

Food Safety and Product Data Harmonization



David Alexander





Agenda

- Krusteaz overview
- Food Safety Data / Process
- Allergen Example
- Questions

OUR HERITAGE

A long line of Makers

It all began in 1932 in Seattle, when Rose Charters tackled the challenge of making the perfect, easy-to-prepare pie crust. Cleverly combining “crust” plus “ease,” she named her product Krusteaz and began selling to local restaurants and businesses. Her ingenuity and entrepreneurial spirit set the standard for how Krusteaz would grow and innovate for years to come.

The Heily family joined the business in the 1940’s and expanded the Krusteaz portfolio with delicious innovations such as donuts, pancakes and biscuits. Each new mix was made with the same commitment to delicious taste and quality that defined Krusteaz from the start.

Since the 1940’s, three generations of the Heily family scaled the business with ingenuity and integrity. We’ve built world class manufacturing facilities, expanded distribution nationally and expanded our product portfolio across baking and breakfast occasions, delighting Makers everywhere.

For 80 years, our ability to grow and thrive have been rooted in our fierce commitment to our customers and employees, to never compromise on quality or taste, and to maintain the persistence and passion that have defined Krusteaz since the start. We embody the Makers mindset in everything we do, bringing a spirit ingenuity and entrepreneurship to our day-to-day work. We are for Makers, by Makers.

Big-Batch Business

THE pinch-of-this-and-a-pinch-of-that recipes handed down by Grandma have resulted in some pretty good eating. But they hardly would do for a company that turns out mixes used by the modern housewife.

In two ways the approaches to cooking are vastly different—in precision and quantity.

This is evident in the operation of Continental Mills, Inc., which moved recently into new quarters at 1915 Gorgias Drive S. The firm turns out piecrust, doughnut, pancake and biscuit mixes for the retail market as well as many mixes for institutional use.

Instead of using the “pinch” system, the plant employs precise measuring devices for every batch. And the batches, instead of serving four, six or eight, probably would serve thousands, since they usually total 4,000 pounds.

Continental Mills hasn’t always worked in such large batches. It began 30 years ago on a scale closer to the housewife’s.

James Charters, now vice president, and a partner began packaging and selling a piecrust mix that Mrs. Charters had developed for use in a restaurant. The Charters were operating. The quarters of the new firm were a small room overlooking the waterfront. Equipment was an old mixing machine, several wooden benches and a second-hand chair and desk. Women, who came in for an hour or two a day to fill packages by hand, were paid in shares.

The company struggled along through the Second World War until John Heily became president and put new capital into the operation. From then on things picked up. From 1947 to last year the production volume of Continental Mills multiplied 30 times.

Times Photos by Roy Scully



MAKERS WANTED

We are Makers.

Being a Maker is a mindset.

An attitude. A shared belief.

Makers say “I get to!” instead of “I have to.”

Rooted in a spirit of savvy ingenuity

and fierce commitment to better,

we bring our own kind of special, every day.

We. Make. It. Happen.

OUR PURPOSE

*To inspire joyful
connection through
making, baking
and sharing.*



OUR VISION

*To build the most
beloved and
wow-inspiring
brands in the
industry.*



Our products...

KRUSTEAZ



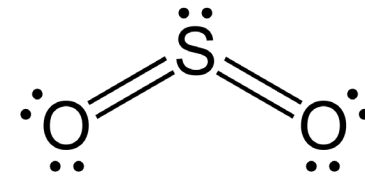
WildRoots
real food for real people™



KRETSCHMER

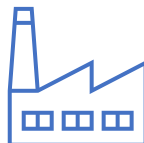


The KRUSTEAZ Company



Agenda

- Krusteaz overview
- Food Safety Data / Process
- Allergen Example
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Devex Objects

