoxidative fat spoilage. Rancidity is easily detected by sensory testing.

**Raw-cooked meat products**
For these products, the components meat, fat and non-meat ingredients are processed raw (“raw”=uncooked) by comminuting and mixing. The viscous mix/batter is portioned (in sausages, etc.) and then submitted to heat treatment (“cooking”), where protein coagulation results in the firm-elastic texture typical for ready-to-eat raw-cooked products. Raw-cooked meat products are mostly manufactured and marketed as sausages in small to larger calibre casings, but are also available as meat loaves, meat balls or as canned products. The most common are the small-calibre “Frankfurters”, “Vienna sausage” and “Hotdogs”, the large calibre “Bologna” and “Lyoner” and the canned “Luncheon meat”.

**Raw-fermented sausages**
These are uncooked meat products and consist of comminuted lean meats and fatty tissues with a mixture of salts, nitrite (curing agent), sugars and spices. Sometimes fermenting organisms (microbial starter cultures) are added. After stuffing the mixture into casings, the sausages undergo a drying and ripening process. Here bacterial fermentation (lowering of pH to 4.9 – 5.4) and dehydration (moisture content about 30%) takes place. The products are traditionally not subjected to heat treatment and usually also consumed raw.

**Reconstituted**
In meat processing, this term refers mainly to products such as cooked hams, where individual pieces of meat are put together to form a bigger ham.

**Reduction**
This term refers to the chemical process in which the substance oxygen is chemically reduced. One typical example is the reduction of sodium nitrite (NaNO₂) to nitrogen oxide (NO) during curing.

**Refrigeration chain**
Meat and processed meat products are highly perishable goods and must therefore be generated, stored and transported under refrigeration. All these individual stages of refrigeration form the “refrigeration chain” or “cold chain”.
**Rind**
By definition, the term rind refers to the scalded and dehaired skin of pigs, which contains mainly connective tissue proteins.

**Sausages**
This term refers to meat mixes which are stuffed into natural or artificial casings of various calibres.

**Saccharose**
The scientific term saccharose refers to the common household sugar, which is partly also used in the manufacturing of sausage products (taste, assisting starter cultures). Saccharose is sweeter than dextrose.

**Salmonellae**
Salmonellae are the best known and most feared type of bacteria, as they can lead to a great number of food poisonings (vomiting, diarrhoea, typhoid fever). Salmonellae belong to the Enterobacteriaceae family. Heating to a temperature of 68°C will kill salmonella bacteria reliably; storage temperatures of below 4°C inhibit their growth. Salmonellae have been primarily being identified in pork and poultry meat.

**Separator**
A separator is a device designed to separate different components from liquid or solid substances. One well-known type of separator equipment is the blood separator used to separate and obtain blood plasma; other types include the hard separator used for separating muscular protein and connective tissue from bones and the soft separator used to separate muscle tissue from connective tissue.

**Sheep casing**
When the small intestines of sheep are cleaned and properly processed, natural casings are obtained with small calibres (18-24mm). These casings are edible and mainly used for frankfurter type or BBQ sausages. Available and widely used are also artificial casings, which resemble sheep casings. These casings are obtained from collagen material and are also edible.

**Smoke**
The most common way of generating smoke is by smoldering of wood, wood shavings or sawdust. The process of smoking plays an important role in meat processing, as it not only contributes to meat product preservation, but also adds to the flavour and taste of such products.

**Soy protein**
In terms of nutritional value, soy protein is a high-quality protein with a wide application in meat processing all over the world. Depending on the
way of fabrication, it acts as binder (soy isolate) or meat extender (soy concentrate).

**Spices (condiments, seasonings)**
Spices are derived from certain parts of plant species processed to maintain their naturally occurring taste or flavour for use in foods and processed products.

**Stabilizer**
When stated in the list of ingredients, stabilizer is regarded as a class name which stands collectively for all ingredients and additives used for product stabilization in the broadest sense. As regards the manufacturing of meat products, citrates and phosphates are viewed as stabilizers.

