

MANGOEARTH EXPORTS LLP

SPECIFICATION FOR FINISHED PRODUCT

ASEPTIC PAPAYA PULP

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Product Description

Aseptic Papaya Pulp/Puree is extracted from sound, mature, ripe papayas (red/yellow flesh). Fruit is inspected, washed with disinfectant, and sorted for ripeness and quality. Sorted fruit is de-seeded and the pulp is extracted, refined to remove fibre and foreign matter, standardized for Brix/acidity, homogenized and de-aerated. The pulp is then thermally processed via PLC-controlled pasteurization and aseptically filled under aseptic conditions, packed in lacquered tins or poly-lined MS drums, and passed through 100% metal detection. Available Natural (no added sugar) or sweetened. Overall processing is carried out by maintaining strictly hygienic conditions throughout the processing line.

Variety	Red / Yellow flesh Papaya
Botanical Name	Carica papaya

Organoleptic Parameters

Color	Yellow to orange-red
Taste & Flavour	Natural, mild, characteristic ripe papaya, free from off-flavour
Texture	Smooth, homogeneous puree
Appearance	Homogeneous, free from foreign matter

Physico-Chemical Parameters

Parameter	Natural	Sweetened
Ingredients	100% papaya pulp — no added sugar, water or preservative	Min. 90% papaya pulp; Sugar, Water, Citric Acid (E330) added
Brix (°Bx at 20°C)	8.0 – 11.0 (target 9.0)	11.0 – 14.0 (target 12.0)
Acidity (as citric acid)	0.40 – 0.60% (target 0.50%)	0.40 – 0.60% (target 0.50%, incl. added citric acid)
pH	4.50 – 5.50 (low-acid product)	4.30 – 5.30 (low-acid product)
Consistency (Bostwick, 20±2°C)	05 – 12 cm / 30 sec	05 – 12 cm / 30 sec

Sweetened Brix is standardized higher via added sugar syrup, consistent with verified commercial pulp formulations (typically 90–97% fruit content with added sugar, water and citric acid). Acidity is maintained via added citric acid as a permitted acidity regulator; confirm exact target with your processor's formulation.

Microbial Parameters

Ref: ICMSF — International Commission on Microbiological Specifications for Foods

Parameters	Method	UOM
Total Plate Count	100/g	cfu/gm
Coliforms	10/g	cfu/gm
E. coli	Absent	cfu/gm
Yeast and Moulds	10/g	cfu/gm
Staphylococcus aureus	Absent	cfu/gm
Listeria monocytogenes	Absent/25g	cfu/gm
Salmonella	Absent/25g	cfu/gm

Storage and Transportation

Store at ambient temperature, in a cool, dry place, not below 4°C. Avoid exposure to high temperature, humidity and direct sunlight. Aseptic pulp is shelf-stable at ambient condition and does not require refrigerated/reefer storage or transport, unlike frozen products.

Packing and Loadability

Available across four pack formats — 450 g, 850 g and 3.1 kg lacquered tins (retail/foodservice), and 215 kg aseptic drum (bulk) each offered Natural or Sweetened.

	450g Tin	850g Tin	3.1kg Tin	215kg Drum
Net weight per unit (kg)	0.45	0.85	3.10	215.00
Units per carton / drum	24.00	12.00	6.00	1.00
Carton / drum net wt (kg)	10.80	10.20	18.60	215.00
Approx. per 20' FCL	1,700.00	1,800.00	1,000.00	80.00
Approx. per 40' FCL	2,450.00	2,600.00	1,400.00	115.00

Pack sizes confirmed as established standards across UAE, Saudi Arabia, UK, Netherlands, USA and Australia retail and foodservice channels (e.g. Kiril Mischeff, KTC, TRS, Natco, Deep, Rani, Ashoka — 850g and 3.1kg are the two dominant tin sizes; 450g is a confirmed smaller retail format; 215kg aseptic drum is the industry-standard bulk export unit).

Loading Quantity

Container	Configuration	Loading Quantity (indicative)
20' Standard Container	850g tins, without pallets	1,800 cartons × 10.20 kg ≈ 18,360 kg per 20' container
20' Standard Container	215 kg drums, without pallets	80 drums × 215 kg ≈ 17,200 kg per 20' container
40' Standard Container	215 kg drums, without pallets	≈115 drums × 215 kg ≈ 24,725 kg per 40' container

Loading figures are weight-limited, indicative planning benchmarks per pack format — confirm exact carton/drum counts with your CHA/forwarder before quoting. 215kg drum loading (80/20') is consistent with published processor technical data sheets.

Shelf Life

18 months from date of manufacture. Store at ambient temperature, in a cool, dry place, away from direct sunlight.

Quality & Compliance

ALLERGEN • FACILITY CERTIFICATIONS • EXPORTER REGISTRATIONS

Allergen status: Free from the 14 major allergens under EU Regulation 1169/2011 and FDA 21 CFR (cereals containing gluten, crustaceans, eggs, fish, peanuts, soybeans, milk, tree nuts, celery, mustard, sesame, sulphur dioxide & sulphites, lupin, molluscs).

