

PHILIPPINE NATIONAL STANDARD

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Flour sticks (pancit canton) – Specification



BUREAU OF PRODUCT STANDARDS

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Foreword

The Philippine National Standards for Flour Sticks (Pancit Canton) and Recommended Code of Practice for the Processing and Handling of Flour Sticks (Pancit Canton) are product standards being developed by the Commodity Working Group (CWG) composed of representatives from Department of Trade and Industry-Bureau of Product Standards (DTI-BPS), Department of Health-Bureau of Food and Drugs (DOH-BFAD), Department of Science and Technology (DOST) Testing Laboratory (Industrial Technology Development Institute-Standards and Testing Division (ITDI-STD) and Pancit Canton processors (Jeverps, Florence, Sodeska, Fitrite, Filchoice, Gem Food, Recipe Foods), with Food Processing Division (FPD-ITDI) as Secretariat.

The CWG analyzed commercial samples of the product. They visited different Pancit Canton Plants such as Florence Foods Corporation and the Festive Foods, both in Novaliches, Quezon City, 888 Food Products in Bulacan, Bulacan and Jeverps Food Products in Parañaque City. The draft Standard and Recommended Code of Practice was reviewed by the Food Standards Technical Committee (FSTC), before these were submitted to the BFAD for public consultation.

Posting at the BFAD website, www.bfad.gov.ph, of the draft standard and recommended code of practice was made to solicit comments and suggestions from different stakeholders. Public consultation workshop was conducted in Metro Manila where the product is commonly produced.

The final drafts were forwarded to the Bureau of Agriculture and Fisheries Product Standards-Department of Agriculture (BAFPS-DA) for notification by the World Trade Organization Secretariat.

The final copy was submitted to the Bureau of Product Standards-Department of Trade and Industry (BPS-DTI) for adoption.

This Standard was developed not only to serve as guide for the assurance of safety and quality but also to make the products more competitive in the local and world market.

Flour sticks (Pancit canton) – Specification

1 Scope

The standard shall apply to processed flour sticks (*pancit canton*) for human consumption as described in Section 3.

2 Definition of terms

For the purpose of this standard, the following definitions shall apply:

2.1**container**

means any form of packaging material, which completely or partially encloses the food (including wrappers). A container may enclose the food as a single item or as several units or types of prepackaged food when such is presented for sale to the consumer

2.2**current food manufacturing practices (cGMP)**

a quality assurance system aimed at ensuring that products are consistently manufactured, packed or repacked or held to a quality appropriate for the intended use. It is concerned with both manufacturing and quality control procedures

2.3**deep frying**

cooking in hot oil that is enough to keep the food entirely immersed

2.4**food**

any substance, whether processed, semi-processed or raw, which is intended for human consumption, and includes drink, chewing gum and any substance which has been used in the manufacture, preparation or treatment of "food" but does not include cosmetics or tobacco or substances used only as drugs

2.5**food additive**

refers to any substance the intended use of which results or may reasonably be expected to result, or indirectly, in its becoming a component or otherwise affecting the characteristics of any food (including any substance intended for use in producing, manufacturing, packing, processing, preparing, treating, packaging, transporting, or holding food; and including any source of radiation intended for any such use), if such substance is generally recognized, among experts qualified by scientific training and experience to evaluate its safety, as having been adequately shown through scientific procedures to be safe under the conditions of the intended use. (RA No.3720)

2.6**food standard**

is a regulatory guideline that defines the identity of a given food product (i.e. its name and the ingredients used for its preparation) and specifies the minimum quality factors and, when necessary, the required fill of the container. It may also include specific labeling requirements other than or in addition to the labeling requirements generally applicable to all prepackaged foods

2.7

free fatty acids

is the amount of fatty acids, in the product, liberated from fats or oils through hydrolysis and used as a quality indicator of hydrolytic rancidity

2.8

ingredient

any substance including food additive, used as a component in the manufacture or preparation of a food and present in the final product in its original or modified form

2.9

label

includes any tag, brand, mark, pictorial, or other descriptive script, written, printed, marked, embossed or impressed on, or attached to the container

2.10

labeling

means any written, printed or graphic matter (1) upon any article or any of its container or wrappers and/or (2) accompanying the packaged food

2.11

lot

food produced during a period of time and under more or less the same manufacturing conditions indicated by a specific code

2.12

moisture content - the percentage weight of water in relation to the dry weight of the product.

