

The Pineapple Industry Ordinance, 1957

(No. of 1957).

THE PINEAPPLE INDUSTRY

GRADING, LABELLING AND MARKING

REGULATIONS, 1958.

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Johore Bahru.
Malaya.
October, 1958.

THE PINEAPPLE INDUSTRY (GRADING, LABELLING AND MARKING)
REGULATIONS, 1958.

In exercise of the powers conferred by section 19 of the Pineapple Industry Ordinance, 1957, the Pineapple Industry Board, with the approval of the Yang di-Pertuan Agong/Governor in Council hereby makes the following Regulations :-

PART I

Preliminary

1. These Regulations may be cited as the Pineapple Industry (Grading, Labelling and Marking) Regulations, 1958, and shall come into force either in whole or in part on a date or dates to be notified by the Malayan Pineapple Industry Board in the Gazette. Title.
2. The Regulations are divided into Parts as follows :- Arrangement of Regulations

PART I	-	Preliminary	
PART II	-	General Provisions as to Export of Canned Pineapple.	
PART III	-	Labelling and Marking of Retail Packs of Canned Pineapple.	
PART IV	-	Disposal of Canned Pineapple Graded as "Sub-standard" or "Reject".	
PART V	-	Definitions of Grades, Styles of Cut and Fixed Standards for Canned Pineapple.	
PART VI	-	Collection, Examination and Marking of Samples of Canned Pineapple.	
PART VII	-	Determination of the Final Quality Grade Designation of a Sample and of a Batch of Samples.	
PART VIII	-	Feeding and Accommodation of Inspectors.	
3. In these Regulations, except where the context otherwise requires expressions used have respectively the same meaning as in the Pineapple Industry Ordinance 1957 Interpretation

" case " means a wooden case, fibreboard carton or other package used as a container of cans of pineapple;

" batch " means all cans produced in any one day of any particular style of cut of a particular grade in any one can size.

" export " means to despatch for export to any country or place outside Malaya;

" export item " means a quantity of canned pineapple intended for export as one lot and recorded as a separate item in an outward declaration;

" Industry " means ' Malayan Canned Pineapple Industry ';

" label " means descriptive matter printed, lithographed or stencilled on a paper wrapper affixed to the body of a can or reproduced directly on the body of a can;

" Malaya " means the 'Colony of Singapore' and the 'Federation of Malaya';

" Malayan canned pineapple" means the pineapple whole, cut, crushed or in pulp or juice form which has been pre-heated, cooked, preserved, dehydrated, quick frozen or otherwise processed whether before or after being placed by a registered canner in a hermetically sealed bottle or container made of glass, metal, plastic, paper or any other material.

" outward declaration " means a declaration made in compliance with rule 5 of the Registration of Imports and Exports Rules, 1935;

"PIS" means the Malayan Pineapple Industry Board Process Research Station;

"a packing" means a can of pineapple of a stated specification which complies with one or other of the specifications contained in these Regulations as to size of can and contents;

"packing season" means a period of six months either from 1st April to 30th September or from 1st October to 31st March;

"quality grade designation" means a word or combination of words used to indicate the quality grade of canned pineapple as defined in Part V of these Regulations;

"retail packs" means canned pineapple packed in one or other of the containers specified in sub-paragraph (a) of sub-regulation (1) of regulation 14 of the Pineapple Industry Regulations, 1952;

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"a shipment of canned pineapple" means the total quantity of canned pineapple specified in any one outward declaration;

"sliced pineapple" means pineapple cut into slices whether 'Round Cut' or 'Spiral Cut' as defined in Part V of these Regulations;

"syrup" means a solution of refined sugar in water except that pineapple juice may be used instead of water as a base for the syrup;

"the Ordinance" means the 'Pineapple Industry Ordinance, 1957'; and

"whole slice pack" means a can of pineapple which purports to contain whole unbroken slices of pineapple whether 'Round Cut' or 'Spiral Sliced'.

PART II

General Provisions as to Export of Canned Pineapple

4. The export of Malayan canned pineapple is prohibited unless
- (a) the outward declaration in respect of such canned pineapple complies with the conditions set out in regulation 5 of these Regulations; and
 - (b) the Officer of Customs at the port of export is furnished with a quality Grading and Labelling Certificate in respect of such canned pineapple in the form stipulated in regulation 6 of these Regulations.
5. Outward declarations covering shipments of canned pineapple shall contain the particulars and shall comply with the conditions set out below.
- (a) Each registered exporter shall number serially his outward declarations covering shipments of canned pineapple and the serial number of an outward declaration shall be marked on the top left-hand corner of the declaration;
 - (b) Each outward declaration covering a shipment of Malayan canned pineapple shall specify in addition to such particulars as may be required to comply with any legislation in force in the Colony at the time of shipment, the following particulars in respect of each export item:-
 - (i) the number of cases; the number of cans contained in each case; and the size of such cans described in accordance with the nomenclature set out in sub-regulation (2) of regulation 14 of the Pineapple Industry Regulations, 1952;

Conditions
applying to
export of
pineapple.

Outward
declaration
canned pine

(ii) The style of cut and quality grade designation of the canned pineapple ; and

(iii) the brand name of the labels used for labelling the cans.

6. A registered exporter intending to export Malayan canned pineapple shall surrender to the Officer of Customs at the port of export, in addition to an outward declaration, a Quality Grading and Labelling Certificate in Form I of the First Schedule to these Regulations duly signed by the registered canner whose cannery the canned pineapple was manufactured and by an inspector.

Quality
Grading and
Labelling
Certificate

PART III

Labelling and Marking of Retail Packs of Canned Pineapple.

7. A registered canner shall indelibly print or emboss one end of each can of canned pineapple produced at his cannery with the registered mark of the cannery as provided under Section 16 of the Ordinance and a code mark consisting of a combination of figures or letters or both signifying the year, month and day on which the can is packed and the following particulars of the contents of the can:

Marking
of cans.

- (a) Quality Grade Designation;
- (b) Style of Cut; and
- (c) Syrup Specification.

A registered canner shall supply to the Board full particulars of all code marks used at his cannery and their interpretations.

