

Specifications exist within Ishka Spring Water for raw materials including packaging, finished products and any product or service which could affect the integrity of the finished product.

Product Name	500ml Sparkling Spring Water with Flat Cap
Manufacturer Name	Ishka Spring Water
Manufacturer Address	Shelton Park, Ballyneety, Co. Limerick. Republic of Ireland
Manufacturer Registration Number	HSE Registration No : 77318
Manufacturer Phone Number	Phone : 061 450705
Manufacturer Email Address	info@irishspringwater.com
Production/ Technical Contact	Mr. Denis Sutton (Managing / Production Director) Mr. Michael Sutton (Managing / Commercial Director) Mr. Mark Taylor (Operations Manager)
Quality Contact	Mrs. Mairead Wharton-Evans (Quality Manager) Mrs. Moyra Brennan (QA Assistant)

Product Description	500ml Bottled Pure Irish Sparkling Water - Ólin
Country of Origin	Republic of Ireland

Product Formulation/Origin of Ingredients/Raw Materials
Ishka Pure Irish Still Water is exploited and bottled at source from the Ishka Springs, which are located on site at Ishka Spring Water, Shelton Park, Ballyneety, Co. Limerick. Co2 is the only Ingredient added to the 500ml Sparkling product.

The following are the defined Legislative Limits as per S.I. 282 of 2016 EU Natural Mineral Waters, Spring Waters & other Waters in Bottles & containers Regs 2016 Ref Rec - 095 Ishka Micro Sampling Plan for Microbiological Criteria	Microbiological Parameter	Parametic Value/Defined Limits
	Escherichia Coli (E.Coli) at 37°C for 48 hours	0 cfu/250ml
	Total Coliforms at 37°C for 48 hours	0 cfu/250ml
	TVC (Total Viable Count) at 22°C for 72 hours	100 cfu/ml
	TVC (Total Viable Count) at 37°C for 24 hours	20 cfu/ml
	Pseudomonas Aeruginosa at 37°C for 48 hours	0 cfu/250ml
	Intestinal Enterococci at 37°C for 48 hours	0 cfu/250ml

Characteristic Ingredients/Composition (key characterising ingredients listed on pack)	Product Ingredient/Content	Typical Analysis of Final Product
	Calcium (Ca)	130mg/l
	Magnesium (Mg)	20mg/l
	Sodium (Na)	14mg/l
	Potassium (K)	<5mg/l
	Bicarbonate (HCO3)	329mg/l
	Chloride (Cl)	25mg/l
	Sulphate (SO4)	<20mg/l
	Nitrate (NO3)	12mg/l
	PH	7

Defined Limits for Chemical Properties that impact food safety e.g. PH, ref Rec - 004 Chemical Sampling Plan

- Quarterly Indicator/Label Chemical Analysis, reference **Rec - 105**
- Yearly Chemical Analysis, reference **Rec - 104(a)**
- 4 Yearly Chemical Analysis, reference **Rec - 104(b)**
- Monthly Test for Ammonia, reference **Rec - 105(b)**
- Yearly Dissolved Solids & Suspended Solids, Reference **Rec - 130**

PH - The purpose of the PH test is to check the stability of the water. A PH reading above 7 is Alkaline and below 7 is Acidic. The PH reading should be between 6.5 and 9.5 for ground water systems according to the EU Natural Mineral Waters, Spring Waters and other Waters in Bottles or containers Regulations 2016 **S.I. 282 of 2016**.

Ishka PH - the internal PH limit for Sparkling Water at Ishka Spring Water which is based on analysis of record history is between **4.5 and 5.5**

PH readings can change slightly due to temperature. A change in Temp (by 1-2 deg C) can have an impact on the PH reading. However **a sudden change outside the set limits could be an indication that something is going on underground** and Ishka will not bottle water outside the acceptable PH levels listed above.

Defined Limits for Physical Properties that impact food safety e.g. Organoleptic Properties

Appearance	Colourless/Clear
Aroma	Odourless
Flavour Profile	Normal Water Taste
Colour	Colourless/Clear

Treatment and Processing e.g. heating, freezing, salting

Ishka Spring Water receives the following treatment :

Filtration : All source water entering the factory passes through a 5µ (micron) bag filter, 1.5µ pre-filter and 2 x 1µ Final filters which are installed in the production line. The purpose of the 5µ bag filter and the 1.5µ pre filter is to protect the downstream 1µ membrane filters. The filters act as a physical barrier to eliminate dissolved solids in the water and prevents Microbiological contamination (Build up of microbial load in the water source).