2.13

packaging

is the process of packing in a protective container, as part of the production cycle, applied to a bulk product to obtain the finished product. It consists of any material, including painted material, employed in the packaging of a product including any outer packaging used for transportation and distribution. Packaging materials may either be primary or secondary depending on whether they are or not in direct contact with the food product itself

2.14

processed food

shall refer to foods that have been subjected to some degree of processing (e.g. milling, drying, freezing, concentration and canning, etc), which partially or completely change the physico-chemical and/or sensory characteristics of the raw material

2.15

potable water

water fit for human consumption and in which potability has been determined by health authorities cited in the Philippine National Standards for drinking water (PNS 991:1993 Agricultural and Other Food Products – Bottled Drinking Water Specifications)

3 Description

3.1 Product definition

Flour sticks or '*pancit canton*' are molded and fried noodle strands, which can be consumed with or without prior cooking preparation, made from wheat flour, singly or in combination with other flours and/or starches, water and salt with or without added optional ingredients.

3.2 Process definition

Flour sticks or '*pancit canton*' are prepared from a dough that is formed into sheets, cut into strands, blanched, washed in water and molded into nest-like forms and deep fried in oil.

4 Essential composition and quality factors

4.1 Ingredients

4.1.1 Basic ingredients

- a. **Wheat flour** - shall be prepackaged fortified wheat flour, fit for human consumption as per RA 8976 or the Philippine Food Fortification Act of 2000.
- b. **Potable water** - water fit for human consumption and meets the potability requirements cited in Philippine National Standards for Drinking Water or the A.O. No. 18A, s. 1993 or the Regulation on Bottled Drinking Water
- c. **Salt** - shall be of food grade quality and meets the purity requirements of standards for iodized salt as per R.A. No. 8172 or An Act Promoting Salt Iodization Nationwide and for Related Purposes.
- d. **Cooking oil** - shall be fortified edible, refined vegetable oil as per RA 8976 or the Philippine Food Fortification Act of 2000.

4.1.2 Optional ingredients

All other ingredients used shall be of food grade quality and conform to all applicable standards, which may include, but not limited to the following:

- a. other flours and starches
- b. fresh eggs or egg powder;
- c. fresh or powdered fruits and vegetables; and
- d. seasonings and condiments

4.2 Quality criteria

4.2.1 General requirements

Flour sticks or '*pancit canton*' shall conform to the following characteristics:

a. Moisture content

The product shall have moisture content not greater than 8 %.

b. Free fatty acids

The % free fatty acid of the fat content shall not be greater than 0.5 % (as oleic acid).

c. Sensory properties

The product shall have a uniform size of noodle strands with acceptable color, no rancid odor and taste and crispy texture.

5 Types of defects

The sample unit shall be considered defective when it exhibits any of the defects as defined and prescribed below.

5.1 Foreign matters

The presence in the sample unit of any matter which: has not been derived from the components or constituents of ingredients used in the product and listed in subsection 4.1; does not pose a threat to human health and can be recognized without magnification or is present at a level determined by any method including magnification that indicates non-compliance with good manufacturing and sanitation practices.

5.2 Appearance

- a. Brownish or blackish specks or discoloration that affects more than 5% of the sample unit.
- b. Loose or broken noodle strands present in weights more than 5% of the weight of the sample unit after manufacture.

5.3 Odor and flavor

- a. Objectionable odor and flavor indicative of deterioration or contamination (like rancidity, fermentation or taints) on uncooked and cooked noodles
- b. Pronounced burnt odor on uncooked and cooked noodles.

5.4 Classification of “defectives”

A container whose contents exceed the limits of any of the type of defects set in subsections 5.1 to 5.3 shall be considered as “defective”.

