

**PS: 383-2003**  
**(ICS No. 67.060)**

**PAKISTAN STANDARD**  
**SPECIFICATION**  
**FOR**  
**BISCUITS (EXCLUDING WAFER BISCUITS)**  
**(2<sup>ND</sup> REV.)**



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**PAKISTAN STANDARDS AND QUALITY CONTROL AUTHORITY**  
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PAKISTAN STANDARD SPECIFICATION  
FOR  
BISCUITS (EXCLUDING WAFER BISCUITS (2<sup>ND</sup> REVISION))

0. FOREWORD

- 0.1 This Pakistan Standard Specification was adopted by the Pakistan Standards Institution on 28-01-2003 after the draft finalized by the Cereal, Pulses & Their Products Sectional Committee and approved by the Agricultural & Food Products Divisional Council.
- 0.2 In the preparation of this standard the views of the Manufacturers, Consumers, Scientists, Technologists & Testing Authorities have been taken in to consideration.
- 0.3 The term ‘Biscuits’ covers a large variety of sweet, salted, filled and coated biscuits. This standard mainly lays down essential requirements to which biscuits of different varieties should conform.
- 0.4 The quantities appearing in this standard have been expressed in rounded off values in SI Units.
- 0.5 For the purpose of deciding whether a particular requirement of this standard is complied with, the final value, observed or calculated expressing the results of a test or analysis, shall be rounded off in accordance with PS: 103. The number of significant places retained in the rounded off value should be the same as that of the specified value in this standard.
- 0.6 This standard is intended chiefly to cover the technical provisions relating to the supply of the material and it does not purport to include all the necessary provisions of a contract.

1. SCOPE

- 1.1 This standard prescribes the essential requirements; methods of sampling and test for biscuits baked from dough containing essential materials (see 2) with or without the addition of other ingredients (see 3)

1.2 This standard applies to all type of Biscuits (excluding Wafer Biscuits) but does not apply to Biscuit loose/un-packed.

## 2. ESSENTIAL MATERIALS

2.0 The following materials shall be used in the preparation of biscuit dough.

2.1 Maida Flour - Conforming to PS: 381-1983.

2.2 FAT OR SHORTENING – Hydrogenated Edible Vegetable Oil, PS: 221-2003 for Banaspati (3<sup>rd</sup> Rev.), Bakery Shortenings, Refined Edible Vegetable Oil, Butter, PS:1831-1987 Butter Oil PS:2856-1990 for Butter Oil Anhydrous Butter Oil and Anhydrous Milk Fat, (Ghee) or Margarine (PS:1653-2002)

2.3 WATER – Water Potable PS: 1932-2002.

## 3. OTHER INGREDIENTS

3.1 In addition to the essential ingredients specified under 2 any of the following ingredients may be used in the preparation of biscuits.

### 3.1.1 Cereals and Cereals Products.

Whole Meal Wheat Flour (Atta) PS: 380-1992 (1<sup>st</sup> Rev.).

Semolina SUJI OR RAVA OF FARINA PS: 190-1991.

Barley Flour (see PS: 192-1962)

Gram Flour (PS: 1798-1986)

Edible Food Grade Salt PS: 3746 – 1996.

Edible Oat or Oat Flour,

Corn Flour

Rice Flour

Malt Flour

### 3.1.2 Oil Seed Products.

Soyabean Flour (full fat or solvent extracted) / defated.

Peanuts

Peanuts Butter

Peanut Flour, Expeller Pressed (see PS:223-1999) (1<sup>st</sup> Rev.) or Solvent Extracted.

Cottonseed Flour.

### 3.1.3 Edible Starches

Tapioca Starch, (PS: 676-2968)

Potato Starch, (PS: 154-1962 for Maize, Rice, Wheat and Potato Starch)

Sweet-Potato Starch, (PS: 547-1964)

Arrowroot Starch, (PS: 370-1963)

Maize Starch, PS: 4456-1999 for Corn Flour Maize Starch (Food Grade)

Tapioca Starch, PS: 676-1968

Wheat Starch

### 3.1.4 Milk & Milk Products.

Casein, Edible (PS: 758-1969)

Milk Powder (Whole & Skim) (see PS: 363-1982) (1<sup>st</sup> Rev.)

Butter Milk and its solids

Pasteurised Milk (see PS: 4561-2000).

Condensed Milk (PS: 364-1991)

Cheese PS: 526-1964.

Whey Solid

### 3.1.5 SWEETNERS

Sugars (see PS:362-1991).

