

RNED BEEF

Section 5 of 6

Processing Procedures

- E.
1. Cure meat in 68°F pickle with spice
 2. Overall, 10 days
 3. Cure completed in 21 days
 4. Dry

- F.
1. Cure meat in 68°F pickle with spice
 2. Overall, 10 days
 3. Cure completed in 21 days
 4. Dry
 5. Rubbed with garlic and pepper
 6. Smoke

- G.
1. Pump, 15%
 2. Place in vat with spice
 3. Cover with pickle
 4. Cure, 38°F, 4 days

H. Dry Cure

- I.
1. Remove connective tissue
 2. Slice, 1"
 3. Simmer, 200°F
 4. Grind, 1"
 5. Mix with salt and nitrite
 6. Stuff
 7. Retort
 8. Chill

Cooking Forms

1. Cans
2. Plastic bags

Section 6 of 6

CORNED BEEF HASH

CORNEI

Average Values

Section 1 of 5

	M o i s t u r e	F a t	P r o t e i n	% C o l l a g e n	B i n d	C o l o r	Pounds for Various Formulations							
							A	B	C	D	E	F	G	
Meat block														
Beef														
Bull F.C.	70	10	20	20	30	47	50							
Clod	72	7	20	25	27	42		100						
Cooking broth beef	99	0	1	0	0	0			25					
Corned beef, canned	44	32	22	30	18	16				100				
Cow F.C.	68	14	18	21	24	39			75		100	100		
Flank	43	42	13	24	12	20			25					
Shank, cured	73	6	20	48	28	30	50							
Trim 90 (lean)	71	11	18	28	27	43								100
Dry Ingredients														
Cereal flour	12	1	10	0	18	0		38						
Gelatin	13	0	85	0	20	0	1.5							
MGS	0	0	0	0	0	0								0.6
Non-fat dry milk	3	1	38	0	25	0		36						
Salt	.01	0	0	0	40	0	1.5	8	3	2.8	2.8	2.8	3	
Moist Ingredients														
Oil	0	100	0	0	0	0		24						
Water or ice	100	0	0	0	0	0	10	140		100	63	63	41	
Fruit & Vegetables														
Onion	89	0	1	0	0	0					8.6			
Potato, dehydrated	5	1	7	0	0	0				34	22	22	22	
Potato, fresh	80	0	2	0	0	0	96							
Calculated composition 7% shrink														
Moisture							*92.8	*60.1	65.1	*58.6	*69.0	*68.1	*65.5	
Fat							5.7	9.9	17.6	14.7	7.8	8.1	7.2	
Protein							17.1	11.6	14.3	11.1	10.7	11.2	12.6	
Properties														
% Collagen (Max. 35)							20.5	13.4	21.2	27.0	19.3	19.3	25.8	
Bind Points (Min. 1.8)							3.1	3.0	3.0	1.8	2.4	2.5	3.1	
Color Points (Min. 2)							4.0	2.6	5.0	*1.6	3.8	4.0	5.0	

Meat block
Beef
Trim 90 (l
Dry ingred
MGS
Salt
Moist Ingre
Water or i
Fruit & Veg
Potato, de
Potato, fr
Calculated co
Moisture
Fat
Protein
Properties
% Collag
Bind Poi
Color Poi

CORNER BEEF HASH

Section 2 of 5

Average Values

	M o i s t u r e	F a t	P r o t e i n	% C o l l a g e n	B i n d	C o l o r	Pounds for Various Formulations										
							H	I									
Meat block																	
Beef																	
Trim 90 (lean)	71	11	18	28	27	43	100	100									
Dry Ingredients																	
MGS	0	0	0	0	0	0											
Salt	.01	0	0	0	40	0	3	3									
Moist Ingredients																	
Water or ice	100	0	0	0	0	0	74										
Fruit & Vegetables																	
Potato, dehydrated	5	1	7	0	0	0	22										
Potato, fresh	80	0	2	0	0	0		96									
Calculated composition 7% shrink							*71.4	*72.3									
Moisture							6.1	5.9									
Fat							10.6	10.8									
Protein																	
Properties							25.7	25.2									
% Collagen (Max. 35)							2.6	2.6									
Bind Points (Min. 1.8)							4.2	4.2									
Color Points (Min. 2)																	

G

100

0.6

3

41

22

65.5
7.2
12.6

25.8
3.1
5.0

CORNED BEEF HASH

CORNED 1

Average Values

Section 3 of 5

	Average Values			Oz. unless indicated otherwise per 100 lbs. of meat							
	M o i s t u r e	F a t	P r o t e i n	1	2	3	4	5	6	7	8
Curing Ingredients											
Na or K Nitrite	0.1	0	0	0.25	0.25	0.25					
Spices											
Celery seed	6	25	18	1			0.7				
Mustard seed, ground	6	29	30		4	2		6			
Onion powder	5	1	10		9	10	2.5				
Pepper black	11	8.5	12	12	1.9	6	2	2.8			
Pepper, white	11	8.5	1.3						4		
Vinegar	94	0	0		48						

- Meat block
- Beef
- Comed beef, c
- Trim 90 (lean)
- Dry Ingredients
- Dextrose
- Gelatin
- Non-fat dry m
- Noodle, raw
- Pistachio nut
- Salt
- Moist Ingredi
- Mayonnaise
- Water or ice
- Fruit & Vegetab
- Pimiento
- Calculated compo
- Moisture
- Fat
- Protein
- Properties
- % Collagen (
- Bind Points (
- Color Points (

Processing Procedures

Section 4 of 5

- A.
1. Cook meat until tender
 2. Grind
 3. Mix
 4. Stuff
 5. Ham retainer
 6. Cool
- B.
1. Grind meat, 3/8"
 2. Mix
 3. Stuff in cans
 4. Retort

Cooking Forms

Section 5 of 5

1. Cans
2. Molds

CORNED BEEF LOAF

Average Values

Section 1 of 4

	M o i s t u r e	F a t	P r o t e i n	% C o l l a g e n	B i n d	C o l o r	Pounds for Various Formulations		
							A	B	C
Meat block									
Beef									
Comed beef, cured	44	30	23	30	20	16	100	50	
Trim 90 (lean)	71	11	18	28	27	43			100
Dry Ingredients									
Dextrose	.06	0	0	0	10	0			1
Gelatin	13	0	85	0	20	0		7.5	
Non-fat dry milk	3	1	38	0	25	0			15
Noodle, raw	10	5	13	0	10	2		50	
Pistachio nut	5	54	19	0	0	0		6.2	
Salt	.01	0	0	0	40	0		2.5	5
Moist Ingredients									
Mayonnaise	15	80	1	0	0	0		20	
Water or ice	100	0	0	0	0	0		37	
Fruit & Vegetables									
Pimiento	92	1	1	0	0	60		15	
Calculated composition 7% shrink									
Moisture							39.8	39.4	56.0
Fat							*32.3	21.1	9.9
Protein							24.7	14.8	21.1
Properties									
% Collagen (Max. 35)							30.0	13.3	21.3
Bind Points (Min. 1.8)							4.9	2.4	5.6
Color Points (Min. 2)							4.0	*1.2	6.9

CORNED BEEF LOAF

Average Values

Section 2 of 4

	M o i s t u r e	F a t	P r o t e i n	Oz. unless indicated otherwise per 100 lbs. of meat								
				1	2	3	4	5	6	7	8	
Curing Ingredients												
Na or K Nitrite	0.1	0	0	0.25								
Na or K Nitrate	0.1	0	0	1								
Spices												
Allspice	8.5	8.7	6	2	2							
Bay leaves	5	8	8	3	4							
Celery seed	6	25	18			1.2						
Cloves	7	22	6	2	2							
Garlic Powder	6	1	17	0.5								
Lemon Extract	20	5	0			1.2						
Mace	8	30	7			1.2						
Onion powder	5	1	10	1								
Parsley	85	1	4			5						
Pepper black	11	8.5	12	8								
Pepper, white	11	8.5	1.3		8	7.5						

CORNED

Processing Proc

A.

1. Grind me
2. Cook, 3-
3. Stuff
4. Flauen

B.

1. Cook no
2. Cut beef
3. Mix
4. Mold
5. Cook, 2
6. Cool, 12

C.

1. Grind, 1
2. Mix salt
3. Place in
4. Water c
5. Mix
6. Stuff
7. Cool

Cooking Forms

1. Pan
2. Molds
3. Artificia
4. Nets

CORNERED BEEF LOAF

Section 3 of 4

Processing Procedures

A.

1. Grind meat, 1-1/2" plate
2. Cook, 3-1/2 hours, 160°F, seasoning in bag
3. Stuff
4. Flatten

B.

1. Cook noodles in 160°F water until tender
2. Cut beef to 1/2" cube and add
3. Mix
4. Mold
5. Cook, 2 hours at 160°F
6. Cool, 12 hours at 40°F

C.