5.5 Lot acceptance

A lot shall be considered acceptable when it complies with the applicable quality parameters as prescribed in Sub-section 4.2.1 and the number of “defectives”, as defined in Sub-section 5.4, does not exceed the acceptance number of the appropriate sampling plan.

6 Food additives

6.1 Food additives when used shall be in accordance with the regulations established by the Bureau of Food and Drugs (BFAD) (Bureau Circular No. 016, s.2006. Updated List of Food Additives) and/or the Codex Alimentarius Commission. The food additives listed in Table 1, but not limited to, may be used for the manufacture of Flour Sticks or ‘Pancit Canton’.

Table 1 – Food additives for flour sticks or 'pancit canton' as per BFAD Bureau Circular No. 016 s. 2006. (Updated List of Food Additives)*

Food additive	Maximum use level
a. Acidity regulator	
Sodium hydroxide **	GMP
b. Antioxidant	
Butylated Hydroxyanisole (BHA)**	100mg/kg
Butylated Hydroxytoluene (BHT)**	200 mg/kg
Tocopherol*	GMP
c. Color	
FD&C Yellow # 5 (Tartrazine) **	300 mg/kg
FD&C Yellow # 6 (Sunset Yellow) ***	300 mg/kg
d. Flour treatment agent	
Phosphates (as sodium or potassium phosphates)**	2,200 mg/kg
e. Raising agent/stabilizer	
Sodium carbonate***	2,600 mg/kg
Potassium carbonate***	2,600 mg/kg
* Based on the Food Category System: ** 06.2 - Flours and starches *** 06.4.2 - Pre-cooked or dried pastas and noodles and like products	

6.2 Others

All others not included in the above list shall be allowed as carry-over, provided they are approved by the BFAD regulation and shall be in accordance to Section 5.2 of the "Principle Relating to the Carry-Over of Food Additives into Foods" (CAC/Volume 1 1991).

7 Hygiene

7.1 The product covered by the provisions of this standard shall be prepared and handled in accordance with the appropriate sections of the Recommended International Code of Practice – General Principles of Food Hygiene (CAC/RCP 1 – 1969, Rev. 4-2003) and/or the A.O. No. 153 s. 2004 – Guidelines on the Current Good Manufacturing Practices in Manufacturing, Packing, Repacking or Holding Food and processed according to the Recommended Code of Practice for the Processing of Flour Sticks (*Pancit Canton*) (PNS 19:2008).

7.2 When tested by appropriate methods of sampling and examination, the product:

- a. shall be free from filth that may pose a hazard to health;
- b. shall be free from parasites which may represent a hazard to health;

- c. shall not contain any substance originating from microorganisms in amounts which may represent a hazard to health; and
- d. shall be free from spoilage or pathogenic microorganisms capable of survival and multiplication under normal conditions of storage.

8 Packaging and labeling

8.1 Retail packs in primary packaging shall contain one (1) or more pieces of molded noodles. Bulk packed products in secondary packaging materials such as shipping cartons and plastic bags may contain 2 or more pieces of retail packs.

8.2 The product shall be packed in suitable hygienic primary and secondary packages that will maintain its quality during storage and transport.

8.3 The average net weight of the sample unit may exceed the declared net weight; however, no individual package shall be less than 95% of the declared net weight. (Bureau Circular No. 6A, s. 1998 Subject: Permissible Net Content Variation in Pre-packaged Food).

8.4 Labeling of retail packages/container

Each retail container shall be labeled and marked with the information in accordance with current BFAD Labeling Regulations and shall contain the following information:

- a. The name of the product. The name of the product shall be "Flour Sticks" or "Pancit Canton". The product may be called by other common names like: "Wheat Flour Sticks", "Wheat Noodles", "Wheat Flour Noodles", "C(K)anton Noodles" or "*Panc(s)it* C(K)anton Noodles", provided such name is accepted in the country of distribution.
- b. The name and the address of either the manufacturer, packer, distributor, importer, exporter or vendor of the food.
- c. The complete list of ingredients and food additives used in the preparation of the product in descending order of proportion.
- d. The net content by weight in the metric system. Other systems of measurement required by importing countries shall appear in parenthesis after the metric system unit.
- e. The words "Best/Consume Before"/"Use by date" indicating end of period at which the product shall retain its optimum quality attributes at defined storage conditions.
- f. Lot identification marked in code identifying product lot.
- g. The words "Product of the Philippines" or similar expressions, or the country of origin if imported.
- h. Additional requirements

A pictorial representation of the product(s) on the label should not mislead the consumer with respect to the product so illustrated.