Sugars (Sucrose) (see PS:1822-1997).

Dextrose Monohydrate (see PS:140-2001).

Jaggery and Khandsari.

Sugarcan Molasses (PS:139-1994).

Lactose, Fructose.

Malt extract.

Honey (PS:1934-1992).

### 3.1.6 Fruit & Fruit Products.

Dessicated Coconut.

Fresh / Dry Fruits

Edible Nuts.

### 3.1.7 Miscellaneous

Pectin (See PS:4715-2001).

Jam (see PS:2096-1989).

Spices

Ginger

Chilli Powder (PS:1742-1997 for Chilli Powder (1<sup>st</sup> Rev.)

Black Pepper (PS:3432-1993 for Black Pepper & White Pepper.

Saffron (PS:2987-1991 for Saffron)

AJOWAN (PS:4565-2000 for Ajowan.

Cardamom (PS:2094-1989 for Cardamom (Lesser Elaichi)

Cumin (PS:3112-1991 for Cumin Whole)

Other Edible Permitted Spices.

Coffee Powder (PS:763-1969)

Cocoa Powder (PS:4435-1995 for Cocoa Powders (Cocoas) and Dry Cocoa Sugar Mixtures.

Covering Chocolate (PS:736-1991) for Chocolate & Covering Chocolate (1<sup>st</sup> Rev.).

3.1.9 Proteolytic / enzymes and Gluten Conditioners – preteolytic (Halal) and amylases, sodium bisulphate and sodium metabisulphite.

Potassium bromate (Food grade), Ammonium chloride (Food grade).

### 3.1.10 Food Additives

3.1.10.0 Malt Syrup.

3.1.10.1 Flavour-Flavouring Essences, improvers and fixer.

3.1.10.2 Colouring matter-only permitted Food Grade colour be used.

3.1.10.3 Antioxidants –as permitted by FAO / WHO.

3.1.10.4 Emulsifying agents –as permitted by FAO / WHO.

### 3.1.11 Leavening Agents as permitted by FAO / WHO.

Baking powder (see PS:657-1968)

Ammonium bicarbonate

Sodium bicarbonate

Ammonium carbonate (BP)

Active baker's yeast (*Saccharomyces cerevisiae*)

Any other approved aerating agent.

### 3.1.12 Nutrients (Food grade)

Vitamins and Minerals Permitted by FAO/WHO.

Lysine monohydrochloride

Protein concentrates (Halal).

### 3.1.13 Edible Vegetables or Vegetable Products – Soya bean Milk, Tartaric acid and Citric acid.

## 4 REQUIREMENTS

4.1 General Requirements – The biscuits shall be properly baked so that they are crisp and have uniform texture and appearance. The design, if any, on the biscuits should be clear. They shall have desirable and agreeable flavour typical of wellbaked biscuits of different types and shall be free from any soapy or bitter after-taste. The biscuits shall be free from fungus and insect infestation, rancid taste and odour.

4.1.1 Filled Biscuits – Filled biscuits shall be biscuits sandwiched with a filling of either cream, jam, jelly, marshmallow, caramel, chocolate, cocoa powder, dry fruit, cheese, and other ingredients of nutritional value, or the like.

4.1.2 Coated Biscuits – Coated biscuits shall be biscuits as such or with the filling in between but coated with chocolate or caramel or cocoa and cocoa cream or the like.

4.1.2.1 Biscuits labeled as “Biscuits” or those in which the presence of butter is highlighted, shall contain not less than 14 percent of milk fat by mass of the product. If the total fat content of the product exceeds 14 percent by mass of the product, if the total fat content of the product exceeds 50 percent the total fat shall be milk fat.

4.1.2.2 Biscuits labeled as “Milk Biscuits” or those in which the presence of milk is highlighted, shall contain not less than 4 percent by mass of milk solids calculated on dry basis.

4.1.2.3 Biscuits labeled as “Cheese Biscuits” or those in which the presence of cheese is highlighted shall contain not less than 3.5 percent of cheese solids calculated on dry basis.