1. Grind, large plate
2. Mix salt, cure, 5 days, 38°F
3. Place in nets
4. Water cook
5. Mix
6. Stuff
7. Cool

Cooking Forms

Section 4 of 4

1. Pan
2. Molds
3. Artificial casing
4. Nets

COTECHINO

Average Values

Section 1 of 4

	M o i s t u r e	F a t	P r o t e i n	% C o l l a g e n	B i n d	C o l o r	Pounds for Various Formulations									
							A	B	C	D	E	F	G			
Meat block																
Pork																
Skin	40	32	28	99	6	1	30									
Trim 80 (lean)	60	23	16	25	16	25	50									
Trim 15 (fat)	11	85	3	60	3	1	20									
Dry Ingredients																
Salt	.01	0	0	0	40	0	3.4									
Calculated composition 12% shrink																
Moisture							34.9									
Fat							*41.9									
Protein							18.9									
Properties																
% Collagen (Max. 35)							*62.1									
Bind Points (Min. 1.8)							2.0									
Color Points (Min. 2)							2.3									

COTECHI

Curing Ingredient
Na or K Nitrate
Spices
Cinnamon
Cloves
Nutmeg
Pepper, white

Processing Process

A.

1. Chop, rinse
2. Cut fat into
3. Mix
4. Store to cool
5. Stuff
6. Hang 50°
65°
52°
7. Boil or cook

Cooking Forms

1. Pork casing
2. Artificial casing

COTECHINO

Average Values

Section 2 of 4

	M o i s t u r e	F a t	P r o t e i n	Oz. unless indicated otherwise per 100 lbs. of meat								
				1	2	3	4	5	6	7	8	
<u>Curing Ingredients</u>												
Na or K Nitrate	0.1	0	0	3								
<u>Spices</u>												
Cinnamon	10	3	4	1								
Cloves	7	22	6	1								
Nutmeg	8	33	7	0.5								
Pepper, white	11	8.5	1.3	4								

Processing Procedure

Section 3 of 4

- A.
1. Chop, rind and pork trim
 2. Cut fat into fine pieces
 3. Mix
 4. Store to cure
 5. Stuff
 6. Hang 50°F for 48 hours
65°F for 24 hours
52°F for 48 hours
 7. Boil or cook

Cooking Forms

Section 4 of 4

1. Pork casing
2. Artificial casing

CRACKLING

CURING

Average Values

Section 1 of 3

	M o i s t u r e	F a t	P r o t e i n	% C o l l a g e n	B i n d	C o l o r	Pounds for Various Formulations								
							A	B	C	D	E	F	G		
Meat block															
Pork															
Backfat	5	93	1	95	0	0	75								
Skin	40	33	28	99	6	1	25								
Calculated composition	76% shrink														
Moisture							11.8								
Fat							22.8								
Protein							65.5								
Properties															
% Collagen (Max. 35)							*98.6								
Bind Points (Min. 1.8)							1.8								
Color Points (Min. 2)							*0.3								

Meat block
 Dry Ingredient
 Phosphate
 Saccharin
 Salt
 Sugar (suc)
 Moist Ingredient
 Water or ice
 Calculated component
 Moisture
 Fat
 Protein
 Salt
 Phosphate
 Sugar

Processing Procedures

Section 2 of 3

- A.
1. Portion of rind and fat tissue remaining after lard is rendered
- B.
1. Crackling bread
 2. Press as much fat from rendered tissue as possible
 3. Work into a dough with corn meal
 4. Bake into bread

Cooking Form

Section 3 of 3

1. Kettle

CURING BRINE

Average Values

Section 1 of 4

	M o i s t u r e	F a t	P r o t e i n	% C o l l a g e n	B i n d	C o l o r	Pounds for Various Formulations					
							A	B	C	D		
Meat block												
Dry Ingredients												
Phosphate	1	0	0	0	40	0	3.0					
Saccharin	0	0	0	0	0	0		0.025				
Salt	.01	0	0	0	40	0	14.5	18.6	9.0	7.1		
Sugar (sucrose)	.06	0	0	0	10	0	3.0	0	1.4	0.4		
Moist Ingredients												
Water or ice	100	0	0	0	0	0	79.3	81.2	88.9	92.2		
Calculated composition 0% shrink												
Moisture							79.5	99.9	89.6	92.5		
Fat							0	0	0	0		
Protein							0	0	0	0		
Salt							14.5	18.6	9.0	7.1		
Phosphate							3.0	0	0	0		
Sugar							3.0	0	1.4	0.4		

CURING BRINE

DANISH 1

Average Values

Section 2 of 4

	M o i s t u r e	F a t	P r o t e i n	Oz. unless indicated otherwise per 100 lbs. of brine									
				1	2	3	4	5	6	7	8		
<u>Curing Ingredients</u>													
Na or K Nitrite	0.1	0	0	3.4	2.6	1.7	1						
Na or K Nitrate	0.1	0	0			1.7	12.3						
Prague Powder	0	0	0										
Na Ascorbate	0.1	0	0										
Na Erythorbate	0.1	0	0			1.4							

Processing Procedure

Section 3 of 4

A.

1. 18.6% salt, pump 10%

Cooking Form

Section 4 of 4

1. Vat

Meat block
Beef
Trim 75
Trim 60
Pork
Trim 80 (lean)
Trim Reg
Dry Ingredients
Dextrose
Salt
Sugar (sucros)
Fruit & Vegetal
Garlic, fresh
Calculated compo
Moisture
Fat
Protein
Properties
% Collagen (
Bind Points (
Color Points

DANISH DRY SAUSAGE

Average Values

Section 1 of 4

	M o i s t u r e	F a t	P r o t e i n	% C o l l a g e n	B i n d	C o l o r	Pounds for Various Formulations							
							A	B						
Meat block														
Beef														
Trim 75	58	25	16	38	22	34	40							
Trim 60	45	43	12	40	16	25		50						
Pork														
Trim 80 (lean)	60	23	16	25	16	25	30	35						
Trim Reg	34	58	8	36	10	8	30	15						
Dry Ingredients														
Dextrose	.06	0	0	0	10	0	0.25							
Salt	.01	0	0	0	40	0	3	3						
Sugar (sucrose)	.06	0	0	0	10	0	0.25							
Fruit & Vegetables														
Garlic, fresh	61	0	6	0	0	0	0.03	0.03						
Calculated composition 25% shrink														
Moisture							32.9	29.6						
Fat							*44.2	*49.5						
Protein							17.5	16.6						
Properties														
% Collagen (Max. 3.5)							33.1	33.0						
Bind Points (Min. 1.8)							3.1	2.6						
Color Points (Min. 2)							4.6	3.9						

DANISH DRY SAUSAGE

DEBRECZ

Average Values

Section 2 of 4

	M o i s t u r e	F a t	P r o t e i n	Oz. unless indicated otherwise per 100 lbs. of meat									
				1	2	3	4	5	6	7	8		
Spices													
Anise seed, ground	10	16	18	0.5									
Bitters	3	14	8		2								
Caraway seeds	10	15	20	1									
Cinnamon	10	3	4	0.5									
Cloves	7	22	6	0.5									
Coriander	5	18	15		3	3							
Dill	7	4	20	0.75									
Ginger	9	4	8.5			2							
Marjoram	4	7	11		0.75	0.75							
Pepper, white	11	8.5	1.3	5	6	6							

Meat block
 Beef
 Trim 80
 Pork
 Trim 80 (lean)
 Trim 50
 Dry Ingredient
 Salt
 Moist Ingredient
 Water or ice
 Calculated comp
 Moisture
 Fat
 Protein
 Properties
 % Collagen
 Bind Points
 Color Points

Processing Procedures

Section 3 of 4

- A.
1. Cure
 2. Grind
 3. Mix
 4. Stuff
 5. Hold, 24 hours, 38°F
 6. Smoke and cook
 7. Cook, hot water, prior to eating
- B.
1. Cure
 2. Grind
 3. Mix
 4. Stuff
 5. Place in box
 6. Sprinkle with salt and brown sugar
 7. Hold 5 days, 30°F
 8. Smoke and cook, to internal temperature of 140°F

Cooking Form

Section 4 of 4

1. Artificial casing

DEBRECZINER

Average Values

Section 1 of 4

	M o i s t u r e	F a t	P r o t e i n	% C o l l a g e n	B i n d	C o l o r	Pounds for Various Formulations						
							A	B					
Meat block													
Beef													
Trim 80	63	20	17	30	24	39	50						
Pork													
Trim 80 (lean)	60	23	16	25	16	25		50					
Trim 50	36	52	10	34	12	9	50	50					
Dry Ingredients													
Salt	.01	0	0	0	40	0	2.5	2.5					
Moist Ingredients													
Water or ice	100	0	0	0	0	0	20	20					
Calculated composition 12% shrink													
Moisture							50.8	49.4					
Fat							*33.4	*34.8					
Protein							12.5	12.1					
Properties													
% Collagen (Max. 35)							31.5	28.4					
Bind Points (Min. 1.8)							2.4	*1.7					
Color Points (Min. 2)							3.5	2.3					

DEBRECZINER

DEVIL

Average Values

Section 2 of 4

	M o i s t u r e	F a t	P r o t e i n	Oz. unless indicated otherwise per 100 lbs. of meat									
				1	2	3	4	5	6	7	8		
<u>Curing Ingredients</u>													
Na or K Nitrite	0.1	0	0	0.25									
Na Erythorbate	0.1	0	0	0.87									
<u>Spices</u>													
Caraway seed, ground	10	15	20	3.5									
Garlic, Powder	6	1	17	1									
Pepper black	11	8.5	12	3.5									

Meat block
Pork
Ham fat
Ham, sn
Ham, tri
Other Mea
or Undes
Cooking
Dry Ingre
Salt
Moist Ingr
Worcest
Calculated c
Moisture
Fat
Protein
Properties
% Colla
Bind Poi
Color Pc

Processing Procedures

Section 3 of 4

A.

