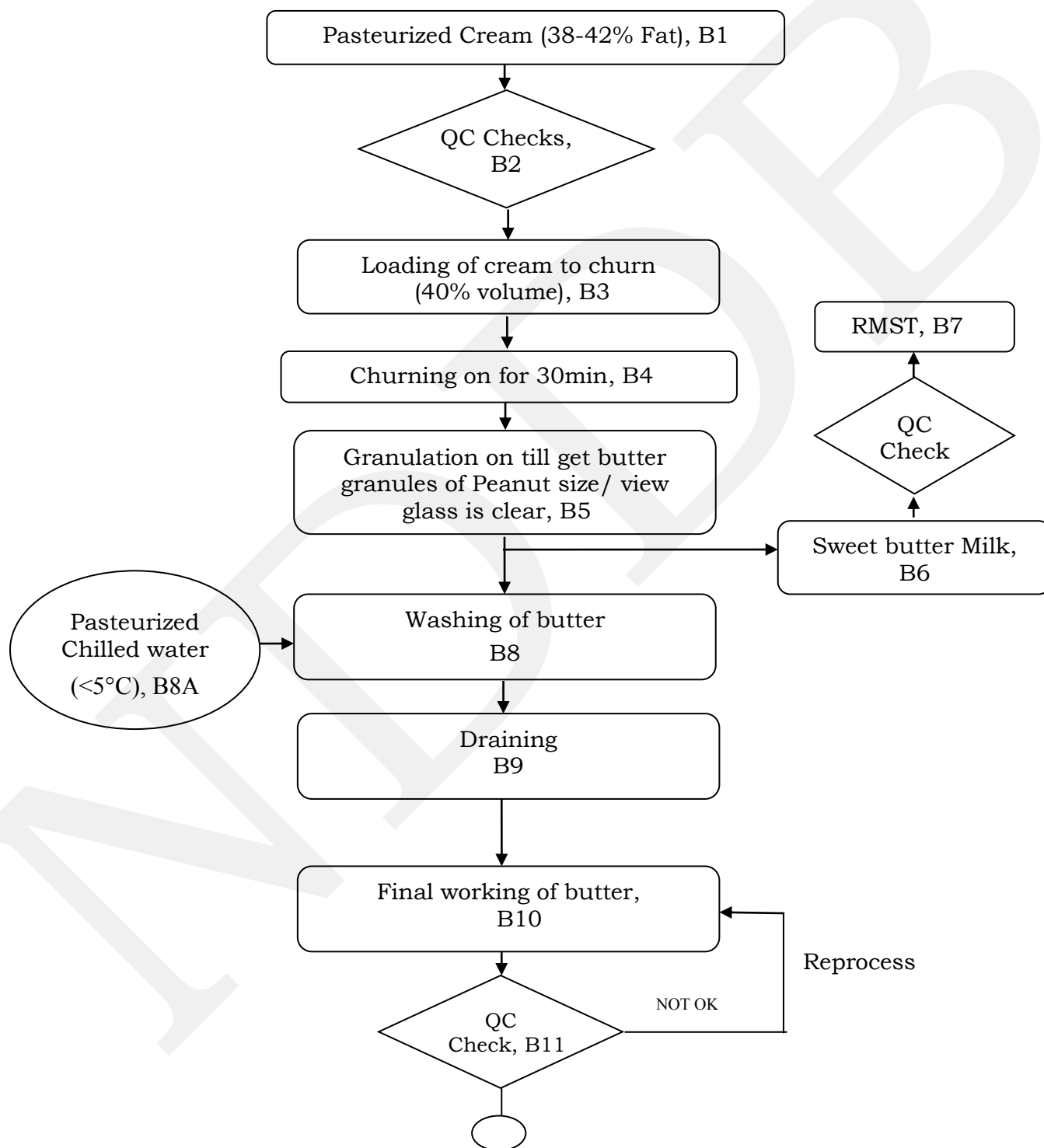
