



## Technical Specifications for

### HALVA/HALWA TEHENIA

Version: 1

Replacing: Ration Specification V2

Date of issue: 25 June 2021

The key changes are:  
Provide more detailed product requirements (e.g. raw materials, processing)

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#### 1. Introduction

This specification applies to **HALVA**, also called **HALWA TEHENIA** (hereafter called the product) distributed by WFP.

“Halwa Tehenia” designates a heat-processed food product made of tahina, natural sugars and other ingredients with the composition provided for in Section 3. Its texture is consistent or crumbly (Fibrous Halwa). Tahina is food product made by grinding peeled and roasted sesame seeds.

#### 2. Standards and references

Except when specified otherwise in the contract, the product shall comply with latest versions of recognized international standards and best practices and/or guidelines such as:

- CODEX GENERAL PRINCIPLES OF FOOD HYGIENE INCLUDING ANNEX “HAZARD ANALYSIS AND CRITICAL CONTROL POINT (HACCP) SYSTEM AND GUIDELINES FOR ITS APPLICATION” (CXC 1-1969)
- CODEX GENERAL PRINCIPLES FOR ADDITION OF ESSENTIAL NUTRIENTS TO FOODS (CXG 9-1987)
- CODEX GENERAL STANDARD FOR CONTAMINANTS AND TOXINS IN FOOD AND FEED (CXS 193- 1995)
- CODEX GENERAL STANDARD FOR FOOD ADDITIVES (CXS 192-1995)
- CODEX GENERAL STANDARD FOR THE LABELLING OF PREPACKED FOODS (CXS 1-1985)
- CXS 309R-2011 - REGIONAL STANDARD FOR HALWA TEHENIA
- CODEX GUIDELINES FOR THE USE OF FLAVOURINGS (CAC/GL 66-2008)

Additionally, the supplier shall comply with relevant local regulations/standards of the food originating and recipient countries.

#### 3. RAW MATERIALS

Product shall be manufactured from ingredients that are fresh, of good quality, free from foreign materials and substances hazardous to health, that comply with Codex Alimentarius and relevant food laws and standards of the originating and recipient countries. The quality of raw materials should be adequate so that the final product will meet all requirements specified in this document.

The raw materials can include tahina, natural sugars, soapwort extract or authorized substitutes, almonds, pistachios, walnuts, dried fruits and/or cocoa powder.

#### 4. PROCESSING

##### 4.1 Food safety and risk assessment at manufacturing premises

For compliance with Codex standards, the processor shall be able to demonstrate by principle and practice the adoption, implementation and recording of:

- Good Manufacturing Practice
- Hazard Analysis Critical Control Point program
- Global Food Safety Initiative (GFSI) scheme

In this context an appointed WFP staff/ WFP appointed Inspector / Quality Surveyor is entitled to visit the factory without prior notice during any period when WFP product is being manufactured to check that production is done as per WFP contract specification. The Inspector / Quality Surveyor may request to see:

- **Records** (i.e. names of people in charge of the process and quality control, temperatures of the process, mixing times / net contents, cleaning schedules, CCP monitoring, traceability etc.).
- **Procedures** (e.g. cleaning, personnel hygiene, risk assessment and HACCP, environmental monitoring programme, sampling & analysis, product release and control of non-conformance etc.).
- **Instructions** (e.g. process instructions, cleaning instructions, zoning instructions etc.).
- The **quality manual** for the process or factory.
- Conditions in the factory (process rooms, warehouses, laboratories, cloakrooms, factory grounds, utility rooms, etc.)

## 5. Product Specifications

### 5.1 General requirements

The product shall comply with requirements stated in Table 2 of this document. Additionally, the sesame oil shall be minimum 25% (m/m) of the product.

### 5.2 Contaminants

The product shall be free from contaminants in amounts which may represent a hazard to health. The product shall comply with those maximum contaminant limits established by the Codex Alimentarius for this commodity. This includes compliance with Codex General Standard for Contaminants and Toxins in Food and Feed (CXS 193-1995) and Codex Maximum Residue Limits for pesticide residues. Additionally, the product shall meet the requirements stated in Table 2.

### 5.3 Hygiene

It is recommended that the products covered by the provisions of this standard 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), and other Codes of Practice recommended by the Codex Alimentarius Commission which are relevant to these products. To the extent possible in good manufacturing practice, the products shall be free from objectionable matter. When tested by appropriate methods of sampling and examination, the product:

- shall be free from micro-organisms in amounts which may represent a hazard to health;
- shall be free from parasites which may represent a hazard to health; and
- shall not contain any substance originating from micro-organisms in amounts which may represent a hazard to health.

### 5.4 Shelf life

As per contract

### 5.5 Fit for human consumption guarantee

Suppliers shall have to check the quality of their products and guarantee that the product is 'fit for human consumption'.