1. Grind, 1/4" plate
2. Preblend
3. Chop, 1/3 fine
4. Chop, 2/3 coarse
5. Mix
6. Stuff
7. Cook and heavy smoke to 155°F internal temperature

Cooking Form

Section 4 of 4

1. Use 22-30 mm casings

DEVILED HAM

Average Values

Section 1 of 4

	M o i s t u r e	F a t	P r o t e i n	% C o l l a g e n	B i n d	C o l o r	Pounds for Various Formulations						
							A	B					
Meat block													
Pork													
Ham fat, cured	15	81	4	93	0	0	33	33					
Ham, smoked	71	7	20	24	15	18	67						
Ham, trim, cooked	60	10	23	27	15	15		67					
Other Meats or Mixtures or Undesignated													
Cooking broth	99	0	1	0	0	5	33	50					
Dry Ingredients													
Salt	.01	0	0	0	40	0		3					
Moist Ingredients													
Worcestershire sauce	62	1	6	0	0	90		0.04					
Calculated composition 8% increase in wt.													
Moisture							*66.7	*64.7					
Fat							21.9	20.2					
Protein							10.5	10.4					
Properties													
% Collagen (Max. 35)							29.5	31.3					
Bind Points (Min. 1.8)							*1.4	*1.4					
Color Points (Min. 2)							*1.7	*1.3					

DEVEILED HAM

Section 2 of 4

Average Values

	M o i s t u r e	F a t	P r o t e i n	Oz. unless indicated otherwise per 100 lbs. of meat									
				1	2	3	4	5	6	7	8		
Curing Ingredients													
Na or K Nitrite	0.1	0	0	0.25									
Na or K Nitrate	0.1	0	0	4									
Spices													
Mustard seed, ground	6	24	30	0.6	7.5								
Paprika	10	13	15		0.3								
Pepper, red	8	17	12	0.2	0.4								
Pepper, white	11	8.5	1.3	3	0.1								
Tumeric	11	10	8		0.4								

DEVEILED

Processing Procedure

- A.
1. Pump ham :
 - 16.5
 - 2.7
 - 0.6
 - 2.5
 - 0.6
 2. Cover with
 3. Cure 10 day
 4. Bone ham
 5. Cook in wa
 6. Grind ham
 7. Mix
 8. Re grind, 1/
 9. Place in car
 10. Retort

B.

1. Cut, lean ir
2. Water cook
3. Grind, lean
4. Mix
5. Re grind, 1
6. Stuff
7. Retort

Cooking Form

1. Cans, 3 oz

EVILED HAM

Section 3 of 4

Processing Procedures

A.

1. Pump ham 10% with

16.5 pounds water
2.7 pounds salt
0.6 ounce sodium nitrite
2.5 ounce sodium nitrate
0.6 pounds sugar

2. Cover with diluted brine (50°)
3. Cure 10 days
4. Bone ham and cube, 1 pound cubes with some fat
5. Cook in water
6. Grind hams and fat, 1/2"
7. Mix
8. Re grind, 1/16"
9. Place in cans hot
10. Retort

B.

1. Cut, lean into, 1 pound cubes
2. Water cook
3. Grind, lean and fat, 1/2"
4. Mix
5. Re grind, 1/16"
6. Stuff
7. Retort

Cooking Form

Section 4 of 4

1. Cans, 3 oz.

DICED LOAF

Average Values

Section 1 of 4

	M o i s t u r e	F a t	P r o t e i n	% C o l l a g e n	B i n d	C o l o r	Pounds for Various Formulations							
							A							
Meat block														
Other Meats or Mixtures or Undesignated														
Bologna, broken	56	30	12	31	8	20	100							
Dry Ingredients														
Gelatin	13	0	85	0	20	0	3							
Moist Ingredients														
Water or ice	100	0	0	0	0	0	12							
Calculated composition 0% shrink														
Moisture							59.5							
Fat							26.1							
Protein							12.7							
Properties														
% Collagen (Max. 35)							25.5							
Bind Points (Min. 1.8)							*1.3							
Color Points (Min. 2)							2.1							

DICED 1

Spices
Lemon Ext
Vinegar

Processing Pro

A.

1. Dice bc
2. Mix wi

Cooking Form

1. Loaf pe

DICED LOAF

Average Values

Section 2 of 4

	M o i s t u r e	F a t	P r o t e i n	Oz. unless indicated otherwise per 100 lbs. of meat							
				1	2	3	4	5	6	7	8
				Spices							
Lemon Extract	20	5	0	1							
Vinegar	94	0	0	32							

Processing Procedure

Section 3 of 4

A.

1. Dice bologna
2. Mix with heavy gelatin

Cooking Form

Section 4 of 4

1. Loaf pan

DRIED BEEF LOAF

DRIED B

Average Values

Section 1 of 4

	M o i s t u r e	F a t	P r o t e i n	% C o l l a g e n	B i n d	C o l o r	Pounds for Various Formulations							
							A	B	C	D	E	F	G	
Meat block														
Beef														
Clod	72	7	20	25	27	42	100							
Round	73	5	21	20	27	45		100						
Trim 90 (lean)	71	11	18	28	27	43			100					
Dry Ingredients														
MSG	0	0	0	0	0	0	0.06			0.06				
Salt	.01	0	0	0	40	0	4	4	4					
Sugar, brown	2	0	0	0	0	0				2.2				
Moist Ingredients														
Corn syrup	20	0	0	0	5	0	0.5	0.5	2.2					
Water or ice	100	0	0	0	0	0				10				
Calculated composition 8% shrink														
Moisture							66.3	67.3	66.1					
Fat							7.3	5.2	10.1					
Protein							20.8	21.8	16.5					
Properties														
% Collagen (Max. 35)							25.0	20.0	28.0					
Bind Points (Min. 1.8)							5.6	5.9	4.5					
Color Points (Min. 2)							8.7	9.8	7.1					

Curing Ingredi
Na or K Nitr
Na or K Nitr
Prague Pow-
Na Erythorb

Processing Proc

- A.
1. Grind, 1
 2. Mix
 3. Place in
 4. Cook in
 5. Keep pr
 6. Dry in s

- B.
1. Grind
 2. Mix
 3. Cure, 4
 4. Stuff
 5. Cook to
 6. Smoke

Cooking Form:

1. Loaf pa
2. Mold

DRIED BEEF LOAF

Average Values

Section 2 of 4

	M o i s t u r e	F a t	P r o t e i n	Oz. unless indicated otherwise per 100 lbs. of meat								
				1	2	3	4	5	6	7	8	
Curing Ingredients												
Na or K Nitrite	0.1	0	0	0.25	0.25							
Na or K Nitrate	0.1	0	0	0.5	0.25							
Prague Powder	0	0	0			4						
Na Erythorbate	0.1	0	0		1	1						

Processing Procedures

Section 3 of 4

- A.
1. Grind, 1/2" plate
 2. Mix
 3. Place in mold
 4. Cook in water bath at 180°F for 4 hours
 5. Keep pressure on top of mold, internal temperature to 160°F
 6. Dry in smokehouse, 4 hours at 130°F

- B.
1. Grind
 2. Mix
 3. Cure, 4 days, 40°F
 4. Stuff
 5. Cook to internal temperature of 160°F
 6. Smoke