**Delta-D (Staged) cooking**
This term refers to a cooking technique used in cooked ham or other cooked products of larger calibres such as Mortadella sausages. According to this technology the “cooking” temperature (cooking chamber or cooking vat temperature) is kept in relation to the core temperature of the product, in practice always approx. 25°C-30°C above the prevailing core temperature. Upon reaching the chosen temperature of the cooking chamber/cooking vat (e.g. 75°C for cooked ham), this temperature is not increased further, but cooking continues until the required core temperature in the product has been achieved. This method reduces cooking losses and sensory damage.

**Starch**
Starch is a polysaccharide based on glucose. When placed in warm water (+50°C), starch undergoes intensive swelling resulting in glue formation. Because of its glue-forming property, starch is used in its modified form as a binding agent for soups and sauces, but also as a filler with binding properties in meat products.

**Starter cultures**
This is the term used for cultures of microorganisms which are helpful in fermentation of foodstuffs. Commercially marketed starter cultures for raw fermented sausage production usually contain *Lactobacilli* (lowering of pH-value) and *Micrococi* or *Staphylococi* (flavour building). Such cultures are marketed in either freeze-dried (lyophilisized) or deep-frozen form. Due to specific metabolic reactions, starter cultures initiate fermentation processes such as carbohydrate degradation and acid formation, nitrate reduction and thereby stable red colour formation and flavour development.
**Sterilization**
Sterilization refers to the heat treatment of meat products at temperatures above the boiling point. For meat and processed meat products mostly the temperature range of +105 to +121°C is used. Sterilized products are free of vegetative forms of microorganisms and practically also free of spores (Exception: Commercially sterile products, see page 294). Depending on the degree of sterilization, packaging material used and prevailing storage temperature, the shelf life of such products can be substantially extended.

**Temperature**
This term describes a measure for hotness or coldness of solids, liquids or gases, and is expressed in degrees (e.g. Celsius, Fahrenheit).

**Tenderizer, biochemical**
In this context, the term tenderizer refers to enzymes which can split meat proteins, thus increasing the tenderness. Such tenderizers, used in meat technology, are papain, bromelain, actinidin and ficin extracted from papaya, pineapple, kiwi and pig respectively.

**Tenderizer, mechanical**
In this context, the term tenderizer refers to equipment or tools used to incise (steak) meat pieces intended for grilling or pan-frying or production of cooked hams prior to curing/tumbling. The purpose of this action is to break down muscle fibre structures (tenderness) and also enlarge the meat surface for protein extraction.

**Tendon**
Tendons are connective tissue structures made of elastin, which serve to attach muscles to bones. Another name for tendon is sinew.

**Texture**
This term is used in sensory evaluation describing those physical properties of foods, which are noticed by touch, bite and feel.

**Tumbler**
Tumblers are used for the processing of meat products such as whole-muscle or reconstituted hams. A rotating drum with steel paddles inside slowly moves the meat pieces causing a mechanical massaging effect. This process helps to achieve equal brine distributions and sets free muscular protein from the meat tissue which joins the meat pieces firmly together during the following heat treatment.

**TVP**
The abbreviation TVP stands for textured vegetable protein. Suitable plant proteins, in the first place soy protein, are treated to obtain a
certain structure and texture and are used as extenders or meat replacers.

**Vacuum stuffer**
A vacuum stuffer (filling machine) has a built-in vacuum pump which extracts air from the sausage mix prior to stuffing. This results in reduction of air pockets in the mix, the presence of which could lead to discolouration or gel/fat separation in the final product.

**Water**
Water (H₂O) is the main component of meat (up to 80% in lean meat). Besides this “natural” water, water can also be used in some processed meat products as an ingredient. During the manufacture of raw/cooked meat batters water acts together with salt and phosphates to solubilize muscle proteins. Water is also needed as a solvent for curing substances or other non-meat ingredients.

**Water activity**
See aₜ-value

**Water holding capacity**
The ability to bind or release water is an important property of muscular protein in meat processing. For raw-cooked products a high water binding capacity is desirable, but for raw-fermented products a low water binding (increased release of water) is important. A first step is therefore the selection of suitable meat material and identification of suitable additives to support the desired properties. The higher the pH-value, the better will be the water holding capacity; the lower the pH-value, the higher the water loss.

**Wet curing**
Wet curing describes a technique where meat pieces are first injected with and later submerged in brine.

**Yeast**
In meat processing yeasts can be both, desirable and damaging. Selected yeasts are applied in fermentation of bread, raw hams, raw sausages and cheese, but undesirable yeasts can result in spoilage of meat products due to gas formation and excessive growth.

