

**PURE DAKOTA
STANDARD OPERATING PROCEDURE
EDIBLE FORMULATION**

SOP #X -Edible Formulation

Purpose-

At Pure Dakota we use different kinds of food grade edible molds that have specific filling instructions. Each specific filling instruction must be followed to guarantee the apparatus works correctly. Lab personnel will use tools within the lab to fill the edible molds successfully.

Responsibilities:

Lab personnel will begin portioning edibles once Hash has been tested and resulted. Lab personnel will fill the edible molds according to the specified instructions and set aside for packaging. Lab personnel are responsible for cleaning and sanitizing all tools and glassware immediately after the process has been completed. Lab personnel will review the instructions that adhere to the RoboCAP RL-301 VF Semi-Automatic Liquid Cartridge Filler.

Policies/Procedures:

- a. Choose the proper lot# and coinciding PDO that has a new passing result.
- b. Move the jar from the Vault to the Robot Room in Biotrack.
- c. Warm up PDO using a hot water bath or oven set to 140 degrees Fahrenheit.
- d. PDO should start to warm up and become less viscous (liquid) than it was at room temp.
- e. Formulate PDO into edible mixture and place into the mixing container. (?)
- f. Once the PDO/ (edible mixture?) has been warmed enough to pour out of the mixing container, follow **SOP# 70.1- Set-Up and Operation of the RoboCAP RL-301VF Semi-Automatic Liquid Cartridge Filler.**
- g. As (X amount of mL) edibles are being portioned by the RoboCAP RL-301VF, food grade silicone molds of 150 edibles will be briefly shown to the camera for compliance then placed into a chiller to settle/rest.
- h. After edibles have been in the chiller for (X amount of time) they will be removed from food grade mold and placed onto a clean surface lined with parchment paper.
- i. Edibles will then be coated in sugar to protect from coagulation and to help with handling during the packaging.
- j. Repeat steps G-H until the entire pressure vessel full of edible mixture has been dispensed into food grade silicone molds of size (--mL).
- k. After all of the edibles have been portioned and no residual (edible mixture) remains in the pressure vessel, follow **SOP# 70.2 - Cleaning of the RoboCAP RL-301VF Semi-Automatic Liquid Cartridge Filler.**
- l. Weekly maintenance of the RobCAP machine will need to be performed following **SOP#70.3 - Preventative Maintenance of the RoboCAP RL-301VF Semi-Automatic Liquid Cartridge Filler.**

MELT-TO-MAKE™ GUMMY DRYING GUIDE

Drying your gummies properly is a critical step in the gummy production process. It is of great importance to dry your finished gummies to the target water activity level to ensure their optimal food safety, stability and texture. A temperature/humidity gauge is required to monitor your drying conditions. We highly recommend using a dehumidifier (or humidifier for more arid conditions) to achieve a controlled relative humidity of 35% in your drying room, with a temperature that does not exceed 80°F. A water activity meter is also recommended if one wishes to precisely control the final water activity of the finished product for the most consistent end result.

DRYING TIMES WILL VARY DEPENDING ON THE SIZE OR WEIGHT OF YOUR GUMMIES, AS WELL AS THE RELATIVE HUMIDITY IN YOUR DRYING ROOM

GELATIN GUMMIES

(SUGAR COATED AND DRIED ON SHEET PANS IN A SINGLE LAYER)

Final water activity range: 0.65-0.67

GUMMY SIZE: Less than 3 g

Estimated drying time: 12-24 hours
RH in drying room: 35%

PECTIN GUMMIES

(SUGAR COATED AND DRIED ON SHEET PANS IN A SINGLE LAYER)

Final water activity range: 0.60-0.63

GUMMY SIZE: Less than 3 g

Estimated drying time: 48-96 hours*
RH in drying room: 35%

*Continue drying past 48 hours until the desired consistency and water activity level is reached.

SUGAR-FREE PECTIN GUMMIES

(WAX COATED AND DRIED ON SHEET PANS IN A SINGLE LAYER)

Final water activity range: 0.60-0.63

GUMMY SIZE: Less than 3 g

Estimated drying time: 72-120 hours
*RH in drying room: 35%

*Continue drying past 72 hours until the desired consistency and water activity level is reached.

GELATIN/PECTIN BLEND GUMMIES

(SUGAR COATED AND DRIED ON SHEET PANS IN A SINGLE LAYER)

Final water activity range: 0.60-0.63 for a higher melting point

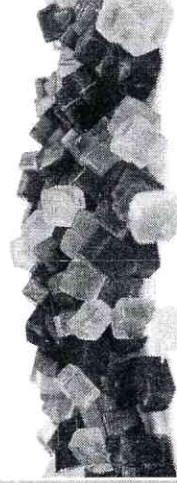
Final water activity range: 0.65-0.67 for a softer chew

GUMMY SIZE: Less than 3

Estimated drying time: 24-72 hours
RH in drying room: 35% - depending on your texture preference

WAX COATING

If you are drying your gummies in the provided wax coating, please expect that your gummies will typically take an extra day to dry.



WATER ACTIVITY METER



Click here or scan the QR code to view our Pectin equipment list including our preferred water activity meter.



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