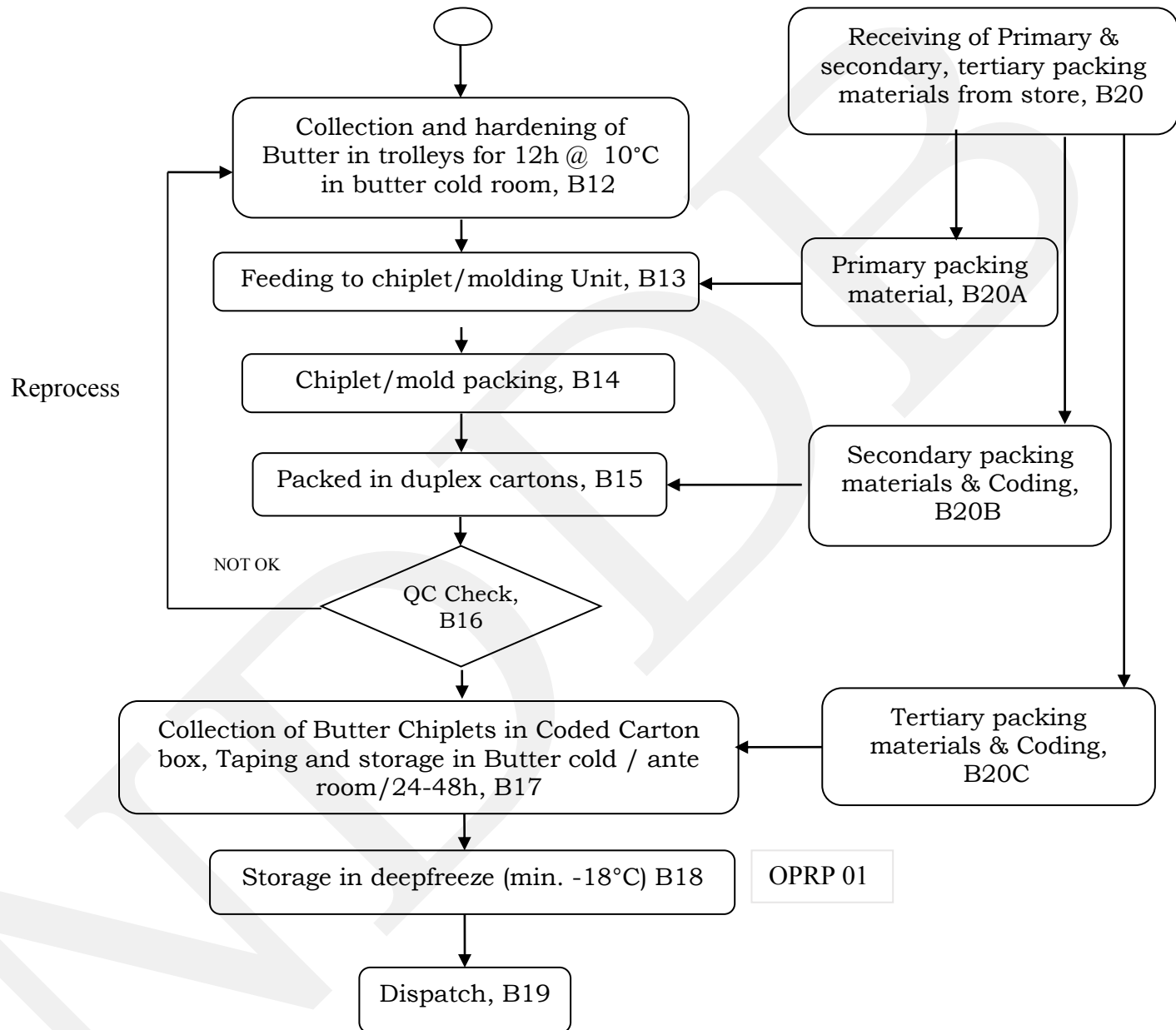


