

Rowse Honey Ltd
QUALITY ASSURANCE MANUAL

Product:	Rowse Clear Honey 3.17kg	Product Code:	27060
Spec Version No:	14	Specification Issue	05/08/2026

1.0 PRODUCT INFORMATION

Product Title	Rowse Clear Honey
Sub Text / Marketing Text	Rowse Honey makes the perfect accompaniment to any breakfast; drizzle over morning goods, on toast and over porridge. Our honey is also great used as a base for marinades and dressings, grills and glazes.
Strength Guide	N/A
Label Barcode	5011273070602
Outer Case Label Barcode	N/A
Unit Weight	3.17kg
Origin Declaration	A blend of EU and non-EU honeys. Packed in the UK. Not for EU.
Warning	Unsuitable for infants under 12 months.
Date Code Location	Back label
Product Coding Format	Small white label with BEST BEFORE END MONTH YEAR 4 Digit Production code, line ID Product Code & Title Example: SEP 2022 8198B 10:00 Where: 8 – year packed 2022 / 198 – Julian date packed / B – line packed / 10:00 – time packed. Best Before End - 18 months

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Product Life From Packing	BBE 18 months
Minimum Life On Delivery	13 months
Storage Conditions	Ambient 18- 24 °C, away from direct sunlight and strong odours. Clear honey may begin to crystallise if stored at low temperatures. For further details on crystallisation, see statement at the bottom of the specification
Product Life Once Opened	Use by the end of BBE date
Post Opening Storage Conditions	Ambient 18- 24 °C, away from direct sunlight and strong odours. Use by the end of BBE date
Suitable For Freezing	No
Delivery Conditions	Clean dry area, delivered in ambient 18 – 24 °C

3.0 RECIPE & INGREDIENTS

Ingredient	% in recipe	Supplier	Country of manufacture	Country of origin
Honey	100	Rowse approved Suppliers	UK	Argentina, Brazil, Greece, China Mexico, Turkey, Vietnam, Romania, Spain, Uruguay, UK, New Zealand, India
Ingredient Declaration	N/A: Honey is a single ingredient product.			

4.0 NUTRITIONAL INFORMATION

NUTRIENT	per 100g	Source of Data
Energy kJ	1398	Analysis
Energy kcals	329	
Fat (g)	<0.5	
of which saturates (g)	0.2	
Carbohydrate (g)	81.5	
of which sugars (g)	80.8	
Fibre (g)	<0.5	
Protein (g)	<0.5	
Sodium (mg)	12	
Salt (sodium x 2.5) (g)	0.03	

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5.0 ALLERGENS AND SENSITIVE INGREDIENTS

5.1 Allergens

ALLERGEN	PRESENT IN PRODUCT (Yes/No)	PRESENT ON SITE (Yes/No)	CONTAMINATION RISK PRESENT (Yes/No)	DETAILS
Cereals containing gluten (e.g. wheat, spelt, rye, barley, oats etc)	No	No	No	
Crustaceans (e.g. prawns, crab, lobster, crayfish)	No	No	No	
Egg	No	Yes	No	
Fish	No	No	No	
Peanuts	No	No	No	
Nuts; namely almond, hazelnut, walnut, cashew, pecan nut, Brazil nut, pistachio nut, macadamia nut	No	No	No	
Soybeans	No	Yes	No	
Milk (including lactose)	No	Yes	No	
Mustard	No	No	No	
Sesame	No	No	No	
Sulphur dioxide / sulphites, where added and at a level above 10ppm in the finished product.	No	Yes	No	
Lupin	No	No	No	
Molluscs (e.g. mussels, clams, oysters, scallops, snails and squid)	No	No	No	
Celery	No	No	No	

5.2 Contains

INGREDIENT	PRESENT IN PRODUCT (Yes/No)	PRESENT ON SITE (Yes/No)	CONTAMINATION RISK PRESENT (Yes/No)	DETAILS
Maize	No	Yes	No	
Additives (declared additives or processing aids)	No	Yes	No	
Antioxidants	No	No	No	

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INGREDIENT	PRESENT IN PRODUCT (Yes/No)	PRESENT ON SITE (Yes/No)	CONTAMINATION RISK PRESENT (Yes/No)	DETAILS
Natural Colourings	No	No	No	
Artificial Colourings (incl. NI)	No	No	No	
Natural Flavourings	No	Yes	No	
Artificial Flavourings (incl. NI)	No	No	No	
Flavour Enhancers	No	No	No	
Preservatives	No	Yes	No	
Sweeteners	No	No	No	
Alcohol (abv %)	No	Yes	No	