4.1.3 Biscuits shall also comply with the requirements given in Table – 1.

**TABLE – 1**  
**REQUIREMENTS FOR BISCUITS**

SL.NO.	CHARACTERISTIC	REQUIREMENT	METHOD OF (REF. TO APPENDIX)
i.	Moisture, percent by weight, Max.	4.0	B
ii.	Acid insoluble ash (on dry basis), percent by m/m, Max..	0.05	C
iii.	Acidity of extracted fat (as oleic acid), percent by m/m, Max.	1.0	D

## 5. PACKING AND MARKING

5.1 **Packing** – Biscuits shall be packed in clean dry and sound containers, made of tinfoil, PCRC sheets, cardboard paper (BOPP) Bioxyline Oriented Polypropylene Food grade Flexible Packaging, material agreed upon between the purchaser and the vendor, in such a way as to protect them from breakage, damage contamination, absorption of moisture and seepage of fat from the biscuits into the packing materials. The biscuits shall not come in direct contact with the packing materials other than greaseproof or sulphite paper, cellulose film or any other non-toxic food grade packing material which may be covered with a moisture-proof film, waxed paper or moisture-proof laminates or coated paper. The biscuits in tins should not come in direct contact with the metal walls.

5.1.1 In the case of printed packaging material the printing ink shall not come into direct contact with the product.

5.2 **Marking** – The following particulars shall be clearly and indelibly marked on label on each container :-

- a. Name or trade name of the biscuit,
- b. Name and address of the manufacturer,
- c. Batch or code number,
- d. Net mass,
- e. The statement of ingredients including permitted flavouring and colouring agents used,
- f. Date of Manufacture and Expiry,
- g. PS Mark and PS Number,
- h. Licence Number.

**NOTE:** - Packets containing less than 60 g of biscuits may not be marked with the particulars mentioned under 5.2. But packets having more than 60 g and less than 120 g of biscuits shall be marked as required under 5.2 (a), (b) and (e) and may not be marked with particulars required under 5.2 (c) and (d).

5.2.1 Each pack of biscuits may also be marked with the PSQCA, SDC, and Certification Mark.

## 6. SAMPLING

6.1 The method of drawing representative samples of the biscuits and the criteria for conformity shall be as prescribed in Appendix – D.

## 7. TESTS

7.1 Tests shall be carried out as prescribed under 4.1 and in the appropriate appendices specified in col 4 of the Table – 1.

7.2 **Quality of Reagents** – Unless specified otherwise, pure chemicals of laboratory analytical grade shall be employed in tests and distilled water shall PS:593-1991 for Water for Analytical Laboratory Use (1<sup>st</sup> Rev.) be used in the analysis and in the preparation of reagents.

NOTE: - ‘Pure Chemicals’ shall mean chemicals that do not contain impurities which affect the results of analysis.

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### APPENDIX – A (TABLE-1, Item (i)) DETERMINATION OF MOISTURE

#### A-1 APPARATUS

A-1.1 Moisture Dish made of porcelain, silica, glass or aluminium.

A-1.2 oven – Electric, maintained at  $105 \pm 1$  °C.

A-1.3 Desiccator.

#### A-2 PROCEDURE

A-2.1 Weigh accurately about 5 g of the prepared sample (see D-3.3.3) in the moisture dish, previously dried in the oven and weighed. Place the dish in the oven maintained at  $105 \pm 1$  °C for 4 hours or till to constant weight. Cool in the desiccator and weigh. Repeat the process of drying, cooling and weighing at 30 minutes intervals until the difference

between the two consecutive weighing is less than one milligram. Record the lowest weight.

### A-3 CALCULATION

$$\text{A-3.1 Moisture, percent by weight} = \frac{100(W_1 - W_2)}{W_1 - W}$$

Where

$W_1$  = weight in g of the dish with the material

$W_2$  = weight in g of the dish with the material after drying to constant weight, and

$W$  = weight in g of the empty dish.

## APPENDIX – B (TABLE – 1, Item (ii))

### DETERMINATION OF ACID INSOLUBLE ASH

#### B-1 APPARATUS

B-1.1 Dish – Silica or porocelain

B-1.2 Muffle Furnace – maintained at  $600\text{ }^{\circ}\text{C} \pm 20\text{ }^{\circ}\text{C}$ .

B-1.3 Water Bath

B-1.4 Desiccated.

#### B-2 REAGENT

B-2.1 Dilute Hydrochloric Acid – approximately 5 N prepared from concentrated hydrochloric acid.