Cooking Forms

Section 4 of 4

1. Loaf pan
2. Mold

DUTCH LOAF

DUTCH

Average Values

Section 1 of 4

	M o i s t u r e	F a t	P r o t e i n	% C o l l a g e n	B i n d	C o l o r	Pounds for Various Formulations						
							A	B	C	D	E	F	G
Meat block													
Beef													
Bull F.C.	70	10	20	20	30	47	35						
Cow F.C.	68	14	18	21	24	39		35					
Trim 90 (lean)	71	11	18	28	27	43			20				
Trim 70	55	30	15	39	20	31				40			
Veal													
Lean	69	10	19	27	26	30				15	35	25	
20													
Pork													
Bacon ends	19	68	12	86	1	3						15	
Check meat	67	15	17	72	9	29			40			40	
Head meat	65	16	17	70	7	16				15		5	
Liver	73	7	19	24	2	49				15		5	
Trim 80 (lean)	60	23	16	25	16	25	30	30			35	55	
Trim Reg	34	58	8	36	10	8	35	35	40	30		40	
Dry Ingredients													
Cereal flour	12	1	10	0	18	0			5			5	
Cheese, cheddar	37	32	25	0	0	1				10			
Corn syrup solids	3.5	0	0	0	5	0			2			2	
Dextrose	0.6	0	0	0	10	0						1	
Farina	10	1	11	0	16	0					3		
MSG	0	0	0	0	0	0				0.12			
Non-fat dry milk	3	1	38	0	25	0			2.5			12	
2.5												2.5	
Salt	.01	0	0	0	40	0	2.75	2.75	3	3	3	4	
3												3	
Soy protein concentrate	8	0	75	0	45	0	3	3	2.5			2.5	
Sugar (sucrose)	.06	0	0	0	10	0	0.4	0.4		0.5	0.5		
Moist Ingredients													
Water or ice	100	0	0	0	0	0	10	10	20	10	15	20	
Worcestershire sauce	62	1	6	0	0	90				0.5			
Fruit & Vegetables													
Garlic, fresh	61	0	6	0	0	0						0.12	
Onion	89	0	1	0	0	0	3	0.2				4	
Calculated composition 6% shrink													
Moisture							53.7	52.2	53.1	51.5	63.6	44.5	53.9
Fat							27.4	29.4	24.8	*30.1	14.3	24.2	23.9
Protein							15.1	14.8	13.3	14.3	15.5	18.9	13.1
Properties													
% Collagen (Max. 35)							21.3	21.8	*41.7	27.9	*38.2	25.3	*41.3
Bind Points (Min. 1.8)							3.7	3.3	2.4	1.9	2.7	3.6	2.4
Color Points (Min. 2)							4.2	3.5	3.0	3.7	3.7	3.5	2.6

- Curing Incred
- Na or K Nit
- Na or K Nit
- Na Ervthort
- Spices
- Caraway
- Cardamon
- Garlic, Pow
- Ginger
- Mace
- Marjoram
- Mustard see
- Nutmeg
- Onion chips
- Pepper black
- Pepper, whi
- Sage
- Vinegar

DUTCH LOAF

Average Values

Section 2 of 4

	M o i s t u r e	F a t	P r o t e i n	Oz. unless indicated otherwise per 100 lbs. of meat							
				1	2	3	4	5	6	7	8
Curing Ingredients											
Na or K Nitrite	0.1	0	0	0.25	0.25	0.25	0.25				
Na or K Nitrate	0.1	0	0	1	1	0.5		1			
Na Erythorbate	0.1	0	0	0.87							
Spices											
Caraway	10	15	20			1.5					
Cardamon	8	3.5	9					0.5			
Garlic, Powder	6	1	17			0.25					
Ginger	9	4	8.5				1	1			
Mace	8	30	7					0.5			
Marjoram	4	7	11		2		2				
Mustard seed, ground	6	24	30	2			2				
Nutmeg	8	33	7	1			2				
Onion chips	4	1	9	8							
Pepper black	11	8.5	12	4			4				
Pepper, white	11	8.5	1.3		8	1.5		6			
Sage	3	14	8.5	1	2						
Vinegar	94	0	0			3					

DUTCH LOAF

Section 3 of 4

FARMERS

Processing Procedures

A.

1. Grind, 1/4"
2. Mix
3. Cure, 1 hour, 40°F
4. Stuff
5. Cook at 165°F in water to internal temperature of 152°F
6. Shower to 120°F
7. Chill, 18 hours, 38°F

B.

1. Grind
2. Mix
3. Cure, 1 hour, 40°F
4. Place in mold
5. Bake
 - 120°F, 30 minutes
 - 150°F, 30 minutes
 - 180°F, 30 minutes
 - 200°F to internal temperature of 152°F

6. Chill

C.

1. Chill meat to 32°F
2. Grind pork, 1/4"
3. Grind beef, 1/8"
4. Chop, beef
5. Mix
7. Bake to internal temperature of 155°F
8. Chill

Cooking Forms

1. Fibrous casing
2. loaf pans
3. Mold

Section 4 of 4

<u>Meat block</u>
<u>Beef</u>
<u>Chuck</u>
<u>Trim 90 (lean)</u>
<u>Trim 75</u>
<u>Pork</u>
<u>Backfat</u>
<u>Lowl, skinned</u>
<u>Liver</u>
<u>Trim 80 (lean)</u>
<u>Trim 50</u>
<u>Trim Reg</u>
<u>Dry Ingredients</u>
<u>Corn syrup soli</u>
<u>Dextrose</u>
<u>Salt</u>
<u>Sugar (sucrose)</u>
<u>Fruit & Vegetabl</u>
<u>Onion</u>
<u>Calculated compos</u>
<u>Moisture</u>
<u>Fat</u>
<u>Protein</u>
<u>Properties</u>
<u>% Collagen (M</u>
<u>Bind Points (V</u>
<u>Color Points (f</u>

FARMERS SAUSAGE

Average Values

Section 1 of 4

	M o i s t u r e	F a t	P r o t e i n	% C o l l a g e n	B i n d	C o l o r	Pounds for Various Formulations									
							A	B	C	D	E	F	G			
Meat block																
Beef																
Chuck	66	16	18	30	24	38	35									
Trim 90 (lean)	71	11	18	28	27	43		80								
Trim 75	58	25	16	38	22	34			40							
Pork																
Backfat	5	93	1	95	0	0	13	5								
Jowl, skinned	24	71	5	43	5	2				15						
Liver	73	7	19	24	2	49				30						
Trim 80 (lean)	60	23	16	25	16	25	52	15		15						
Trim 50	36	52	10	34	12	9				40						
Trim Reg	34	58	8	36	10	8			60							
Dry Ingredients																
Corn syrup solids	3.5	0	0	0	5	0		1								
Dextrose	.06	0	0	0	10	0	0.1		0.25							
Salt	.01	0	0	0	40	0	3.4	3.75	3	1.5						
Sugar (sucrose)	.06	0	0	0	10	0	0.1		0.25							
Fruit & Vegetables																
Onion	89	0	1	0	0	0				1						
Calculated composition 25% shrink																
Moisture							37.4	50.8	22.8	31.4						
Fat							*38.2	21.5	*37.7	*48.1						
Protein							19.0	21.4	14.4	16.7						
Properties																
% Collagen (Max. 35)							27.7	27.8	*37.2	28.4						
Bind Points (Min. 1.8)							3.7	5.4	2.6	*1.3						
Color Points (Min. 2)							5.8	8.6	3.3	4.9						

FARMERS SAUSAGE

Average Values

Section 2 of 4

	M o i s t u r e	F a t	P r o t e i n	Oz. unless indicated otherwise per 100 lbs. of meat								
				1	2	3	4	5	6	7	8	
Curing Ingredients												
Na or K Nitrite	0.1	0	0	0.25								
Na or K Nitrate	0.1	0	0		3	3						
Spices												
Allspice	8.5	8.7	6				1.25	1.25				
Coriander	5	18	15		3							
Ginger	9	4	8.5		2		1.5	1.5				
Marjoram	4	7	11				3	3				
Nutmeg	8	33	7		2		1.5	1.5				
Onion powder	5	1	10				1					
Pepper, white	11	8.5	1.3		6	4	3.25	3.25				
Pepper, white, cracked	11	8	10			2						
Sage	3	14	8.5		1							

FARME

Processing Pr

- A.
1. Grind
 2. Mix
 3. Cure,
 4. Stuff
 5. Hang,
 6. Heavy
 7. Cook,

- B.
1. Grind
 2. Mix
 3. Cure,
 4. Stuff
 5. Green
 6. Smok
 7. Dry re

- C.
1. Grind
 2. Mix
 3. Cure,
 4. Stuff
 5. Hold,
 6. Heavy
 7. Dry, 2

- D.
1. Blanc
 2. Preco
 3. Chop,
 4. Stuff i
 5. Cook,
 6. Chill i
 7. Cold s

Cooking For

1. Use 3-
2. Protei
3. Doubl
4. Liver

FARMERS SAUSAGE

Section 3 of 4

Processing Procedures

A.

1. Grind
2. Mix
3. Cure, 38°F
4. Stuff
5. Hang, 30°F, 4 days
6. Heavy smoke, 10 hours, 125°F
7. Cook, 160°F to internal temperature of 140°F

B.

1. Grind
2. Mix
3. Cure, 38°F
4. Stuff
5. Green room, 5 days
6. Smoke, 24 hours, 70°F
7. Dry room, 50 days

C.

1. Grind
2. Mix
3. Cure, 3 days, 36°F
4. Stuff
5. Hold, 75°F, 80% RH, 12 hours
6. Heavy smoke, 75°F, 75% RH
7. Dry, 30 days, 54°F, 65% RH

D.