8.5 Labeling of non-retail, bulk containers

The name of the product, lot identification code and the name and address of the manufacturer or packer shall appear in the container. However, the name and address of the manufacturer may be replaced by identification marks provided that such mark is clearly identified with accompanying documents.

8.6 Nutrition labeling

Nutrition labeling shall conform to established regulations by the BFAD.

9 Method of sampling and analysis

9.1 Method of sampling

Sampling shall be in accordance with the FAO/WHO Codex Alimentarius Sampling Plans for Prepackaged Foods - CAC/RM 42-1969).

9.2 Methods of analyses

9.1.1 Determination of Moisture Content

According to the method of AOAC (2005, 18th Edition) using the Oven Method.

9.2.2 Determination of free fatty acids (FFA)

According to the method of AOAC (2005, 18th Edition) using the Titrimetric Method.

9.2.3 Determination of net weight

According to the procedure described in Annex C - Determination of Net Weight.

Annex A

Standard parameters and values for drinking water

Table A.1 – Standard values for bacteriological quality

Source and mode of supply	Bacteria	Standard value (no./100mL)
a. All drinking water supplies under all circumstances (Level I, II, III bottled water and emergency water supplies)	<i>E.coli</i> or thermotolerant (fecal) coliform bacteria	0
b. Treated water entering the distribution system	<i>E.coli</i> or thermotolerant (fecal) coliform bacteria	0
c. Treated water in the distribution system	<i>E.coli</i> or thermotolerant (fecal) coliform bacteria	0
	Total coliforms	Must not be detectable in any 100 mL sample. In case of large quantities where sufficient samples were examined, it must not be present in 95% of samples taken throughout any 12-month period.

Table A.2 – Standard value for biological organisms for drinking water

Constituent	Permissible Limit
Total count/ml	10

Table A.3 – Standard values for physical and chemical quality: aesthetic quality

Constituent maximum or characteristics	Level (mg/L)
Taste	Unobjectionable
Odor	Unobjectionable
Color	5 TCU
Turbidity	5 NTU
Aluminum	0.2
Chloride	250
Copper	1
Hardness	300 (as CaCO ₃)
Hydrogen sulfide	0.05
Iron	1
Manganese	0.5
pH	6.5 – 8.5
Sodium	200
Sulfate	250
Total dissolved solids	500
Zinc	5

(Sec.2 Philippine National Standards for Drinking Water, Department of Health, Manila.)

Annex B

Standard for iodized salt

B.1 Scope

This standard applies to iodized salt used as condiment or an ingredient in the preparation of food in households, food service and food manufacturing establishments.

B.2 Description

Iodized salt is food grade salt that contains the prescribed level of iodine. It shall be produced refined or unrefined (crude) salt obtained from underground rock salt deposits or by evaporation of seawater or natural brine. The finished product shall be in the form of solid crystal or powder, white in color, without visible spots of clay, sand, gravel or other foreign matter.