#### B-3 PROCEDURE

B-3.1 Weigh accurately about 20 g of the biscuits sample (D-3.3.2) in the dish and ash in the muffle furnace at  $600\text{ }^{\circ}\text{C} \pm 20\text{ }^{\circ}\text{C}$  until light grey ash is obtained. Remove the dish from the furnace and allow it to cool at room temperature. Add 25 ml of the hydrochloric acid to the dish, cover with a watch-glass and heat on the water-bath for 10 minutes. Mix the

contents with the tip of a glass rod and filter through Whatman filter paper No.42 or its equivalent. Wash the filter paper with water until the washings are free from acid tested with a blue litmus paper. Return the washed filter paper to the dish for ashing in the muffle-furnace as above. Cool the dish in a desiccator's and weigh. Again ignite the dish for half an hour in the furnace, cool and weigh. Repeat this operation until the dish has a constant weight, the difference between successive weighing being less than 1 mg. Filter 25 ml of the hydrochloric acid through a blank filter paper, wash, ash and weigh it as in the case of acid insoluble ash. Subtract its weight from the weight of insoluble ash of the sample.

#### B-4 CALCULATION

$$\text{B-4.1 Acid insoluble ash, percent by weight (A)} = \frac{100 (W_1 - W)}{W_2}$$

Where,

$W_1$  = weight in g of the dish containing acid insoluble ash (see Note),

$W_2$  = weight in g of empty dish in which the sample is taken for ashing, and

$W$  = weight in g of the sample

NOTE: - Correct the acid insoluble ash weight for the blank of filter paper, if any.

$$\text{B-4.2 Acid insoluble ash, percent by weight (dry basis)} = \frac{A \times 100}{100 - M}$$

where

$A$  = acid insoluble ash, percent by weight (B-4.1) and

$M$  = percentage of moisture in the biscuit (A-3.1).

APPENDIX – C(TABLE-1, Item (iii))DETERMINATION OF ACIDITY OF EXTRACTED FAT

## C-1 APPARATUS

C-1.1 Soxhlet apparatus – With a 250-ml flat bottom flask.

## C-2 REAGENTS

C-2.1 Petroleum Ether – boiling point 40 °C to 80 °C.

C-2.2 Benzene – Alcohol – Phenolphthalein Stock Solution – to one litre of distilled benzene add one litre of alcohol or rectified spirit and 0.4 g of phenolphthalein. Mix the contents well.

C-2.3 Standard Potassium Hydroxide Solution – 0.05 N.

## C-3 PROCEDURE

C-3.1 Weigh accurately about 10 g of biscuit powder D-3.3.2) and transfer it to the thimble and plug it from the top with extracted cotton and filter paper. Dry the thimble with the contents for 15 to 30 minutes at 100 °C in an oven. Take the weight of empty dry soxhlet flask. Extract the fat in the Soxhlet apparatus for 3 to 4 hours and evaporate of the solvent in the flask on a water-bath. Remove the traces of the residual solvent by keeping the flask in the hot air oven for about half an hour and weigh. Cool the flask and add 50 ml of mixed benzene-alcohol-phenolphthalein reagent (C-2.2) and titrate the contents to a distinct pink colour with the potassium hydroxide solution taken in a 10-ml microburette. If the contents of the flask become cloudy, during titration, add another 50 ml of the reagent (C-2.2) and continue titration. Make a blank titration of the 50 ml reagent. Subtract from the titre of the fat, the blank titre.

## C-4 CALCULATION

$$\text{C-4.1 Acidity of extracted fat (as oleic acid), percent by weight} = \frac{1.41 \times V}{W_1 - W}$$

Where,

V = volume of 0.05 N Potassium hydroxide solution used  
In titration after subtracting the blank,

$W_1$  = weight in g of Soxhlet flask containing fat, and

W = weight in g of empty Soxhlet flask.

## APPENDIX – D

### (Clause 6.1)

## SAMPLING OF BISCUITS

### D-1 GENERAL REQUIREMENTS OF SAMPLING

D-1.0 In drawing, preparing, storing and handling samples, the following precautions and directions shall be observed.

D-1.1 Samples shall be taken in a protected place not exposed to damp air, dust or soil.

D-1.2 Precautions shall be taken to protect the samples, the lots being sampled, the sampling instrument and the containers for samples from contamination.

D-1.3 The samples shall be stored at room temperature.

D-1.4 Each container containing the samples shall be sealed air-tight and marked with full details of sampling such as date and time of sampling, batch or code number, name of the manufacturer, and other relevant particulars.

## D-2 SCALE OF SAMPLING

D-2.1 Lot – All the biscuit containers in a single consignment drawn from the same batch of manufacture shall constitute a lot. If the consignment is declared to consist of different batches of manufacture, the batches shall be marked separately and groups of containers in each batch shall constitute separate lots.

D-2.1.1 Samples shall be tested for ascertaining the conformity of the biscuits to the requirements of the specification.

D-2.2 The number of containers to be sampled from each lot shall depend on the size of the lot and be in accordance with Table-2.