Customer				
Finished Good	Preliminary FG Material	Finished Good Material	Code Date Instruction Spec (CD)	
	Preliminary FG Plant Material	Finished Good Plant Material	FG Manufacturing Spec (MA)	Cost Request Spec
Formula	Experiment Material (EXP)	R&D Formula Material	Sample Material (SMP)	Application Formula Material
	Bench Trial Material (EXP)	R&D Plant Trial Formula Material (T)	R&D Plant Formula Material	Claim
	Formula Spec (FO)		Formula Manufacturing Spec (MA)	Restriction
	Label Spec (LB)			Regulatory Guideline
Packaging	Material (PKG)	Packaging Trial SKU Material (PTP)		
	Die Line Spec (DIE)	Packaging SKU Material		
Ingredient	Experimental Ingredient Material (EXI)	Ingredient Material (ING)	Regulatory Substance (SB)	
	Ingredient Trial SKU Material (PTI)	Ingredient SKU Material	Allergen Source	
	Ingredient Vendor Questionnaire Spec	Ingredient Spec (EXI/ING)	Prep Ingredient	
Vendor	Purchase Vendor (PV)	Branch Plant	Warehouse	
	Plant of Manufacture (PM)	Co-Man		

Other Specifications	Drawing
	Standard Operating Procedure

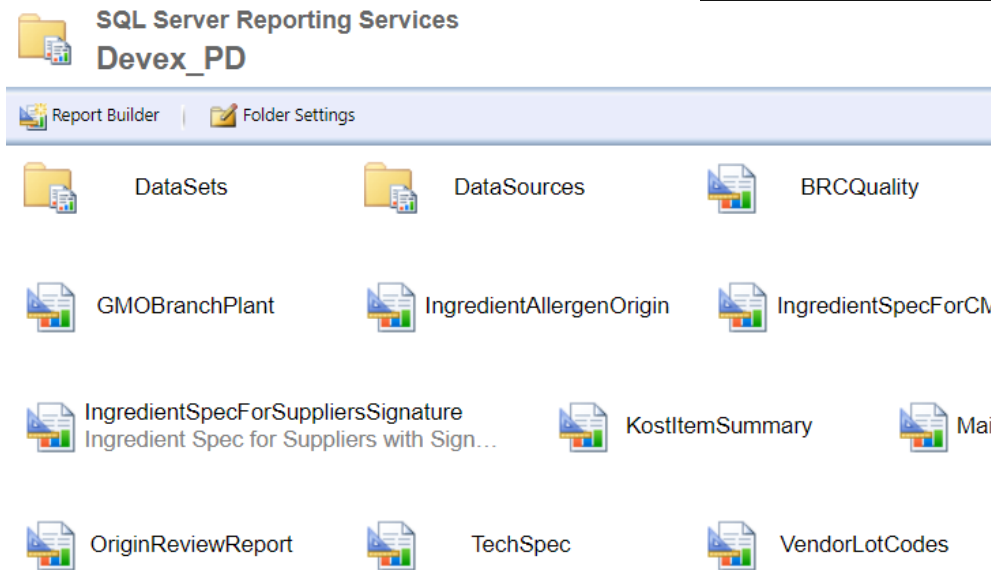
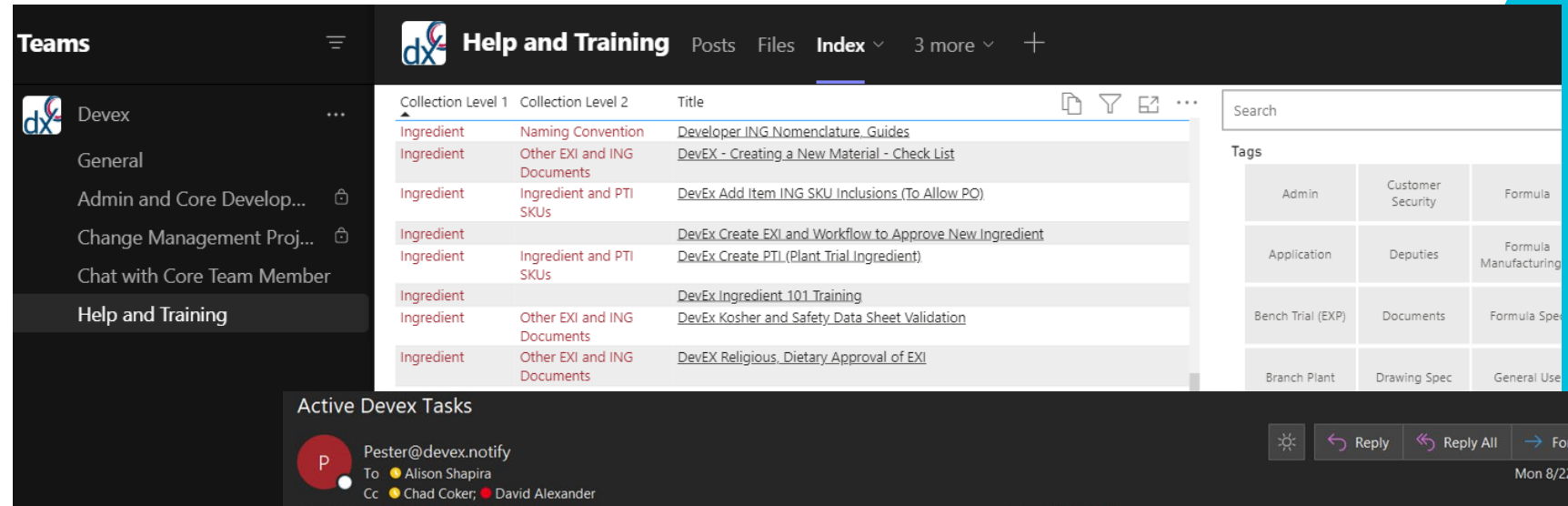
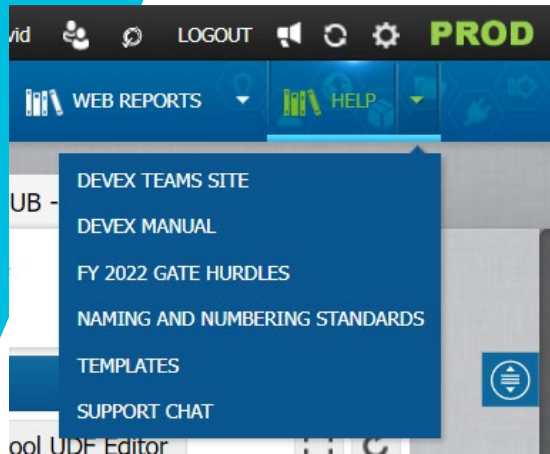
Ideas

