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AJINOMOTO®

Application Data Sheet:
ADS_WM_CH_IM_E

Cooked Ham with Injection of ACTIVA® WM

Problem:	Unsecurity in production due to quality differences of raw material (e. g. PSE meat), high losses during thin industrial slicing, decreased connectivity in intramuscular connective tissue
Solution:	**ACTIVA® WM → addition / injection directly with the brine**
Benefits of ACTIVA® WM:	1. Improved peelability and slice stability especially with "wafer thin" slices
	2. Reduced losses during industrial slicing, less production breakdowns, increased slicing speed
	3. Improved connectivity between intramuscular connective tissue → e. g. intramuscular fat
	4. Standardization of material and process, no influence on yield

Brine Recipe:

Brine recipe with and without ACTIVA® WM (example)
(for 100 liters of brine, injection volume: 18 %)

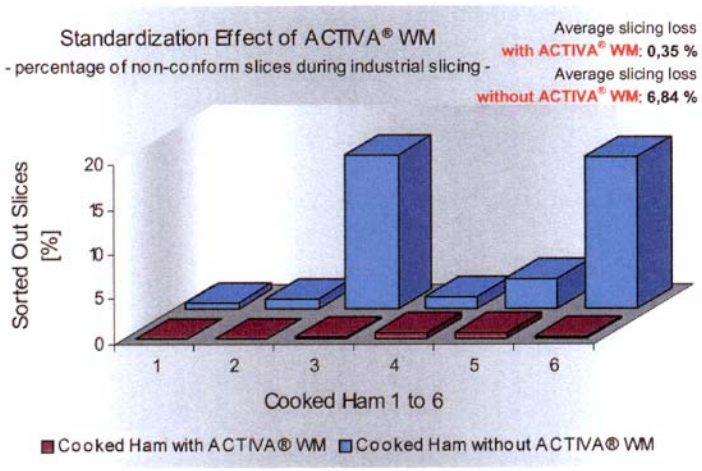
	without ACTIVA® WM	with ACTIVA® WM
Ingredient	**Weight [kg]**	**Weight [kg]**
Water	48,850 kg	48,250 kg
Ice	25,000 kg	25,000 kg
Nitrite curing salt	12,700 kg	12,700 kg
Maltodextrin	8,000 kg	8,000 kg
Dextrose	4,000 kg	4,000 kg
Glutamate	0,650 kg	0,650 kg
Sodium ascorbate	0,500 kg	0,500 kg
Di-Phosphate	0,300 kg	0,300 kg
ACTIVA® WM*1	**0,000 kg**	**0,600 kg**
Total brine	**100,000 kg**	**100,000 kg**

Manufacturing Process:

Meat selection
↓
Brine preparation and injection (18 %)
↓
Tumbling process (over night)
↓
Filling into casings or metal forms/molds
↓
Cooking process (start within 3 hours)
↓
Cooling

Cooked ham slice with ACTIVA® WM

Typical problem in cooked ham slice stability **without** ACTIVA® WM



*1 This equals approximately 1,0 gram of ACTIVA® WM per kg of end product (with 18 % injection and an estimated yield of 8 %).