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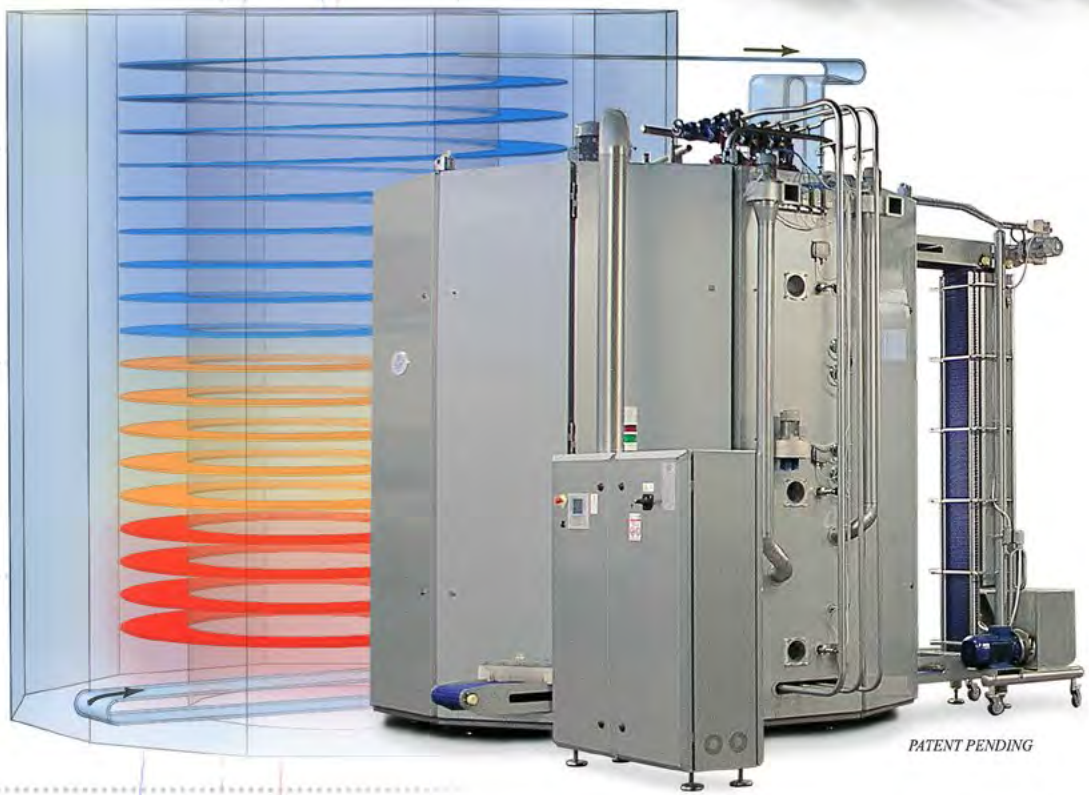
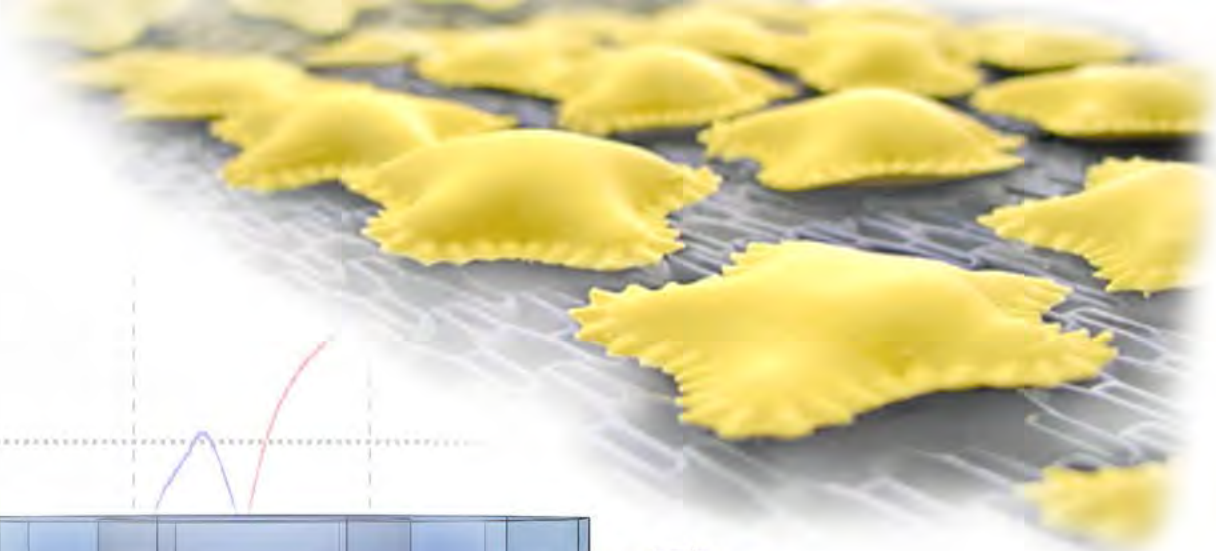
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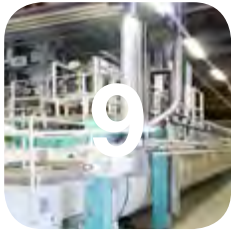


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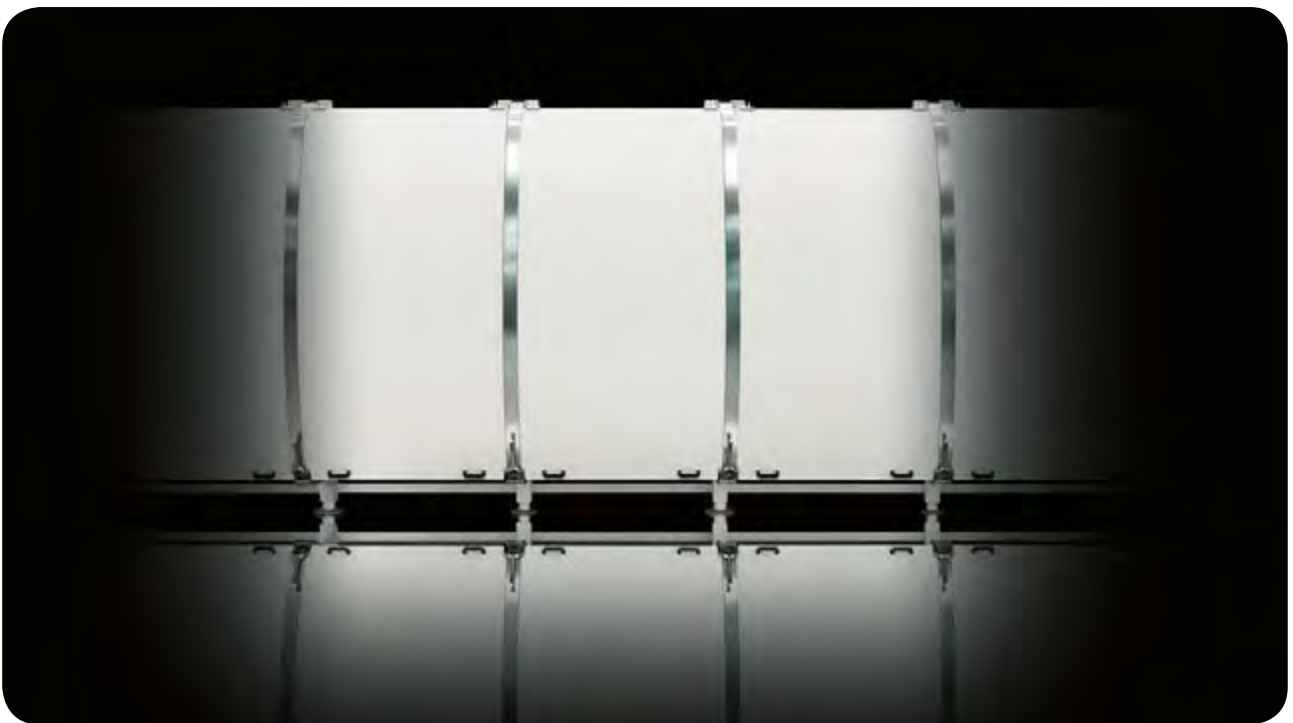
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efficient technology for the industrial **drying** of long pasta



High product quality, incredible energy savings and extreme simplicity of use: these are the main features of the latest generation **Ecothermatik industrial dryers** by Bühler.

The Bühler Group, with head offices in Uzwil, Switzerland, has once again proved itself supplier par excellence for industrial scale dry pasta production lines by developing the latest generation of dryers in the



Ecothermatik™ range, technology which was first placed on the market at the beginning of 2012.

Product quality

The main priority when producing a food product such as dry pasta is to obtain the desired aspect together with a good resistance against breakage and product stability. The technological basis for being able to specify a line's drying profile is provided by the glass transition point, a concept derived from materials science: pasta is considered a material which, over a given temperature, takes on a rubber-like, plastically deformable state, which depends heavily on the concentration of elasticizing substance (water content), whereas below this temperature it is in a brittle, glass state.

During traditional drying processes, the surface of the pasta is taken to the glass state right from the pre-drying stage, due to the use of relatively dry, warm air. As the product loses most of its water content inside the pre-dryer, stress occurs inside the product caused by simultaneous shrinking. This stress is not reduced except in the main drying stage and especially in the long stabilization phase. This occurs because, in conventional processes, the rubber characteristics of the surface are not restored before this point due to the relatively high temperatures encountered in this stage.

The Ecothermatik process by Bühler tackles and solves this problem as early as the pre-drying stage. Its revolutionary climate control system and drying curve which uses humidified air in the pre-dryer, make it possible to stop the surface of the pasta from initially becoming glass-like. The rubber state of the pasta is preserved throughout the entire drying process, even on the surface, an aspect which is crucial for the qualitative characteristics of the end product.

The benefits gained from maintaining the rubber state of the pasta during the drying process are:

- outstanding cooking characteristics (thanks to the rubber state of the pasta, the proteins in the dough can move freely and consequently bind in an ideal way, particularly on the surface of the pasta; this helps to preserve the “al dente” characteristics and stability of the pasta during cooking)
- adjustable pasta colour (in the stabilization stage, which is separate from the drying stage, the colour of the pasta can be determined by selecting different temperatures)
- drying without stress (in the rubber state the stress caused by product shrinkage can easily be alleviated, without having to wait for the stabilization stage).

Top speed pasta stabilization

Ecothermatik technology is able to produce completely stable pasta by means of an extremely quick stabilization process (less than 75 minutes). This eliminates the unwelcome and much feared effect -



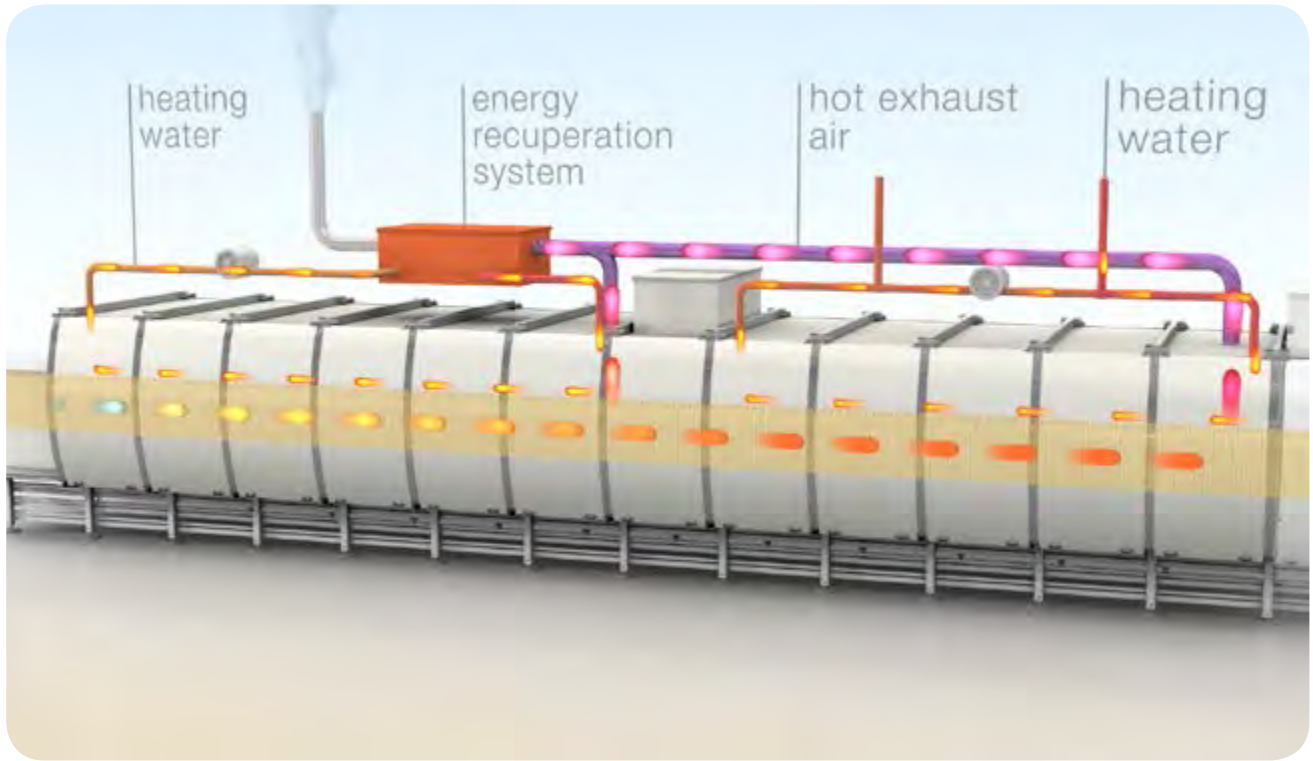
product breakage.

Furthermore, as a result of strict control over the process water flowing through the heat exchanger in the opposite direction to pasta flow, a continuous, peak-free temperature profile is achieved along the whole length of the dryer. This lack of transition between the various zones stops any condensation forming on the pasta caused by sudden climate changes and ensures uniform and gentle drying and shrinking of the pasta.