PDP Projects	Type 1 - Major Development/Change
	Type 2 - Minor Development/Change
	Type 3 - Simple Development/Change

Other Creation Projects	Create Packaging Material	Cost Request
	Create Experimental Packaging SKU	Create Finished Good Material
	Create Packaging SKU	Create Finished Good Plant Material
	Create Ingredient	Create Plant of Manufacture
	Create Experiment Ingredient SKU	Create Purchase Vendor
	Create Ingredient SKU	Plant Trial

Change Projects	Many project types are used to add plants, reactivate, obsolete, create new versions, or otherwise modify materials and vendors
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Devex Objects



Active Devex Tasks

From: Pester@devex.notify
To: Allison Shapira
Cc: Chad Coker; David Alexander
Retention Policy: 1 Week Delete (1 week)
Expires: 8/29/2022

My Active and Overdue Tasks:

Report Group	Task Name	Project	Project Manager	Object	User Name	Date Active	Due Date	Presentation Ready Date	First Ship Date
Overdue	Complete FG SKU Plant 1st Run Validation for R&D		Molly Norman	727-7235-871-001 - 727-7235-871-001 2022.02.13	Alison Shapira	6/8/2022	6/15/2022	9/1/2022	5/15/2023
Active	Add formula and quantity to FG Plant BOM		Molly Norman	220000023.SKU005.871 - BEN	Alison Shapira	9/24/2021		9/1/2022	5/15/2023
Active	[1,2] R&D completes R&D inputs, approves food (Bench) & completes Risk Summary		Mark Brown		Alison Shapira	4/28/2022		9/11/2022	
Active	Add R&D data to the Preliminary FG SKU	230000047 - Frozen RL Biscuit (Club)	Mark Brown		Alison Shapira	5/2/2022		9/11/2022	4/2/2023
Active	Add R&D data to the Preliminary FG SKU		Mark Brown	230000047.SKU004 - PLT-RL CHDBY FZN BISC	Alison Shapira	8/18/2022		9/15/2022	3/1/2023
Active	EXI Spec: Enter Regulatory/Analytical Requirements Data	15020001790 - new ingredient milk whole 26% dry		EXI11689 - Milk Whole Fat 26% Dry	Alison Shapira	8/19/2022			