8. A registered canner shall label all retail packs produced at his cannery before removal from the cannery and the labels used for this purpose shall be marked with:-

- (a) The true and correct quality grade designation, i.e. -
" Choice Golden Quality " (alternatively for U.S.A. and Canada, " Choice Quality ")
or " Standard Quality " ;
or " Sub-standard Quality "
as the case may be.
- (b) The net weight of the contents of the can marked in ounces avoird
and/or in metric grammes.
- (c) A true and correct description of the style of cut.
- (d) A clear indication of the country of origin, e.g. "Malayan Pineapple"
- (e) A description of the liquid contents of the can expressed as
specified below, i.e.

	<u>Nature of Liquid Contents</u>	<u>Description to be Marked on Labels</u>
(i)	Standard Syrup	" In Syrup " or " In Standard Syrup " or " In 17 % Sugar Syrup " .
(ii)	Light Syrup	" In Light Syrup "
(iii)	Syrup containing not more than 8 % of sugar.	" Au Nat " or " Au Naturel " .
(iv)	Syrup of a density other than specified above.	A declaration of the percentage of sugar in the syrup followed by the words " sugar syrup " or such other description as may be approved by the Board as being an accurate description having regard to the legislation and trade customs applying to the canned fruit in the country to which the canned pineapple is to be shipped.
(v)	Heavy Syrup	" In Heavy Syrup "
(vi)	Extra Heavy Syrup	" In Extra Heavy Syrup "

(f) Any additional printed matter which does not conflict with or modify any of the declarations specified in this regulation.

9. The character of the lettering used on labels for the purpose of marking the declarations stipulated in regulation 8 of these Regulations shall be as clear and conspicuous as that of any other lettering on the label and the minimum size of such lettering shall be as specified below for the declaration and the size of can concerned, i. e.

Character and size of lettering on labels.

Declaration	Size of Can	
	Over 16 oz.	16 oz. & under
(a) Quality Grade designation	1/4"	3/16"
(b) Net Weight	1/8"	3/32"
(c) Style of Cut	1/8"	1/8"
(d) Country of Origin	3/16"	1/8"
(e) Syrup Specification	1/8"	1/32"

10. (1) No label shall be used for labelling canned pineapple until such label has been submitted to the Board in Form II of the First Schedule to these Regulations either by the owner of the label or by a packer and has been approved by the Board in Form III of the Schedule..

Approval of labels by the Board.

(2) No label of the same brand designation shall be approved for more than one quality of canned pineapple unless the Board is satisfied that the label for each quality is so different that they cannot be confused one with the other.

11. (1) The Board shall not approve any label which does not comply with the requirements of regulation 8 and 9 of these Regulations or any label which includes an illustration of cut pineapple which does not depict with reasonable accuracy pineapple of the style of cut and quality grade designation marked on such label.

Refusal to approve labels.

(2) The Board shall notify in writing their refusal to approve any label submitted to them and shall specify their reasons for refusal.

12. The Board shall -
 (a) allot a distinctive serial number to each approved label; and
 (b) keep a register of all approved labels and the register shall include the particulars of each label as set out in Form III of the First Schedule to these Regulations, together with a specimen of the label.

Registration of labels.

13. If any alteration is made in the printed matter or layout or design of a label after it has been registered, the label shall be re-submitted to the Board in Form II of the First Schedule to these Regulations and shall not be used for labelling canned pineapple until it has been approved by the Board in Form III of the Schedule.

Alteration of label after registration.

14. Any person aggrieved by the refusal to register a label may appeal to the Board of Appeal appointed under section 24 of the Ordinance whose decision shall be final,

Appeal against refusal to register a label.

15. The Board may agree to modify any of the conditions stipulated in regulations 8 and 9 of these Regulations in the case of labels to be used for labelling canned pineapple for shipment to a specified country overseas if they are satisfied that modification is necessary to comply with the labelling regulations in force in such country and that the modification or modifications proposed will not be detrimental to the interests of the Industry.

Power of Board to modify Regulations.

16. A registered canner shall stencil legibly on one end of each case containing Malayan canned pineapple before removal from the cannery the following particulars:

Marking of cases of canned pineapple.

- (a) The registered mark of the cannery in which the Malayan canned pineapple was prepared.
 (b) The quality grade designation and style of cut of the Malayan canned pineapple.
 (c) The number and size of the cans contained in each case.

A registered canner shall display on each batch of canned pineapple stored in his cannery stores Card clearly marked with the following particulars:

Arrangement in cannery

17.

- (a) A distinctive Stores Batch Number.
- (b) The number of cans in the batch or, if the cans are packed in cases, the number of cases and the number and size of the cans contained in each case.
- (c) The quality grade designation and style of cut of the pineapple contained in the cans.
- (d) The nature of the liquid contents of the cans described as stipulated in sub-regulation.
- (e) of regulation 8 of these Regulations.

PART IV

Disposal of Canned Pineapple Graded as "Sub-standard" and "Reject"

18. Canned pineapple which is graded as "Reject" in accordance with the provision of Part VII of these Regulations shall be disposed of as may be directed by the Board but shall not in any circumstances be exported from the Federation/Colony.
19. The Board may by notification in the Gazette notify any particular territory or territories to which retail packs of canned pineapple which are graded as "Sub-standard" under Part VII of these Regulations shall not be exported.

Disposal of Canned pineapple graded as "Reject"

Restriction of export of canned pineapple graded as "Sub-standard".

PART V

Definitions of Grades, Styles of Cut and Fixed Standards for Canned Pineapple

20. A registered canner shall grade the canned pineapple produced at his cannery to one or other of the quality grade designations, "Choice Golden Quality", "Standard Quality" or "Sub-standard Quality", in accordance with the specification of the quality grade for the Style of Cut concerned as set out below.

Quality grade designations and specifications.