Manufacturing Facility Certifications:

Important: The following certifications and registrations relate to the applicable partner processing/manufacturing facilities. They are not certifications owned by Mangoeearth Exports LLP.

Sourced from FSSC 22000 / SGF / Halal / Kosher-certified partner processing facilities, holding FSSAI and USFDA registration and SEDEX membership. Certificate of Analysis issued per batch.

Exporter registrations (Mangoeearth Exports LLP): IEC ACFFM2045J · APEDA RCMC 32429/2026-2027 ·

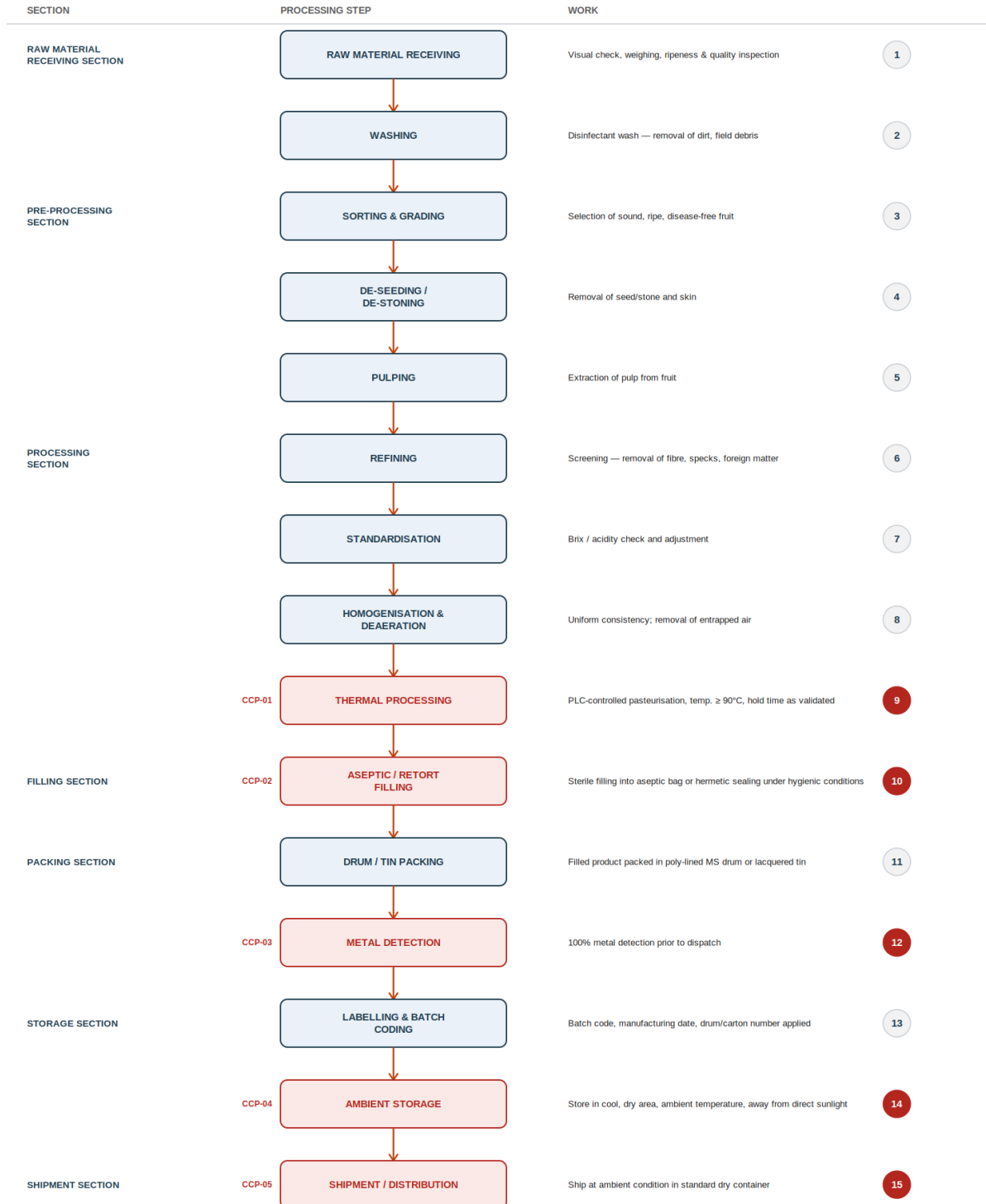
This specification reflects the standard process and typical parameters of our certified partner processing facility. Values may vary slightly by crop season; the binding specification is the buyer-approved spec sheet with a Certificate of Analysis issued per batch. Mangoeearth Exports LLP is a merchant exporter; production and facility certifications belong to the manufacturing facility.

Flow Chart — Aseptic Papaya Pulp *Critical Control Points (CCP-01 to CCP-05) are highlighted in red — thermal processing, aseptic/retort filling, metal detection, ambient storage and shipment/distribution.*

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Process Flow Chart — Aseptic Fruit Pulp

ISSUE 01



○ Standard processing step

● Critical Control Point (CCP)

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