1. Blanch (hot water), liver
2. Precook, pork
3. Chop, liver till bubbly, add pork
4. Stuff in liver sausage casing
5. Cook, steam or water, 170°F to internal temperature of 155°F
6. Chill in ice water bath
7. Cold smoke

Cooking Forms

Section 4 of 4

1. Use 3-3-1/2 beef middles
2. Protein lined casings
3. Double wall bungs
4. Liver sausage casing

FRANKFURTER

FRANK

Average Values

Section 1 of 25

	M o i s t u r e	F a t	P r o t e i n	% C o l l a g e n	B i n d	C o l o r	Pounds for Various Formulations						
							A	B	C	D	E	F	G
Meat block													
Beef													
Bull F.C.	70	10	20	20	30	47	75	70	70	70	60	60	60
Fat, brisket	5	93	1	95	0	0		30					
Plate	41	40	18	42	16	25					40		
Pork													
Backfat	5	93	1	95	0	0	25		20	20			
Trim 80 (lean)	60	23	16	25	16	25					20	20	
Trim Reg	34	58	8	36	10	8			10	10		20	
Trim, 15 (fat)	11	85	3	60	3	1							20
Dry Ingredients													
Cereal flour	12	1	10	0	18	0						3.5	
Non-fat dry milk	3	1	38	0	25	0	3.5		3.5				3.5
Salt	.01	0	0	0	40	0	3	2.75	2.75	2.75	3	2.5	2.75
Soy protein concentrate	8	0	75	0	45	0				3.5			
Sugar (sucrose)	.06	0	0	0	10	0	0.5	0.4	0.5	0.5	0.5		0.5
Moist Ingredients													
Water or ice	100	0	0	0	0	0	20	20	10	10	25	25	10
Fruit & Vegetables													
Onion	89	0	1	0	0	0		0.2					
Calculated composition 10% shrink													
Moisture							53.5	52.6	49.3	49.5	61.0	62.0	52.0
Fat							26.9	*31.4	29.9	29.9	19.0	18.9	26.3
Protein							14.5	12.9	15.5	16.8	16.6	14.5	16.3
Properties													
% Collagen (Max. 35)							19.5	21.5	20.1	18.6	28.3	22.1	20.8
Bind Points (Min. 1.8)							4.2	3.8	4.4	5.2	4.1	3.7	4.3
Color Points (Min. 2)							6.2	5.9	6.3	6.3	6.4	5.6	6.1

Meat block
 Beef
 Bull F.C.
 Pork
 Trim Reg
 Dry Ingredi
 Cheese, c
 MSG
 Non-fat d
 Salt
 Soy prote
 Sugar (su
 Moist Ingre
 Water or
 Fruit & Veg
 Garlic, fr
 Onion
 Calculated co
 Moisture
 Fat
 Protein
 Properties
 % Collage
 Bind Poir
 Color Poi

FRANKFURTER

Average Values

Section 2 of 25

	M o i s t u r e	F a t	P r o t e i n	% C o l l a g e n	B i n d	C o l o r	Pounds for Various Formulations						
							H	I	J	K	L	M	N
Meat block													
Beef													
Bull F.C.	70	10	20	20	30	47	60	60	60	60	60	60	60
Pork													
Trim Reg	34	58	8	36	10	8	40	40	40	40	40	40	40
Dry Ingredients													
Cheese, cheddar	37	32	25	0	0	1	30	15					
MSG	0	0	0	0	0	0			0.2				
Non-fat dry milk	3	1	38	0	25	0	5		3.5				
Salt	.01	0	0	0	40	0	3	3	2.75	2.75	3	3	3
Soy protein concentrate	8	0	75	0	45	0			3.5				
Sugar (sucrose)	.06	0	0	0	10	0	0.5	0.5	0.5	0.5	1	0.5	0.5
Moist Ingredients													
Water or ice	100	0	0	0	0	0			10	10	40	20	20
Fruit & Vegetables													
Garlic, fresh	61	0	6	0	0	0	0.01					0.06	
Onion	89	0	1	0	0	0	3						
Calculated composition 10% shrink													
Moisture							43.5	46.2	51.5	51.4	*62.7	56.9	56.9
Fat							*30.5	*31.9	27.7	27.8	22.5	26.3	26.3
Protein							19.3	17.8	16.9	15.7	11.7	13.7	13.7
Properties													
% Collagen (Max. 35)							14.5	18.7	20.0	21.5	23.4	23.3	23.3
Bind Points (Min. 1.8)							3.5	3.7	4.8	4.0	3.0	3.5	3.5
Color Points (Min. 2)							4.7	5.6	5.6	5.6	4.5	5.3	5.3

FRANKFURTER

FRANKI

Average Values

Section 3 of 25

Meat block	M o i s t u r e	F a t	P r o t e i n	% C o l l a g e n	B i n d	C o l o r	Pounds for Various Formulations							
							O	P	O	R	S	T	U	
Beef														
Bull F.C.	70	10	20	20	30	47	60	60	55	50	50	40	40	
Fat, brisket	5	93	1	25	0	0						35		
Trim 40	27	65	7	36	8	14							20	
Veal														
Lean	69	10	19	27	26	30						25		
Pork														
Cheek meat	67	15	17	72	9	29							15	
Trim 50	36	52	10	34	12	9			45					
Trim Reg	34	58	8	36	10	8	35			50	50		25	
Trim, 15 (fat)	11	85	3	60	3	1		20						
Dry Ingredients														
MSG	0	0	0	0	0	0				0.25	0.25			
Non-fat dry milk	3	1	38	0	25	0	5		3.5	3.5			3.5	
Salt	.01	0	0	0	40	0	3	2.75	2.5	2.75	2.75	2.75	2.75	
Soy protein concentrate	8	0	75	0	45	0		3.5			3.5			
Sugar (sucrose)	.06	0	0	0	10	0		0.5		0.5	0.5	0.4	0.5	
Moist Ingredients														
Water or ice	100	0	0	0	0	0	25	10	20	10	10	20	10	
Fruit & Vegetables														
Garlic, fresh	61	0	6	0	0	0						0.06		
Calculated composition 10% shrink														
Moisture							57.5	53.5	54.9	47.9	48.0	49.3	47.9	
Fat							22.9	24.7	25.5	*32.3	*32.3	*35.2	*32.2	
Protein							14.5	17.7	14.8	14.6	15.8	11.8	14.5	
Properties														
% Collagen (Max, 35)							20.4	28.0	22.2	22.4	20.7	27.1	30.6	
Bind Points (Min, 1.8)							3.8	4.9	3.7	3.5	4.4	3.3	3.1	
Color Points (Min, 2)							5.1	6.3	4.9	4.8	4.8	4.7	4.6	

Meat block
Beef
Bull F.C.
Cheek me:
Trim 40
Tripe, fres
Veal
Lean
Pork
Cheek me:
Jowl, skin
Trim Reg
Dry Ingredi
Dextrose
MSG
Non-fat di
Salt
Soy protei
Sugar (suc
Moist Ingre
Water or i
Fruit & Veg
Garlic, fr
Calculated co
Moisture
Fat
Protein
Properties
% Collage
Bind Poir
Color Poi

FRANKFURTER

Average Values

Section 4 of 25

U
40
20
15
25
3.5
2.75
0.5
47.9
*32.2
14.5
30.6
3.1
4.6

	M o i s t u r e	F a t	P r o t e i n	% C o l l a g e n	B i n d	C o l o r	Pounds for Various Formulations							
							V	W	X	Y	Z	AA	AB	
Meat block														
Beef														
Bull P.C.	70	10	20	20	30	47	40	40	40	30	30	30	20	
Check meat	70	20	18	59	14	48				30	30		20	
Trim 40	27	65	7	36	8	14	20							
Tripe, fresh	82	10	9	100	0	0								10
Veal														
Lean	69	10	19	27	26	30		20	20			20	20	
Pork														
Check meat	67	15	17	72	9	29	15			10	10	35		
Jowl, skinned	24	71	5	43	5	2				30	30			
Trim Reg	34	58	8	36	10	8	25	40	40					30
Dry Ingredients														
Dextrose	.06	0	0	0	10	0						1		
MSG	0	0	0	0	0	0				0.25				
Non-fat dry milk	3	1	38	0	25	0		7	5	3.5		5		
Salt	.01	0	0	0	40	0	2.75	2.5	3	2.75	2.75	3	3	
Soy protein concentrate	8	0	75	0	45	0	3.5			3.5				
Sugar (sucrose)	.06	0	0	0	10	0	0.5	0.5	0.5	0.5				0.4
Moist Ingredients														
Water or ice	100	0	0	0	0	0	10	20	25	10	10			25
Fruit & Vegetables														
Garlic, fresh	61	0	6	0	0	0					0.015			
Calculated composition 10% shrink														
Moisture							48.1	53.5	55.9	51.6	42.5	58.1	*62.6	
Fat							*32.1	25.0	24.3	*30.2	*30.3	13.6	22.8	
Protein							15.8	15.1	14.1	15.1	16.4	20.6	12.7	
Properties														
% Collagen (Max. 35)							28.1	21.4	22.3	*39.3	*36.3	*36.0	*38.9	
Bind Points (Min. 1.8)							3.9	3.7	3.5	3.0	3.8	4.5	2.5	
Color Points (Min. 2)							4.6	4.4	4.3	5.6	5.6	6.8	4.3	