(a) CHOICE GOLDEN QUALITY (alternatively named " CHOICE QUALITY ")

S t y l e o f C u t	
Cubes, Dices, Chunks, Fingers, Spears, Round Cut Slices, Whole Fruit, Spiral Slices, Broken Slices, Salad Cuts and Tid-bits (cut from Round Cut Slices only)	Crushed Pineapple
To qualify as Choice Golden Quality the contents of the can shall be such and shall be so processed as to conform with the Fixed Standards specified in regulation 30 and the fruit shall be fully mature pineapple of bright attractive appearance with an average colour depth of not less than 8 (PRS Scale); uniformity of colour shall be such that at least 80 % of the sample has a colour depth of not less than 8 (PRS Scale) and not part of the sample has a colour depth below 7 (PRS Scale); uniformity of cutting shall be not less than 80% and, in the case of sliced pineapple, variation in slice diameter shall not exceed 1/4". The penalty incurred for trimming faults and defects shall not exceed 4 marks; the fruit shall be at least 90 % free of toughness or sponginess and shall possess a distinct true pineapple flavour.	To qualify as Choice Golden Quality the can contents shall be such and shall be so processed as to conform with the Fixed Standards specified in regulation 30: the fruit shall have a colour depth of at least 8 (PRS Scale) and uniformity of colour shall be not less than 80 %. The marks scored for absence of defects shall be not less than 24; the fruit shall be practically free from core and shall possess a distinct true pineapple flavour.

(b) STANDARD QUALITY

S t y l e o f C u t	
Cubes, Dices, Chunks, Fingers, Spears, Round Cut Slices, Whole Fruit, Spiral Slices, Broken Slices, Salad Cuts and Tidbits (cut from Round Cut Slices only)	Crushed Pineapple
To qualify as Standard Quality the can contents shall be such and shall be so processed as to conform with the Fixed Standards specified in regulation 30. The fruit shall be reasonably mature (not dull) in appearance with an average colour depth of at least 5 (PRS Scale); uniformity of colour shall be such that at least 70 % of the sample has a colour depth of not less than 5 (PRS Scale) and no part of the sample has a colour depth below 4 (PRS Scale). Uniformity of cutting shall be not less than 80 %. In the case of sliced pineapple variation in slice diameter shall not exceed 3/8". The penalty incurred for trimming faults and defects shall not exceed 6 marks; the fruit shall be 80 % free of toughness and shall possess a noticeable pineapple flavour.	To qualify as Standard Quality the can contents shall be so processed as to conform with the Fixed Standards specified in regulation 30; the fruit shall have a colour depth of at least 5 (PRS Scale) and uniformity colour shall be not less than 70 %. The marks scored for absence of defects shall be not less than 21; the fruit shall be reasonably free from core and shall possess a noticeable pineapple flavour.

(c) SUB- STANDARD QUALITY

Cubes, Round Cut Slices, Spiral Slices, Broken Slices, Salad Cuts, Tidbits and Broken Pieces	Crushed Pineapple
To qualify as Sub-standard Quality the fruit contained in the can shall have an average colour depth of not less than 1 (PRS Scale); uniformity of colour and cut shall be not less than 60 %. In the case of sliced pineapple variation in slice diameter shall not exceed 1/2". The penalty incurred for defects and trimming faults shall not exceed 8 marks; the fruit must be 60 % free of toughness and flavour shall be not less than 'slightly fruity'.	To qualify as Sub-standard Quality the fruit contained in the can shall have an average depth of not less than 1 (PRS Scale) and uniformity of colour shall be not less than 60 %. The marks scored for absence of defects shall be not less than 18; the fruit shall be reasonably free of core and flavour shall be graded not lower than 'slightly fruity'.

21. No Sub-standard Crushed Pineapple shall packed other than in A10 cans without the prior approval of the B o a r d. Sub-standard Crushed Pineapple.
22. Except as provided in regulation 23 of these Regulations, all retail packs of Malayan canned pineapple shall be prepared in conformity with the specification of one or other of the Styles of Cut set out below. Styles of Cut for Malayan Mark Pineapple.

Style of Cut	Specification
(a) Round Cut Slices	A Round Cut Slice consists of a whole slice of pineapple practically circular in outline that has been cut approximately at right angles to the longitudinal axis of the fruit. The hole cut in the slice for the purpose of removing the core shall be circular in outline and situated in the centre of the slice.

Style of Cut	Specification												
(b) Spiral Cut Slices or Spiral Slices	A Spiral Cut Slice or a Spiral Slice consists of a whole slice of pineapple that has been cut approximately at right angle to the longitudinal axis of the fruit. It is circular in general outline but the circumference of the slice is serrated by a series of fairly regular wedge-shaped incisions made for the purpose of removing the 'eyes' from the fruit. The hole cut in the slice for the purpose of removing the core shall be circular in outline and situated in the centre of the slice.												
(c) Cubes and Dices	<p>Cubes and Dices consist of an approximately cube-shaped piece cut out of a pineapple which conforms reasonably to one or other of the following specifications:-</p> <p><u>Large Cubes:</u> 3/4" to 1" x 3/4" to 1" x 3/4" to 1"</p> <p><u>Small Cubes:</u> 1/2" to 3/4" x 1/2" to 3/4" x 1/2" to 3/4"</p> <p><u>Diced Pineapple:</u> 5/16" to 1/2" x 5/16" to 1/2" x 5/16" to 1/2"</p> <p>All Cubes or Diced pineapple packed in any one can shall conform to one or other of the above specifications and the contents of any one can shall consist of large cubes, small cubes or dices but not more than one type.</p>												
(d) Chunks	<p>* Chunk is a rectangular piece approximately square in cross section cut out of a pineapple which conforms one or other of the following specifications;</p> <table><tr><th></th><th><u>Large Chunks</u></th><th><u>Small Chunks</u></th></tr><tr><td>Cross section</td><td>3/4" to 1"</td><td>1/2" to 3/4"</td></tr><tr><td>Length</td><td>1 7/8" to 2"</td><td>1 7/8" to 2"</td></tr></table> <p>The contents of any one can shall consist of either small chunks or large chunks but not both.</p>		<u>Large Chunks</u>	<u>Small Chunks</u>	Cross section	3/4" to 1"	1/2" to 3/4"	Length	1 7/8" to 2"	1 7/8" to 2"			
	<u>Large Chunks</u>	<u>Small Chunks</u>											
Cross section	3/4" to 1"	1/2" to 3/4"											
Length	1 7/8" to 2"	1 7/8" to 2"											
(e) Segments	<p>A Segment is an approximately wedge-shaped section of pineapple produced by dividing a Round Cut Slice into equal portions by radial cuts. Segments shall conform in size to one or other of the following specifications;</p> <table><tr><th></th><th><u>Small Segments</u></th><th><u>Large Segments</u></th></tr><tr><td>Length of Chord outside arc</td><td>7/8" - 11/8"</td><td>11/8" - 11/4"</td></tr><tr><td>Thickness</td><td>5/8" - 7/8"</td><td>5/8" - 7/8"</td></tr><tr><td>Radial Length</td><td>5/8" - 7/8"</td><td>7/8" - 11/4"</td></tr></table> <p>All the segments packed in any one can shall conform to one or other of the above specifications and the contents of any one can shall consist of either small or large segments but not both. The words 'Segments' shall constitute a sufficient description of the Style of Cut on labels used for labelling cans containing either large or small segments.</p>		<u>Small Segments</u>	<u>Large Segments</u>	Length of Chord outside arc	7/8" - 11/8"	11/8" - 11/4"	Thickness	5/8" - 7/8"	5/8" - 7/8"	Radial Length	5/8" - 7/8"	7/8" - 11/4"
	<u>Small Segments</u>	<u>Large Segments</u>											
Length of Chord outside arc	7/8" - 11/8"	11/8" - 11/4"											
Thickness	5/8" - 7/8"	5/8" - 7/8"											
Radial Length	5/8" - 7/8"	7/8" - 11/4"											
(f) Salad Cuts	The word 'Salad Cuts' may be used as an alternative description of Segments subject to compliance with the specifications and regulations applying to segments												