Thermal and electric energy savings and food production sustainability

Pasta drying is a process which entails the consumption of huge amounts of energy needed to extract 260 kg of water from each ton of dry pasta produced. In traditional drying processes, this water





content is removed as vapour by both the pre-dryer and the main dryer, in the flow of air exhausted into the atmosphere. In traditional technologies it is not cost-effective to try and recover the energy held in the steam. In these processes, in fact, there may be as many as 6 exhaust air flows within the drying stage, all at different temperatures. The first exhaust air flows from the pre-drying stages hold most of the water which needs to be evaporated. However, the temperatures are relatively low as is the relative humidity level. Consequently, there is no efficient way of recovering energy from these air flows. Furthermore, the temperature level of the recovered energy would be too low for use in the process itself. A relatively high temperature can only be found in the end exhaust air flows in the main drying stage. But these no longer extract a very large quantity of water from the pasta, an aspect which makes them unsuitable for efficient energy recovery.

The new Ecothermatik process offers a brilliant solution to this process engineering challenge. Via this new drying technology the exhaust air is vented in just two points during the pre-drying and main drying stages. The water contents and temperature levels of these two air flows are exceptionally suitable for heat exchange and the recovered energy can then be reused in the process.



This reduces the thermal energy needed to dry long pasta by up to 40% which translates into a reduction of between approximately 25-15 kW/h per 100 kg of pasta. This energy saving significantly improves efficiency in pasta production. Assuming that the thermal energy costs amount to approximately 2-3% of the total production cost for dried pasta, a 40% saving in the thermal energy needed in the process will reduce production costs by approximately one percentage point, with equivalent benefits felt directly on profit margins. But efficiency does not represent the overall benefit: a substantial contribution is also given to food production sustainability, as a lot less energy is consumed to create the necessary thermal energy. If, for example, all the long pasta produced in Italy were dried using Ecothermatik technology, it would be possible to avoid the consumption of approximately 11,000,000 litres of fuel oil or approximately 28,000 tons of coal. In particular the reduction in carbon emissions has a positive effect to be taken into great consideration when differentiating between pasta products offered on supermarket shelves.

The reduction in thermal energy consumption is also associated with low electrical energy consumption. This additional benefit is derived from the use of high efficiency fans which, thanks to their recirculation of larger volumes of air inside the dryer, cut electrical energy costs by approximately 10% all thanks to the innovative geometry of the fan blades.

Last but not least, the thermal system relative to the whole line, specially designed and optimized from an energy point of view, also makes it possible to reduce cooling energy by about 20%. In conventional lines, this cooling energy is used in the humidification zones and often further cooling is required in the stabilization zone. This is all very different to what happens in an Ecothermatik dryer where these functions are not carried out by flows of actively cooled process water but by recirculation flows.

Easy to use, service and sanitize

The automation system of the line is easy to understand and logical to use ensuring that all operators can acquire a perfect grasp of all the functions quickly and easily: from the creation of production programs to process control and troubleshooting.

From a construction point of view, the line is characterized by a low level of mechanical complexity and consequently quick assembly, not to mention very low maintenance requirements. Elements which contribute to such simplicity are the complete integration of the heating and cooling piping system, the absence of any infrastructure for air reintegration, the positioning of the piping for clean and exhausted air inside the dryer not to mention the lower number of circuits for regulating the climate, with relative thermal control equipment. Furthermore, the lower level of complexity combines perfectly with easier access and improved sanitization.



As well as ensuring uniform distribution with low load losses, the transversal section of the generously sized elements, make all maintenance and cleaning operations much simpler. The mechanically synchronized long pasta conveyors ensure a high level of operating reliability. Last but not least, the systematic use of hard wearing and food-safe materials guarantee the quality for which Bühler is well known.

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changes to the italian standard governing pasta



While awaiting ratification from the President of the Republic and subsequent publication of the measure (approved by the Council of Ministers on 22 January 2013) in the Official Journal of the Italian Republic, we are telling our readers **what to expect from the new aspects introduced in the standard regulating Italian pasta production** and comparing the amended text with the one still officially in force.

The Italian standard governing pasta dates back to Law no. 580 of 4 July 1967. This law contains the “regulation on the manufacturing and marketing of cereals, milling products, bread and pasta”.





The law was first amended following approval of Presidential Decree no. 187 of 9 February 2001, published in the Official Journal on 22 May that same year.

The Presidential Decree in question contains the “Regulation for the revision of the standard on the manufacturing and marketing of milling products and pasta, in accordance with article 50 of Law no. 146 of 22 February 1994”. In other words, the 2001 legislator did not totally repeal the 1967 law and replace it with a new text but limited itself to simply deleting a series of the provisions therein and keeping part of the original legislation in force while introducing only a few new provisions.

It should be pointed out that the regulation contained in the Presidential Decree does not hold the standing of an ordinary law, but is simply a regulation, in other words a secondary source of law.

To be able to understand such a statement it is necessary to specify how rules of law are structured in accordance with a very precise hierarchal order.

At the very top there are the constitutional laws, immediately followed by primary sources of law (EU standards, ordinary laws, ordinary Regional statutes, legislative decrees, regional laws), while at the bottom there are secondary level standards, including the regulations we are dealing with here.

Regulations can be defined as acts which have the force and value of secondary sources of law. They can be issued by the Government, by individual Ministries, by the Regions, Town Councils and Provinces.

They contain general and abstract provisions and consequently they are suitable for making changes to the general legal system, even if on a lower level compared to legislative level sources of law.

Regulations issued by the Council of Ministers are approved subject to the opinion of the State Council and are issued by decree of the President of the Republic.



The provisions discussed here belong to this category.

Going back to Presidential Decree no. 187 of 2001, this was issued based on art. 50 of Law no. 146 of 22 February 1994, which envisaged the issuing of regulatory standards to review the manufacturing and marketing of preserved and unpreserved food products, although not disciplined by law.

Having specified the above, on the proposal of the Ministry of Agricultural, Food and Forestry Policies and the Ministry for Development, the Council of Ministers has recently put its hand to amending the aforementioned Regulation.

While awaiting ratification from the President of the Republic and subsequent publication of the measure, which was approved on 22 January 2013, in the Official Journal of the Italian Republic, this commentary aims to inform our readers in advance of the new aspects introduced and comparing the amended text with the one still officially in force.

The purpose behind the amending law

On the internet page of the official Government website, it is possible to find the bulletins issued by the Council of Ministers relative to the provision being commented on.

Amongst these one can read the reasons behind the issuing of the amendments to the Presidential Decree.

In particular the new standards propose to simplify and rationalize the obligations which must be fulfilled by manufacturers, eliminating those which new technologies and computerization of administrative procedures have rendered obsolete.

Furthermore, in observance of EU regulations and provisions concerning the topic of food safety, in future it will be permitted to produce additional varieties of milling products and pasta in order to satisfy the demand for quality and differentiation expressed by consumers

Article 6 “Pasta”: amendments

The first five articles of the Regulation have not been amended and therefore remain unaltered in their original wording.

The first modification is encountered in art. 6 on “Pasta”.

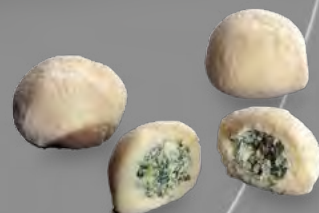
The original prohibition on the manufacturing of dry pasta made from soft wheat milling products referred to in paragraph 4 has been amended as the following version: “except in the case of pasta destined for sale in other Member Countries of the European Union or other states which have signed the European Economic Area Agreement, as well as destined for export, as referred to in art. 12, paragraph 1, the manufacture of dry pasta prepared using soft wheat flour is forbidden”.





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It is obvious how the new wording of the regulation has felt the effects of the interpretation formulated by the Constitutional Court of Italy under sentence no. 443 of 30 December 1997 on art. 30 of Law no. 580 of 1967 on the subject of special pasta.

This case came about from opposition proceedings against an injunction order issued against the legal representative of a pasta manufacturer who had produced and marketed dry pasta containing garlic and parsley, ingredients which were not allowed under the standard in force at that time.

The court dealing with the case in question pointed out a violation of art. 3 of the Constitution (principle of equality) with reference to the different treatment reserved by the Italian law for subjects producing pasta containing prohibited ingredients, depending on whether or not the product was intended for sale on the national or EU market.

It should be remembered how the Council settled the matter based on the principle of the free circulation of goods, by which it is forbidden for one Member State to apply a national standard limiting the import of goods produced and marketed in accordance with the laws in force in the country of origin.

Based on this fundamental principle of EU law, the Italian state had no power to obstruct the production of pasta in a EU Member State destined for consumption in Italy containing ingredients which are not authorized by national law but are allowed under EU law.

In this clash between the Italian regulation, introduced to protect the qualitative characteristics of traditional national production, and EU rules established to promote the free circulation of goods within the European market, bearing in mind the hierarchal principle mentioned above, the internal regulation is forced to back down and give priority to EU law.

Going back to the amendments being discussed, wording has therefore expressly been added within the text of the regulation, alongside the general prohibition on the use of soft wheat flour in the manufacture of dry pasta, allowing



the use of said flour for products destined for markets outside Italy.

In the following paragraph 6 of art. 6, confirmation is given concerning the possibility to re-use, in the production of pasta, special pasta, and egg pasta, product or parts of the same from the manufacturing or packaging processes, as long as this process is performed in the same production plant.

Following the explicit abrogation of Legislative Decree no. 155 of 1997, by Legislative Decree no. 193 of 2007, reference to said regulation is cancelled and confirmation is given to the power of the Ministry of Health, in agreement with the Ministry of Economic Development and the Ministry of the Agricultural, Food and Forestry Policies, to establish the methods of application of the aforementioned regulation on re-use by means of a special decree.

“Special pasta”

Other new aspects have been introduced in the text of art. 7 of Presidential Decree no. 187 of 2001.

The provision in question deals with special pasta types.

Authorization to produce special pasta, in other words pasta types which contain different ingredients, other than soft wheat flour, and which meet health requirements, remains unmodified.

It is clarified how “Special pasta must be sold with the sales name durum wheat semolina pasta or durum wheat low grade semolina pasta or durum wheat wholemeal semolina pasta on the packaging completed by mentioning the ingredient used, and, in the case of pasta made using several ingredients, by mentioning the characterizing ones”.

Article 7 also envisages, in the new paragraph 4, the possibility of producing special pasta by mixing durum wheat semolina and/or durum wheat low grade semolina and/or durum wheat wholemeal semolina in observance of the sales names envisaged in art. 6, paragraph 3 and paragraph 2 of this article.

When comparing with the old regulation, one notes the introduction of the possibility to use wholemeal ingredients or mixtures of durum wheat semolina and wholemeal semolina in the production of special pasta types, which, as already mentioned above, is designed to uniform the standard to the demands put forward by consumers.

A specification of a technical nature has been introduced with an additional paragraph in art. 7.

The whole provision reads as follows:

“In dry, fresh or stabilized special pasta, the analytical parameters envisaged in art. 6, paragraph 3, are applied exclusively to the primary raw material used; in the assessment of said parameters, one must take into consideration both the input added to the raw material used and the effect which the added ingredient/s may have on the final analytical parameter; for this purpose, during the analytical verification stage, it will be necessary to verify the recipe at origin which the food manufacturer must always submit to the controlling body whenever requested.”

It should be remembered that the parameters referred to are those concerning the maximum moisture permitted in the end product, ash and protein content (per 100 parts of dry matter) and the maximum acidity subject to analytical



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control by public authorities appointed to verify adherence to the legal provisions governing pasta.

The clarification added by the amending law appears most appropriate for avoiding any possible disputes which could result from incorrect methods of analysis.

“Egg Pasta” art. 8: amendments

On the topic of egg pasta, the provision has also undergone only minor changes.

Paragraph 3 of the provision in question envisages a lower ethereal extract content and sterol content than is currently in force.

The variation would appear to be minimal, in fact from a minimum accepted value of 2.80 g and 0.145 g respectively per one hundred parts of dry matter, the new values have been set at 2.50 g and 0.130 g with reference to the end product.

Evidently the Government has considered it necessary to update the value in light of the lower quantities of ethereal extract and sterols found inside the eggs used by the manufacturers of this kind of pasta. (On this topic, please refer to the article “Egg pasta and Sterols; the problems linked to observing normative requirements”).

Prohibitions art. 11: amendments

Paragraph 2 of art. 11 on the subject of prohibitions has been removed from the Regulation.

The provision envisaged prohibition on the sale or storing for later sale of pasta which has been altered, adulterated, contaminated or is infected with animal or vegetable parasites.

Now, it becomes evident from simply reading the provision that it merely repeated, for the products in object, for the products in object, the overall prohibitions established in art. 5 of Law no. 283 of 30 April 1962.

Therefore being as the provision was a duplicate of the general standard in force concerning food and drink products, the decision for its removal seems logical.

Transitional and Final Provisions art. 12: amendments

The text of the transitional and final provisions is also reworded with the introduction of the explicit reference to Regulation (EC) no. 852 of 2004 relative to the hygiene of food products in general.

The manufacturing of milling products and pasta with requisites different from those set out in chapters I and II of the aforementioned Presidential Decree, is permitted when the end product is destined for sale on the EU market or in other countries.

Obligations concerning communication with the Ministry of Agricultural, Food and Forestry Policies shall be established by special decree issued by the Ministry itself.



Another important new aspect should be pointed out for manufacturers in relation to the legal provision in art. 11. It is expressly specified that raw materials and substances different from those which may be used to manufacture milling products and pasta for the Italian market, as well as finished products with different requisites from those prescribed, may be stored inside the same premises as those used to store end products, raw materials and substances which may be used in the manufacture of milling products and pasta intended for the Italian market. The only condition is that the products themselves, stored within the same warehouses, must be clearly marked by special signs upon which the following text must be written in clearly legible characters: "RAW MATERIALS AND/OR END PRODUCTS FOR THE NATIONAL MARKET".

The above text may be replaced by other wording as long as it is always possible for the special surveillance bodies to immediately and directly perform their control procedures.

Finally, the individual basic raw materials with requisites different from those prescribed, as well as those substances which are not authorized for use in the production of pasta with different requisites from those prescribed for the Italian market must be recorded in special loading and unloading logbooks which shall be established by a specific ministerial decree.

These provisions should be welcomed as in fact they render the work, logistical organization and storage procedures simpler for operators.