My Active Project Teams:

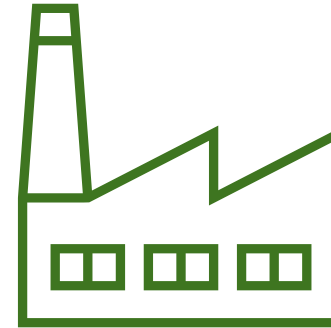
Project	Status	Project Manager	Team Member
240000018 - Non PDP Add Plt WM GV AP BAKE KNT	Stage 1	Emily Thompson	Alison Shapira
240000019 - Non PDP Add Plt KR Meyer Lemon PdCke KNT	Stage 1	Emily Thompson	Alison Shapira
240000046 - Red Lobster Brand Packaging Update	Stage 1	Julie Fluke	Alison Shapira
9194 - Optimization / Agglomerated Items Chai and Cocoa	Stage 1	Maki Herr	Alison Shapira
230000047 - Frozen RL Biscuit (Club)	Stage 1	Mark Brown	Alison Shapira
230000069 - Red Lobster Frozen LX Honey Butter	Stage 1	Mark Brown	Alison Shapira
220000023 - AP Oatmilk Hot Cocoa Mix	Stage 3	Molly Norman	Alison Shapira

13 Records.

Food Safety

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	Ingredient Vendor Questionnaire Spec	Ingredient Spec (EX/ING)	Prep Ingredient	
Vendor	Purchase Vendor (PV)	Branch Plant	Warehouse	
	Plant of Manufacture (PM)	Co-Man		

Plant of Manufacture



- Product Type
- Food Contact
- Lot Code Interpretation
- Allergen Concerns
- Contacts
- Partners in Quality (PIQ)
- Audit Results
- Qualification Notes / Status

Food Safety

Plant of Manufacture



- Product Type
- Food Contact
- Lot Code Interpretation
- Allergen Concerns
- Contacts
- Partners in Quality (PIQ)
- Audit Results
- Qualification Notes / Status

Ingredient



- HACCP
- Authenticity
- GM
- Organic
- Gluten Free
- Nutritional Claims
- Allergens Contained
- Allergen for PAL
- Nutritional
- Substances
- Testing Requirements

Formula



- HACCP
- Product Type
- Intended Use
- Authenticity
- GM
- Organic
- Gluten Free
- Nutritional Claims
- Allergens Contained
- Allergen for PAL
- Nutritional
- Regulatory Label Spec
- Approved Plants
- Approved Countries
- Testing Requirements

Packaging SKU



- Versioning level for label art
- Preprinted or Plant Printed

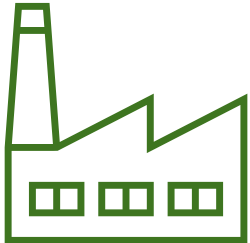
Packaged Product



- Allergens Contained
- Allergen for PAL
- Nutritional

Allergen Example

Plant of Manufacture



EFF - EFFINGHAM PLANT

Branch Plant: 035

Audit Delete Security Report

TAGS:

General

Edit

Vendor Name: EFF - EFFINGHAM PLANT

Vendor Status: Ownership type:

Allergen Concerns: EFF Central has gluten free dry mix production. Special care required for review of ingredients to be used for products in this area.

Additive Concerns:

Vendor Web Page:

Maximum Shipments Per Day: Temperature Capabilities: Frozen storage available at East but not Central

Special Requirements:

NDA in Place: N/A NDA Comments:

Notes: EFF East and EFF central are separate buildings but managed as one branch plant for system purposes. Unique requirements for each including allergen put away handled by Eagle.