FRANKFURTER

FRANKFU

Average Values

Section 5 of 25

	M o i s t u r e	F a t	P r o t e i n	% C o l l a g e n	B i n d	C o l o r	Pounds for Various Formulations									
							AC	AD	AE	AF	AG	AH	AI			
Meat block																
Beef																
Bull F.C.	70	10	20	20	30	47	20	20	18	17	15	15				
Check meat	70	20	18	59	14	48			17	17						30
Cow F.C.	68	14	18	21	24	39										30
Trim 90 (lean)	71	11	18	28	27	43					50					
Trim 60	45	43	12	40	16	25							50			
Tripe, cooked	80	2	19	100	0	0			13							
Veal																
Lean	69	10	19	27	26	30	45	45	17	17						
Pork																
Check meat	67	15	17	72	9	29								25	10	
Jowl, skinned	24	71	5	43	5	2										30
Trim 80 (lean)	60	23	16	25	16	25					10	10				
Trim 50	36	52	10	34	12	9				35						
Trim Reg	34	58	8	36	10	8	35	35	35		25					
Tripe	74	15	10	100	0	0				14						
Dry Ingredients																
Cereal flour	12	1	10	0	18	0			4.5	4.3						
Dextrose	.06	0	0	0	10	0	1									
Mustard, heat treated	6	25	31	0	16	5	1									
Non-fat dry milk	3	1	38	0	25	0	4.5	5			5	5	3.5			
Salt	.01	0	0	0	40	0	3	3	3	3	3	3	2.75			
Sugar (sucrose)	.06	0	0	0	10	0					0.5	0.5	0.5			
Moist Ingredients																
Water or ice	100	0	0	0	0	0	36	30	20	20	20	25	10			
Fruit & Vegetables																
Onion	89	0	1	0	0	0					0.2					
Calculated composition 10% shrink																
Moisture							60.0	59.0	57.8	57.8	58.7	56.2	51.1			
Fat							20.7	21.6	24.0	23.7	20.6	24.2	31.4			
Protein							13.3	13.9	13.6	13.1	15.1	13.9	14.6			
Properties																
% Collagen (Max. 35)							23.7	23.8	*44.1	*39.6	24.2	*38.6	*40.3			
Bind Points (Min. 1.8)							3.2	3.4	2.4	2.4	3.7	2.5	2.5			
Color Points (Min. 2)							3.6	3.8	3.8	3.8	5.0	3.8	5.0			

Meat block
Beef
Check meat
Chuck
Cow F.C.
Lip
Trim 90 (lean)
Trim 75
Trim 50
Tripe, fresh
Pork
Backfat
Check meat
Jowl, skinned
Tongue
Trim 50
Trim Reg
Other Meats or
or Undesignat
Rework
Dry Ingredients
Cereal flour
Corn syrup s
Dextrose
Non-fat dry r
Salt
Soy protein c
Sugar (sucros
Textured veg
Moist Ingredi
Water or ice
Fruit & Vegeta
Garlic, fresh
Calculated comp
Moisture
Fat
Protein
Properties
% Collagen
Bind Points
Color Points

FRANKFURTER

Average Values

Section 6 of 25

Meat block	M o i s t u r e	F a t	P r o t e i n	% C o l l a g e n	B i n d	C o l o r	Pounds for Various Formulations						
							AJ	AK	AL	AM	AN	AO	AP
Beef													
Cheek meat	70	20	18	59	14	48	30	20	10				
Chuck	66	16	18	30	24	38				60	36	10	
Cow F.C.	68	14	18	21	24	39	30					34	75
Lip	66	17	17	90	0	1		20					
Trim 90 (lean)	71	11	18	28	27	43			40				
Trim 75	58	25	16	38	22	34						6	
Trim 50	38	50	11	42	12	19						50	
Tripe, fresh	82	10	9	100	0	0		20					
Pork													
Backfat	5	93	1	95	0	0		20					25
Cheek meat	67	15	17	72	9	29	10						
Jowl, skinned	24	71	5	43	5	2	30						
Tongue	63	19	17	66	8	36			10				
Trim 50	36	52	10	34	12	9					64		
Trim Reg	34	58	8	36	10	8			40	40			
Other Meats or Mixtures or Undesignated													
Rework	56	30	12	31	8	20		20					
Dry Ingredients													
Cereal flour	12	1	10	0	18	0			2				
Corn syrup solids	3.5	0	0	0	5	0						2	
Dextrose	.06	0	0	0	10	0		1					
Non-fat dry milk	3	1	38	0	25	0				5	6		3.5
Salt	.01	0	0	0	40	0	2.75	2.5	3	3	3.5	3	3
Soy protein concentrate	8	0	75	0	45	0	3.5						
Sugar (sucrose)	.06	0	0	0	10	0	0.5		1				0.5
Textured veg. protein	8	1	50	0	35	0		20			9.5		
Moist Ingredients													
Water or ice	100	0	0	0	0	0	10	20	40	25	68	33	20
Fruit & Vegetables													
Garlic, fresh	61	0	6	0	0	0	0.015						
Calculated composition 10% shrink													
Moisture							51.3	48.8	*61.6	54.3	*57.7	*57.5	52.2
Fat							*31.4	26.5	24.0	27.4	23.3	*30.5	29.6
Protein							15.8	16.6	10.7	13.3	11.8	11.6	13.2
Properties													
% Collagen (Max. 35)							*37.3	*36.9	*38.0	27.6	20.7	31.2	20.4
Bind Points (Min. 1.8)							3.3	3.2	2.1	2.8	2.7	2.2	3.1
Color Points (Min. 2)							5.0	*1.7	3.7	3.6	*1.8	3.6	4.6

FRANKFURTER

Average Values

Section 7 of 25

	M o i s t u r e	F a t	P r o t e i n	% C o l l a g e n	B i n d	C o l o r	Pounds for Various Formulations						
							AQ	AR	AS	AT	AU	AV	AW
Meat block													
Beef													
Cow F.C.	68	14	18	21	24	39	70	70	70	70	60	60	60
Pork													
Backfat	5	93	1	95	0	0	30	20	20				
Cheek meat	67	15	17	72	9	29				20	20		
Jowl, skinned	24	71	5	43	5	2							40
Trim Reg	34	58	8	36	10	8		10	10	30			
Trim 15 (fat)	11	85	3	60	3	1					20	20	
Dry Ingredients													
Mustard, heat treated	6	25	31	0	16	5	1						1
Non-fat dry milk	3	1	38	0	25	0		3.5			3.5		
Plant protein hydrolysate	8	0	30	0	20	0						0.12	
Salt	.01	0	0	0	40	0	3	2.75	2.75	2.5	2.75	2.75	3
Soy protein concentrate	8	0	75	0	45	0			3.5			3.5	
Sugar (sucrose)	.06	0	0	0	10	0		0.5	0.5	0.5	0.5	0.5	
Moist Ingredients													
Corn syrup	20	0	0	0	5	0	2						2
Water or ice	100	0	0	0	0	0		10	10	20	10	10	
Fruit & Vegetables													
Garlic, fresh	61	0	6	0	0	0						0.015	
Calculated composition 10% shrink													
Moisture							40.8	48.0	48.2	59.2	52.2	52.3	42.2
Fat							*39.8	*32.6	*32.5	24.6	27.1	27.0	*38.8
Protein							13.8	14.2	15.4	13.6	15.4	16.6	13.7
Properties													
% Collagen (Max. 35)							22.3	20.9	19.3	23.3	31.4	29.1	23.9
Bind Points (Min. 1.8)							3.2	3.3	4.1	2.9	3.1	3.9	2.9
Color Points (Min. 2)							5.2	4.7	4.7	4.6	5.0	4.9	4.5

FRANKFU

Meat block
Beef
Cow F.C.
Trim 40
Pork
Cheek meat
Trim Reg
Dry Ingredients
MSG
Mustard, heat
Non-fat dry m
Salt
Soy protein co
Sugar (sucro
Moist Ingredient
Corn syrup
Water or ice
Calculated compo
Moisture
Fat
Protein
Properties
% Collagen C
Bind Points (
Color Points

FRANKFURTER

Average Values

Section 8 of 25

	M o i s t u r e	F a t	P r o t e i n	% C o l l a g e n	B i n d	C o l o r	Pounds for Various Formulations						
							AX	AY	AZ	BA	BB	BC	BD
Meat block													
Beef													
Cow F.C.	68	14	18	21	24	39	60	60	60	55	50	50	40
Trim 40	27	65	7	36	8	14							20
Pork													
Cheek meat	67	15	17	72	9	29							15
Trim Reg	34	58	8	36	10	8	40	40	40	45	50	50	25
Dry Ingredients													
MSG	0	0	0	0	0	0	0.25				0.25		
Mustard, heat treated	6	25	31	0	16	5				1			
Non-fat dry milk	3	1	38	0	25	0		3.5			3.5		3.5
Salt	.01	0	0	0	40	0	2.75	2.75	2.75	3	2.75	2.75	2.75
Soy protein concentrate	8	0	75	0	45	0	3.5					3.5	
Sugar (sucrose)	.06	0	0	0	10	0	0.5	0.5	0.5		0.5	0.5	0.5
Moist Ingredients													
Corn syrup	20	0	0	0	5	0				2			
Water or ice	100	0	0	0	0	0	10	10	28		10	10	10
Calculated composition 10% shrink													
Moisture							50.3	50.3	*58.6	44.6	46.9	47.2	47.9
Fat							30.0	*30.1	26.8	*35.7	*34.2	*34.3	*32.2
Protein							15.8	14.6	11.9	14.5	13.6	14.9	14.5
Properties													
% Collagen (Max. 35)							20.6	22.3	24.3	24.4	23.3	21.3	30.5
Bind Points (Min. 1.8)							3.9	3.1	2.5	2.9	2.7	3.6	3.1
Color Points (Min. 2)							4.2	4.3	3.8	4.4	3.6	3.6	4.6