23. A registered canner shall not pack pineapple in a Style of Cut other than those specified in regulation of these Regulations until he has submitted to the Board a full specification of the Style of Cut concerned and particulars of the nomenclature to be used to describe it and has been notified of the Board's approval of such specification and nomenclature.

Use of new
Styles of Cut.

24. The Board shall not withhold approval of a specification submitted under regulation 23 of these Regulations unless they consider that -

Approval of new
Styles of Cut.

(a) the specification so closely resembles the specification of one or other of the Styles of Cut enumerated in regulation 22 of these Regulations as to constitute a mere variation of it; or

(b) the specification indicates a Style of Cut the marketing of which is likely to be detrimental to the reputation of the Industry.

25. All Malayan canned pineapple shall comply with the Fixed Standards for the factors Net Weight of Contents, Drained Weight of Fruit, Final Syrup Density, Number of Slices and Degree of Vacuum as specified in this regulation except as therein provided in case of Sub-standard grade. The conditions applying to Fixed Standards shall be:

Fixed Standard
for canned
pineapple.

F a c t o r		F i x e d S t a n d a r d s				
a)	Net Weight of Contents	In a sample batch of 12 cans the average weight of the contents of a can shall be not less than the weight stipulated in Column 1 below, for the size of can concerned				
		Column 1		Column 2		
		Size of Can	Oz. Avoir	g. metric	Oz. Avoir	g. metric
		301 x 310	12	341	11 3/4	334
		401 x 212	16	454	15 3/4	447
		301 x 400	16	454	15 3/4	447
		307 x 408	20	822	19 1/4	546
		401 x 411	28	567	27 1/2	779
		603 x 700	105	2977	103	2921
		If in any sample batch of 12 cans there shall be found more than one can having a net contents weight less than that stipulated in Column 2 below for the size of can concerned, the inspector shall direct that the net weight declared on the labels used or in the invoice or other document furnished for the purpose of labelling the canned pineapple represented by the sample batch shall be the net contents weight of that can in the sample batch which has the lowest net contents weight.				
(b)	Drained Weight of Fruit	The average drained weight of fruit for a sample batch of 6 cans shall be not less than the weight stipulated in Column 1 below and no can in the batch shall have a drained weight less than the weight stipulated in Column 2 below for the size of can and Style of Cut concerned.				
		(i) Round Cut Slices and Whole Fruit				
		Column 1		Column 2		
		Size of Can	Oz. Avoir	g. metric	Oz. Avoir	g. metric
		301 x 310	6 1/2	185g	6 1/4	178 g.
		401 x 212	10	284g	9 1/2	270 g.
		301 x 400	10	284g	9 1/2	270 g.
		307 x 408	12 1/2	355 g	12	341 g.
		401 x 411	18 3/4	531g	18	510 g.
		603 x 700	61	1730 g	58	1645 g.

F a c t o r

Fixed Standards

(b) Drained Weight of Fruit
- Contd.

(ii) Spiral Slices & Broken Slices

Size of Can	Column 1		Column 2	
	Oz. Avoir	g. metric	Oz. Avoir	g. metric
301 x 300	6	171 g.	5 3/4	164
401 x 212	9 1/4	263 g.	8 3/4	249
301 x 400	9 1/4	263 g.	8 3/4	249
307 x 408	11 1/2	323 g.	11	313
401 x 411	17 1/4	493 g.	16 1/2	468
603 x 700	61	1 730 g.	58	1645

(iii) Cubes, Dices, Segments, Fingers, Spears, Chunks, Broken Pieces and Tid-bits.

Size of Can	Column 1		Column 2	
	Oz. Avoir	g. metric	Oz. Avoir	g. metric
301 x 310	6	171 g.	5 3/4	164
401 x 212	9 1/4	263 g.	8 3/4	249
301 x 400	9 1/4	263 g.	8 3/4	249
307 x 408	11 1/2	323 g.	11	313
401 x 411	17 1/4	493 g.	16 1/2	468
603 x 700	66	1872 g.	62 3/4	1780

(iv) Crush

Size of Can	Column 1		Column 2	
	Oz. Avoir	g. metric	Oz. Avoir	g. metric
401 x 212	11	312 g.	10 1/2	298
301 x 400	11	312 g.	10 1/2	298
307 x 408	13 3/4	391 g.	13	370
401 x 411	20 3/4	589 g.	20 1/4	575
603 x 700	72	2042 g.	68 1/2	1942

(v) Crush (Heavy Pack)

Size of Can	Column 1		Column 2	
	Oz. Avoir	g. metric	Oz. Avoir	g. metric
401 x 212	12	340 g.	11 3/4	334
301 x 400	12	340 g.	11 3/4	334
307 x 408	15	425 g.	14 3/4	419
401 x 411	22 3/4	638 g.	21 1/4	603
603 x 700	78 3/4	2233 g.	76 3/4	2175

(vi) Crush (Solid Pack)

Size of Can	Column 1		Column 2	
	Oz. Avoir	g. metric	Oz. Avoir	g. metric
401 x 212	13	369 g.	12 1/2	355
301 x 300	13	369 g.	12 1/2	355
307 x 408	16	454 g.	15 3/4	446
401 x 411	23 1/4	660 g.	22 3/4	645
603 x 700	84	2382 g.	82	2325

The drained weight shall be determined by pouring the contents of the can on a round sieve made with woven stainless steel wire-cloth with a wire diameter of 0.041 of an inch and an opening of 0.084 of one inch using a sieve 8 inches in diameter for containers of less than 3 lbs. net contents and 12 inches diameter for larger containers. Incline the sieve without shifting the contents to facilitate drainage. Allow to drain for 2 minutes from the time the contents of the containers are poured onto the sieve. Immediately transfer the pineapple to a clean dry tared pan in one moderately rapid motion and determine the weight of the drained pineapple.