Paragraph 4 of art. 12 confirms the prohibition to import milling products and pasta with characteristics different from those prescribed by the rules set out in the regulation.

However, the regulation must be read and interpreted in light of the initial discussion which expressly refers to two legal provisions, in other words art. 48 of Law no. 128 of 24 April 1988 and art. 9 of Presidential Decree no. 502 of 30 November 1998.

The first rule referred to is held in the so-called "Community law 1995 - 1997" which envisages the provisions for the fulfilment of the obligations derived from Italy's belonging to the European Community.

Cited art. 48 expressly lays down that: "the provisions concerning the ingredients, composition and labelling of food products referred to in Law no. 580 of 4 July 1967 on the manufacturing and marketing of cereals, milling products, bread and pasta, shall not be applied to food products imported and sold on national territory which have been legally manufactured and marketed in other EU Member States or other countries which have signed the European Economic Area agreement".

Presidential Decree no. 502 of 30 November 1998 concerns the regulation holding rules for the revision of the standard on the manufacturing and marketing of bread, in accordance with article 50 of Law no. 146 of 22 February 1994.

Art. 9 of the aforementioned regulation envisages the mutual recognition, in other words consent, that the provisions in the same regulation shall not be applied to bread imported and sold on national territory which is



legally manufactured and marketed in EU Member States or comes from countries which have signed the European Economic Area Agreement.

Conclusion

The new aspects introduced by the amending law on the whole should receive a positive appraisal.

The main rules in the regulation are confirmed whereas the amendments concern aspects which on the whole have only a moderate impact on producers.

While reserving a more in depth look for future issues of “Pastaria” the only complaint to be made is the fact that part of the original standard dating back to 1967 still persists.

Said provisions were kept in force by the 2001 Legislator, despite important and substantial amendments and approval of the regulation in question.

Greater attention concerning overall clarity of the normative texts not to mention a renewed respect for operators would have suggested regulating the whole matter in a single text.

In this way it would have been possible to avoid annoying references to provisions spread out over various different legislations.

However, we will come back to this topic with comments on sanctions which have not been dealt with here due to a lack of editorial space.

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Storci has dedicated years to developing the Premix™ pre-mixing unit for pasta makers. 600 of these machines have already been installed around the world and many attempts have been made to imitate it.

It can be installed on all kneading tanks, presses and dough sheeters and offers a range of advantages: it is easy to use, ensures perfect flour hydration, requires no heating of the product and guarantees low energy



consumption, high productivity and easy accessibility and cleaning. The result, in just a few simple words? Revolutionary dough making. Mechanically the Premix machine has always been extremely reliable, but now thanks to the latest modifications, wear on construction materials has been reduced by 30% while it still remains extremely easy to clean. What's more, it has been developed with particularly fine and light raw materials also in mind (such as soft wheat flour).

Storci installs its pre-mixer on all kneading tanks and on the presses used in the large-scale dry pasta production lines built by Fava, Storci's partner and market leader. They are also installed on the dough making units Storci develops, such as the Beltmix and the Bakmix and also constitutes an obvious choice for use with the Trolley Premix. It is ideal for small artisanal pasta makers and small-to medium-size pasta plants as it can be used for various kinds of

production processes: fresh pasta, fresh filled pasta, sheet pasta, dried pasta, gluten-free pasta and gnocchi. Trolley Premix is a centralized dough preparation system (with automatic dosing of all the ingredients) built to supply different dough user units (presses, sheeters, shaping machines for regional pasta shapes etc.), thanks



to the various configuration options available. The “wheeled” version means it can be moved over to the units needing the dough.

Developed mainly with the aim of reducing the number of personnel needed to prepare the dough, leaving them free to work in other departments, it is designed to obtain dough mixes that maintain uniform characteristics over time. The PLC allows the user to store a high number of recipes which are easy to modify. The other units can be adjusted more quickly and efficiently (for example different sheets for filled pasta or for long pasta).

This system is ideal for the production of coloured dough thanks to the self-cleaning unit which guarantees maximum speed for recipe changeover.

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egg pasta and sterol content: the problems linked to observing normative requirements



Unfortunately, when making dough for the production of egg pasta, strict observance of the Italian Standard stipulating the use of at least 200g of eggs (without the shells) per kilo of flour, may in many cases not be enough to protect the manufacturer from **charges of marketing fraud**. The problem stems from the limits enforced in the current standard, reduced only in part by the latest version of Presidential Decree 66/2013 (not yet in force), and the official analytical method for the determination of sterols, as highlighted in the study published in this issue.



Presidential Decree no. 66 of 22 January 2013, recently approved by the Council of Ministers, will amend Presidential Decree no. 187 of 9 February 2001 - "Regulation for the revision of the standard on the manufacturing and marketing of flour and pasta, in accordance with article 50 of Law no. 146 of 22 February 1994"

The definition of egg pasta remains the one provided by Presidential Decree 187/2001: egg pasta may only be manufactured using durum wheat semolina and at least 4 hens' eggs weighing at least two hundred grams, without the shells, per kilogram of semolina. Instead of eggs a corresponding amount of liquid egg product may be used. It must have been produced using only hens' eggs and comply with the requirements set out in Legislative Decree No. 65, dated 4 February 1993.

With regards to the analytical determination of the number of eggs in egg pasta, based on the real sterol content of the eggs, Presidential Decree no. 66 of 22 January 2013 reduces the minimum number of sterols in egg pasta from 0.145 grams per 100 parts of dry matter, to 0.130 grams per 100 parts of dry matter, and consequently also the ethereal extract from 2.80 g to 2.50 g.



Verification of the sterol content in certain products available on the market

In order to assess the overall situation of the market a number of samples were taken produced by manufacturers of fresh, dry and filled egg pasta to determine total sterols using chromatography.

The method which must be used to calculate the number of eggs is defined in Ministerial Decree 23/07/1994 which envisages:

$$N = (\% \text{ sterols DM} - 0.05)/0.025$$

The calculation was modified following the amendment to Presidential Decree 187/01 envisaging a reduction in the sterol content from 0.150 % in DM to 0.145 % in DM:

$$N = (\% \text{ sterols DM} - 0.05) \times 4 / 0.095$$

At the time of publication of Presidential Decree no. 66 of 23 January 2013 in the Official Gazette, it will be necessary to revise the calculation still further as follows:

$$N = (\% \text{ sterols DM} - 0.05) \times 4 / 0.08$$

In the calculations provided, the value "0.05" refers to the mean content of sterols (phytosterols) as provided by the flour (% DM).

In the table below, the number of eggs was calculated by keeping a fixed value for the phytosterols of 0.05% DM as envisaged in the governing standard.

Description of the Product	% egg declared on the pasta	Total sterols % DM	No. eggs in compliance with 187/01	No. eggs in compliance with 66/2013
fresh egg tagliatelle	25	0.130	3.4	4
fresh egg lasagna	25	0.141	3.8	4.6
fresh egg lasagna	20	0.110	2.5	3
dry egg lasagna	28.3	0.195	6.1	7.3
dry egg pasta nests	28.3	0.205	6.5	7.8
fresh egg ravioli	22	0.075	1.1	1.3
fresh egg cappelletti	25	0.170	5.1	6



Calculation of the sterols added to the pasta by an egg with a “standard” sterol content

In its databases, INRAN (Istituto Nazionale di Ricerca per gli Alimenti e la Nutrizione - National Institute for Food Research and Nutrition) defines tables for the composition of foodstuffs. The table below provides the indications it provides for whole hens' eggs:

CHEMICAL COMPOSITION AND ENERGY VALUE OF AN AVERAGE HEN'S EGG PER 100 g OF EDIBLE PORTION	
Chemical composition	Value for 100 g of edible portion
edible portion (%)	87
water (g)	77.1
proteins (g)	12.4
lipids (g)	8.7
cholesterol (mg)	371
available carbohydrates (g)	traces
starch (g)	0
soluble sugars (g)	traces
total fibre (g)	0
soluble fibre (g)	0
insoluble fibre (g)	0
alcohol (g)	0

Source: Inran

The average hen's egg (for 100 g of edible portion) contains therefore 371 mg of cholesterol per 100 g of edible substance.

Let us now take into consideration the preparation of a dough in compliance with the indications provided in article 8, paragraph 1 using therefore 200 g of egg (without shells) per kilogram of flour.

By means of a calculation we can come to define what the cholesterol content of the dough should be (% DM):

Component	Egg	“00” finely ground flour	Total
use	200 g	1000 g	1200 g
cholesterol content	0.371 g/100 g	0 g/100 g	0.371 g
lipid content	8.7 g/100 g	0.7 g/100 g	9.4 g
dry matter	22.9%	85.9%	-
cholesterol provided	0.742 g	0 g	0.742 g
lipids provided	17.4 g	7 g	24.4 g
dry matter	45.8 g	859 g	904.8 g



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Processing of pasta which is always fresh with minimum recycling of dough scraps (less than 7%). Special filling injection system which ensures that the quality of the filling is maintained intact.

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Exceptionally efficient use of the pasta sheets: up to 90%. For the diagonal cut – unique and patented – shaping of several different products using the same sheet (up to 30% more than competitors).

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**TORTELLINI TO A T**

Only the combination of love of tradition and twenty years' experience in the production of automatic shaping units for filled pasta could develop industrial machines with the capacity to produce tortellini and tortelloni that seem handmade. Indeed, our high performance machines follow to a t the manual techniques of the dexterous Emilian "sfogline" (female pasta makers), thereby guaranteeing continuity with the local tradition.



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Referring the cholesterol to 100 parts of dry matter a value of 0.082% DM is obtained.

Having obtained this datum, not by direct analysis on the pasta but via a calculation, when evaluating the number of eggs used in the pasta the contribution connected to the phytosterols is omitted and the sterols in the egg will be considered as if they were represented by the cholesterol only.

Calculation of the number of eggs in accordance with Presidential Decree 187/01:

$$\text{No. of eggs} = \text{cholesterol (g/100g DM)} \times 4 / 0.095 = 3.5 \text{ per kg of flour}$$

Calculation of the number of eggs in accordance with Presidential Decree 66/13:

$$\text{No. of eggs} = \text{cholesterol (g/100g DM)} \times 4 / 0.080 = 4.1 \text{ per kg of flour}$$

Analytical determination of the number of eggs with the gravimetric method of the total sterols expressed as



digitonids for a well-known industrial pasta dough.

Taking into consideration an industrially manufactured dough in which 238 g of egg are used for each kg of flour.

The characteristics of the eggs used are as follows:

- dry residue: 23% (min)
- sterols: 0.4% (min)
- lipids: 9% (min)

For the dough manufactured in these conditions the sterols were determined by means of the official method, the results of which are provided below:

Samples	Sterols (% DM)	Number of eggs per kg of flour
sample 1	0.149	4.17
sample 2	0.158	4.55
sample 3	0.149	4.17
sample 4	0.164	4.80
sample 5	0.149	4.17
sample 6	0.170	5.05
sample 7	0.149	4.17
sample 8	0.137	3.66
sample 9	0.149	4.17
sample 10	0.150	4.21

As can be seen, when using a higher quantity of egg product than that established by law, in most cases a number of eggs is found which is lower than expected.

Conclusions

Determination of the sterol content in products present on the market highlights how, despite manufacturers using quantities of eggs which are always higher than the minimum quantity stipulated in the relative standard in force (the addition of just 4 eggs per kg of flour corresponds to approximately 14-15% egg in the dough), under Presidential Decree 187/2001 4 out of 7 cases showed a sterol value below the minimum limit; the situation would improve only in part with the adoption of Presidential Decree 66/2013 which would result in 2 products out of 7 being outside the legal limits.

The data provided also shows how, although from a mathematical point of view the use of an egg defined here as "standard" (sterols = 0.371%) when added to 200 g per kg of flour would apparently be sufficient to reach a sterol content in the dough equal to 0.130 % DM, as is to be introduced by Presidential Decree 66/2013, the fact of the matter is that analytical determination does not reveal this concentration at all, the data collected in



fact shows that of the 100% of the sterols introduced with the egg into the dough, the official analytical method detects just 85%.

The considerations outlined above highlight how today's pasta manufacturers are faced with a burdensome inconsistency which penalizes them in terms of the market and in terms of the supervisory bodies; observance of the indications provided in the standard when the dough is made, i.e. using 200 g of egg per kg of flour, may in many cases risk being considered a marketing fraud when analytical verification is performed.

In conclusion, although Presidential Decree 66/2013 moves closer to the technical/production reality of egg pasta, it does not completely solve the problems and the inconsistencies mentioned above; to resolve these problems it is believed that the following should be defined:

- the standard cholesterol content of the eggs and egg products; only in this way, once the minimum quantity of egg added for each kg of flour has been defined, will it be possible to establish the quantity of cholesterol added with the eggs and the definitive sterol content which one can expect to find in the pasta.
- a more up-to-date official analytical method for the determination of sterols; on this topic instrumental analytical techniques, for example Gas chromatography (GC-FID) would appear to be more precise and accurate compared to the current gravimetric method of determination; another advantage which this technique would offer is the possibility to determine the quantity of cholesterol, a parameter which is closely linked to the quantity of egg added as this substance is not found in flour.
- a tolerance towards the bottom of the minimum sterol limit in the pasta in order to bear in mind situations where egg distribution during the dough making process may not be uniform, a problem which cannot be overlooked, especially in artisanal and small-scale industrial settings.

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presidential decree 66/2013 and egg pasta: **appafre's appeal**



by **Luigi Pelosini**

Secretary-General of APPFARE

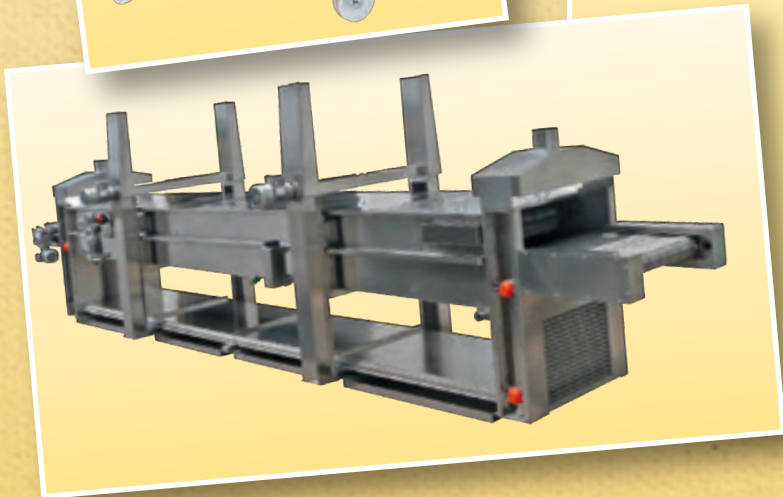
APPFARE's position on the new regulations governing egg pasta set to be introduced by Presidential Decree 66/2013. According to the Italian Association of Small/Medium Fresh Pasta and Gnocchi Manufacturers and Artisanry paragraph 3 in the Decree needs to be revised.