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|  NDDDB Flow Chart | BUTTER | Document No. | NDDDB/FC/05 |
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1. Flow Chart For Table Butter in Churner

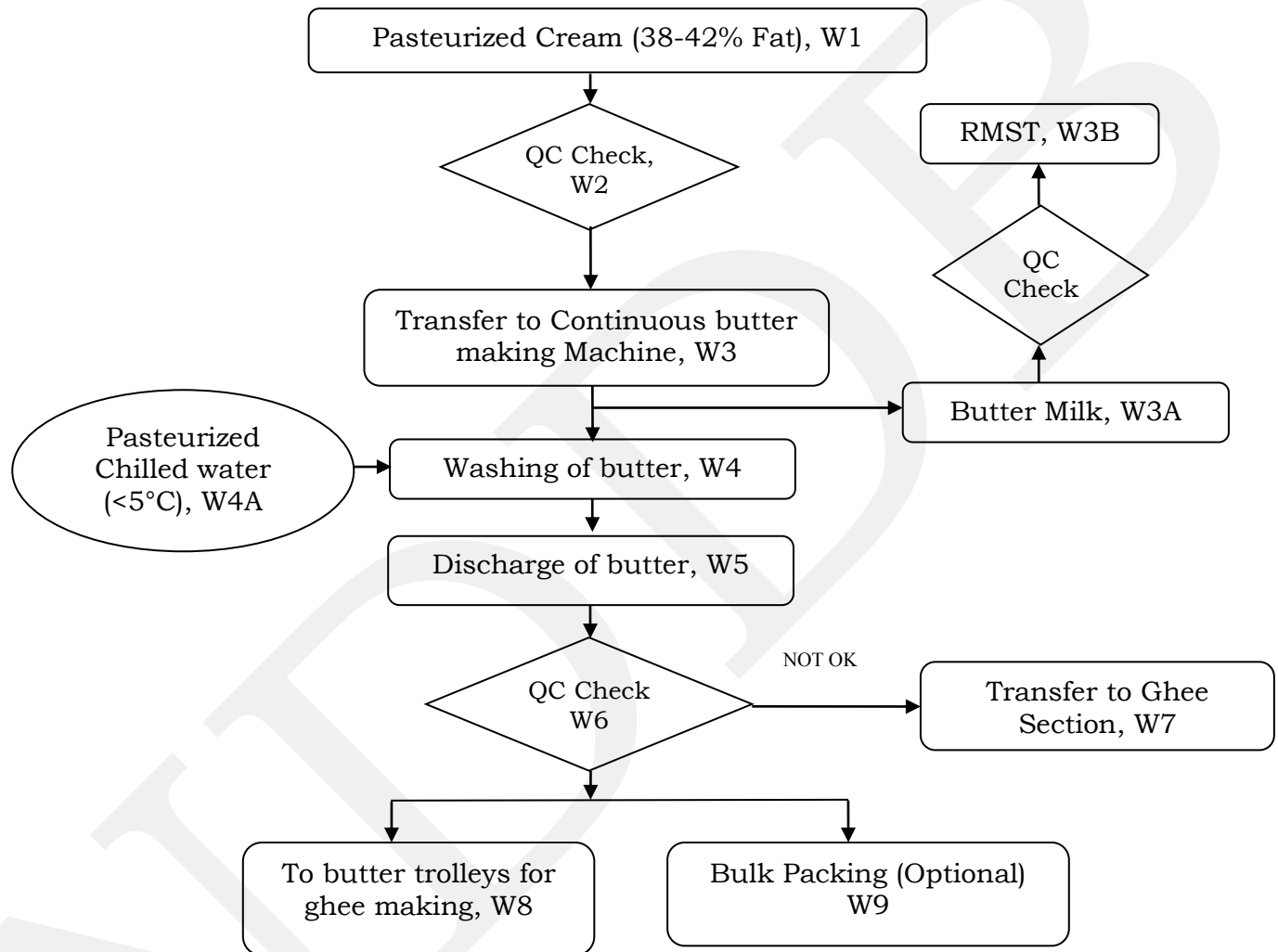


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2. FLOW CHART FOR WHITE BUTTER



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I. Butter manufacturing in CBMM

1. Cream will be stored in cream storage tank. Before taking to production quality control checks of cream for the quality parameters such as fat, SNF, acidity, temperature will be carried out. If found ok issued to butter section if not ok will be taken back for reprocessing.
2. Receiving of cream to the cream balance tank of CBMM (Continuous butter making machine)
3. From cream balance tank cream will fed/transferred to CBMM.
4. Pasteurized water is used for washing of butter and sweet butter milk which is obtained during washing of water will be a by-product and butter milk will be tested for quality parameters and then transferred to raw milk silos.
5. Butter will be removed from CBMM through kneader section.
6. During production online butter sample will be taken for testing of quality parameters if it is not satisfactory transferred to ghee section for ghee making.
7. After getting clearance from quality control section butter will be wrapped in LDPE liners and packed in 20 / 25 kg butter cartons and also transferred to butter trolleys for ghee making.
8. Butter box will be weighed for 20 / 25 kg net weight.
9. Online checks are done to confirm to standard weight requirement and verification of taping and coding.
10. Butter box will be taped by using Bopp tape and coding is done for date, batch no. machine number box number for traceability.
11. Butter boxes are transferred to ante room for hardening of butter for 1 day.
12. After hardening of butter, it will be transferred to deep freezer at or below -18 degrees to ensure quality of butter till consumption

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13. Quality control Checks will be carried out before dispatch of butter and also during transfer of butter during ghee production. As per requirement the butter are packed in retail cartons.

14. Dispatch of butter.

II. Butter manufacturing in Batch process (Churner)

1. Receiving of pasteurized cream and check for its chemical and biochemical requirements as per quality plan.
2. Aging of cream for min 4 hrs at 5-10°C.
3. Load the cream in to churner approximately 40% of churner capacity and close the lid and safety gears.
4. Switch on the churners for 30 min and observe till get the proper granulation of Peanut size/ view glass is clear.
5. Drain the butter milk and collect it for further processing.
6. Wash the butter with pasteurized chilled water, Drain the wash water.
7. Work the butter till you get desired good body & texture at 4th Gear.
8. Up on completion of working check for its chemical composition (Moisture, salt and fat %) as per quality plan.
9. Once QA cleared the batch unload the butter in to cleaned and sanitized butter trolleys and close the lids and keep it for hardening in cold rooms for 12hrs @ below 10 °C.
10. Upon hardening, cut the butter blocks and load it in to cleaned and sanitized chiplet/molding unit. If it's manual loading personal and equipment hygiene has to be taken care by the supervisor.
11. Receiving of packaging materials and coding with batch number and date of manufacture/packed date.
12. Packing in to respective SKUs as per demand in primary packaging, secondary cartons and tertiary CFB cartons.

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13. Ensure the coding, taping on packed boxes and check for its final quality clearance.
14. Butter carton boxes are held in butter cold room / anteroom for 24 to 48 h allowing to set before shifting it to deep freezer at -18°C until dispatch.