RESOURCE (LINE)

Branch	Resource (Line)
EFF - Effingham Plant	
EFF - Effingham Plant	
EFF - Effingham Plant	

Allergens

- Allergens
- Milk
- Eggs
- Soy
- Without

Allergen Example

☆ FLOUR ALMOND BLANCHED (VALID) | Specification ING10902 v. 0 of Type Ingredient Specification (0)

⚡ Actions ▾ ▶ Approval ▾ 🔒 Security 📄 Report

TAGS: ✎

Regulatory

▼ Allergens and Sensitivities - Includes

JDE Managed ▾	Allergen and Sensitivity Material	Status	Quantity	Determination Method	Last Update Date	Notes
Yes	Wheat	No		Analyzed	10/1/2014	
Yes	Soy	No		Analyzed	10/1/2014	
Yes	Eggs	No		Analyzed	10/1/2014	
Yes	Milk	No		Analyzed	10/1/2014	
Yes	Almond	Yes		Analyzed	10/1/2014	

📄 Analytical Requirements ▾

📄 Shipping & Storage ▾

📄 Receiving Requirements ▾

📄 Quality Requirements ▴

Allergens and Sensitivities -
Made on Equipment Required

▼ Allergens and Sensitivities - Made on Equipment

Allergen and Sensitivity	Line	Plant	Provided by Vendor
Buckwheat	Yes	Yes	Yes
Soy	Yes	Yes	Yes

Total Allergens - Made on
Equipment

Ingredient



Allergen Example

Details on SFV

Formula: EXP005050003__1 Recipe

Views Regulatory MFV

Recipe editing mode No Target

	Line No.	Code	Description	UOM	Quantity	Quantity %	QS	Batch Quantity	Allergens and Sensitivities	Kosh Typ
1	1	301-1400	FLOUR #lb	✓	50.0000	50.000	<input type="checkbox"/>		Wheat	Pareve
2	2	411-0500	ALMOND lb	✓	17.0000	17.000	<input type="checkbox"/>		Almond	Pareve
3	3	304-0305	DEXTRC lb	✓	15.0000	15.000	<input type="checkbox"/>		Sulfites	Pareve
4	4	303-1000	SUGAR lb	✓	9.0010	9.001	<input type="checkbox"/>		Sulfites	Pareve
5	5	401-4505	SODA #lb	✓	5.0000	5.000	<input type="checkbox"/>			Pareve
6	5	404-0021	SALT TC lb	✓	4.0000	4.000	<input type="checkbox"/>			Pareve
7	12.34 oz, 1 cup water, 3 egg, 1/4 oil									

Summary on Formula Material

Quality

Edit

Total Allergens and Sensitivities: Wheat; Sulfites; Almond

Total Allergens and Sensitivities: Buckwheat; Soy

- Made on Equipment

Formula



Attempted formula activation

Attempted addition of ING SKU to plant



Branch Plant:
Component 411-0500-ALMOND UNBL MEAL does not exist in Branch Plant 035-EFF - EFFINGHAM PLANT

Ok

PROJECT: 15250000900 (ADD ALMOND FLOUR TO EFF)

Task: ING SKU: enter initial data; Assignee: Alexander, David



Validation failed. Please look at the Validation section for details.

GENERAL

VALIDATION

The Branch Plant 035 - EFF - EFFINGHAM PLANT

does not allow Almond

Allergen Example

4 OF 4 INGREDIENT STATEMENT

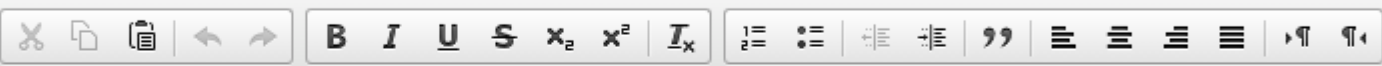
Ingredient Statement

Label Specification




INGREDIENTS: enriched bleached flour (wheat flour, niacin, reduced iron, thiamin mononitrate, riboflavin, folic acid), ground almonds, dextrose, sugar, baking soda, salt.

Additional Ingredient Statement

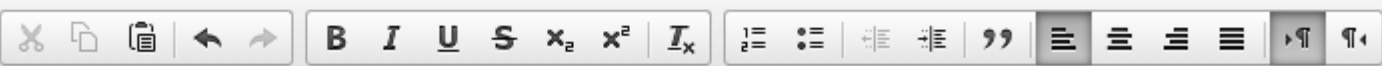


Allergen Statement



CONTAINS: Wheat, Almonds.