5.3 Other Considerations

	Yes / No	Details if Yes
Is the product packaged in Modified Atmosphere?	No	
Is this product treated using ionising radiation?	No	
Does this product contain Genetically Modified Ingredients?	No	
Is this product a possible source of phenylalanine?	No	
Is this product a possible source of histamines?	No	
Does the product contain hydrogenated fats?	No	
Does the product contain palm oil?	No	

6.0 SUITABILITY DATA

	Yes / No	Declared	Details
Suitable for Vegetarians	Yes	No	
Suitable for Vegans	No	No	Honey is derived from bees
Halal Certified	No	No	
Kosher Certified	No	No	
Suitable for Coeliacs	Yes	No	Naturally gluten free however not tested for it
Organic Certified	No	No	

7.0 PACKAGING

7.1 Packaging details

Packaging Item / Level	Specification	Dimension (mm)	Material	Weight (g)	% Recycled Content	Recyclable (Yes/No)
Primary	Pre-printed bucket & lid Colour bucket: transparent clear, Colour lid: black	Lidded height 141 / External lidded diameter 196	Plastic PP	121	0	Yes

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Primary	Self-adhesive white label	39 x 25mm	Paper label	1.0	0	Yes (label stuck on the tub)
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7.2 Palletisation Information

Units per outer	1
Outers per layer	30
Layers per pallet	6
Cases per pallet	180

8.0 FINISHED PRODUCT STANDARDS

8.1 Organoleptic Evaluation

	Acceptable	Unacceptable
Appearance	- Fill should be clean and level - Air bubbles may be present in the shoulder of the bucket, which may look like slight foaming. The ring should be no more than 1cm thick. - Minimal small air bubbles or no larger bubbles present in body of the product. - The product is a viscous pourable liquid. - Glossy appearance. - Free from foreign bodies. 	- Very pale or dark in colour, or very cloudy. - Low fill level. - Excessive air bubbles - Product is very thick and not pourable.
Colour	- Consistent medium amber colour and varies from being clear to slightly opaque - Accept 30-60 mmpfund	- Very pale or dark in colour, or very cloudy. - Reject <30 / >60 mmpfund
Texture	- The honey is a viscous pourable liquid. - Dissolves easily in the mouth. - Not tacky or sticky in the mouth. - Generally smooth and not grainy. - Crystallisation may occur over life.	- Larger sugar crystals in mouthfeel - Fully crystallized

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Aroma	• Typical honey aroma. • No off odours present.	• Non honey aroma • Off odours present.
Flavour	• Sweet, mild flavour typical of honey with delicate fruity & floral notes. • Acidity should not dominate but may be present in the aftertaste. • No off, fermented or bitter flavours to be present.	• Tastes burnt or distinct strong caramel flavour. • Excessive acidic notes dominate. • Off, fermented or bitter flavours present.

8.2 Quality Analysis

Test	Frequency	Method	Accept	Reject
HMF at time of packing	Every Batch	Spectrophotometer	≤ 40 mg/kg	>40 mg/kg
Colour	Every Batch	Lovibond Comparator	30 – 60 mmpfund	<30 / >60 mmpfund
Moisture	Every Batch	Refractometer	≤ 20 %	>20 %

8.3 Veterinary Residues

Test	Target	Reject	Method	Frequency
Chloramphenicol	0-0.3 ppb	>0.3 ppb	VETRES02	Routine sampling of honey by batch verification
Streptomycin	0-10 ppb	>10 ppb	VETRES05	Routine sampling of honey by batch verification
Tetracycline's	0-10 ppb	>10 ppb	VETRES11	Routine sampling of honey by batch verification
Sulphonamides	0-5 ppb	>5 ppb	VETRES03	Routine sampling of honey by batch verification
Nitrofurans	0-0.5 ppb	>0.5 ppb	VETRES08	Routine sampling of honey by batch verification
Macrolides	0-2 ppb	>2 ppb	VETRES09	Routine sampling of honey by batch verification
Nitroimidazoles	0-1 ppb	>1 ppb	Imid.P	Routine sampling of honey by batch verification
Trimethoprim	0-5 ppb	>5ppb	VETRES09	Routine sampling of honey by batch verification

All honey is sampled for Veterinary Residues/Antibiotic testing by an accredited, independent laboratory in accordance with the European Union and United Kingdom regulations. Antibiotic residue testing is based on risk assessment. Rowse may alter the testing suite due to changes within the risk assessment. Evidence of homogenisation is provided prior to delivery; all homogenised loads are sampled as per guideline of the square root +1 of the number of barrels in a container. If it is not homogenised sampling is done on a risk assessment basis.