B.3 Iodization process

B.3.1 Salt may be iodized with potassium iodate (KIO_3) or potassium iodide (KI) by means of any of the following methods:

- a) dry mixing of salt in powdered form
- b) dip feeding or spray mixing if salt is in crystal form
- c) submersion of ice crystals in iodated brine

B.4 Essential composition and quality factors

To ensure the stability of iodine, salt to be iodized must conform with the following quality requirements:

Moisture, minimum	4 % for refined salt 7 % for unrefined salt
NaCl minimum	97 % dry basis
Calcium and magnesium, maximum	2 %
Water insolubles, maximum	0.2 %
Heavy metal contaminants	
Arsenic as As	0.5 mg/kg
Cadmium as Cd	0.5 mg/kg
Lead as Pb	2.0 mg/kg
Mercury as Hg	0.1 mg/kg

B.4.1 Naturally present secondary products and contaminants in raw salt

Notwithstanding the purity requirements in 4.1. the raw salt may contain naturally secondary product, which are present in varying amounts depending on the origin and method of production of salt, and which are composed mainly of calcium, potassium, magnesium and sodium sulphates, carbonates, bromides and of calcium, potassium chlorides as well as natural contaminant may also be present in amounts varying with the origin and method of production of the salt.

B.5 Labeling

B.5.1 Iodized salt for commercial distribution shall carry appropriate labeling in accordance with BFAD rules and regulations on labeling of prepackaged foods. Specifically, the following information shall be declared in every container of iodized salt whether in bulk or retail package.

B.5.1.1 For locally produced iodized salt

- a) The name of the product, "IODIZED SALT", printed in bold capital letters
- a) Name and address of manufacturer
- b) Net weight
- c) Iodine compound used
- d) Chemical additives, e.g. anti-caking agents, emulsifiers
- e) Open date marking, e.g. "Best Before" or "Consume Before" Date
- f) Lot identification code (replacers must use manufacturer's lot identification code)
- g) Storage Instruction: STORE IN COOL DRY PLACE

B.5.1.2 For imported Iodized salt

- a) same as 5.1.1 (a), (c) to (h)
- b) Name and address of Importer/Local Distributor
- c) Country of Origin

B.5.2 Labeling of non-retail containers

In the case of non-retail containers of at least 25 kg of iodized salt, the labeling information required in sections 5.1.1. (b), (d) or in 5.1.2 (b) may not be declared if such bulk packages are intended for delivery to distributors of food manufacturers/institutional users, provided every shipment or delivery is accompanied by a document containing all information in 5.1.1. or 5.1.2.

B.5.3 Iodine levels based on WHO recommendation

In order to meet national needs, the prescribed levels of iodized salt be indicated follows:

	Type of container	Packages
Sampling point	Bulk (>2 kg)	Retail (<2 kg)
Production site	70-150 g/kg	60-100 mg/kg
Port of entry*	70-150 mg/kg	60-100 mg/kg
Retail site	> 50 mg/kg	> 40 mg/kg
* For imported iodized salt, also at importer's/distributor warehouse.		

B.6 Food additives

B.6.1 All additives used, including KIO and KI, and shall be of food grade quality and shall conform to the specifications prescribed by JECFA of the Food Chemicals Codex.

B.6.1.1 Anti-caking agents	Maximum level in the final product
B.6.1.1.1 Coating agents; Carbonate.)	
Calcium/magnesium, Magnesium oxide;)	20 g/kg singly or in
Phosphate, Tricalcium; Silicon dioxide,)	Combination
amorphous; Silicates, calcium , magnesium,)	
sodium alumino or soduim or sodium calcium)	
alumino)	
 B.6..1.1.2 Coating hydrophobic agents,)	
aluminum, calcium, magnesium, potassium or)	
sodium salts of myristic, palmitic or stearic acid)	
)	
B.6.1.1.3 Crystal modifiers: ferrocyanide,)	10 mg/kg singly or in
calcium, potassium combination or sodium)	combination,
)	expressed as {Fe(CN)}
 B.6.1.2 Emulsifiers polysorbate 80	10 mg/kg
 B.6.1.3 Processing aid dimethylpolysiloxane)	10 mg of residue/kg
)	

B.7 Packaging

All iodized salt shall be packed in woven propylene bags, clean and unused jute bags, or other non-porous material with a lining of high density polyethylene to ensure the retention of appropriate iodine level at the time of consumption.