F a c t o r

F i x e d S t a n d a r d s

(b) Drained Weight of Fruit - Contd

If a sample fails to comply with the requirements of this sub-regulation it shall be graded not higher than Sub-standard.

(c) Final Syrup Density

Final Syrup Density shall be determined after the contents of the can have reached stability. The final density of standard syrup shall be not less than 17° Brix and all retail packs shall be deemed to be packed in Standard Syrup unless the cans are labelled -

- (i) " Packed Au Naturel " in which case the final syrup density shall be not less than 8° Brix and not more than 14° Brix.
- (ii) In Light Syrup in which case the final syrup density shall be not less than 14° Brix and not more than 16° Brix.
- (iii) In Heavy Syrup in which case the final syrup density shall be not less than 18° Brix and not more than 22° Brix.
- (iv) In Extra Heavy Syrup in which case the final syrup density shall be not less than 22° Brix and not more than 35° Brix.
- (v) With a declaration of the syrup specification expressed as a percentage of sugar by weight in which case the final syrup density shall conform with that specification within a tolerance of 3° Brix more.

A sample which does not conform with the requirements of this sub-regulation shall be graded not higher than Sub-standard.

(d) Number of Slices per Can

All retail packs of sliced pineapple shall contain in each can the number of slices specified below for the size of can concerned unless some different number of slices is clearly specified on the label in which case the number of slices contained in the can shall be the number so specified.

Number of Slices per Can.	
Size of Can	No. of Slices
301 x 310	8
401 x 212	6
301 x 400	10
307 x 408	10
401 x 411	10

If a sample fails to comply with the requirements of this regulation it shall be graded not higher than Sub-standard.

(e) Degree of Vacuum

Each can of Malayan Pineapple shall have a degree of vacuum of not less than 6 " Hg. as measured by a Budenburg F.I.R.A. gauge at room temperature (i. e. 84°F. approx.). If a sample fails to comply with the requirements of this sub-regulation it shall be graded not higher than Sub - standard.

(f) Can Contents

Each can of Malayan canned pineapple shall contain pineapple and syrup only.

(g) Colour.

Each can of Malayan canned pineapple the contents of which comply with the minimum standards for depth of colour of any quality grade as provided in Regulation 34 shall not be designated as of a lower quality grade unless it fails to obtain the minimum marks for that quality grade as provided in Regulation 33 or otherwise fails to comply with the minimum standards for that grade. Save that the Board may upon application in writing by a canner grant an exception.

26. Provided always that if a sample batch of canned pineapple fails to comply with one or more of the Fixed Standards by so wide a margin that in the opinion of the Board the export of the canned pineapple represented by the sample would be seriously detrimental to the reputation of the Industry, the Board may prohibit the export of such canned pineapple.

Export of pineapple below "Fixed Standard" may be prohibited.

PART VI

Collection, Examination and Marking of Samples of Canned Pineapple.

27. For the purposes of these Regulations inspectors shall be entitled to take without payment a number of cans calculated as one can for each four thousand cans manufactured at the cannery. If at the end of a packing season it is established that the number of cans taken from a cannery by the inspectors is in excess of the number so calculated the owner of the cannery may require the Board to pay for the excess cans at the market price as notified by the Canners' Representative Association as gazetted under section 19 of the Ordinance. Arrangements for drawing and examining samples.
28. The samples taken from a registered cannery as provided in regulation 27 shall be grouped by the inspector into lots of twelve cans of the same packing and each lot shall be divided into two sample batches each of six cans and one such sample batch shall be examined by the inspector not less than ten days after the date of removal from the registered cannery and graded by him in accordance with the provisions of Part VII of these Regulations. If, as a result of this examination, the sample batch fails to qualify for classification in the quality grade claimed by the registered canner the remaining six cans (which may be referred to as 'the duplicate sample batch') shall be examined and the quality grade designation of the batch of twelve cans shall be determined as stipulated in regulation 36 of these Regulations.
29. The inspector shall notify the packer of the date, time and place of examination of samples drawn from his registered cannery and the packer or his accredited representative shall have the right to be present at such examination. Notification of examination to packer.
30. Each sample can of pineapple examined by the inspector shall be tested by him to determine whether or not it complies with the Fixed Standards as stipulated in regulation 25 of these Regulations and the inspector shall then award marks to the sample for the following Quality Factors, i. e. - Marking of samples for Quality Factor.

<u>Quality Factor</u>	<u>Maximum Marks</u>
Depth of Colour . . .	20
Uniformity of Colour . . .	10
Uniformity of Cut . . .	10
Absence of Defects . . .	20
Texture . . .	10
Flavour . . .	20
Clarity of Syrup . . .	10
	<u>100</u>

31. The method of assessing the marks to be awarded for each of the Quality Factors enumerated in regulation 30 of these Regulations shall be as set out below.