Presidential Decree no. 66 of 22 January 2013 has amended paragraph 3 of art. 8 of Presidential Decree no. 187 of 2001 which indicated the analytical parameters for ascertaining the egg content in pasta, parameters arrived at by means of an official reference method indicated in the Ministerial Decree of 23 July 1994.

Unfortunately, however, we find that merely reducing the quantity of ethereal extract from 2.80 g to 2.50 g and of sterols from 0.145 g - 0.13 g per 100g of dry substance does not solve the problem of establishing the real egg content in pasta.

What our pasta manufacturers hope is that before Presidential Decree no. 66 is published in the Official Journal, the aforementioned paragraph 3 will be rewritten to include indications on the analytical methods needed to determine more accurately the number of eggs used to make the pasta.





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de matteis, new cogeneration plant

De Matteis is focusing on cogeneration. In other words on the simultaneous production of both electricity and useful heat from fossil fuel combustion. The company from Irpinia has in fact had a plant built, one of the largest in Campania, designed to optimize production and safeguard the environment by reducing CO₂ emissions. The plant built by Grastim J.V. (a Neapolitan leader in this sector which operates in various European countries) makes it possible to increase efficiency in fuel usage by over 80%, leading to lower procurement costs and lower emissions of pollutants and greenhouse gases. Usually conventional power stations are characterized by low energy efficiency: only 40-50% of the thermal energy locked in the fuel is actually converted into electricity, while the rest is released into the environment unused. Cogeneration on the other hand ensures that the heat generated is used in production processes or on a civil level to heat buildings.

annoni becomes american

122 years after it was founded, the Annoni pasta factory is changing family: it is becoming American. The company with its head office in Fara Gera d'Adda, in the Province of Bergamo (Italy) has in fact been acquired by Pasta Lenzi. This company, although it has its head office in Verolanuova in the Province of Brescia, actually belongs to AIPC (American Italian Pasta Company), the biggest pasta manufacturers in North America. What's more, AIPC belongs to Ralcorp Holdings, an American multinational with an overall turnover amounting to 5 billion US dollars. Pastificio Annoni, Italy's number one producer of egg and durum wheat cannelloni, and the second largest egg and durum wheat lasagna manufacturer, has 36 employees and in 2011 registered a turnover of over 11 million Euros, double the sum recorded five years earlier. The last few years have been very positive for the company which is why the surface area occupied by the plant grew from 4,000 to 8,000 m² with the opening of a new production line, involving an investment of 3 million Euros and bringing the daily production capacity up to 45 tons of finished product. Pasta Lenzi on the other hand produces different types of pasta but is specialized in organic, premium, egg and gluten-free pastas. In 2011 its turnover reached 36 million Euros.



fad, the double-sheet ravioli maker for **medium- and large-scale production plants**

High levels of performance, incredible sturdiness and exceptionally easy to sanitize: these are the features, guaranteed by the usual design and construction standards applied by Pasta Technologies Group, which make the FAD double-sheet ravioli maker the ideal shaping machine for medium- and large-scale production plants.

Following the demands and requests of the modern pasta manufacture, Pasta Technologies Group has developed a double-sheet ravioli forming machine really practical and extremely versatile that boasts to a 'truly' complete clearing and fulfil the hardest international standards in themes of hygiene and sanitization.

The main frame of the equipment as well as the forming die are manufactured using high quality stainless steel to offer the best resistance to chemical corrosion and aggression from cleansers and additives used during the daily washing operations.

The die which contains the forming and cutting rolls and the rods-rack for the stuffing, can be easily disassembled from the main body and washed thoroughly in all its parts without risk of corrosion or deterioration due to chemical agents.

The design of the machine is developed with a special care to areas of contact between the pasta sheet when processed and the moving parts of the machine itself: all cinematics and drives of the main motors are grouped and 'separated' from the product contact area, a stainless shoulder assures this separation and guarantees maximum hygiene and the maintenance of high standards of security against the proliferation of bacteria and microorganisms.

The machine is available in two models to meet the specific needs of production and flexibility that characterizes each pasta factory: model FAD 540 is designed to satisfy the medium - large industry to work raw pasta sheet 540 mm wide and guarantees high production volumes, even up to 800 kg/h with the smaller double sheets ravioli. The smaller machine can process a 300 mm pasta sheet and it is widely used in today's market small industries or in workshops



that aim to flexibility and prompt responds to the consumer requests. The laminating unit placed over the forming is provided with micrometric calibrators and large diameter rollers to laminate the raw sheet gently without compromising its elasticity. The motor speeds are independents and controlled by a VSD inverter of the latest generation so to satisfy the request of the forming die (acting as a master) and so the plant productivity necessities. The exclusive pre-setting of the machine allows to operate the change of fresh pasta format in just few minutes, after having removed the die group, replacing it with a new one is really a matter of few minutes. Thanks to the PTG technology the synchronization of the molding - cutting - filling movements takes place in an automatic manner with no needs of manual rough adjustments. The new forming die is automatically controlled by PLC integrated in the electrical cabinet as new 'ricetta' so that all the production variables such as time, number of strikes, filling speed are set and memorized (by the PTG technician) and therefore repeatable, but this is not all: the PLC programmable logic consents to add new ricette and then new pasta formats can be processed.

Following the research of a continuous improvement in order to optimize the forming process, PTG has implemented the original pattern and found a technological solution for the dosing of the filling, to guarantee that the right amount of



filling goes into the fresh raviolo format.

The micrometric adjustment of the amount of filling is possible thanks to the calibrating screws which act on the feeding channel net section while a jet-pulse system uses pressurized air spray to push all the filling inside the ravioli belly during the forming. This technology in concomitance of a PTG patented system to create the raviolo pocket through the use of vacuum, ensures particularly creamy and sticky stuffing, also with different granulometry, decreasing the risk of smudging and obtaining a perfect sealing of the same.

The filling is usually managed with a lobe pump with the characteristic variable lobe sections that permits a constant and uniform feeding even with the classic ingredients like meat and creamy filling made of soft cheese, without damaging the organoleptic properties of product.

According to the particular needs of the Customer, the machine is provided with a set of accessories and optional that help client in the management of the process and increases the level of automation and plant reliability. Among these, the scraps recovery group complete of blade cutter and pneumatic transport from the forming to the mixer allows to recuperate and reintroduce in process the scraps.

The electrical cabinet is supplied with the push-button control panel, with touch screen for the management of the production parameters via pre-set recipes.

The forming machine mod. FAD is designed to be easily placed in a fully automated pasta plant to minimize the operator presence for maintenance or just for the supervision of the machine activity. Once integrated with a PTG mixer & kneader system, it becomes a complete automatic plant for the production of fresh filled pasta.

The machine is manufactured in full compliance with the requirements of the most strictly safety regulations required by nowadays international markets.

The versatility of the machine is guaranteed by the possibility of using different dies to produce not only the classic rectangular ravioli shape, in mini and max size but also agnolotti and half-moons, triangles and sun-flowers, with specifically designed solutions to meet every requests.

TECHNICAL FEATURES OF THE FAD MODEL DOUBLE-SHEET SHAPING MACHINE

	FAD 300	FAD 540
sheet width (mm)	300	540
hourly production rate, fresh pasta* (kg/h)	250-400	500-900
output capacity/1'	fino a 160	fino a 160
overall dimensions WxLxH (mm)**	2400x1800x1700	2600x1800x1800
installed power (kW)	4.2	8
weight (kg)	800	1600
* indicative production capacity, variable depending on the size and characteristics of the ravioli produced		
** overall dimensions taking into account the feed system (filling pump)		



Together with high performance double and single sheet forming machines, Pasta Technologies Group is proud to offer the manufacturing and installation of complete turn-key pasta plants for the production of pasteurized fresh pasta, pre-cooked and ready meals as well as a wide range of thermal treatment systems.

Nowadays Pasta Technologies Group has a consolidated position on international markets with customers ranging from medium handicraft pasta wholesalers to the modern processing industry and our machines are everywhere recognized for the high quality construction and for meeting the more rigorous standards in on hygiene and sanitation of the machine.

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made in italy pasta

record exports in 2012



by Carlo Pisani

Revenues in pasta sales over the 2 billion Euro mark (8% higher than in 2011). Overseas is still a good reason for investment.

The year 2012 saw a boom in Italian pasta exports. With the Germans still heading the list of most loyal consumers, they are closely followed by the French and British. However, things are moving faster above all in emerging countries, thanks to a surge in sales in large countries such as Russia, China and Brazil, where last year exports were able to catch the wave of rapidly increasing demand.

In other words, the overseas markets still represent a good reason for investing. The big groups know it, as do the smaller-scale companies, which continue to look beyond the borders with high expectations and confidence.

On the other hand, spaghetti and maccheroni sell better compared to other products, even those in the same food section, because they are cheap, sought after and a favourite in terms of image when it comes to tastes and trends.

Especially in those markets where full potential is still not being met and where the number of pasta consumers (although still small at this present time) is destined to grow at an exponential rate, offering enormous business opportunities for all companies operating in this sector.

The overall report, although still incomplete in terms of official statistics (the month of December still has not been included in the annual balance sheet), provides a mathematical certainty that exports have exceeded the record 2 billion euro mark.



A mega-turnover, reached in the past only in 2008 (a year in which prices skyrocketed however due to the sharp increases in wheat prices), which incorporates over the last 12 months an excellent trend in physical shipments of Italian pasta.

The figures, up to and including November, confirm an overseas revenue of around 1.9 billion Euros. If to this figure we add the 170 million Euros (minimum) in exports expected for the month of December, the overall result should reach somewhere in the region of 2.1 billion. A total which crowns the success of the Italian pasta makers, with export volumes in the meantime reaching 1,000,733 tons up to the end of November, meaning an overall annual increase of 2.4%.

The turnover, as it emerges from the relative data, has marched at an even faster pace, growing by a more robust 7.8% compared to the January - November period of 2011. A monetary performance which incorporates, as well as an increment in the quantities exported, an increase in prices of around 5%, with one kilo of Made in Italy pasta selling for an average price of €1.09 Fob (Free on board), as opposed to the €1.04 recorded in 2011.

When it comes to the different types of pasta, overseas markets above all reward traditional dry pasta shapes.

Exports (almost one and a half million tons in the 11-month balance sheet) have been able to experience a growth of approximately 3 percentage points, bringing one billion and 360 million Euros into the coffers, 9% more than a year ago. On the other hand, overseas sales of egg pasta are struggling somewhat, with 80,000 tons exported (-0.3% compared to the first 11 months in 2011) and revenues exceeding the 140 million Euro mark (+5%).

Amongst the other reference markers, positive developments can be seen in the shipments of filled pasta (108,000 tons, +1.6% over annual sales) in a year which on the other hand has “frozen” the figure referring to exports of cooked and ready-made pasta at 73,000 tons, the same levels recorded in 2011.

The price effect however has ensured that even these two categories have been able to record a marked improvement in turnover in 2012, with an increase of 3% and almost 7% respectively.

In terms of destinations, European countries still remain the Italian pasta makers' main market outlet, taking two thirds of the exports in terms of monetary value and a similar figure in terms of volumes. Both in the EU and the rest of the world, pasta exports have been able to experience growths of over 2 percentage points. But beyond the EU confines, turnover has grown at a more substantial rate (+11%) compared to the figure recorded in the European Union (+6.5%), making the most of both the price lever and the novelty factor associated with typical Made in Italy products, especially in South-East Asian markets and a few Middle East countries.

When it comes to Italy's customers, Germany remains top of the list. In the year 2012 the German market absorbed 5% more than the quantities recorded in 2011, totaling approximately 370,000 tons (estimated). Close behind is France which hovers around the 300,000 ton mark. The market north of the Alps has not however recorded growth of any particular note, nor has the British market (approximately 260,000 tons). Taking into consideration that Italian pasta exports to both Paris and London have grown by just a few tenths of a point (+0.3/+0.4%), turnover has still managed to increase by over 6%.





DOUBLE SHEET FORMING MACHINE

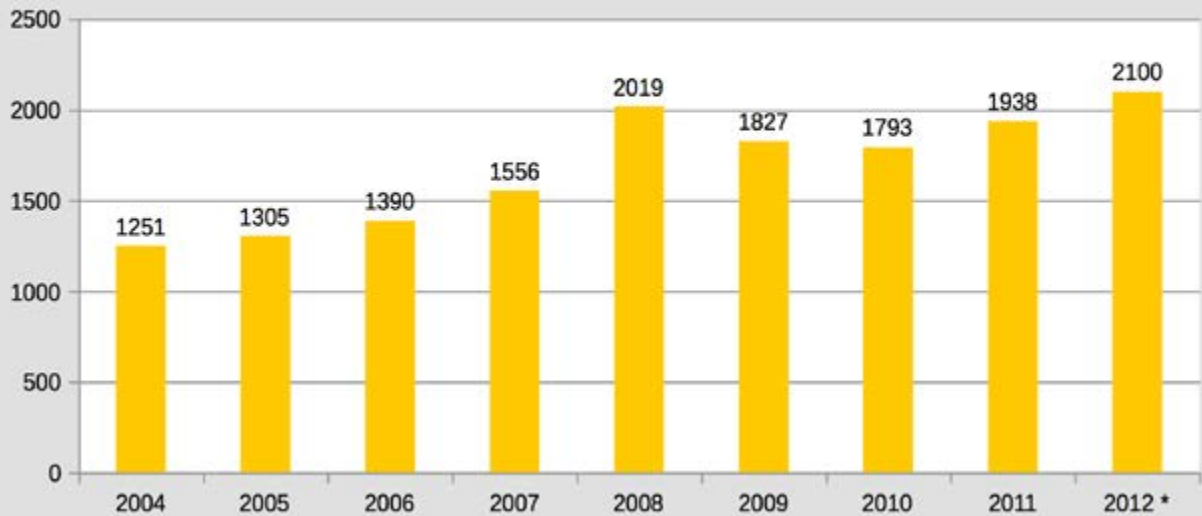
Suitable for industrial production of double sheet ravioli in different sizes, with various filling having different thickness. Maximum sanitization, ease employment and maintenance, high production efficiency are the main features of this machine, which is different from the traditional ones for the above mentioned peculiarities.