8.4 Other Contaminants

Pesticide testing is completed annually by the Honey Association and results are all within the tolerances set in Regulation (EC) 396 2005, foods which do not have an MRL for any particular pesticide there is a general MRL of 0.01mg/kg.

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8.5 Microbiological Analysis

Test	Method	Frequency	Units	Target	Reject
TVC	TP4100	Quarterly	Cfu/g	<10000	>10000
Yeast	TP4109	Quarterly	Cfu/g	<1000	>1000
Mould	TP4109	Quarterly	Cfu/g	<1000	>1000

8.6 Other

Certificate of Conformance:	An annual certificate of conformance can be supplied by email upon request.
Laboratory Details:	Internal: CLAS Compliant External: UKAS Accredited

9.0 AUTHORISATION

NAME	SIGNATURE	POSITION	DATE
Luis Alberola	LA	Specifications Technologist	05/08/2026

REFERENCE

The honey supplied in this product complies to the following documents.

Honey (England) Regulations 2015
EC Directive 2001/110/EC relating to honey with Directive 2014/63/EU amendments
EC Directive 2008/772/EC on the approval of residue monitoring plans submitted by third countries in accordance with Council Directive 96/23/EC
Commission Regulations (EU) No 37/2010 on pharmacologically active substances and their classification regarding maximum residue limits in foodstuffs of animal origin
CODEX Standard for Honey 12-1981

CRYSTALLISATION OF HONEY

Honey is a natural product completely free of additives of any kind. As such, its constituent parts are variable according to the floral and geographic origin of the plants visited by the bees. Approximately 80% of honey is invert sugar in various forms. The two main ones are fructose and glucose. As a general rule, those honeys which are high in glucose will crystallise readily, perhaps within a matter of weeks and sometimes, exceptionally quickly, even before the honey is extracted from the comb. Conversely, honeys which are high in fructose will stay liquid for a greater length of time and in some cases indefinitely. The main bulk of honeys will re - crystallise naturally within about six months.

When honey sets some of the glucose comes out of the solution and forms crystals. The process can be accelerated by keeping the honey at the optimum temperature for crystallisation and by starting off with a nucleus of crystals on which further crystals can grow. Other matter, such as pollen, can also act in the same way and cause the precipitation of crystals to be accelerated. The process can be reversed by warming the honey, thus melting the crystals, but they will usually form again within a short period of time. It always follows that a honey with very little pollen in it will stay liquid for a longer period of time.

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It is important to realise that honey which crystallises naturally does so more slowly and the formation of the crystals is less controlled and results in a coarse texture. There is nothing wrong with the honey, it is perfectly edible, and the only difference between it and smooth spreadable set honey is that the latter has been crystallised under strictly controlled temperature conditions.

THE STORAGE OF HONEY

Honey is formed from nectar which is converted by the bee into a concentrated solution containing many sugars, but in the main glucose and fructose.

All honey should be stored in a clean warehouse away from strong odours and out of direct sunlight.

Clear Honey

Clear honey should be stored at 20°C (68F) on average, but no higher than 24°C (75F) or lower than 15°C (59F). Lower temperatures will hasten the appearance of glucose crystals which, although harmless, detract from the appearance of the product.

SUMMARY OF SPECIFICATION CHANGES

SPEC VERSION NO	DATE	SUMMARY OF AMENDS
5	05/07/2021	New Specification to update allergen list with celery
6	17/05/2022	Update contacts, amend sodium content
7	07/07/2022	Updated contacts, added the BOP & FOP artwork snip. Packaging label added
8	15/12/2022	Amended version number.
9	03/03/2023	Turkey added as COO. Ina contact changed for Lucy.
10	18/07/2024	COO, Kosher Status, Removed BOP Label due to presence of Kosher logo, Packaging Details, Contact Details and Internal Lab Details
11	11/11/2024	Technical contact details and label update
12	24/06/2025	Allergen table update to reflect the introduction of gluten and celery to site
13	23/01/2026	Contact details and date code label updated, Not for EU statement addition.
14	05/08/2026	Celery and gluten removed from site. India added as COO.

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