## 6. Packaging

The products covered by the provisions of this specification must be packed in appropriate packaging which safeguard the hygienic, nutritional, technological, and organoleptic qualities of the product, and fit for storage and multiple handling. primary packaging must be food grade and comply with general requirements stated in the contract.

## 7. Marking

As per contract. Labels of package and carton must be approved by WFP.

The labelling of the product shall comply with Codex General Standard For The Labelling Of Prepacked Foods (CXS 1-1985).

## 8. Stuffing of Containers and other transport vehicles<sup>1</sup>

If pallets<sup>2</sup> are used for transportation : it is highly recommended to have 3 first bottom layers placed as column stacking, the rest can be interlocked (cross-stacking) for load stability. Pallet shall be wrapped in a suitable manner (locked to the pallet, enough containment force) and the cartons should be banded when necessary. The cartons shall be secured to pallets in order to prevent any damage to the contents or packaging during transport. Pallet used should be strong enough to support the charge during transportation. Pallets shall be stackable (minimum double stock) without damage to the cartons during shipment. The pallets are recommended to be heat treated as per ISPM 15 standards (methyl bromide fumigation is not allowed).

If no pallets are used for transportation: dunnage (of strong sheets such as carton, plywood...) should be placed inside each container/vehicle at every three layers of cartons to provide the required stacking strength. In addition, protecting material like air bag, carton, polystyrene, can be used. Also, kraft paper shall be adhered to all internal sides, door, and floor of container. Kraft paper also need to be placed on the top of packaging.

For transportation, unless fully shrink-wrapped pallets are used, and unless otherwise specified in the contract, it is highly recommended to place desiccant at appropriate location in order to absorb moisture.

Supplier needs to use high quality desiccant and calculate the quantity of desiccant based on:

- Efficiency of desiccant
- Length of time in transit in container
- Container capacity

Supplier needs to provide in the offer the type of desiccant and quantity to be used for the consignment.

The following table provides a guideline on the quantity to be used:

*Table 1: Guideline on the quantity to be used for calcium chloride-based desiccants:*

<b>Estimated days in container</b>	<b>20 ft container</b>	<b>40 ft container</b>
15-59 days	9.00 kg	17.50 kg
60-89 days	11.25 kg	22.50 kg
90-120 days	13.50 kg	25.00 kg

<sup>1</sup>For more details, please refer to container loading procedure:

[https://documents.wfp.org/stellent/groups/public/documents/manual\\_guide\\_proced/wfp254688.pdf](https://documents.wfp.org/stellent/groups/public/documents/manual_guide_proced/wfp254688.pdf)

<sup>2</sup> Slip sheet can be used instead of pallets upon agreement with WFP.

Better alternative material can be used upon agreement with WFP.

Empty containers/vehicles shall be clean, pest free and free of damage, odours and previous cargo remains. Ventilation holes shall remain clear and unsealed.

## 9. Storing

The product shall be stored under dry, ventilated and hygienic conditions and away from direct sunlight.

## 10. Analytical Requirements

As per contractual agreement, WFP can appoint an inspection company to check that the food matches requirements of this specification. Analytical tests in table 2 are usually utilized, and additional tests might be performed. Suppliers shall follow its own food safety and quality management plan. WFP reserves the rights to change the testing plan at any time.

Table 2: List of compulsory tests and reference method

No	Tests	Requirements	Reference methods (or equivalent; Latest version)
1	Foreign matter	free from impurities, foreign bodies, pathogens and insects and its parts	Visual examination
2	Smell and Taste	acceptable smell and taste free of molds	Organoleptic examination
3	Characteristics	homogenous crumply texture and easily cut	Visual examination
4	Color	White (slight yellow color is acceptable as well)	Visual examination
5	Moisture	Max. 3.0 %, m/m	AOAC 925.10
6	Total ash	Max. 2.0 %, m/m	ISO 2171
7	Acid insoluble ash	Max. 0.2 %, m/m	ISO 5985
8	Fat	Max. 28.0 %, m/m	AOAC 996.06
9	Total sugar (Glucose Syrup)	Max. 55.0 %, m/m	NEN 3571
10	Saponin	Max. 1.0 %, m/m	HPLC method
11	Zn	Max. 55 mg/kg	AOAC 999.1
12	Mg	Max. 2750 mg/kg	AOAC 974.27
13	Al	Max. 65 mg/kg	J AOAC Int. 2001 Jul-Aug;84(4):1187-93. or ISO 12020
14	Tin	Max. 0 mg/kg	
15	As	Max. 1 mg/kg	AOAC 973.78
16	Pb	Max. 5 mg/kg	AOAC 999.1
17	Cu	Max. 20 mg/kg	AOAC 999.1
18	Staphylococcus aureus	Max. 10 cfu/g	ISO 6888-1, 2, 3
19	Salmonella	Absent in 25g	ISO 6579