

CODEX ALIMENTARIUS

INTERNATIONAL FOOD STANDARDS



Food and Agriculture
Organization of
the United Nations



World Health
Organization

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STANDARD FOR EVAPORATED MILKS

CXS 281-1971

Adopted in 1971. Revised in 1999. Amended in 2010, 2018.

1. SCOPE

This Standard applies to evaporated milks, intended for direct consumption or further processing, in conformity with the description in Section 2 of this Standard.

2. DESCRIPTION

Evaporated milks are milk products which can be obtained by the partial removal of water from milk by heat, or by any other process which leads to a product of the same composition and characteristics. The fat and/or protein content of the milk may have been adjusted, only to comply with the compositional requirements in Section 3 of this Standard, by the addition and/or withdrawal of milk constituents in such a way as not to alter the whey protein to casein ratio of the milk being adjusted.

3. ESSENTIAL COMPOSITION AND QUALITY FACTORS

3.1 Raw materials

Milk and milk powders¹, cream and cream powders¹, milkfat products¹.

The following milk products are allowed for protein adjustment purposes:

- Milk retentate: Milk retentate is the product obtained by concentrating milk protein by ultrafiltration of milk, partly skimmed milk, or skimmed milk;
- Milk permeate: Milk permeate is the product obtained by removing milk proteins and milkfat from milk, partly skimmed milk, or skimmed milk by ultrafiltration; and
- Lactose¹.

3.2 Permitted ingredients

- Potable water
- Sodium chloride.

3.3 Composition

Evaporated milk

Minimum milkfat	7.5% m/m
Minimum milk solids ^(a)	25% m/m
Minimum milk protein in milk solids-not-fat ^(a)	34% m/m

Evaporated skimmed milk

Maximum milkfat	1% m/m
Minimum milk solids ^(a)	20% m/m
Minimum milk protein in milk solids-not-fat ^(a)	34% m/m

Evaporated partly skimmed milk

Milkfat	More than 1% and less than 7.5% m/m
Minimum milk solids ^(a)	20% m/m
Minimum milk protein in milk solids-not-fat ^(a)	34% m/m

Evaporated high-fat milk

Minimum milkfat	15% m/m
Minimum milk solids-not-fat ^(a)	11.5% m/m
Minimum milk protein in milk solids-not-fat ^(a)	34% m/m

^(a) The milk solids and milk solids-not-fat content includes water of crystallization of the lactose.

¹ See *Standard for Sugars* (CXS 212-1999).

4. FOOD ADDITIVES

Only those food additives listed below may be used and only within the limits specified.

INS no.	Name of additive	Maximum level
Firming agents		
508	Potassium chloride	2 000 mg/kg singly or 3 000 mg/kg in combination, expressed as anhydrous substances
509	Calcium chloride	
Stabilizers		
331	Sodium citrates	2 000 mg/kg singly or 3 000 mg/kg in combination, expressed as anhydrous substances
332	Potassium citrates	
333	Calcium citrates	
Acidity regulators		
170	Calcium carbonates	
339	Sodium phosphates	
340	Potassium phosphates	
341	Calcium phosphates	2 000 g/kg singly or 3 000 g/kg in combination, expressed as anhydrous substances
450	Diphosphates	
451	Triphosphates	
452	Polyphosphates	
500	Sodium carbonates	
501	Potassium carbonates	
Thickener		
407	Carrageenan	150 mg/kg
Emulsifier		
322	Lecithins	Limited by GMP

5. CONTAMINANTS

The products covered by this Standard shall comply with the maximum levels for contaminants that are specified for the product in the *General Standard for Contaminants and Toxins in Food and Feed* (CXS 193-1995).

The milk used in the manufacture of the products covered by this Standard shall comply with the maximum levels for contaminants and toxins specified for milk by the *General Standard for Contaminants and Toxins in Food and Feed* (CXS 193-1995) and with the maximum residue limits for veterinary drug residues and pesticides established for milk by the CAC.

6. HYGIENE

It is recommended that the products covered by the provisions of this standard be prepared and handled in accordance with the appropriate sections of the *General Principles of Food Hygiene* (CXC 1-1969), the *Code of Hygienic Practice for Milk and Milk Products* (CXC 57-2004) and other relevant Codex texts such as Codes of Hygienic Practice and Codes of Practice. The products should comply with any microbiological criteria established in accordance with the *Principles and Guidelines for the Establishment and Application of Microbiological Criteria Related to Foods* (CXG 21-1997).

7. LABELLING

In addition to the provisions of the *General Standard for the Labelling of Prepackaged Foods* (CXS 1-1985) and the *General Standard for the Use of Dairy Terms* (CXS 206-1999), the following specific provisions apply:

7.1 Name of the food

The name of the food shall be:

Evaporated milk

Evaporated skimmed milk

Evaporated partly skimmed
milk

Evaporated high-fat milk

according to the composition specified in
Section 3

Evaporated partly skimmed milk may be designated "evaporated semi-skimmed milk" if the milkfat content is 4.0–4.5% and the minimum milk solids is 24% m/m.

7.2 Declaration of milkfat content

If the consumer would be misled by the omission, the milkfat content shall be declared in a manner found acceptable in the country of sale to the final consumer, either (i) as a percentage by mass or volume, or (ii) in grams per serving as quantified in the label provided that the number of servings is stated.

7.3 Declaration of milk protein

If the consumer would be misled by the omission, the milk protein content shall be declared in a manner acceptable in the country of sale to the final consumer, either as (i) a percentage by mass or volume, or (ii) grams per serving as quantified in the label provided that the number of servings is stated.

7.4 List of ingredients

Notwithstanding the provision of Section 4.2.1 of the *General Standard for the Labelling of Prepackaged Foods* (CXS 1-1985), milk products used only for protein adjustment need not be declared.

7.5 Labelling of non-retail containers

Information required in Section 7 of this Standards and Sections 4.1 to 4.8 of the *General Standard for the Labelling of Prepackaged Foods* (CXS 1-1985), and, if necessary, storage instructions, shall be given either on the container or in accompanying documents, except that the name of the product, lot identification, and the name and address of the manufacturer or packer shall appear on the container. However, lot identification, and the name and address of the manufacturer or packer may be replaced by an identification mark, provided that such a mark is clearly identifiable with the accompanying documents.

8. METHODS OF SAMPLING AND ANALYSIS

For checking the compliance with this standard, the methods of analysis and sampling contained in the *Recommended Methods of Analysis and Sampling* (CXS 234-1999) relevant to the provisions in this standard, shall be used.