Sheet width: from 300 mm.

- The machine is provided with a patented system which creates vacuum, that permits the use of creamy filling without any leak, assuring a perfect sealing;
- Interchangeable dies provided with trolley for an easy handling;
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- Filling distribution system to the die;
- Conveyor belts transporting the sheet from the calibrator to the forming die;
- Scraps return system to the mixer with cutting group;
- Operator panel with touch screen for the supervision and the control of the machine.



Trends history for Italian pasta exports (in millions of Euro)



Source: data processing by Pastaria using ISTAT (Italian State Statistics Institute) figures - (*) Pastaria estimate

Out of the traditional markets, worthy of note are the positive results achieved in the US sales campaign, with exports (over 150,000 tons in the overall 2012 forecast) showing a growth of 7% in terms of volume and 18% in terms of monetary value. Also in Japan, which stands at fifth place in the reference market, things are going better than expected with over 90,000 tons of exports, corresponding to a growth of 3% from one year to the next (+8% in monetary value). The balance sheet for sales in Benelux and Australia is excellent while in both Spain and Scandinavian countries exports over the last 12 months have come to a standstill.

Of the less traditional outlets, the growing importance of the Russian market is being felt, where both Horeca (Hotel, Restaurant and Catering) distribution and off-trade channels (traditional retail, department stores, etc.) have given momentum to Italian pasta sales which have shot up to around 32,000 tons (+12%). In the same area, Uzbekistan, Tajikistan and Kazakhstan are all promising goals. The role of Brazil is also worthy of note, where, with 20,000 tons (roughly the same amount as is exported to Poland) growth appears to be quite strong (+9%).

A giant leap forward of over 60% has been recorded in China, where exports have now almost reached the 10,000 ton mark. Much weaker on the other hand is progress in Hong Kong, Singapore and Taiwan, markets which in any case have recorded positive levels of sales in 2012. While in the Middle East, exports last year recorded a growth of 9%, with positive developments above all in the United Arab Emirates and, to a lesser extent, Israel, while sales in Saudi Arabia remain stationary.





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garofalo focuses on social aspects and eco-sustainability

The Garofalo pasta factory is placing its focus on the community. Not only the real community that purchases and eats pasta but also the virtual community which surfs the net for information. For both these communities, the company is investing in cinema, the Internet and eco-sustainability. For example, with the support of Nokia Italia, Garofalo has launched the free iPhone and Android application “Gente del Fud” (“Food People”): in a little over a year, no less than 360 Italian food bloggers have become involved in the project and have talked about the gastronomic delights of Italy and relative producers. The app is part of a wider project, the “Social Fud Network” which intends to publish information sheets on Italian products and producers as well as recipes. Furthermore, via the app it is possible to access gastronomic itineraries, add contents or report new producers in the hope of promoting some of the smaller businesses. For some time now the company has been investing in cinema, putting its name to cinematographic productions such as Erri De Luca’s short film “Di là dal vetro” (Beyond the Glass) and last but not least it is also focusing on eco-sustainability. In fact “Garofalo numero zero” (Garofalo Zero) is a pack of pasta made using “zero km” raw materials and eco-sustainable packaging and was presented at the 8th edition of the Salone Internazionale del Gusto (International Taste Exhibition).

“starting again with pasta”: granoro launches a project in trani prison

Let’s start again. Also thanks to pasta. This is the idea behind the project set up by the Granoro pasta factory in the women’s prison in Trani. “Starting again with pasta” is a training course for ten prisoners which deals with the production of dry pasta made from durum wheat semolina. Joining in the partnership are the Factory del Gusto and the prison management. The idea was thought up by two women: Marina Mastromauro, CEO of Granoro S.r.l., and Bruna Piarulli, Deputy Warden of the prison. The initiative underlines the importance of work in the social reintegration of prisoners.



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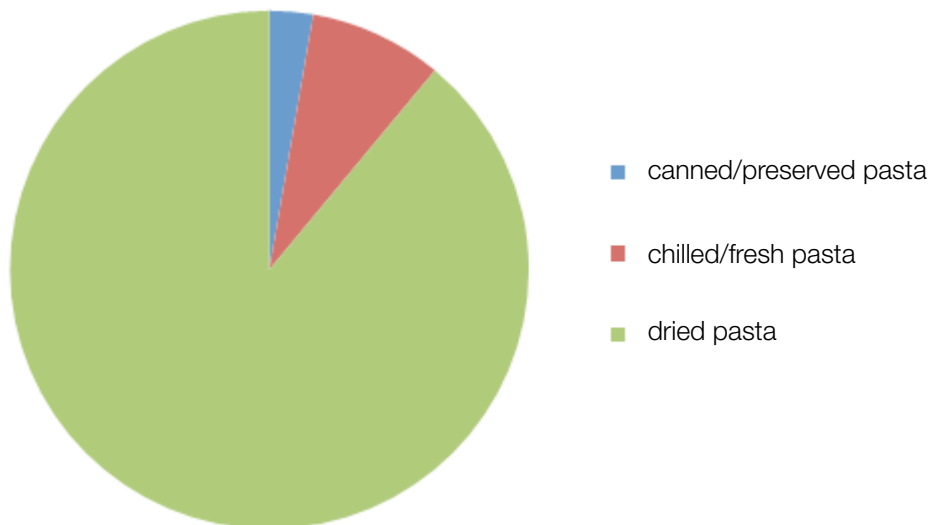


pasta in united states

by Euromonitor International

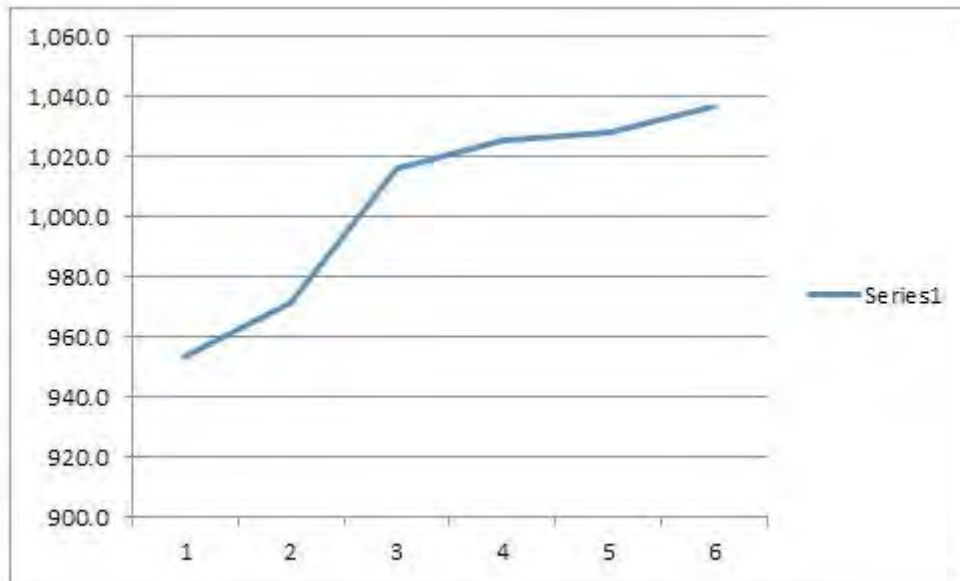
Positive results are shown by the latest **data on pasta trends in the United States**. Prospects are looking good for gluten-free pasta and more in general for health-food and functional pasta aimed at special diets.

According to Euromonitor International, retail sales of pasta have witnessed growth in both value and volume terms in 2011 and 2012. Pasta's positioning as a quick and low-cost home meal helped the



Pasta in United States - Retail volume 2012

('000 tons)



category to maintain sales during the recession, as Americans had turned to cooking pasta at home instead of eating out.

While dried pasta dominates, fresh pasta represents the fastest growing category in 2012, with current value and retail volume sales growing by 3% and 2% respectively, according to Euromonitor International. Fresh pasta is benefiting from consumers' perception of it as a healthier and tastier alternative to dried pasta.

One of the fastest growing health and wellness pastas is gluten-free pasta. While accounting for only a small fraction of overall pasta sales, gluten-free products have grown at twice the rate of the category. Pasta health and wellness trends will continue in the next five years. According to Euromonitor International, health and wellness pasta products are expected to account for 12% of total pasta retail volume sales and 24% of retail value sales by 2017.

For more information: <http://www.euromonitor.com/pasta>





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- **QUOTA DI MERCATO PASTA FRESCA IN EUROPA: 60%.**
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- **A.P.P.F. in sinergia con U.N.I.P.I.** è associata, quale rappresentante nazionale, ad E.C.F.F. (European Chilled Food Federation), associazione che annovera le più importanti associazioni europee del settore (C.F.A., SynaFap, ecc.).
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pasta lab by zindo, a complete, space-saving pasta production system



An example of a Pasta Lab set up at a recent demonstration

A **complete pasta production system** capable of producing an infinite number of pasta types and shapes, modular and space-saving, not only is it ideal for anyone who is planning on starting up an artisanal pasta business with limited funds but also for large companies where it can be used as a pilot system for testing out new products.

Increasingly more convinced that local artisanal production, with its enormous variety and specialty of shapes, is a resource which can be extended over much wider horizons, Zindo Pasta Machines & Processing in Barletta (Italy)





has perfected a compact pasta production system which can produce 25 - 30 kg/h of fresh regional pasta, filled and extruded pasta, long- and short-cut pasta. Whether they are made from durum wheat semolina, egg or gluten-free pasta, all the shapes can be pasteurized and pre-dried ready to be packaged in MAP or subsequently dried. By applying technologies and experience in automated industrial and semi-industrial lines, Zindo offers small production facilities the opportunity to increase the shelf-life of their products while still maintaining an artisanal quality, thus making it possible for them to increase their consumer catchment area.

In fact the Pasta Lab includes shaping machines which can make most types of pasta shapes because it can alternate production, making regional pasta, double-sheet ravioli of any shape, long- and short-cut extruded pasta as well as all pasta types made from sheeted dough.

The real mainstay of the Pasta Lab however, is the Pasto-dryer, a dual function machine which can turn out a pasteurized product with just the right level of humidity ready for MAP packaging, a feature which is particularly useful in filled pasta production.

The system comes complete with a work top for weighing out and packaging the pasta, indicating the type of pasta and the sell-by date, so that it can be marketed on a wider scale.

Designed to be modular, functional and space-saving, the Pasta Lab provides an opportunity to enter and establish oneself in the fresh pasta business with only a minimum initial investment.

The simplicity of use and flexibility in production, switching from one shape to another, make it possible to produce



small batches and rationalize stocks based on sales, an aspect which is particularly important for filled pasta. It is also suitable for large-scale companies, especially those abroad, where it can be used as a pilot system for testing and carrying out market analysis before actually investing in lines dedicated to specific products.

To summarize the plus points incorporated in the Pasta Lab, we can say:

- installation space is kept to a minimum
- it can produce an unlimited number of pasta types and shapes
- the modern design means that the pasta is made in full view
- it is extremely easy to use and clean
- no extraction duct required
- it requires only a moderate level of investment and is easily financed.

for further information

It's quick, easy and free. Contact the company by filling in the form or use the email or phone number: **+39 0883 510672 • info@zindo.com**

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felicetti & scabin at identità golose 2013



Pasta is back in the spotlight at **Identità Golose 2013** (Milan, Italy 10-12 february).

With Monograno Felicetti at Identità Golose 2013 pasta is thrown into the spotlight thanks to the rediscovery of the main course and of tradition, in perfect harmony with the theme of the event.

The awareness campaign advertisement that accompanies the start of all European Championship football games is called 'Respect'. Clarence Seedorf is the first testimonial of this video clip promoting respect regardless of race, gender or age. The exchange of t-shirts and smiles among the characters evokes a kind of respect which is too often





Davide Scabin

overlooked, in society as well as in sports. It is not by chance, therefore, that the fundamental and revolutionary value of respect was chosen as the main theme of Identità Golose 2013. Respect for nature, for raw materials, for clients. And the clients' respect for chefs and food professionals.

"For me, respect simply means acting responsibly" says Riccardo Felicetti, president of Italian pasta-makers. "It means acting responsibly in every aspect of our day-to-day work: selecting ingredients, creating quality products, striving for innovation. But it also means respecting the centuries old tradition of pasta-making."

The Felicetti stand was full of surprises: pasta from Northern, Central and Southern Italy. Each type of pasta has been analysed, studied and re-elaborated by Davide Scabin, with whom Felicetti went on a kind of round-the-world trip. Europe, America, Asia. "Recently" Felicetti explains, "we have successfully shown that pasta can be presented in many different ways. In 2013 we have rediscovered tradition, locally sourced ingredients, reproducible recipes and respect for the chef who, after an extenuating process of trial and error, of adjustments and changes, of asking himself and others whether he was on the right path, has offered a contemporary interpretation of this tradition."

Davide Scabin, chef of the Combal Zero in Rivoli, adds: "My job is to give pleasure and inspire feelings. Such pleasure can be standardised. And this is the chef's real satisfaction: letting himself be openly and willingly copied. This time respecting tradition and that marvellous invention called pasta".



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la casa del **tortellino**



It goes by the name of “La casa del tortellino” and is located in Angri, in the Province of Salerno: this is the artisanal production facility for fresh and dried pasta run by the Orlando family.

The Agro Nocerino-Sarnese is the area which the Romans knew as Campania Felix (“fertile countryside”) extending from the fertile foothills of the Lattari Mountains as a verdant paradise dotted, at this time of the year, with the joyful, golden fruit of citrus trees all the way from Naples to Salerno (Italy). The small farms which decorate the plain stretch



out as orchards and neatly cultivated fields.