FRANKFURTER

FRANKFURTER

Average Values

Section 9 of 25

	M o i s t u r e	F a t	P r o t e i n	% C o l l a g e n	B i n d	C o l o r	Pounds for Various Formulations							
							BE	BF	BG	BH	BI	BJ	BK	
Meat block														
Beef														
Cow F.C.	68	14	18	21	24	39	40	30	30	10				
Flank	43	42	13	24	12	20					30			
Heart	70	13	17	27	6	40						27	20	
Plate	41	40	18	42	16	25						35		
Trim 80	63	20	17	30	24	39					70			
Trim 75	58	25	16	38	22	34		15						45
Trim 40	27	65	7	36	8	14	20							
Veal														
Lean	69	10	19	27	26	30			20	20				
Pork														
Backfat	5	93	1	95	0	0							10	
Check meat	67	15	17	72	9	29	15	12						
Defatted solids	10	3	86	95	0	0		15						
Stomach	71	13	15	62	1	0							28	
Trim 80 (lean)	60	23	16	25	16	25				30				
Trim 50	36	52	10	34	12	9			50	40				
Trim Reg	34	58	8	36	10	8	25	28						35
Dry Ingredients														3
Cereal flour														
Dextrose	.06	0	0	0	10	0			1				2	
Non-fat dry milk	3	1	38	0	25	0		3.5	3	3.5				
Salt	.01	0	0	0	40	0	2.75	3	3	2.5	2.6	2.5	3	
Soy protein concentrate	8	0	75	0	45	0	3.5					4		
Sugar (sucrose)	.06	0	0	0	10	0	0.5			0.5	1			0.5
Moist Ingredients														
Corn syrup	20	0	0	0	5	0			2.5		2	2		
Water or ice	100	0	0	0	0	0	10	30	25	20	25	30	30	
Calculated composition 10% shrink														
Moisture							47.4	52.6	54.5	53.1	59.0	55.6	*55.9	
Fat							*33.6	21.6	27.2	27.3	22.6	24.1	27.8	
Protein							15.0	21.4	12.0	13.8	13.4	14.4	11.2	
Properties														
% Collagen (Max. 35)							29.0	*63.1	27.2	25.2	28.6	*36.2	34.0	
Bind Points (Min. 1.8)							3.3	2.1	2.4	2.6	2.8	2.1	1.8	
Color Points (Min. 2)							3.7	3.0	3.1	3.0	4.6	2.7	3.3	

Meat block
Beef
Heart
Lip
Plate
Tongue
Trim 90 (lean)
Trim 75
Tripe, fresh
Veal
Lean
Pork
Backfat
Heart
Jowl, skinned
Snout
Stomach
Trim 50
Trim Reg
Dry Ingredients
Dextrose
Non-fat dry m
Salt
Soy protein cc
Sugar (sucros
Moist ingredi
Corn syrup
Water or ice
Fruits & Veget
Garlic, fresh
Calculated comp
Moisture
Fat
Protein
Properties
% Collagen (
Bind Points (
Color Points

FRANKFURTER

Average Values

Section 10 of 25

BK
20
45
35
3
0.5
30
*55.9
27.8
11.2
34.0
1.8
3.3

	Average Values						Pounds for Various Formulations						
	Moisture	Fat	Protein	% Collagen	Bind	Color	BL	BM	BN	BO	BP	BO	BR
Meat block													
Beef													
Heart	70	13	17	27	6	40	20	6					
Lip	66	17	17	90	0	1			5	5			
Plate	41	40	18	42	16	25		24			35		
Tongue	66	16	18	60	7	61		28					
Trim 90 (lean)	71	11	18	28	27	43			35	30		65	60
Trim 75	58	25	16	38	22	34	45						
Tripe, fresh	82	10	9	100	0	0			5	10			
Veal													
Lean	69	10	19	27	26	30			10	10			
Pork													
Backfat	5	93	1	95	0	0					10		
Heart	73	10	15	27	6	32			13	10	27		
Jowl, skinned	24	71	5	43	5	2		14					
Snout	45	40	14	80	2	1			5	5			
Stomach	71	13	15	62	1	0					28		
Trim 50	36	52	10	34	12	9							20
Trim Reg	34	58	8	36	10	8	35		22	25		35	20
Dry Ingredients													
Dextrose	.06	0	0	0	10	0		3			2		
Non-fat dry milk	3	1	38	0	25	0	3.5		5	5			5
Salt	.01	0	0	0	40	0	3	3.4	3	3	2.5	2.5	3
Soy protein concentrate	8	0	75	0	45	0		5			4		
Sugar (sucrose)	.06	0	0	0	10	0	0.5		0.5	0.5			
Moist Ingredients													
Com syrup	20	0	0	0	5	0		3			2		
Water or ice	100	0	0	0	0	0	30	38	35	30	30	25	25
Fruits & Vegetables													
Garlic, fresh	61	0	6	0	0	0							0.015
Calculated composition 10% shrink													
Moisture							55.5	58.0	*63.9	*62.0	56.2	*61.3	57.2
Fat							27.7	20.3	17.9	19.7	23.4	23.9	23.9
Protein							11.9	14.5	12.7	12.6	14.0	12.6	13.6
Properties													
% Collagen (Max. 35)							31.6	34.3	32.9	*35.5	*36.4	29.6	26.3
Bind Points (Min. 1.8)							2.1	3.1	2.4	2.3	2.1	3.0	3.2
Color Points (Min. 2)							3.3	4.9	3.3	3.0	2.3	4.6	4.1

FRANKFURTER

FRANKFU

Average Values

Section 11 of 25

	M o i s t r e	F a t	P r o t e i n	% C o l l a g e n	B i n d	C o l o r	Pounds for Various Formulations							
							BS	BT	BU	BV	BW	BX	BY	
Meat block														
Beef														
Trim 90 (lean)	71	11	18	28	27	43	60	55	50	40	20		65	60
Trim 85	66	15	18	28	26	41								
Tripe, fresh	82	10	9	100	0	0			20					
Veal														
Lean	69	10	19	27	26	30				10				
Pork														
Backfat	5	93	1	95	0	0					27			
Heart	73	10	15	27	6	32				8				
Jowl, skinned	24	71	5	43	5	2		45						
Skin	40	32	28	99	6	1					20			
Trim 80 (lean)	60	23	16	25	16	25					33			
Trim 50	36	52	10	34	12	9						35		
Trim Reg	34	58	8	36	10	8	40		30	30				40
Tripe	74	15	10	100	0	0				12				
Dry Ingredients														
Cereal flour	12	1	10	0	18	0				3.5				
Corn syrup solids	3.5	0	0	0	5	0								2.25
Dextrose	.06	0	0	0	10	0				1				1
Hydrolyzed Veg.														
Protein (HVP)	10	0	31	0	20	0							0.25	0.5
Non-fat dry milk	3	1	38	0	25	0							3.5	4
Salt	.01	0	0	0	40	0	3	2.5	3	3	2.5	2.6	4	4
Soy protein concentrate	8	0	75	0	45	0		4						2
Sugar (sucrose)	.06	0	0	0	10	0	0.5	2	0.5				1	
Moist Ingredients														
Corn syrup	20	0	0	0	5	0		2						
Water or ice	100	0	0	0	0	0	25	35	25	40	33	20	25	
Calculated composition 10% shrink														
Moisture							*59.1	54.2	*64.2	*64.7	51.5	54.9	51.8	
Fat							25.8	29.0	21.5	19.2	*33.9	24.4	25.8	
Protein							12.1	11.6	11.4	10.7	12.1	14.5	13.8	
Properties														
% Collagen (Max. 35)							29.8	24.6	*39.3	34.6	*55.1	26.9	24.3	
Bind Points (Min. 1.8)							2.8	3.2	2.3	2.1	1.8	3.3	3.1	
Color Points (Min. 2)							4.2	3.3	3.5	3.2	2.4	4.5	3.8	

- Meat block
- Beef
- Trim 80
- Trim 75
- Veal
- Lean
- Pork
- Backfat
- Trim 80 (lean)
- Trim 50
- Trim Reg
- Dry Ingredients
- Cereal flour
- Dextrose
- Non-fat dry m
- Salt
- Sugar (sucros
- Moist Ingredi
- Corn syrup
- Water or ice
- Fruit & Vegetal
- Garlic, fresh
- Onion
- Calculated comp
- Moisture
- Fat
- Protein
- Properties
- % Collagen (
- Bind Points (
- Color Points

