



**ASSURED MEAT PROCESSING
STANDARD - AMPS**

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Suppliers - AIMS**

Audited by KIWA PAI

PORK SAUSAGE MODULE

Assured Meat Processing Standard - Pork Sausage Module (PS)

Pork Sausage		
Ref	Requirement	Guidance
PS1.1	<p>During the preparation of sausage it is possible that the mix temperature may exceed 5°C (as a result of mincing, mixing and chopping). The increase in temperature must be limited to +5°C of the normal temperature and must not exceed +7°C.</p> <p>A record of temperature must be maintained</p>	
PS1.2	After filling, finished packed sausages must be chilled to less than 4°C within 4 hours of final pack.	
PS1.3	<p>There is no restriction on the type of casing that can be used for sausages.</p> <p>Traceability must be maintained for casings</p>	
PS1.4	<p>Meat Content</p> <ul style="list-style-type: none"> • Products must have a minimum meat content of 52%, the meat being defined in accordance with Commission Directive 2011/101/EC which introduces the European generic definition of meat for the purposes of labelling • The definition includes maximum percentage limits (on fat 30% of the pork meat content and connective tissue 25% collagen/protein ratio in the case of pork) that may be counted, along with the skeletal muscle, towards the meat content of the product • Fat and connective tissue in excess of the limits laid down are not be permitted 	
PS1.5	<p>Restricted Ingredients</p> <ul style="list-style-type: none"> • Neck end (Jowl meat) must be less than 10% of the meat content of the sausage unless trimmed of all glands • Rinds including dehydrated at a level greater than that which is naturally associated with the pork used, which is assumed to be less than 10% (hydrated rind) of the pork. • Salt (Sodium Chloride) maximum 1.4g salt or 550mg sodium per 100g (equivalent to a maximum of 1.3% salt). To use the claim "low sodium/salt" the product must contain no more than 0.12g of sodium, or 0.31g of salt per 100g • Added Phosphate: not more than an equivalent level of di, tri or polyphosphate of 0.5% (calculated as P205) (E450, E451, E452) • Colours: only those permitted for sausages in Schedule 3 of the Colours in Food Regulations 1995. Note: EC regulation 884/2007 suspending the use of food colour Red 2G (E128) • Where the only permitted preservative sulphur dioxide is included it must not exceed 450ppm of the final product at point of sale. Where other preservatives are used they must be compliant with the relevant legislation 	<p><i>Rind and dehydrated rind must be used in accordance with the Food Standards Agency's Guidance Notes on the Labelling and Composition of Meat Products</i></p> <p><i>Non-permitted ingredients</i></p> <ul style="list-style-type: none"> • <i>Head meat (with the exception of masseters)</i> • <i>Liver skirts</i> • <i>Blood products</i> • <i>Offal meats as listed in Clause 6 (2) in the Meat Products Regulations 2003 (as amended)</i> • <i>Mechanically separated meat</i> • <i>Mono sodium glutamate</i> • <i>Functional proteins and fat emulsions</i>

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<p>PS1.6</p>	<p>The microbiological quality of the raw sausage must be tested periodically throughout and beyond end of coded life to confirm shelf life</p>	<p><i>The following micro standards are what would typically be expected for finished raw sausage and sausage stuffing's:</i> <i>TVC - Target <5 x 10⁵ CFU/g; Limit <5 x 10⁶ CFU/g</i> <i>Yeast/Moulds - Target <1 x 10³ CFU/g; Limit <1 x 10⁴ CFU/g</i> <i>Salmonella Limit ND in 5 10g samples</i></p>
<p>PS1.7</p>	<p>Sausage Characteristics:</p> <ul style="list-style-type: none"> • After cooking the product must be an even light brown colour and must retain its original shape with no splitting or significant shrinkage • Texture must be firm and succulent with absence of bone particles, gristle and excessive fattiness • Flavour must be well balanced and free from off flavours and taints • Cooking losses of the sausage must be specified within a quality specification document. 	<p><i>Calculating cooking loss, follow the cooking instructions for the product to achieve a minimum internal centre temperature of 72°C.</i> <i>Finished cooked (+72°C) weight ÷ Raw weight x 100 = total cooked weight % (difference up to 100 = % cook loss)</i> <i>Cooking loss + 100 - (X/Y x 100).</i> <i>Weight of the product raw (Y). Weight of the product cooked (X).</i></p>
<p>PS1.8</p>	<p>Sausage organoleptic testing must be undertaken at a frequency to ensure products comply with the sausage specification</p>	<p><i>Storage temperatures used for shelf life assessment must reflect potential customer abuse.</i></p>