Angri, a small historical town, is home to the “Casa del Tortellino”, today run by the young Gioacchino Orlando, a graduate in Food Science and Technology. The name of this pasta factory may seem out of place (or rather out of region) but Gioacchino’s father, who founded the company in 1992, used to work in the field of precision machinery, forging dies for fresh pasta and it is from here that his interest in pasta making stems. In a Southern environment, where nearly everyone goes by a nickname, Carminuccio, better known as “Tortellino” (it goes without saying that his wife is “Tortellina”) first opened his pasta factory thanks to the money he earned from the expropriation of a small piece of land. He soon began to go beyond fresh pasta making, setting about dry pasta production which today is in the hands of his son Gioacchino. The latter has given a local and organic stamp to all the products used which must strictly (within the limits of possibility) all come from the surrounding regions: the

ricotta is produced locally, sometimes it comes from Nolano, just a few kilometres away while the most widely used cheese is the local provola. The milk comes from Jersey cows farmed in the area which produce a truly special milk in terms of nutritional value. Special care is given to selecting the flour for fresh pasta, which is produced by a



Gioacchino Orlando





well-known mill in the north of Italy, and the durum wheat semolina for dry pasta, which comes from Apulia and is characterized by a particularly high protein content. Kamut and spelt flours on the other hand come from Umbria. The pasta factory also uses local hard wheat: the “Senatore Cappelli” durum wheat comes from the Avellino area and four years ago the pasta factory discovered the precious “Saragolla” durum wheat supplied by Terra Madre and “Carosella” wheat.

They make numerous types of fresh pasta: cannelloni, crespelle and ravioli, which distinguish themselves thanks to the most imaginative fillings possible: aubergine and provola, artichokes and ricotta, while the latest invention is a filling made from local potatoes with provola cheese. But in terms of overall production, the feather in their cap is given by their dry pasta products which comes in around 30 different shapes. Seaweed pasta tagliatelle, rich in plankton, give the taste buds an immediate flavour of marine freshness and are packed with fibre. Like the salicornia, the seaweed comes from the Gulf of Policastro or the Cilento Sea. The flour for the bio Quinoa pasta, which at long last is seeing a revival in the food world and is rich in complete proteins, comes via a fair trade channel. But the lemon used to flavour the spaghetti couldn't but come from the local region, together with the savoury but not sweet Bagni squash used for the scialatelli which are currently a big thing in the “in” restaurants of Naples Today this strange and savoury squash, once known quite simply as the “long of Naples”, has put its place of origin, the area around Nola and Sarno, back on the map, while at the same time boosting the local agricultural economy.

The dry pasta shapes are numerous, from fusilli, to paccheri, scialatelli, tagliolini and spaghetti alla chitarra and they are all made in thicker or thinner formats, the legacy of the past's notorious poverty which sustained the underprivileged of the Kingdom who lived above all on pasta.

The family company employs five people, three family members and two employees and produces approximately





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900 kg of pasta a week, between dry and fresh pasta products. The production facility, measuring approximately 200 m², is equipped with a drier where the pasta is dried at temperatures not exceeding 37°C. On the interior wall of this modern appliance hangs an image of St. John the Baptist, patron saint of the region. Carmine, Gioacchino's father, never used to carry out the first drying tests without the Saint's picture affixed on the inside wall. Now, the old image is still there, watching over the drying procedure, and believe it or not, it always comes out perfect. The rest of the manufacturing process is semi-manual, the pasta is drawn through bronze dies and the end product is distributed all over the region. Fairly decent trade has also been established via the factory's web site and now they make a weekly delivery of pasta to France. Gioacchino's creative pasta is often sought after by Michelin star chefs who are continually experimenting in the kitchen. Today at the Casa del Tortellino, tradition is set for perpetuation





with the arrival of baby Carmine, who will grow up surrounded by the perfume of flours and grain, his DNA incorporating the age-old passion inherited from Grandpa Carmine and his father Gioacchino.

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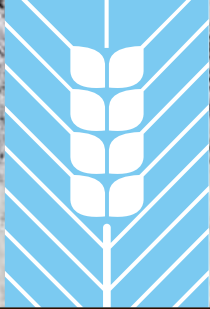
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Linea Pasta Fresca

the art of flour

The journey we have embarked upon thanks to Chef Enrico Bartolini and his book, "PASTA", has led us this month to a very sophisticated dish. A unique recipe emboldened with a modern touch ... coffee. A marriage to be savored and enjoyed.

The origins of pasta go back to the dawn of time

The first traces of pasta we have are tools used for its making and cooking, found in an Etruscan tomb. As early as the period immediately following Christ, the cook Apicio talks in his cookbook about something resembling lasagne, and around the year 1000 we have the first documented pasta recipe in the book, *De arte Coquinaria per vermicelli e maccheroni siciliani* on types of Sicilian pasta, written by Martino Corno, chef to the powerful Patriarch of Aquileia.

Pasta was certainly well-known in Arab countries, where even today they speak of "makkaroni". And from the Arab world it spread to Greece and Sicily.

In fact, historically, Palermo was the first real pasta capital because it is here that we have the first documentation of the production of dried pasta on an artisan and mass level.

In 1150, Arab geographer Al-Idrisi reports that in Trabia, 30 km from Palermo, "they make a lot of pasta in a string shape that is exported

widely, to Calabria and to many Moslem and Christian countries, including by ship".

So pasta's history goes back millennia, continuing up to the present with tagliolini.

Tagliolini are a type of egg pasta typical of Italian cuisine and are included in the list of traditional Italian food products from the Molise region, but they are also part of Piedmont cuisine, where they are better known by the regional name of *tajarin*.

Tradition has it that when knife cut, tagliolini should be as long and thin as a classic julienne. When made using a pasta machine, however, they are 2 or 3 mm wide and should be cut to a length of about 20 cm.

This means that irrespective of how they are made-by hand or machine-a very elastic flour that is easy to handle must be used to avoid waste.

00 Pasta Oro® Molino Pasini flour is perfect because of its extraordinary elasticity and is especially suited to making fresh pasta sheets. It has many advantages because it maintains its natural yellow color without turning gray for several days, retains excellent texture and bite during cooking, including for pre-cooked pasta dishes, and also boasts good body and a rough surface to allow sauce to cling better.

It remains elastic in both manual and machine pasta-making.

So, we hope you try this recipe and remember, there will be many more in future issues.

Buon Appetito!



The Molino Pasini Star of the Year is 
Enrico Bartolini
Devero Ristorante

Tagliolini

with cheese fondue and coffee sauce

4 servings:

250 g of fresh sheeted pasta (made using 00 Pasta d'Oro® Molino Pasini flour from the Farina del Mio Sacco fresh pasta line and eggs).

For the fondue:

200 g whole milk;
200 g Valdostana fontina cheese;
5 egg yolks;
salt;
white pepper;
coffee;
butter;
vegetable stock.

To prepare:

Roll out the pasta into a thin sheet and roll up like a jelly roll, then cut into julienne slices and "fluff" the cut pasta with your hands to separate it. Cook the tagliolini in boiling salted water, drain, and toss with the butter and stock until creamy.

For the fondue, heat the milk in a double boiler, add the cheese and when it reaches a temperature of 75°C, add the first yolk and gradually add the others, incorporating the last when the temperature is 80°C. Bring to 82°C and salt and pepper to taste.

To serve:

Spread the gratinéed fondue on the plates, arrange the tagliolini on top and sprinkle with coffee.

I always use the coffee of Gianni Frasi of the Torrefazione Giamaica in Verona, and for this dish I utilized his Haiti Komet blend.



the **fabianelli** pasta factory obtains **brc** certification

After Kosher certification, BRC certification has now also been obtained. The Fabianelli pasta factory with its Fabianelli, Pasta Toscana and Pasta Maltagliati brands has obtained British Retailer Consortium certification.

This document, born in the United Kingdom, is one of the most widely used tools for assessing the quality of the suppliers of products destined for large retail outlets. Judgment is based on food safety requirements and controls performed on the product, process, personnel and working environments. "This certification allows us to confirm our reliability, genuineness and safety to all our partners operating in EU markets where meeting the BRC standard has now become an essential requisite", the company declared.

With regards to Kosher certification on the other hand, this concerns the nature and handling of the ingredients as well as the whole production process, reflecting dietary customs outlined in Old Testament Jewish law. Basically it certifies that nothing "foreign" is mixed in with the basic pasta ingredients. The kashurt market attracts Muslims but also those customers who are looking for higher quality products and consequently it is growing at a rate of around 12% a year.

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di martino: tax benefits from the campania region

An agreement which aims high. The key words are “production” and “internationalization”. The Di Martino pasta factory and the Campania Region have signed a 32-month program agreement which envisages tax benefits to the tune of over three million Euros and will lead to the creation of 15 new jobs. With this document the Region is launching a complex investment program, at a time of economic crisis, in the hope of promoting one of the region’s historical businesses.

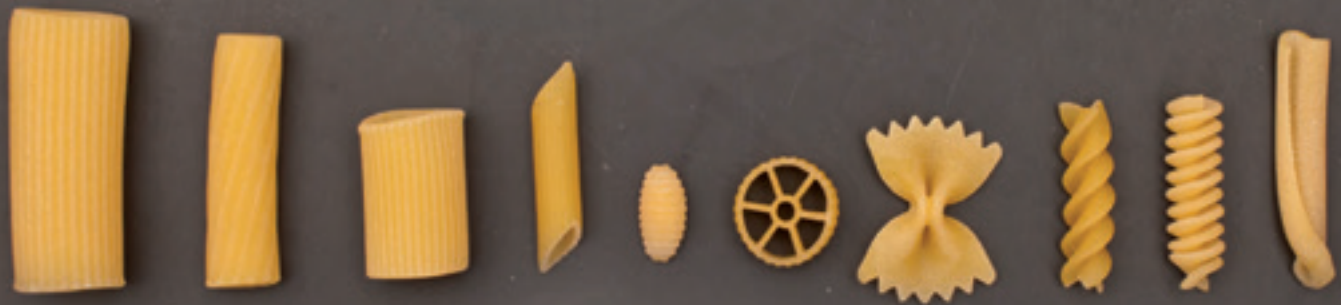
The “Pastificio De Martino” has in fact been operating in the pasta sector since 1912. There are two historical factories in Gragnano, while a third plant was opened in 2007 in Pastorano, in the Province of Caserta, which produces lasagna and nested pasta. The following year the company entered the British market thanks to participation by LDH Ltd., (a leading food distributor) in the company’s share capital. What’s more, as of last year the Group also manages, under a business lease, the historical Amato pasta factory in Salerno. The pasta factory’s products can also be found on the shelves of large retail outlets thanks to business relations above all with Auchan and Ipercoop.

falbo imperiale chieti football sponsor

The Falbo Imperiale pasta factory will be sponsoring the Chieti Calcio football club up until the end of 2014. Arthur Pedace, the managing director of the company (whose brand operates above all overseas) explained that the idea of the pasta factory, based in the Province of Cosenza, becoming a shareholder in the club shouldn’t be excluded. “For me football is a whole new experience,” said Pedace. “At the moment we are acting as Chieti’s sponsor. But in the future, who knows?”. “It is possible that Pedace may take on an important role in the club” confirmed the marketing manager of the football club, Biagio D’Aniello.



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PRODUCED

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PRODUCT

OVER 30%

OF THE WORLDWIDE
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crisis and **european union**



The economic and social situation currently being experienced by many of the countries in the Eurozone is increasing the resentment of those who not only blame the European Union for being incapable to handle emergencies, but even for the international crisis itself. The number of people itching to leave the European Union increases by the day, but a similar increase is observed in those who firmly believe that the only road to recovery is to strengthen the EU. Let's hear the opinion of some Italian pasta producers: **Mimmo Giglio**, **Davide Muscas**, **Fabrizio Cavarero** and **Michele Fiorillo**






The international financial crisis and the debt situation of certain countries in the Eurozone has led to another flare-up of the debate for and against the European Union. A monetary union, without a unified tax and political system, and the differences between the regulations and standards of the Member States makes this Europe a giant with feet of clay, always running the risk of failure, both in its individual initiatives and in its work as a whole. Many are convinced that restoring full autonomy to the individual Member States would finally make it possible for the national economies to get back on their feet. But we mustn't be fooled into thinking that there is a common opinion, because views on the matter are many and varied, and often conflicting. For those (including authoritative opinion leaders) who do not agree with Europe as it is today, there is an equal number of people who, while conceding the need for a number of adjustments, believe nonetheless that an organisation like the European Union is indispensable and, indeed, that it should be given even greater weight and more wide-ranging powers in order to be able to respond to the crisis effectively.

Whatever the position assumed, the fact remains that the European Union is anomalous, due to two elements that make it an exceptional case: a single monetary policy which does not correspond to a centralised tax policy. Quite the opposite: the individual States make their decisions independently on the basis of a precise and strict budgetary discipline, but in a market where goods circulate freely. But this is an anomalous and restricted model, and time has proved it to be unable to handle either day-to-day business problems or serious emergencies, such as the one currently in course.

Added to this is the fact that the countries making up the European Union do not all have the same economic and social situation. Some have weaknesses that others do not have and the integration policy applied up until now – notwithstanding all the efforts made and the funds spent – has not succeeded in compensating for these differences. Not all the peripheral countries have tools for bridging the competitiveness gap and this forces them to



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take actions, e.g. salary cuts and reduction of the presence of the public sector in economic activities, that affect the internal demand, thereby creating a vicious circle and further problems which continue to exacerbate each other.

But although this line has been demonstrating its limits for some time now, the possibility of abandoning it has not yet been considered. Quite the contrary. Notwithstanding the widespread discontent, the subject of a change of course has not yet been broached in an explicit and official manner. At the same time, the disorientation of our governors, at both European and national levels, on how to handle the future – even the immediate future – is blatant. They really just seem to be improvising.

The chorus of voices according to which the monetary union project is heading for failure is becoming ever more insistent, claiming that rather than continue to absorb such high social costs, it would be better to restore to the single States the autonomy and decision-making powers they had before. This position is not only shared by those who think that they are paying the price for the inefficiency of the peripheral countries, but also among poor or marginal countries which firmly believe that Europe, rather than improving the situation, has exacerbated a condition that was already detrimental to them from the start.