D-2.3 The containers shall be selected at random from each lot and for this purpose, random number tables shall be used. In case such tables are not available, the following procedure shall be adopted.

Starting from any container, count them as 1, 2, 3, ....., up to r and so on in one order, where r is equal to the integral part of the value  $N/n$ , being the total number of containers in the lot and n the number of containers to be selected (see Table-2). Every rth container thus counted shall be separated until the required number of containers is obtained from the lot.

TABLE NUMBER OF CONTAINER TO BE SELECTED FOR SAMPLING  
(Clause D-2.2 and S-2.3)

LOT SIZE N	SAMPLE SIZE N
Up to 50	3
51 to 150	4
151 to 300	5
500 and above	7

### D-3 TEST SAMPLES AND REFEREE SAMPLES

D-3.1 Draw from each selected container, required number of biscuits packs. These packs shall be opened and mixed. If the container is packed with loose biscuits, sample of required quantity shall be taken from different parts of the selected container.

D-3.2 Preparation of Individual Sample – from the selected containers about 600 g of biscuits shall be taken from different parts of the container. From this about 300 g of the biscuits shall be taken from testing general requirements. This 300 g of biscuits shall be divided into 3 equal parts, one for the purchaser, another for the vendor and the third for the referee. These biscuits shall be packed in air-tight, dry containers and labeled with particulars as given D-1.5.

#### D-3.3 Preparation of Composite Sample

D-3.3.1 The composite sample shall be prepared from the remaining 300 g of biscuit from each selected container, after the sample for general requirement is taken out as given in D-3.3.1.1 to D-3.3.1.3.

D-3.3.1.1 Plain biscuits – Grind the sample as quickly as possible.

D-3.3.1.2 Filled biscuits – The cream, caramel, chocolate, marshmallow, jam, jelly, or any other filling between biscuits should be removed by gentle scraping, before powdering the sample.

D-3.3.1.3 Coated and filled biscuits – As far as possible, the coating and the fillings should be removed before powdering the biscuits.

NOTE: - The biscuits are highly hygroscopic and take up moisture quickly when exposed to atmosphere. The preparation of sample should be done very quickly, preferably in a dry place.

- D-3.3.2 A small but approximately equal quantity of the material (see D-3.3.1) shall be taken from the powdered sample of each selected container and mixed thoroughly so as to form a composite sample weighing not less than 200 g. This sample shall be divided approximately into three equal parts one for the purchaser, another for the vendor and the third for the referee. These parts shall be transferred immediately to clean, air-tight and dry containers which are then sealed air-tight and labeled with particulars as given in D-1.5.
- D-3.3.3 The remaining portions of the powdered sample from each selected container (after a small quantity needed for the formation of the composite sample has been taken out) shall be divided into approximately three equal parts. These parts shall be transferred to clean, dry and air-tight containers which are then sealed with all the particulars as given in D-1.5. The sample in each such sealed container shall constitute an individual test sample. These individual samples shall be separated into three identical sets of test samples in such a way that each set has a sample representing each selected container (see Table-2). One of these sets shall be marked for the purchaser, another for the vendor and the third for the referee.
- D-3.4 Referee Sample – Referee samples shall consist of a set of individual biscuit samples (see D-3.2) marked for general requirements, a composite sample (see D-3.3.2) and a set of individual test samples (see D-3.3.3) and shall bear the seals of the purchaser and the vendor. These shall be kept at a place agreed to between the two.

#### D-4 NUMBER OF TESTS

- D-4.1 This biscuits selected according to D-3.2 shall be tested for general requirements.
- D-4.2 Test for moisture shall be conducted individually on each of the samples constituting a set of individual test samples (see D-3.3.3).
- D-4.3 Tests for the determination of acid insoluble ash an acidity of extracted fat shall be conducted on the composite sample (see D-3.3.2).

#### D-5 CRITERIA FOR CONFORMITY

- D-5.1 A lot shall be declared as conforming to the requirements of the specification for biscuits when the criteria given in D-5.1.3 are satisfied.

- D-5.1.1 In case of general requirements, the biscuits shall satisfy the requirements as given in 4.1.
- D-5.1.2 In case of moisture each of the test results as obtained from the individual test samples (see D-4.2) shall be less than or equal to 5.5 percent (see Table-1).
- D-5.1.3 For acid insoluble ash and acidity of extracted fat, the test results obtained from the composite sample (see D-4.3) shall be less than or equal to 0.05 percent and 1.0 percent respectively (see Table-1).
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