Specifications for Raw Materials and Packaging are adequate and accurate and ensure compliance with relevant safety and legislative requirements. All materials are traceable to the packaging suppliers (one step back). Certificates of conformance/declaration of compliance are in place for all packaging stating it complies with FCM rules. Reference Supplier Specifications file for evidence of same.

Packaging System/Detail	Detailed Information/Legislative requirements regarding product packaging
Bottles – 500ml (Reference Preform Supplier Specs for Certificates of Conformance)	Water is packaged in Food Grade Approved rPET 500ml bottles, which are blown on site at Ishka Irish Spring Water. The pre-form material used in the manufacture of the bottles meets Commission Regulations (EU) No 1935/2004 and No 10/2011 . The 500ml plastic bottle has been sent for external independent Migration Testing & results are on file for same.
Caps – Flat (Reference Cap Supplier Specs for Certificates of Conformance)	All caps comply with the Plastic Materials and Articles intended to come into Contact with Food Regulations, including Commission Regulations (EU) No 1935/2004 and No 10/2011 . Migration test results are on file for all caps used on site.

Packaging System/Detail	Detailed Information/Legislative requirements regarding product packaging
Pack Size / Weight / Volume	500ml Sparkling Water is shrink wrapped in clear film in cases of 24's. 24 pk Volume is 12 Litres, with 84 cases on a Pallet
Units Per Case	6x4 Units = 24 Bottles

Label
Label Size : 213mm x 33mm. (Reference Label Supplier detailed Specification for Barcodes, colours etc...) Reference Rec - 071(b) Approved Label Artwork Matrix

Storage Conditions / Temperature	Store at ambient temperature in a cool, dry place away from direct sunlight, strong odours and chemicals.
Distribution Conditions / Temperature	Distribute at ambient temperature in a cool, dry container away from direct sunlight, strong odours and chemicals.

Target Safe Product Shelf Life, under prescribed storage and usage conditions	
Maximum Shelf Life	1 year shelf life. Best Before Date lasered on neck of bottle.
Minimum Shelf Life on Delivery	The minimum shelf life we can guarantee on delivery is 6 months.
Maximum Shelf Life After Opening/ Instructions for use	Once opened, refrigerate and consume within 3 days

Intended Use of the Product/ Consumer Use	The intended use of the product is for consumption by the general population and the product is not targeted specifically at any one demographic group. The product is suitable for all persons including vulnerable groups of the population e.g infants, the elderly and allergy sufferers. Intended use • Product is ready to drink • Retail i.e. Supermarket Alternative Use • Boiling for making tea • Used for Cooking
--	---

Allergen Information (Ref Rec - 101 Allergen Control Policy) The following known Allergen Related Food Products have been defined by the EU FIC (Food Information to Consumers) Regulations No 1169/2011	Yes (if yes, please provide details)	No
--	--	-----------

Cereals containing Gluten e.g. Wheat, rye, barley, oats, spelt wheat, kumat knorasan wheat and their hybridised strains containing gluten and products thereof		No
Crustaceans and products thereof e.g. crab, lobster, shrimp, barnacles etc...		No
Molluscs & products thereof e.g. octopus, squid, snails, mussels, clam, oysters, scallops		No
Fish and products thereof		No
Egg and products thereof		No
Peanuts and products thereof (Peanuts are grown on the ground)		No
Nuts and products thereof (grown on trees) - almond, hazelnut, walnut, cashew, pecan, brazil, pistachio, macadamia and queensland.		No
Soyabeans and products thereof		No
Milk and products thereof including lactose, cows, goats & ewes milk		No
Celery and products thereof		No
Lupin and products thereof		No
Mustard and products thereof		No
Sesame Seeds and products thereof		No
Sulphur Dioxide and Sulphites at concentrations of more than 10mg/kg or 10mg/litre expressed as SO ₂ in Final Product		No

Batch Code / Traceability	
Batch Code / Traceability System in place	Laser Traceability System in place where each bottle once rinsed, filled, capped and labelled passes through the Laser traceability machine where it receives two lines of print. As per the Julian Calendar the Batch number has a 5 digit format as follows : 23007, with 23 being the year the product was produced and 007 indicating today is the 7th day of the year. E.07.01.24 IISW • with E standing for estimated shelf life • 07.01 is the production date • 24 indicating a 1-year shelf life i.e. 2024 • IISW is the company name B.23007.09:37 • with B standing for Batch • 09.37 being the exact time the product was produced

Specification Review	Specifications shall be reviewed whenever products change (e.g. ingredients, processing method, legislation etc...) or every year.
Reason for Review	New Specification

Reference documents :	Reference Sop - 045 Product Specifications procedure Reference Rec - 015 Supplier Evaluation Questionnaire Reference Rec - 014 Customer Base Reference Rec - 024 Products Produced on Site
-----------------------	--