Another line of thinking maintains that the only way out is to strengthen the European system, by creating the political union that is lacking today. The monetary union is not supported by just one State, and this anomalous situation presumably prevents general problems from being tackled by means of a single action, a consistent line and a unified front.

Undoubtedly, a more integrated Europe could be the right answer for problems common to all of its members, but we are not the United States of America, which was gradually built up over centuries of history, and in very different times indeed! Perhaps the Member countries still have identities and past experiences that are too diverse and these differences prevent the cohesion required to face difficult times like the present. What binds people together are not documents, nor laws drawn up around a table.

A very different type of glue is required.

But it is not our intention to enter into a debate on the real advantages of remaining in Europe. Given that this type of analysis is difficult even for authoritative economists and sector specialists, our only aim is to sound out the mood of those who work and produce each day, and those who are experiencing the day-to-day reality of this Europe.

The first of these is Mimmo Giglio, owner of a pasta factory in the centre of Palermo, who voices his opinion as follows: “We, in Sicily, are in the suburbs of the suburbs, not only because there is an abyss between Italy and countries such as France and Germany, but also because of the distance that separates the regions of the Southern Italy from those of Northern Italy. It’s difficult to achieve integration in a country with such profound differences. There is too much disparity. We are not only peripheral from a geographical perspective. Not just for



INSIEME PER ESSERE PIÙ FORTI!

A.P.P.A.F.R.E. è stata costituita a Milano, il 28 febbraio 2002, da imprenditori artigianali della piccola e media impresa di pasta fresca e gnocchi, per meglio tutelare gli interessi di una categoria di produttori, troppo spesso dimenticati.

I nostri associati, sono oggi finalmente riconosciuti dalle istituzioni e dal mercato, come categoria di pastai che rappresentano la vera tipicità e la migliore tradizione culinaria italiana, fiore all'occhiello del MADE IN ITALY, riconosciuta ed apprezzata all'estero.

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that. We are peripheral in a general sense, due to the inadequacy of the infrastructures and services. Despite this fact, Europe expects us to make a huge effort to come into step with situations that are incredibly more advanced than our own, demanding that we close, in an impossibly short time, a historical gap that it will take decades and unprecedented efforts to close. It imposes upon us stringent and strict rules which we can no longer submit to and which are likely to ruin us. The irresponsible management of the government accounts in Italy over the last few decades is now forcing us to make unparalleled and often even illogical sacrifices. A classic example of this is IRAP (editor's note: regional tax on productive activities), a tax which does not take labour costs into account. This fiscal pressure is intolerable and is generating extremely heavy social consequences in addition to economic ones. And yet no-one seems to be concerned about it. If all this is a consequence of our being in Europe, perhaps we could have done better without it. The point is that backtracking now would be no easy task, even if we wanted to". We reply that perhaps, at the time, choosing to stay outside of the European Union might not have been such a good move for Italy, but he promptly retorts: "There are countries that managed to keep their distance from this Europe, or that only became involved to a limited degree. Great Britain, for example, very astutely, chose not to enter the monetary union and today its financial and economic situation is much better than ours. But we have always allowed ourselves to be totally conditioned by the European Union and I'm not so sure that this is always an advantage."

Also Davide Muscas, owner of Pastificio Calitai in Assemini, just a short distance from Cagliari, is convinced that Italy would be better off without Europe. "From what emerges from the media, it appears that each decision taken at a European level reflects the exclusive wishes of France and Germany, as though the other States did not have any say in the matter and were always forced, against their will, to conform. So I wonder what the real advantages actually are for us to remain within a system like this, where we have no real weight. But there are also other considerations to be made. I think that, in terms of climate, culture, territory, language, history and much more besides, the nations making up the European Union are very different from one another. This means that their needs differ greatly, from one country to another. So a legislative provision that may be necessary in one State could be perfectly useless in another, and vice versa. This can lead to the passing of superfluous provisions in some contexts and – on the contrary – failure to consider important problems in others. Moreover, the question does not only concern the food sector but also many other sectors." concludes Muscas.

So far, the uneasiness regarding the European Union seems to be rather widespread, but not everyone believes that Italy's current problems are attributable to Europe. Some, on the contrary, are convinced that with the right adjustments, Europe is the only way out in order to resolve the economic and social difficulties that the western world is experiencing. One of these people is Fabrizio Cavarero, co-owner of La Cucina delle Langhe, a pasta factory in Dogliani, in the province of Cuneo. "Italy's problems are mainly attributable to Italy itself and not to Europe. The State should create the right conditions to enable us to work better, but it doesn't, and this penalises



us on all fronts. From bureaucracy to the tax burden, running a business in Italy has become tremendously difficult. It is sufficient to cross the Alps to see that in the other countries of the EU, the situation is completely different. Certain obligations and prohibitions are purely local, and not imposed by the European Union, as some try to fool us into thinking,” maintains the Piedmontese pasta-maker. Quite in contrast with his colleagues, Cavarero believes that Europe is an excellent opportunity for trade. In his opinion, the free circulation of goods helps open up the markets but, even more important, Italian products have excellent opportunities to penetrate the northern markets. In the past, perhaps due to difficulties connected with the transportation of goods or issues related to the life of the product, fresh pasta – for example – was only consumed where it was produced. But now it is enjoyed at great distances from its production area. But if this is possible it is unquestionably due to the fact that the European Union has facilitated passages and mechanisms that years ago were slow and chaotic, preventing the delivery of fresh products within a tolerable period of time. In all this, Europe has certainly been of help. “The individual States should believe more firmly in Europe and give up a little of their own power to strengthen the European Union. The only solution to the crisis is integration, but we must all be willing to play our part.” concludes Cavarero. So, in a nutshell, there are many ways of viewing the problems, some of which are at opposite extremes. On one hand, some maintain that the European Union is to blame for our current economic and social situation, while others believe that the blame lies with the thoughtless and irresponsible way in which the Italians manage government accounts and funds and that, for this very reason, the role of Europe should be strengthened, in order to play a greater or lesser role in controlling countries that are unwilling to manage their accounts more efficiently. Still others tend to stand somewhere in the middle, like Michele Fiorillo, partner of the pasta factory bearing the same name in Piscopio, in the province of Vibo Valentia. “Our accounts, which are in a state of total disaster today, have to be rectified not because Europe demands it of us, but for the simple reason that we cannot go on like this unless we want to end up like Greece. We are at risk of default and, after all, the European Union is only operating in our interests. For decades we have lived above our means, spending money that we didn’t have, and now the accounts just don’t add up. The tendency would be to continue to increase the debt, but we can no longer follow this line”, maintains Michele Fiorillo, who adds: “unfortunately, at the present time, Europe is making us pay the price for a euro which is very strong against the dollar and this is discouraging the exportation of products outside of the Eurozone. Something ought to be done about this. At the same time, the EU should exercise a more protectionist policy, or at least be more vigilant regarding what enters its territory. The product standards that are drawn up in situ are extremely strict, but the same strictness should also be exercised with regard to imported products and foods. European health and hygiene regulations are very stringent and rightly so, and they are continuously updated, but they do not always guarantee that food products are safeguarded and protected as they should be. On this point there is still room for improvement.” concludes Fiorillo. As always, the pasta sector does not just respond with criticism, but also with valuable suggestions.



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salmonella: better food safety with uv-c, even in artisanal production facilities



On the whole, when preparing food products containing eggs, the risk of Salmonella is always just around the corner. **The use of UV-C lamps** during the delicate stage of mechanical egg breaking can help minimize risks, without necessarily hindering optimum production performance, even in small artisanal production facilities.

Toxinfections caused by poor hygiene standards adopted in the preparation of foods containing eggs are being reported increasing more often. In the case in point, food infections which are the major cause for concern, and consequently taken into consideration herein, are Salmonellosis. In fact, in 2006, Salmonella was behind 53.9% of



reported food toxoinfection cases (EFSA, 2007).

Basically one assumes that the food manufacturing process uses eggs from certified producers, not to mention creamy egg products which have been treated at high temperatures (pasteurization, heat treatment, UHT treatment). Despite this however, the risk of contamination must still be assessed, not only because of the critical nature of the hazard itself, but also because suppliers cannot give a one hundred percent guarantee that eggs are salmonella-free. Furthermore, artisanal production facilities often use locally produced eggs, which on the one hand may have better organoleptic characteristics and taste but on the other may be subject to fewer industrial food supply chain controls, and consequently there is a higher risk of them being sources of food toxoinfections.

A need to guarantee food safety has been created and from this a system regulating hygiene and self-control in food production processes has been developed, known as HACCP (Hazard Analysis and Critical Control Points). This self-control hygiene system, based on the principle of preventing food contamination hazards, aims to assess and estimate hazards and risks as well as to establish control measures designed to prevent health and hygiene problems from arising, as defined by EC Regulation 852/2004.

This approach is based on the assessment and systematic control of the risks of biological, chemical and physical contamination during the various stages of food processing and pin-points those delicate stages in the process which may represent critical points.

In the preparation of food products, one of the critical points in microbiological risk assessment is represented by the handling of eggs and the egg breaking process.

Contamination of shelled eggs with *Salmonella enteritidis* occurs mainly due to exogenous (horizontal) contamination and endogenous (vertical) contamination caused by bacteria harbouring hens. Exogenous contamination occurs when the egg shell comes into contact with contaminated environments and by potential subsequent penetration of the *Salmonella* through the tiny pores in the shell which leads to proliferation of the bacteria inside the egg itself. Eggs coming into contact with hen feces is one of the most frequent causes of *Salmonella* contamination; the bacterial load normally present on the shell is in fact represented mainly by Gram-positive and Gram-negative bacteria of enteric origin, including bacteria of the *Salmonella* strain.

The location of *Salmonella*, usually on the surface of the egg, makes it possible to remove the risk of contamination before the egg is actually used.

Even though in food production facilities the eggs in question have usually already undergone external disinfection processes (dry or steam heat treatment, IR or UV radiation, plasma sterilization, etc.), it is still good practice to perform further processes to ensure a lower risk of contamination, thus giving the consumer an even greater guarantees on the food safety of products.

Some of these common practices involve the use of chemical disinfectants which are highly effective, however, quite often they may damage to the egg cuticle making the shell more permeable and consequently exposed to a higher



risk of bacterial penetration (such as with *Salmonella spp*), not to mention the fact that any residues left behind by the disinfectants and detergents may also lead to chemical contamination of the eggs.

Consequently, an alternative means of treatment should be introduced to decontaminate eggs in their shells also at this stage of the food supply chain for egg-based products.

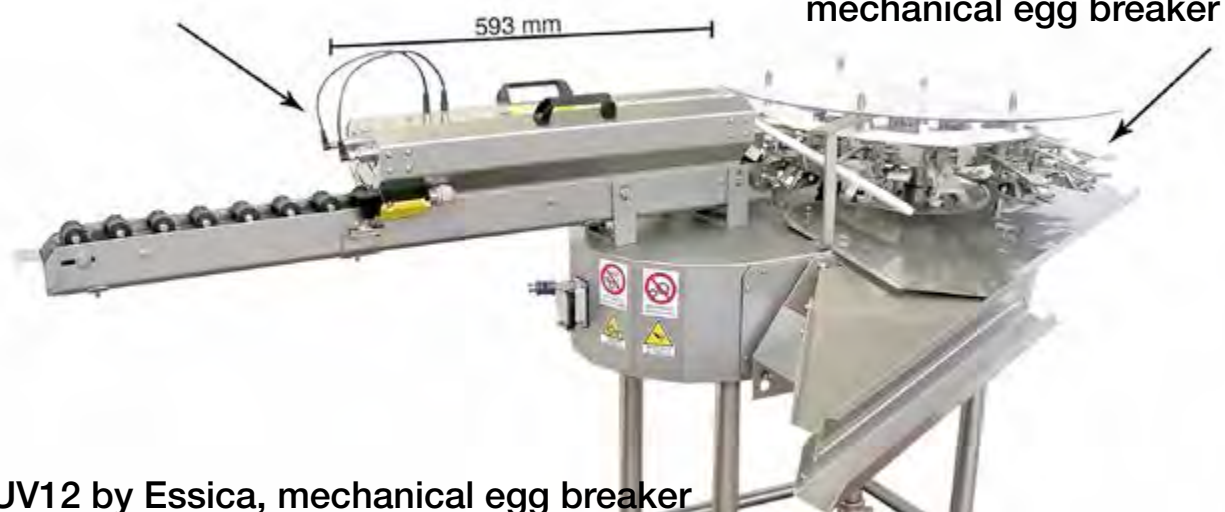
Food-safe egg breaking - new technology from Essica

Essica, a company in Maserà di Padova (Italy) which manufactures systems and technology for the preservation and production of fresh pasta, has perfected new technology to bring an egg sanitization process to the mechanical egg breaker (a machine which significantly speeds up production) by adding a tunnel fitted with UV-C lamps through which the eggs transit (the UV12).

This is useful above all for those products which are not subsequently subjected to heat, for example in confectionary applications, but also to prevent shells from contaminating other surfaces in the plant, operators' hands and equipment, etc..

UV-C radiation offers the advantage of being non-invasive, as the rays do not penetrate the shell, thus avoiding those problems associated with the physical and nutritional degradation of the egg; potentially it is very effective in the abatement of most classes of microorganisms and is easy to use.

tunnel emitting UV-C radiation



UV12 by Essica, mechanical egg breaker combined with a tunnel emitting UV-C radiation



By introducing this process, the risk of bringing *Salmonella* contamination into the production plant is reduced significantly and the need to use chemical disinfectants is eliminated (with obvious benefits).

This new Essica technology springs from the recent application to its mechanical egg breaker (a machine which has already been on the market for some time and is installed in many pasta production facilities) of a tunnel preceding the egg breaking phase which holds two EDT 2030 lamps emitting UV-C beams (254 nm), 10 W in power and 593 mm in length. The egg breaking speed is adjustable and can reach a rate of up to 3600 eggs/h.

Assessment of the bactericidal effect which the UV12 egg breaker has on *Salmonella* spp

Essica asked 3ALaboratori S.r.l. in Maserà di Padova (Italy) to carry out tests in its analysis laboratories to assess the true effectiveness of the antibacterial action provided by the UV-C rays incorporated in Essica technology on the shell of eggs contaminated with *Salmonella* spp.