<u>Quality Factor</u>	<u>Style of Cut</u>	<u>Method Assessing Marks</u>
(a) Depth of Colour	All Styles	Depth of Colour shall be determined by matching the average colour shade of the pineapple contained in the sample with the shade most nearly resembling it on the Scale of PRS Colour Shades at the Government Canning Research Station and the marks awarded to the sample for Depth of Colour shall be the marks shown against the PRS Colour Shade concerned in Scoring Table No. 1 in the Second Schedule to these Regulations. The Colour in the PRS Scale as measured by means of a Lovibond Tintometer are:

Quality Factor	Style of Cut	Method of Assessing Marks			
(a) Depth of Colour - Contd.	All Styles	Shade No.	Blue	Yellow	Red
		1	0.4	1.2	0.3
		2	0.5	2.2	0.7
		3	0.5	3.0	0.7
		4	0.8	3.5	1.0
		5	0.6	4.6	0.9
		6	0.4	6.0	1.0
		7	0.3	7.5	1.2
		8	0.4	8.4	1.2
		9	0.4	10.0	1.4
		10	0.4	12.0	1.6
(b) Uniformity of Colour	All Styles	Uniformity of Colour shall be determined by ascertaining the percentage of the separate portions of pineapple contained in the sample of which the colour shade is included in the same grade as, or a higher grade than the average shade of the sample as determined under sub-regulation (a) of this regulation. The marks awarded to the sample for Uniformity of Colour shall be determined in accordance with Scoring Table No. 2 in the Second Schedule to these Regulations.			
(c) Uniformity of Cut	(i) Round Cut and Spiral Cut Slices	Uniformity of Cut shall be assessed by determining the variations in the lengths of diameters and radial axis measured in different position on the same slice and variations between the lengths of diameters and radial axis of different slices in the same sample can. A slice is excessively trimmed if the portion trimmed away exceeds 5 % of the apparent physical bulk of the perfectly formed unit. The marks awarded to the sample for Uniformity of Cut shall be determined in accordance with Scoring Table No. 3(a) in the Second Schedule to these Regulations.			
	(ii) Cubes, Dices, Segments, Chunks, Fingers, Broken Slices and Tid-bits.	Uniformity of Cut shall be assessed by determining the percentage of the total number of pieces of pineapple in the sample can which conform to the specification for the Style of Cut as set out in regulation 22 and the degree to which all pieces in the sample can conform to a uniform standard of size. Any unit is excessively trimmed if the normal shape of the unit is destroyed by such trimming. The marks awarded to the sample for Uniformity of Cut shall be determined in accordance with Scoring Table No. 3(b) in the Second Schedule to these Regulations.			
(d) Uniformity of Cut	(iii) Whole Pineapple	A Whole Pineapple shall not be trimmed so that the portion trimmed away exceeds 9 % of the apparent physical bulk of the perfectly formed cylinder.			
(d) Absence of Defects	(i) All Styles except Crushed Pineapple	Absence of Defects means that the fruit in the sample can is free from white flecks, bruised or discoloured patches, or other blemishes affecting the appearance of the fruit such as pieces of the skin not cut away, black specks, 'eyes' except in whole pineapple with eyes, seeds, etc. and broken slices in whole-slice packs. The marks awarded to the sample for Absence of Defects shall be determined by deducting from 20 the total of the penalties incurred for defects as set out in Scoring			

(d) Absence of Defects - Contd.	(i) All Styles except Crushed Pineapple.	Scoring Table No. 4 (a) in the Second Schedule to these Regulations.
	(ii) Crushed Pineapple	Absence of Defects means that the Crushed Pineapple the sample can is free from speck, seeds, 'eyes', or other blemishes. The method of marking the sample for Absence of Defects shall be to count and add together the number of such defects or blemishes in one ounce of the drained material and then to award the marks appropriate to such number of defects as set out in Scoring Table No. 4(b) in the Second Schedule to the Regulations. In arriving at the total number of defects as described above, the number of blemishes classified as 'large or prominent' shall be multiplied by 3.
(e) Texture	(i) All Styles except Crushed Pineapple	The texture of the fruit in the sample can should be tender and well cooked and should not be tough or spongy. In samples suspected of having too much core the core material shall be identified, cleanly separated and the aggregate weighed. The marks awarded to the sample for Texture shall be determined in accordance with Scoring Table No. 5 (a) in the Second Schedule to these Regulations.
	(ii) Crushed Pineapple	The texture of the fruit in the sample can should be tender and well-cooked and should be free from tough pieces fruit. In samples suspected of having too much core, the core material shall be identified, cleanly separated and aggregate weighed. The marks awarded to the sample for Texture shall be determined in accordance with Scoring Table No. 5(b) in the Second Schedule to these Regulations.
(f) Flavour	All Styles	The marks awarded to the sample for Flavour shall be determined in accordance with Scoring Table No. 6 in the Second Schedule to these Regulations.
(g) Clarity of Syrup	All Styles except Crushed Pineapple.	Clarity of Syrup shall be determined by the use of the PRS Cloud Test Gauge which is an apparatus consisting of a ventilated box containing a 40 x peare bulb fixed about 6" from the top surface of the box in which is set a double glass screen inter-leaved with a good quality paper inscribed with a 1/4" grid of fine black lines about 1/64" in thickness. The method measuring Clarity is to view the illuminated screen through a 50 ml Nessler tube into which syrup is allowed to flow from a tap funnel until the grid becomes invisible. The syrup level in the Nessler tube is then recorded and marks for Clarity of Syrup are awarded in accordance with the scale contained in Scoring Table No. 7 of the Second Schedule to these Regulations.

PART VII

Determination of the Final Quality Grade Designation of a Sample and of Batch of Samples.

32. To qualify for a particular quality grade designation a sample can of pineapple shall -
- (a) comply with the Fixed Standards as stipulated in regulation 25 except as therein provided in the case of Sub-standard quality; and

Determination
of Quality Grade
of Single Sample.

32. (b) score the minimum marks for each of the Quality Factors as stipulated for the Style of Cut and Quality Grade concerned in regulation 34; and

(c) score a total number of marks for all Quality Factors equal to or more than the minimum total marks for the Quality Grade concerned as stipulated in regulation 37.

33. The stipulated minimum total marks scored for Quality Factors for each of the three quality grades shall be:

Stipulated minimum total marks.

Quality Grade	Minimum Total Marks
Choice Golden	80
Standard	70
Sub-standard	60

34. The stipulated minimum marks to be scored for each Quality Factor for each of the three Quality Grades shall be as set out below in Table A for All Styles of Packs except Crushed Pineapple and in Table B for Crushed Pineapple only, i.e. -

Minimum mark for each Quality Grade.

