Wiskerchen Cheese Inc. SOP	
Title: Cellulose Addition Procedures	# 2.013

Issue Date: 7/20/09	Written By: Thomas Wiskerchen	Approved By: John Wiskerchen	Revision # New	Revision Date:	Revised By:	Supersedes:	Page 1 of 2

Purpose: To ensure Wiskerchen Cheese Inc., is not exceeding the allowable percentage of added cellulose to products.

Scope: Cover the methods used to ensure that cheese products with an allowable added cellulose specification does not receive more than the allowed percentage of added cellulose.

Responsibility: Milling employees

Background:
The cellulose hopper attached to the top of the mill was designed to only hold a volume of 28 liters. One liter of cellulose (packed firmly) weights 12 oz. This would allow for 21 lbs of firmly packed cellulose to be filled into the hopper. However, the hopper will not dispense cellulose unless it is loosely filled in the hopper. One liter of loosely filled cellulose weights 6 oz. This only allows for 11 lbs of cellulose to be filled into the hopper.

A milled tub of cheese typically weights from 1100 lbs to 1200 lbs.

Procedure for customers allowing up to 1% added cellulose:

1. Each tub of milled cheese may receive up to one full hopper worth of cellulose.
2. Prior to starting a new tub the empty cellulose hopper shall be loosely filled with cellulose (about 6 scoops).
3. During milling, the vibration of the hopper shall be regulated by the milling employee such that the cellulose hopper provides an even application of cellulose to the cheese in the tub based on the wetness of the crumbled product.
4. The milling employee may apply less than a full hopper worth of cellulose to the tub of crumbled product if product wetness is low.
5. The milling employee is not allowed to exceed 1 full hopper worth of cellulose.

Procedure for customers allowing up to 2.5% added cellulose:

1. Each tub of milled cheese may receive up to two full hoppers worth of cellulose.
2. Prior to starting a new tub the empty cellulose hopper shall be loosely filled with cellulose (about 6 scoops).
3. During milling, the vibration of the hopper shall be regulated by the milling employee such that the cellulose hopper provides an even application of cellulose to the cheese in the tub based on the wetness of the crumbled product.
4. The milling employee may apply less than a full hopper worth of cellulose to the tub of crumbled product if product wetness is low.
5. The milling employee is not allowed to exceed 2 full hoppers worth of cellulose.

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Procedure for customers with no upper limit for added cellulose:

1. Prior to starting a new tub the empty cellulose hopper shall be loosely filled with cellulose (about 6 scoops).
2. During milling, the vibration of the hopper shall be regulated by the milling employee such that the cellulose hopper provides an even application of cellulose to the cheese in the tub based on the wetness of the crumbled product.
3. The milling employee may apply less than a full hopper worth of cellulose to the tub of crumbled product if product wetness is low.

Procedure for cellulose application on crumbled feta and goat cheese:

1. Prior to starting a new tub the milling employee will lightly dust the interior of the milling tub with cellulose (1 scoop).
2. During milling the milling employee will add cellulose to the product based on the wetness of the crumbled product.
3. Product will be turned occasionally using the stainless steel forks to provide even coverage of the wet crumbles.

Approved By: _____ Date: _____