The bactericidal action was tested in the analysis laboratory by artificially contaminating the shells of a number of eggs with different concentrations of *Salmonella* spp and then subjecting the prepared samples to treatment using the UV12, setting different operating speeds and assessing the effectiveness of bacterial abatement performed by the lamps installed on the egg breaker at various exposure times.

Method

During the first stage of the experiment, the eggs were sanitized by UV-C radiation for approximately 20-30 minutes to ensure total abatement of the bacterial load on the surface of the eggs.

After preparing bacterial cultures of *Salmonella* spp in Petri dishes, the day before testing bacterial solutions were prepared using enriched broth which were then left to incubate at 37°C for 24 h.

The following day the concentrations thus obtained were measured by means of turbidimetric techniques and a number of diluted solutions were prepared so as to have the concentrations required for each test as summarized in the table below.

BACTERIAL CONCENTRATIONS OF THE SOLUTIONS, IMMERSION AND DRYING TIMES			
	Bacterial conc. of immersion sol. (CFU/ml)	Immersion time (minutes)	Drying time (minutes)
test I	9×10^8	20	30
test II	9×10^6	20	30
test III	9×10^4	30	30
test IV	5×10^5	20	30



As stated, the eggs destined for each different test were immersed in the corresponding bacterial solution for approximately 20 minutes, they were then removed and left to dry for another 30 minutes under a laminar flow hood.

The eggs then underwent UV-C treatment using the UV12 device at the times and speeds indicated below for each test/concentration.

SET SPEED FOR TESTING, EXPOSURE TIMES AND PRODUCTIVITY			
	Set speed (%)	Time of exposure to UVC (seconds)	UV12 productivity (eggs/h)
test I	100	8	3600
	70	11.5	2500
test II	100	8	3600
	70	11.5	2500
test III	100	8	3600
	70	11.5	2500
test IV	100	8	3600
	70	11.5	2500
	50	18	1800

For each test and each exposure time applied to the egg, 2 analyses (A and B) were carried out.

Two eggs for each test, on the other hand, were analyzed without undergoing any UV-C treatment (untreated control eggs).

Finally the bacterial load of *Salmonella spp* present on the shell of the treated and untreated eggs was assessed. More specifically, the eggs were placed in sterile bags and immersed in 100 mL of peptone water, they were then adequately stirred for 1 - 2 minutes so that the whole bacterial load present on the egg shell was transferred into a solution ("recovery solution").

Counting of the CFUs for each egg was carried out using two different methods:

- quantitative analysis by inoculating 1 ml of "recovery solution" and any dilutions on non-selective growth medium, followed by incubation at 37°C for 24-48 hours.
- quantitative analysis by filtering a volume of "recovery solution" (10 or 50 mL) through a 0.45 µm membrane and subsequently transferring the membrane into a Petri dish containing non-selective growth medium, followed by incubation at 37°C for 24-48 hours.

Finally the number of colonies on the Petri dishes for both methods of evaluation were counted and the number of CFU/egg were calculated for each test.



Summary of mean effectiveness:

Mean effectiveness when used at 100% Speed = 97.7% abatement

Mean effectiveness when used at 70% Speed = 98.2% abatement

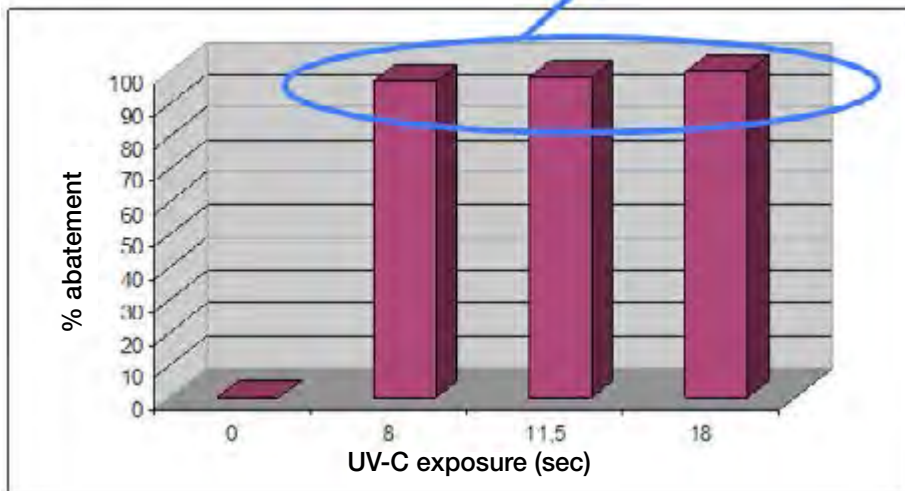
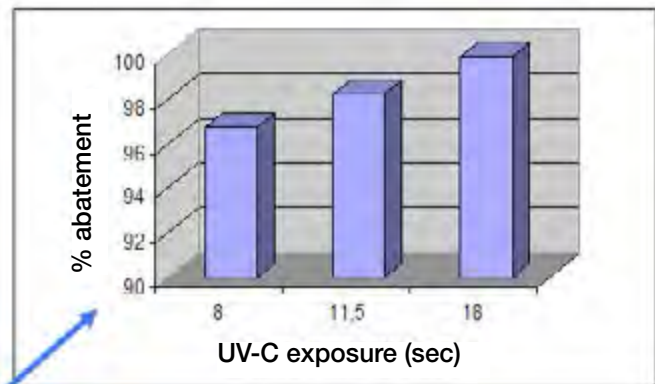
Mean effectiveness when used at 50% Speed = 99.9% abatement

From the figures provided above, it can be seen how treatment with UV-C radiation using the UV12 obtained good results in terms of abating the Salmonella load on the shells of artificially contaminated eggs.

In fact, starting with different concentrations of contamination, percentages of abatement are obtained which on average stand at 97.7%, for operating speeds of 100% (corresponding to approximately 8 seconds of exposure to UV-C radiation), and up to 98.2% when exposure reaches approximately 11.5 seconds (operating speed set at 70%). Only one test was performed for the lowest applicable machine speed (50%) for the simple reason that this setting is not commonly used as it does not optimize the primary function of the machine, i.e. to break as many eggs in the least possible time. This test however still supports the obvious proportionality of results which shows a greater abatement of the Salmonella load in keeping with the higher exposure to UV-C (at 18 seconds, the exposure obtained at 50% speed, abatement stands at around 99.9%).

The figures in this page illustrate graphs highlighting the effectiveness of abatement depending on UV-C exposure time.

The graph on the left highlights and compares the effectiveness of abatement at the various



exposure times (8, 11.5 and 18 seconds) compared to the time zero which refers to those eggs which were artificially contaminated but then not treated. The percentage of abatement is a mean value which takes into consideration all the initial concentrations of contamination applied, hence the value of effectiveness does

not depend on this factor.

The graph on the right simply highlights the difference in effectiveness between the different exposure times tested.

Conclusion

The new Essica technology has therefore proved to be efficacious in its purpose, as effective abatement of the Salmonella load was observed, ranging from 97.7% at the highest speed (lowest exposure time) up to 99.9% at lower speed (involving longer exposure to the treatment).

Exposure times obviously depend on the speed at which the eggs transit through the radiation tunnel which in turn influences the egg breaking capacity of the system.

The user of such a machine is therefore in a position to choose whether to optimize higher production speeds (higher speed, lower UV-C exposure, greater egg breaking/hour capacity) or greater effectiveness of bacterial load abatement on the shell of the eggs (lower speed, higher exposure to UV-C, lower egg breaking/hour capacity) with a partial reduction in productivity.

The recommended speed optimized for the egg breaking process using the UV12 is at an average power of around 70-80% (from 2500 eggs/hour upwards) where the effectiveness of abatement is still significant (over 98%) and is suitable for guaranteeing optimum sanitization of egg shells. Furthermore, it should be underlined that most of the Category A eggs contaminated with Salmonella encountered on the market, have a contamination level lower than 20 cells/egg.

The user also has the possibility of “adjusting” the effectiveness of the machine to the detriment of production in those cases, for example, when the eggs being used do not come from industrial production or when other situations arise where higher contamination of the egg shells may be suspected, in other words he may decrease production speed and consequently increase exposure to UV-C radiation.

The UV12 egg breaker therefore meets the needs of a system which applies HACCP principles, providing a guarantee that the end product is safe and the workplace is a healthier environment for workers.

For further information: **3A Laboratori** | Via A. Volta, 1/d | 35020 Maserà di Padova (Padova, Italia) | T. +39 049 0994658
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aidepi at tuttofood

four appointments not to be missed

During the exhibition there will be four appointments, including workshops and seminars, organized by AIDEPI

For the first edition of Dolce Italia, the exhibition on confectionary products at Tuttofood, AIDEPI is organizing four appointments not to be missed which are open to all. In fact over two days, 20-21 May 2013, at four different times, seminars and workshops will be held dedicated to an audience of experts in raw materials, additives and labelling/claims. The first appointment is for Monday 20 May at 10:00 am, with a seminar organized in collaboration with Aretè (a research company specialized in economic studies in the agro-industrial sector) entitled "Materie prime agroindustriali: forecast raccolti e mercati 2013" ("Agro-Industrial raw materials: harvest and market forecasts for 2013"). The workshop will focus on forecasts based on the latest production data for some of the most important agro-industrial raw materials, including: cereals, milk and dairy products, sugar, cocoa, eggs. Furthermore forecast indications will be given on market trends for the raw materials in question. Speakers will include sector experts of national renown. The second appointment will take place on the same day at 2:00 pm and goes by the title "Linee guida AIDEPI sulla corretta applicazione della nuova regolamentazione additivi" ("AIDEPI guidelines on the correct application of the new regulation on food additives"). Representatives from the Ministry of Health and the Istituto Superiore di Sanità (National Institute of Public Health) are expected to take part. The workshop will be followed by an interactive session during which participants will have an opportunity to ask questions and request further details on the topics discussed. The third appointment will be held on the following day, Tuesday 21 May at 10:00 am and is entitled "II° workshop AIDEPI Etichettatura - il regolamento 1169/2011: come costruire le nuove etichette" (2nd workshop AIDEPI Labelling - regulation 1169/2011: how to create the new labels"). Again participants will be able to listen to indications provided by representatives from the Italian Ministries of Health and Economic Development, in an integrated perspective of the new dispositions indicated by European authorities. This workshop will also be followed by an interactive session during which participants will have an opportunity to ask questions and request further details on the topics discussed. The fourth AIDEPI seminar will be held in the afternoon of 21 May from 2:30 pm onwards and is to be seen as a close examination of the topic of the Claims standard, with particular focus on the situation in Italy with regards comparative claims following the sentences issued by the AGCM (Italian Competition Authority).



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What about you, how do you read Pastaria? Send us a photo of you reading our magazine to redazione@pastaria.it. We will be happy to publish it.



another big success for **taste**



More than 13,500 visitors over the three days dedicated to taste at the Stazione Leopolda in Florence

The eighth edition of Taste (Florence, Italy, 9-11 March 2013) closed at the Stazione Leopolda, with important results in terms of numbers and quality.

nce more, for nearly a whole week, the fair organized by Pitti Immagine – the brainchild of gastronaut Davide



Paolini – transformed Florence into the Italian capital of excellence for taste and foodies.

The most significant figures regard the attendance of buyers and members of the trade: over the three days of the event, there were 3,500 registered buyers at the fair, a 6% increase compared to one year ago, an even bigger increase if we consider the total number of companies attending (+ 14%). Buyers came to Florence from all over the world (+ 38% foreign buyers), from more than 40 countries, which more or less cover all the international markets and areas: from the main European markets, the United States, Far East Asia (Japan, China, Taiwan, Hong Kong), Israel, the United Arab Emirates and Lebanon, Turkey, Mexico, Peru, Australia, etc... The best performances were by buyers from the United States, Japan and Northern Europe.

The total attendance amounted to over 13,500 visitors.

Taste has once again demonstrated its role as the reference event for quality food and wine professionals", says Agostino Poletto, deputy general manager of Pitti Immagine. "The over 280 companies at this edition met with a very high level of buyers, with many top names including representatives from department stores of the caliber of Harrods of London, Eataly of New York, and Japan's Isetan and Takashimaya, as well many other buyers from the most important niche food and wine stores in Italy and the major capital cities of the world. There was also a large public of high level foodies and connoisseurs of good cuisine, who followed with great interest all the events and Rings at the Stazione Leopolda, organized by the gastronaut, featuring top names from the Italian food and wine sector, starred chefs and food opinion-makers. We should also mention the packed program of over 120 FuoriDiTaste events that once again broke records around town, with original and interesting proposals for the general public".

There was also a lot of interest in one of this edition's brand new initiatives, the special area dedicated to three excellent niche products from Spain which launched an international presentation model that will be extended to other countries at future editions. Last but not least, there were record sales for the Taste Shop which, in three days, sold almost 22,000 products.

The winners of the third edition of "King of Catering", the only international award dedicated to catering and banqueting firms, were also announced at Taste: this year the competition's top prize – the "King of Catering Platinum Plus/Ferrarelle" – was awarded to La Fenice Catering of Faenza.

To see all the winners go to: www.kingofcatering.it



eccellenza pastaria 2013 distributed to buyers at rhex



Distribution of the second edition of Pastaria's yearbook on **products of excellence made by Italian pasta manufactures** began at RHEX.

"Eccellenza Pastaria 2013", the second edition of this invaluable book on products of excellence made by Italian pasta manufacturers, was distributed at RHEX, the new trade fair held at Rimini's Exhibition Centre (Italy) incorporating "SIA Guest e Sapore" between 23 - 26 February 2013. Just to remind you, the purpose of this yearbook is to introduce Italian and international buyers (belonging to the HO.RE.CA channel, wholesalers and retailers, large retail outlets) to special and quality pastas produced by large and small, industrial and artisanal Italian pasta manufacturers.

"Eccellenza Pastaria" is handed out to buyers visiting major food sector trade fairs.



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All organizers putting on international food sector trade fairs in 2013, who are interested in distributing free copies of “Eccellenza Pastaria” to buyers, can request the book by filling in the form below or contacting our editorial staff (+39 0521 1564934, redazione@pastaria.it).

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