**Yield**
In the context of meat production and processing, yield describes the fresh weight: product weight ratio.
Index

A
Acidity 92, 93, 117, 120, 123, 125
Additives 59, 180
Aflatoxins 359
Air humidity 122, 322, 323
Air temperature 122, 123, 175, 320, 321
Air-drying 117, 124
Aluminum (aluminium), food grade 367
Aminoacids 3
Analysis, chemical 326
Analysis, microbiological 331
Antibiotics 75, 76
Antioxidants 36, 77
Ascorbic acid / ascorbate 37, 68, 134
Autoclave 280, 281
A_w-meter 323
a_w, see Water activity

B
Bacillus 95, 96, 277
Bacon 35, 42, 185
Bacteria
- contamination 150, 157, 181
- cultures 116
Basil 83
Beef 7, 8, 48, 49, 185, 272
Beef jerky 240
Benzopyrene 40
Biltong 210, 213, 237
Binder 62, 64, 201
Blood 1, 150, 162, 163
- plasma 71
- protein 3, 71
Blood / pork skin mix 165
Blood products 161
Blood sausage 152, 162
Blood sausage, Central European 164
Blood sausage, traditional 163
Bologna 127, 208
Bread crumbs 78, 201, 208
Breakfast sausage 198
Burger 97, 98, 103, 104, 201
C
Can formats 283
Can seaming 286
Canned products 154, 160, 169, 288
Canning 146, 149, 154, 160, 166, 169, 277
Cans 283
Carbohydrate 2, 4, 64
Cardamon 83, 85
Charque 236
Carrageenan 71, 180, 184, 202, 211
Casings 1, 122, 139, 155, 249
- artificial 154, 260
- cellulose 261
- collagen 263
- edible 249
- natural 154, 249
- processing 252
- storage 259
- synthetic 264
Cassava 81, 113, 202
Cellulose fibers 195, 201, 202, 204, 205
Cereal sausage 167
Charque 236
Chicken
- burger 103, 191, 202
- frankfurter 187
- meat 51, 187
- meat balls 187
- nuggets 192
Chilli 83, 85, 86
Chinese sausage 214, 221
Chlorine 75, 76, 376
Cholesterol 15
Chopping process 136, 157, 165
Chorizo, criollo 219
Chorizo, Spanish 117
Cinnamon 85, 86, 135
Cleaning 244, 370
Cleaning agents (alkaline, acid, neutral) 372
Clostridium 95, 277, 293, 295, 358, 360
Cloves 83, 85, 86, 135
Collagen 3, 147, 166
- casings 263
Commercial sterility 294
Comminuting 17, 20, 31, 151, 209, 303
Connective tissue 3, 49, 50, 108, 128, 147
Contact method, microbiological 331, 374
Contamination, microbial 88, 150, 340, 352
Cooked ham 178, 210
Cooker-chopper 151
Cooking 90, 91, 103, 144, 150, 156, 159, 185
Cooking loss 91, 151
Cooking, delta-t 199
Cooling 130, 145, 156
Coriander 83, 85, 86, 135
Corned beef 100, 168
- classical 169, 212
- with jelly 168, 212
Critical control point 345
Cumin 83, 85
Cure accelerators 37, 68, 184
Cured meat cuts 98, 171
- cured-cooked 99, 171, 177, 210
- cured-raw 99, 172
Curing 34, 35, 119, 173
- period 177
- resting period 182, 185
- dry curing 37, 173
- wet curing 38, 174
- injection curing 39, 182
- colour 34, 123, 185
- brine 38, 179, 180, 182, 185
Curing salt 35, 68, 108, 119, 134, 156, 164, 173, 180
Cutting board 367

D
Dehydration 221
Delta-t-cooking 199
Destructive method, microbiological 333
Detergents 372
DFD 5
Disinfection 369, 370
Disinfection chemicals 370, 372, 373
Doener 105
Dried meat products 101, 234
Dry sausage 115
- Semi-dry sausage 125
Drying 122, 221
D-value 296
E
E. coli 104, 357, 360
Emulsion, emulsion-like 156, 158
Enterobacteriaceae 337, 353
Erythorbate 68
Ethnic meat products 213
Extenders 61, 64, 195, 200