FRANKFURTER

Average Values

Section 12 of 25

	M o i s t u r e	F a t	P r o t e i n	% C o l l a g e n	B i n d	C o l o r	Pounds for Various Formulations							
							BZ	CA	CB	CC	CD	CE	CF	
Meat block														
Beef														
Trim 80	63	20	17	30	24	39	40	40						
Trim 75	58	25	16	38	22	34			80	70	70	70	60	
Veal														
Lean	69	10	19	27	26	30	40	40						
Pork														
Backfat	5	93	1	95	0	0	20	20						
Trim 80 (lean)	60	23	16	25	16	25								20
Trim 50	36	52	10	34	12	9				30	30	30		
Trim Reg	34	58	8	36	10	8			20					20
Dry Ingredients														
Cereal flour	12	1	10	0	18	0	3.5							3.5
Dextrose	.06	0	0	0	10	0				2				
Non-fat dry milk	3	1	38	0	25	0		3.5		3.5	3.5	3.5		
Salt	.01	0	0	0	40	0	3	3	3	2.6	2.6	2.6	3	
Sugar (sucrose)	.06	0	0	0	10	0	0.5	0.5	0.5		1			0.4
Moist Ingredients														
Corn syrup	20	0	0	0	5	0					2	2		
Water or ice	100	0	0	0	0	0	25	25	10	25	25	25	10	
Fruit & Vegetables														
Garlic, fresh	61	0	6	0	0	0			0.06					0.06
Onion	89	0	1	0	0	0								0.5
Calculated composition 10% shrink														
Moisture							55.6	55.3	50.8	52.8	52.6	53.1	49.9	
Fat							25.8	25.8	*30.9	27.7	27.5	27.7	29.5	
Protein							12.6	13.4	14.1	13.0	12.9	13.0	14.0	
Properties														
% Collagen (Max. 35)							28.6	26.9	*37.7	33.9	33.9	33.9	33.9	
Bind Points (Min. 1.8)							3.1	3.3	2.9	2.6	2.6	2.6	2.7	
Color Points (Min. 2)							4.2	4.2	4.4	3.4	3.4	3.4	4.0	

BY
60
40
0.5
4
4
2
25
51.8
25.8
13.8
24.3
3.4
3.8

FRANKFURTER

FRANKFURTER

Average Values

Section 13 of 25

	M o i s t u r e	F a t	P r o t e i n	% C o l l a g e n	B i n d	C o l o r	Pounds for Various Formulations						
							CG	CH	CI	CJ	CK	CL	CM
Meat block													
Beef													
Trim 75	58	25	16	38	22	34	60	60	43				
Trim 70	55	30	15	39	20	31				32			
Veal													
Lean	69	10	19	27	26	30				40	50	50	40
Pork													
Check meat	67	15	17	72	9	29							15
Liver	73	7	19	24	2	49				3			
Shoulder	58	27	14	25	18	15				25			
Trim 80 (lean)	60	23	16	25	16	25	20	20					
Trim 50	36	52	10	34	12	9			57				
Trim Reg	34	58	8	36	10	8	20	20			50	50	45
Dry Ingredients													
Cereal flour	12	1	10	0	18	0					3		
Corn syrup solids	3.5	0	0	0	5	0			2				0.9
Dextrose	.06	0	0	0	10	0			1				
Non-fat dry milk	3	1	38	0	25	0	3.5		3	3.5		3	5
Salt	.01	0	0	0	40	0	3	3	3.75	3	2.5	2.5	2.5
Soy flour	8	1	47	0	30	0				3.5			
Sugar (sucrose)	.06	0	0	0	10	0	0.5	0.4		0.5	0.5	0.5	
Moist Ingredients													
Water or ice	100	0	0	0	0	0	10	10	29	20	30	30	25
Fruit & Vegetables													
Onion	89	0	1	0	0	0		0.5					
Calculated composition 10% shrink													
Moisture							49.4	51.4	48.6	58.9	*55.8	55.5	53.9
Fat							29.7	*30.4	*32.4	17.6	27.8	27.8	27.0
Protein							14.9	14.1	11.0	16.6	11.3	12.0	13.0
Properties													
% Collagen (Max. 35)							32.0	34.8	33.1	25.4	29.0	27.3	33.2
Bind Points (Min. 1.8)							3.0	2.7	2.0	3.8	2.4	2.6	2.5
Color Points (Min. 2)							4.0	4.1	2.3	3.9	2.6	2.6	2.8

Meat block
Veal
Lean
Pork
Backfat
Liver
Trim 80 (lean)
Trim 50
Trim Reg
Poultry
Chicken
Fat
Meat
Skin, cooked
Other Meats or
Cooking brot
Dry Ingredients
Cereal flour
Dextrose
Non-fat dry n
Salt
Semolina flo
Sugar (sucros
Moist ingredier
Water or ice
Calculated comp
Moisture
Fat
Protein
Properties
% Collagen (
Bind Points (
Color Points (

FRANKFURTER

Average Values

Section 14 of 25

	M o i s t u r e	F a t	P r o t e i n	% C o l l a g e n	B i n d	C o l o r	Pounds for Various Formulations						
							CN	CO	CP	CO	CR	CS	CT
Meat block													
Veal													
Lean	69	10	19	27	26	30	40	13					
Pork													
Backfat	5	93	1	95	0	0		37					
Liver	73	7	19	24	2	49	3						
Trim 80 (lean)	60	23	16	25	16	25	25	50	75	60	60	60	
Trim 50	36	52	10	34	12	9			25	40			
Trim Reg	34	58	8	36	10	8	32				40	40	
Poultry													
Chicken													
Fat	5	95	1	95	0	0							26
Meat	57	25	17	18	23	19							63
Skin, cooked	22	15	60	99	6	0							11
Other Meats or Mixtures													
Cooking broth	99	0	1	0	0	5							11
Dry Ingredients													
Cereal flour	12	1	10	0	18	0		6			3		
Dextrose	.06	0	0	0	10	0		0.6					3
Non-fat dry milk	3	1	38	0	25	0	5		3.5	3.5		3	
Salt	.01	0	0	0	40	0	3	2.5	2.5	2.5	2.5	2.5	2.5
Semolina flour	12	1	10	0	18	0							11
Sugar (sucrose)	.06	0	0	0	10	0	0.5				0.5	0.5	
Moist Ingredients													
Water or ice	100	0	0	0	0	0	25	18	25	20	20	20	12
Calculated composition 10% shrink													
Moisture							56.2	40.9	56.0	51.1	50.6	50.3	39.7
Fat							23.8	*41.3	25.7	*30.5	*32.7	*32.7	*33.6
Protein							13.8	10.0	13.4	13.2	11.6	12.3	15.0
Properties													
% Collagen (Max. 35)							24.7	26.4	24.4	25.1	27.0	25.5	*46.4
Bind Points (Min. 1.8)							2.8	1.8	2.2	2.1	*1.7	1.9	2.4
Color Points (Min. 2)							3.1	2.4	2.7	2.4	2.3	2.3	*1.6

FRANKFURTER

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Average Values

Section 15 of 25

	M o i s t u r e	F a t	P r o t e i n	Oz. unless indicated otherwise per 100 lbs. of meat							
				1	2	3	4	5	6	7	8
				Curing Ingredients							
Na or K Nitrite	0.1	0	0	0.25	0.25	0.25	0.25	0.25	0.25	0.25	0.25
Na or K Nitrate	0.1	0	0	3	2	2	2	2	2	2	2
Spices											
Cardamon	8	3.5	9		1						
Cinnamon	10	3	4			1					
Coriander	5	18	15		1	2	2	2	2	2	2
Garlic, Powder	6	1	17			1					
Ginger	9	4	8.5				1	1			
Mace	8	30	7	1.5	1	2	1		2	1	
Nutmeg	8	33	7								2
Pepper, white	11	8.5	1.3	3.7	7	6	6	6	4	6	6
Sage	3	14	8.5			1					

Curing Ingre
Na or K Ni
Na or K Ni
Na Ervthor
GDL
Spices
Allspice
Cardamon
Coriander
Mace
Mustard se
Nutmeg
Onion pow
Paprika
Pepper, bla
Pepper, wt

FRANKFURTER

Average Values

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8
0.25
2
2
2
6

	M o i s t u r e	F a t	P r o t e i n	Oz. unless indicated otherwise per 100 lbs. of meat								
				9	10	11	12	13	14	15	16	
Curing Ingredients												
Na or K Nitrite	0.1	0	0	0.25	0.25	0.25	0.25	0.25	0.25	0.25	0.25	0.25
Na or K Nitrate	0.1	0	0	2	2	2	2	2	2	2	2	1
Na Erythorbate	0.1	0	0									0.87
GDL	0	0	0									8
Spices												
Allspice	8.5	8.7	6									1
Cardamon	8	3.5	9									1
Coriander	5	18	15	2	1							1
Mace	8	30	7			2	2	2				
Mustard seed, ground	6	24	30		3	4	3					
Nutmeg	8	33	7	1	2				2			2
Onion powder	5	1	10			1	1					
Paprika	10	13	15			2			1	1		
Pepper, black	11	8.5	12				7					2
Pepper, white	11	8.5	1.3	6	6	7			6	6		