May Contain Statement



MAY CONTAIN: Eggs, Soy.

Formula



Allergen Example

Formula



Devex

Quality

Edit

Total Allergens and Sensitivities Wheat; Sulfites; Almond

Total Allergens and Sensitivities
- Made on Equipment Buckwheat; Soy

Nightly roll-up process ensures allergen sets correctly update at all levels of nested BOMs.

ORACLE JD Edwards EnterpriseOne

Home Navigator Open Applications Recent Reports Favorites

CM - Inventory

Supplemental Data - Inventory Items - General Description Entry

Supplemental Database Code I Type Data IA Allergens

Item Number 1-1108

UDC Table Allergens Code Size 1

Records 1 - 4

	Allergen	Description	Effective Date	User Defined Amount
<input type="checkbox"/>	D	Milk		
<input type="checkbox"/>	S	Soy		
<input type="checkbox"/>	W	Wheat		

CM Warehouse Management System - KENT DRY MIX PLANT

File Receiving Production Picking Supervisory Formulas

Formula Detail 1-1108:M - Read-Only

File Draft Azo BOM

Formula 1-1108 % / F %

Bill Type M Max Batch Qty 5400

As of 08/24/2022 Size 100

24 rows filtered Working Qty 100.0000

ReScale

Record Count: 13

Line	Sku	Effective From	Effective Thru	Allergens
1.41	301-1200	9/29/2017	12/31/2050	W
3.30	302-5285	11/13/2016	12/31/2050	S
4.40	303-1000	11/13/2016	12/31/2050	

Allergen Example



Devex Custom Search

MATERIAL SEARCH

Summary: S.578 — 117th Congress (2021-2022)

[All Information](#) (Except Text)

Listen to this page

There are 4 summaries for S.578.

Public Law (04/23/2021)

[Bill summaries](#) are authored by [CRS](#).

Shown Here:

Public Law No: 117-11 (04/23/2021)

Food Allergy Safety, Treatment, Education, and Research Act of 2021 or the FASTER Act of 2021

This bill expands the definition of *major food allergen* for purposes of certain food-labeling requirements to specifically include sesame. In addition, the Department of Health and Human Services must report on certain information related to food allergy research and data collection activities.

CONGRESS.GOV

Back to top



Results

Actions Refine Export Filter Total rows: 6

<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	Name	Mat Code	Total Allergens and Sensitivities	Total Allergens and Sensitivities - Made on Equipment	Inventory Class	Plant(s) of Manufacture	Actions
<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	PANCAKE	1-2023:04	Wheat; Soy; Milk; Sulfites; Sesame	None	Breakfast	HOP - HOPKINSVILLE PLANT	Open Edit
<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	PANCAKE	1-00006:0	Wheat; Soy; Milk; Sulfites; Sesame	Barley	Breakfast	KNT - KENT MIX PLANT HOP - HOPKINSVILLE PLANT	Open Edit
<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	PANCAKE	1-00006:0	Wheat; Soy; Milk; Sulfites; Sesame	None	Breakfast	KNT - KENT MIX PLANT HOP - HOPKINSVILLE PLANT	Open Edit
<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	SM BUFFA	8-00063:0	Wheat; Milk; Almond; Barley; Sesame	Wheat; Soy; Peanuts; Tree nuts; Sulfites; Mustard	Snack	MNL - MANHATTAN LEVEE PLANT	Open Edit
<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	TM HONEY	8-00028:0	Wheat; Soy; Almond; Barley; Mustard; Sesame	Peanuts; Milk; Tree nuts; Wheat; Sesame; Mustard	Snack	MNL - MANHATTAN LEVEE PLANT	Open Edit
<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	TM SESAM	8-00065:0	Soy; Milk; Almond; Cashew; Sesame; Vegetable	Wheat; Peanuts; Tree nuts; Eggs; Soy; Milk; Sesame; Mustard	Snack	MNL - MANHATTAN LEVEE PLANT	Open Edit

1 - 6 of 6 items shown 20 per page

1

Questions?