TABLE A - All Packs Except Crushed Pineapple

Quality Factor	Minimum Marks	Stipulated Minimum Marks		
		Choice Golden	Standard	Sub-standard
Depth of Colour	20	16	14	12
Uniformity of Colour	10	8	7	6
Uniformity of Cut	10	8	7	6
Absence of Defects	20	16	14	12
Texture	10	8	7	6
Flavour	20	16	14	12
Clarity of Syrup	10	No Stipulated Minimum		
Minimum Totals		80	70	60

TABLE B - Crushed Pineapple only

Quality Factor	Minimum Marks	Stipulated Minimum Marks		
		Choice Golden	Standard	Sub-Standard
Depth of Colour	20	16	14	12
Uniformity of Colour	10	8	7	6
Absence of Defects	30	24	21	18
Texture	20	16	14	12
Flavour	20	16	14	12
Minimum Totals		80	70	60

35. The Quality Grade designation of a batch of six samples examined in accordance with the provisions of Part VII of these Regulations, shall be determined as follows;

Determination of Quality Grade of Batch of Samples.

(a) Each sample which fails to comply with any one of the Fixed Standards for 'Drained Weight of Fruit', 'Final Syrup Density', 'Number of Slices per Can' or 'Degree of Vacuum' shall be graded not higher than Sub-standard irrespective of the marks scored for Quality Factors, but the marks scored for Quality Factors shall be included in the total marks scored by the batch for the purpose of determining the average marks as provided in sub-regulation (c) of this regulation.

- (b) Each sample which complies with the Fixed Standards as stipulated in sub-regulation (a) of this regulation shall be classified for quality grade on the result of the marks awarded to the sample for Quality Factors as provided in regulations 32 and 33 of these Regulations.
- (c) The marks scored by the six samples in the batch shall be added together and divided by six to determine the average marks scored by the batch.
- (d) The average marks scored by the batch shall determine the Quality Grade designation of the batch in accordance with the provisions of regulation 32 of these Regulations provided that not more than one of the six samples in the batch has failed to qualify for the Quality Grade concerned.
- (e) Subject to the provisions of regulation 36 of these Regulations, if more than one sample in a batch fails to qualify for the Quality Grade indicated by the average marks scored by the batch, the final quality grade of the batch shall be that lower quality grade for which at least five of the six samples in the batch qualify, or if this condition cannot be met for either of the three quality grades, the batch shall be graded as "Reject".
- (f) A sample or sample batch which fails to comply with the Fixed Standards for "Net Contents Weight" shall not thereby be excluded from any quality grade for which it qualifies on the result marks awarded to it for Quality Factors but the export of the canned pineapple represented by the sample batch shall be subject to the conditions stipulated in sub-regulation (a) of regulation 25 of these Regulations.
36. If a sample batch of six cans is down-graded or graded as "Reject" under paragraph (e) of regulation 35 of these Regulations, the six cans constituting the duplicate sample batch as described in regulation 28 of these Regulations shall be examined by the inspector and the final quality grade designation of the batch of twelve cans shall be determined as follows :-
- (a) The marks for Quality Factors for the twelve samples shall be added together and divided by twelve to determine the average marks scored by the batch.
- (b) The average marks scored by the batch shall determine the quality grade designation of the batch in accordance with the provisions of regulation 33 of these Regulations provided that not more than three of the twelve samples have failed to qualify for the quality grade.
- (c) If more than three of the samples in the batch of twelve have failed to qualify for the quality grade indicated by the average marks scored by the batch, the final quality grade of the batch shall be that lower quality grade for which at least nine of the twelve samples qualify, or, if the batch does not meet this condition for either of the three quality grades, the batch will be graded as "Reject".

PART VIII

Feeding and Accomodation of Inspectors

37. (1). Every registered canner shall provide at each registered cannery owned by him ;
- (a) desk space and a desk in a place within the cannery to be approved by the Board.
- (b) single accomodation with suitable bathing and toilet facilities in a place and of a type to be approved by the Board.

37. (1) (c) meals equivalent to those eaten by the senior staff of such registered cannery for inspector appointed to such registered cannery by the Board which on request will make such reimbursement for these facilities as it deems fit.

(2) Every cannery shall give at least two days notice to the Board's Inspectorate before commencing to receive fruit after any interruption in production,

FIRST SCHEDULE

Form 1

/ Regulation 6 /

Quality Grading and Labelling Certificate for Canned Pineapple.

Name and Address of Exporter:

.....

.....

.....

Port of Shipment:

Port of Destination:

Serial No. of Outward Declaration	Description and Number of Packages	Size of Can and Number per Package	Quality Grade	Style of Cut	Label Brand

Certification by Registered Canner

I,, hereby certify that the canned pineapple specified in this Certificate was manufactured at the cannery owned by of which I am and that the / specify position held e.g. Director, Manager, etc, /
canned pineapple is graded and labelled in accordance with the provisions of the Pineapple Grading, Labelling and Marking Regulations, 1957.

.....
(Date)

.....
(Signature of Registered Canner)

Certification by Inspector

I hereby certify that to the best of my knowledge and belief the canned pineapple specified in this Certificate comprising packages is graded and / Number of packages in words / labelled in accordance with the provisions of the Pineapple Industry Grading, Labelling and Marking Regulations, 1957.

.....
(Date)

.....
(Signature of Inspector)

FIRST SCHEDULE

Form II

/ Regulation 10 /

Form of Application for Registration of Pineapple Labels under regulation 10 of the Pineapple Industry Grading, Labelling and Marking Regulations, 1957.

I, †Senior Partner/Director/ Secretary of.....
 hereby apply under regulation 10 of these
 Regulations for approval of the labels specified below.

Name and Address of Owners of Labels :
 (If not owned by applicant)

Index No.	Brand Name of Label	Particulars of Packing for which Label is to be Used			
		Size of Can	Quality Grade Description	Style of Cut	Syrup Specification
1					
2					
3					
4					
5					
6					
7					
8					
9					
10					
11					
12					

I enclose 7 specimen copies of each of the labels specified above.

(Date)

(Signature)

† Cross out words which do not apply.

FIRST SCHEDULE

Form III

/ Regulation 10/

Form of Approval of Pineapple Labels submitted to the Board under regulation 10 of the Pineapple Industry Grading, Labelling and Marking Regulations, 1958.

I hereby approve and have this day registered under regulation 10 of these Regulations the labels submitted to me by under date, as specified in the Schedule below and have entered in the Register the particulars set out in columns (2), (3), (4), (5) and (7) of the Schedule.

*Schedule of Approval Labels

[illegible]

(Place)

for and on behalf of
The Malayan Pineapple Industry Board.