F
F-value 279, 289, 295
FAO/WHO Codex Alimentarius
- Code of Hygienic Practice for Meat 341, 361
- Code of Hygienic Practice for Low Acid Canned Foods 294
Fat 2, 8, 10, 14, 132
- beef fat 12
- chicken fat 13, 57
- intermuscular 10
- intramuscular 10
- marbling 10
- mutton fat 13
- pork fat 11, 46, 47
- subcutaneous 10
Fat analysis 327
Fat content 15, 160
Fermentation 100, 115, 122, 123
Fillers 62, 195, 200
Flossy pork 217
Foam cleaning 373
Food borne infection 357, 369
Food borne intoxication 358, 369
Food colourings 73, 206
Food poisoning 104, 357
Formalin 75, 76, 376
Frankfurters 127
Fresh processed meat products 90, 98

G
Galvanized steel 367
Garlic 83, 85, 135
Gelatine 70, 167, 184, 210
Gelatineous meat mixes 166
Ginger 83, 85, 135
Glass jars 154
Glucono-delta-Lactone (GdL) 119, 120, 125
Good Hygienic Practice (GHP) 341, 360
Grading of manufacturing meat 43, 135
  - pork 44
  - beef 47
  - poultry 51
Gyros 105

H
HACCP 279, 339, 341, 342, 344, 350
Halal 54, 55, 72
Ham products 171, 210
Hamburger 103, 201
Heat coagulation 4, 88, 99, 129, 184, 185
Heat treatment 87, 129, 141, 144, 149, 160, 167, 185, 278
High (hydrostatic) pressure treatment 339
High pressure cleaning 371
Hooks 300
Hotdogs 204, 205
Hurdle technology 92
Hygrometer 322

I
Impression plate method 331, 374
Ingredients, non-meat 59
Ingredients, animal origin 62
Ingredients, functional 60
Internal organs 1, 149
Internal (core) temperature 130, 144, 155, 166, 185, 278, 279, 292,
Intestines 1, 252
Irradiation 339

J
Jerky 239

K
Kebab 105
Kilishi 213, 241
Knife sharpening 298
Knives 297

L
Lactic acid 5, 9
Lactic acid bacteria 272, 338, 356
Light, barrier 267
Liver pate 157
Liver sausage 97, 153
  - coarse-mixed 154
- fine emulsion-like 156, 158
Luncheon meat 210
Lux-meter 325
Lyoner 127, 208

M
Mace 83, 85, 86, 135
Maize 78
Marjoram 83, 85
Meat
- additives 59, 63
- animal species 1, 9, 43, 222
- balls 147, 203
- binders 64, 201
- canning 277
- chemical composition 2
- cutting 32, 44, 48, 51, 52, 223
- dishes 90
- drying 101, 122, 221, 233
- extenders 61, 195, 200
- extract 170
- fillers 62, 195, 200
- grading for processing 43
- mechanically deboned (MDM) 55, 56, 196, 206
- loaves 146
- pigment 7, 35, 68, 172
- preservation 34
- taste, flavour 5
- tenderness 8
Meat processing 17, 97
Meat processing equipment
- autoclave 246, 280
- band saw 309
- bowl cutter (chopper) 20, 121, 246, 303
- brine injector 26
- can closing machine 246, 286
- clipping machine 23
- cooking vat 308
- dishes 90
- dryer 226
- emulsifying machine 30
- extender, see Extender
- filling machine (stuffer) 22, 306
- frozen meat cutter 31
- hooks 300
- ice flaker 30
- meat grinder (mincer) 18, 121, 301
- mixer (blender) 29
- smoking equipment 23, 24, 25, 26, 246, 310
- tumbler (massager) 28, 184
- vacuum packaging machine 29, 269
Meat processing hygiene 245, 339, 360
Meat processing, basic 243
Meat ripening 272
Microbiological analysis 331
Microbiological criteria 260, 353
Microorganisms 337
- vegetative 95
- spores 95
Milk proteins 63, 69, 70, 160, 204
Minerals 2, 16, 196, 328
Modified atmosphere packaging (MAP) 275
Moisture analysis 326, 328
Monosodium glutamate 9, 73, 135
Mortadella 198
Moulds 124, 337, 357, 359, 360
Multi-layer films 270
Muscle fibers/cells 3
Mutton 9, 131
Mutton burger 103
Myofibrils 3
Myoglobin 3, 7, 35