B.8 Storage, transport and display at retail

In order to minimize avoidable losses of iodine, iodized salt shall not be exposed to any of the following conditions during storage, transport and display at retail outlets:

- a) direct sunlight or near source of strong light
- b) high temperature and humidity
- c) contamination with moisture, e.g. ran, flood, etc.
- d) contamination with dust or filth from the environment

Reference: Republic Act No. 8172: An Act Promoting Salt Iodization Nationwide and for Related Purposes and Its Implementing Rules and Regulations. Published by the National Nutrition Council, 1996.

Annex C

Determination of net weight

C.1 Apparatus

Weighing balance (sensitivity: 0.10 gram)

C.2 Procedure

C.2.1 Weigh the sample unit on its original sample packed container. This is the gross weight.

C.2.2 Open and transfer the contents of each individual package. Wash the empty package and blot dry.

C.2.3 Weigh out the washed empty package. This is the weight of the packaging material.

C.2.4 Subtract the weight of the empty package from the gross weight. The resulting figure is the net weight of the individual package (net weight = gross weight – weight of packaging).

C.2.5 Average the results from all package of a sample representing a lot. Report result as the average net weight of the product.

Annex D

**Codex Alimentarius Sampling plans for prepackaged foods (AQL 6.5)
(CAC/RM 42-1969)**

**Sampling plan no. 1 – Normal operations
Inspection level 1, AQL 6.5)**

1. Net weight: ≤ 1 kg

Lot size (N)	Sample size	Acceptance number (C)
4,800 or less	6	1
4,801 – 24,000	13	2
24,001 – 48,000	21	3
48,001 – 84,000	29	4
94,001 – 144,000	48	6
144,001 – 240,000	84	9
More than 240,000	126	13

2. Net weight: >1 kg ≥ 4.5 kg

Lot size (N)	Sample size	Acceptance number (C)
2,400 or less	6	1
2,401 – 15,000	13	2
15,001 – 24,000	21	3
24,001 – 42,000	29	4
42,001 – 72,000	48	6
72,001 – 120,000	84	9
More than 120,000	126	12

3. Net weight > 4.5kg

Lot size (N)	Sample size	Acceptance number (C)
600 or less	1	1
601 – 2,000	13	2
2,001 – 7,200	21	3
7,201 – 15,000	29	4
15,001 – 24,000	48	6
24,001 – 42,000	84	9
More than 42,000	126	13

**Sampling plan no. 2 – In case of disputes
Inspection level 2, AQL 6.5)**

1. Net weight: ≥ 1 kg

Lot size (N)	Sample size	Acceptance number (C)
4,800 or less	13	2
4,801 – 24,000	21	3
24,001 – 48,000	29	4
48,001 – 84,000	48	6
94,001 – 144,000	84	9
144,001 – 240,000	126	13
More than 240,000	200	19

2. Net weight: >1 kg ≥ 4.5 kg

Lot size (N)	Sample size	Acceptance number (C)
2,400 or less	13	2
2,401 – 15,000	21	3
15,001 – 24,000	29	4
24,001 – 42,000	48	6
42,001 – 72,000	84	9
72,001 – 120,000	126	13
More than 120,000	200	19

3. Net weight > 4.5 kg

Lot size (N)	Sample size	Acceptance number (C)
600 or less	13	2
601 – 2,000	21	3
2,001 – 7,200	29	4
7,201 – 15,000	48	6
15,001 – 24,000	84	9
24,001 – 42,000	126	13
More than 42,000	200	19

Source: Codex Alimentarius Sampling Plans for Prepackaged Foods - CAC/RM 42-1969, Codex Alimentarius Volume 13.

References

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The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

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B P S

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The use of the PS Certification Mark is governed by the provisions of Department Administrative Order No. 01 series of 1997 – Revised Rules and Regulations Concerning the Philippine Standard (PS) Quality and / or Safety Certification Mark Scheme by the Bureau of Product Standards. This mark on a product/container is an assurance by the manufacturer/producer that the product conforms with the requirements of a Philippine standard. Details of conditions under which a license to use the PS Certification Mark may be granted can be obtained from the Bureau of Product Standards, Department of Trade and Industry, 361 Sen. Gil J. Puyat Avenue, Makati City.



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