Date:

SECOND SCHEDULE

/ Regulation 31 /

Scoring Tables for Quality Factors

SCORING TABLE NO. 1: DEPTH OF COLOUR - All Packs

PRS	Colour Shade	No. of Marks	Quality Grade Classification
Shade No. 10		20	
" " 9		18	
" " 8		16	Minimum for Choice Golden
" " 7		15	
" " 6		15	
" " 5		14	Minimum for Standard
" " 4 & 3		13	
" " 2 & 1		12	Minimum for Sub-standard
Below shade No. 1		0-4	

SCORING TABLE NO. 2: UNIFORMITY OF COLOUR - All Packs

PRS	Colour Shade	No. of Marks	Quality Grade Classification
100 % Uniformity		10	
90 % "		9	
80 % "		8	Minimum for Choice Golden
70 % "		7	Minimum for Standard
60 % "		6	Minimum for Sub-standard
50 % "		5	
Less than 50 % Uniformity		0-4	

SCORING TABLE NO. 3(a): UNIFORMITY OF CUT - Round Cut and Spiral Cut Slices

Degree of Uniformity	No. of Marks	Quality Grade Classification
Diameters and radial practically uniform	10	
Variations in diameters and radial axis not more than:		
1/8" and less than 95 % of the drained weight	9	
1/4" - do -	8	Minimum for Choice Golden
3/8" - do -	7	Minimum for Standard
1/2" - do -	6	Minimum for Sub-standard
Larger variations	0-5	
<p>In order to qualify for Choice Golden or Standard not more than 7 1/2 % of the units in a container may be excessively trimmed, but in any container having not more than 10 units one unit may be excessively trimmed and in any container having more than 10 units but not more than 27 units two units may be excessively trimmed.</p>		

SCORING TABLE NO. 3(b): UNIFORMITY OF CUT - Cubes, Diced Pineapple, Segments, Fingers, Chunks, Broken Slices and Tricots.

Degree of Uniformity	No. of Marks	Quality Grade Classification
All pieces within †specification and 90 % or more pieces of approximately same size	9 - 10	
All pieces within †specification	8	Minimum for Choice Golden
80 % pieces or more within †specification	7	Minimum for Standard
60 % pieces or more within †specification	6	Minimum for Sub-standard
Less uniform	0 - 5	
In order to qualify for Choice Golden or Standard in the case of broken slices or fingers, not more than 15 % by count of the total units in the container may be excessively trimmed and in the case of other packs not more than 15 % of the drained weight shall consist of units excessively trimmed.		

SCORING TABLE NO. 4(a): ABSENCE OF DEFECTS - All Packs except Crushed Pineapple

Nature of Defect	Percentage of Fruit Units Affected				
	20 % or less	21 - 40 %	41 - 60 %	61 - 80 %	81 - 100 %
- D e d u c t -					
<u>White Flecks</u>					
Slight . .	0	1	2	2	3
Noticeable . .	2	3	4	4	5
Very Marked . .	4	5	6	6	7
<u>Bruises, etc.</u>					
Slight . .	1	2	2	3	3
Marked Discolouration . .	3	6	9	12	15
<u>Broken Slices</u>					
In whole-slice packs, for each slice broken into two separate pieces deduct 1 mark.					
<u>Other Blemishes</u>					
Slight . .	1	2	2	3	3
Up to 1/4" diameter . .	3	4	5	6	7
Over 1/4" " . .	5	6	8	9	11

No sample shall be graded higher than Sub-standard if any can -

(a) of slices, more than two units blemished

(b) of any other pack except crushed pineapple more than 12 1/2 % of the units are blemished for this purpose, a blemish shall include any of the following if in excess of 1/16 inch in the longest dimension on the exposed surface of the unit; Eyes, Pieces of Skin, Brown spots, Deep Fruit Eyes or Bruises or other abnormalities that it is possible to detect in good commercial practice before sealing in containers.

† See regulation 22 of these Regulations.

SCORING TABLE NO. 4 (b): ABSENCE OF DEFECTS - Crushed Pineapple

Degree of Freedom from Defects	No of Marks	Quality Grade Classification
Virtually free . . .	30	
Less than 5 per oz. and less than 1/2 % of the drained weight . . .	27	
Less than 10 per oz. and less than 1/2 % of the drained weight . . .	24	Minimum for Choice Golden.
Less than 15 per oz. and less than 1 1/4 % of the drained weight . . .	21	Minimum for Standard
Less than 20 per oz. . .	18	Minimum for Sub-standard
Less than 25 per oz. . .	9	
More than 25 per oz. . .	0	
Insects or other objectionable foreign matter	0	

SCORING TABLE NO. 5 (a): TEXTURE - All Packs except Crushed Pineapple

Nature of Texture	No. of Marks	Quality Grade Classification
All pieces tender, well-cooked and no core	10	
Near perfection and less than 1 % core	9	
Slightly too hard or too soft and less than 2% core	8	Minimum for Choice Golden
Rather too hard or soft or 20 % defective and less than 3 % core . . .	7	Minimum for Standard
Too hard or too soft but edible with up to 40 % defective and less than 4 % core	6	Minimum for Sub-Standard.
Over 40 % to 100 % defective and less than 5 % core	0-5	

SCORING TABLE NO. 5 (b): TEXTURE - Crushed Pineapple

Nature of Texture	No. of Marks	Quality Grade Classification
No core and fully mature fruit	20	
Less than 1 % core but slightly tough texture	16	Minimum for Choice Golden
Less than 2 % core but rather tough texture	15	
Less than 3 % core with texture rather tough but not immature	14	Minimum for Standard
Less than 4 % core but immature fruit	12	Minimum for Sub - standard
Less than 5 % core and too fibrous	0-8	

SCORING TABLE NO. 6: FLAVOUR - All Packs

Nature of Flavour	No. of Marks	Quality Grade Classification
Full, fresh pineapple flavour	20	
Near perfection . . .	18 - 19	
Fairly full pineapple flavour	16 - 17	Minimum for Choice Golden
Very noticeable pineapple flavour	15	
Noticeable pineapple flavour	14	Minimum for Standard
Pleasant fruity flavour	13	
Slightly fruity flavour	12	Minimum for Sub-standard
Tasteless or sweet only	8 - 11	
Off-flavour	0 - 7	