N
Naem 217
Nitrosamine 36
Nitrite 34, 35, 68
Nitrite curing salt, see also Curing salt 35, 68, 134
Non-meat ingredients 59
- application 64
Nutmeg 83, 85, 86, 135

O
Onion 83, 85
Oregano 83
Oximyoglobin 270
Oxygen 275, 276
Oxygen barrier 270, 271

P
Packaging 265
- materials 266
- modified atmosphere 275
- skin 274
- vacuum 271, 273, 274
Paprika 83, 85
Pasteurization 94, 149, 169
Pastirma 218, 238
Patties 103
Pepper 83, 85, 86, 135
pH 4, 116, 178, 321, 322, 339
pH-meter 321
Phosphate 69, 135, 148, 204
Pimento 83, 85
Plastics, food grade 367
Pork 5, 9, 45
Pork fat 11, 45, 117, 118, 132
Pork skin 210
Prebiotic 196
Precooked-cooked meat products 89, 100, 149
Precooking 150, 168
Preservatives 74, 92, 93
- illegal substances 76
- legal substances 77
Probiotic 196
Processed meat products, categories 97
Protective gears 310
Protein 2, 3, 14
- analysis 326, 331
- blood protein 2
- coagulation 129
- collagen, see Collagen
- connective tissue proteins (collagen, elastin) 3, 14
- keratin 3
- matrix 147, 148
- myofibrillar / skeleton muscle 14
- network 129, 147, 158
- sarcoplasmatic 3, 147
- solution 128
PSE 5

R
Raw-cooked meat products 88, 99, 127
- formation of meat mixes 136, 147
- classical products 127
- extended products 204
- typical composition 135
Raw-fermented meat 172, 218
Raw-fermented sausages 90, 100, 115, 219
Reconstituted products 179, 183
Reddening 141, 145
Reformed products 178
Rehydration 66, 68, 80, 234
Residues 25, 35, 40, 76
Resting periods 39, 178, 182
Retort 280
Retortable pouches 285
Rice 78
Ripening 122, 124, 125, 175
  - chamber 116
  - meat 8, 272
S
Salmonella 96, 357, 360
Salt 3, 67, 119, 147
Salting 33
Sanitation 369
Sanitation schemes 378
Sarcoplasma 3, 147
Sausage 1, 98
  - casing 1, 245
  - clipping, linking 23, 140
  - ripening 115, 116
  - stuffing 22
Seasonings / spices 67, 83, 108
Selective plate count 336, 338
Semi-dry sausages 125
Sensory evaluation 259, 315
Single-layer films 269
Shashlik 107
Shelf life 75, 111, 113, 176
Shelf-stable 92, 94, 115
Skim milk 70, 204
Skin 1, 133
Slaughter by-products 1, 149
Smoking 40, 117
  - cold smoking 41, 124, 156, 176,
  - hot smoking 41, 143
  - liquid smoke 42, 144
Solar dryer 226
Solar drying 224, 226
Soy protein 14, 79, 104
Spices 83, 85, 86, 124, 135
Spices extracts 84
Spoilage 222, 354, 369
Spores 95, 278
Stainless steel 366
Staphylococcus aureus 337, 358, 359, 360
Starter cultures 117, 118, 124, 125
Steel, galvanized 367
Sterilization 94, 292, 293
Sugars 73, 120
Sun drying 224
Swab method, microbiological 333

T
Temperature control 320
Texture 326
Thermometer, electronic 318
Thyme 83, 85
Total plate count 335
Traditional meat products 197, 213
Transglutaminase 72, 184, 211
Tumbling 28, 184, 211
Turkey meat 51
TVP 80, 200, 202

V
Vacuum packaging 271, 273, 274
Vegetable oil 72, 206
Vegetables 82, 104
Vienna sausage 127, 204
Viruses 360
Vitamins 15

W
Water 67, 133, 326
Water activity 92, 93, 221, 231, 324
Water holding capacity (WHC) 7, 71, 132, 148, 325
Water, pressurized 371
Water vapour, barrier 267, 270
Wheat 78
White meat products 143

Y
Yeasts 124

Z
z-value 295