



QUALITY STANDARDS

SPECIFICATIONS FOR ORANGE (PNFPL0008)

Santra (Hindi), Kittale (Kannada), Kamla (Tamil), Kamalapandu (Telugu)

1. GENERAL CHARACTERISTICS

Orange shall be mature, firm, juicy, well formed and shall have similar Varietal characteristics. Orange shall be free from black/ brown spots, sunburn, cut/crack, shriveling and superficial healed light brown bruised marks on skin. Orange shall have tight and smooth skin (no granulation) with intact pericarp (stem end). Orange shall have minimum 75% yellow/ orange color. Orange shall be free from internal shriveling caused by frost. Oranges shall be free from soft, bruises, bird pecks, punctured skin, hollow stem, nodes on surface and any type of mechanical, pressure and packing damage. Orange shall be sound and free from rotting (moldy rot or any other rot), insects and disease infestation. Orange shall not have any foreign taste and/or smell.

2. SAMPLING PLAN

Sampling plan-C will be followed for sampling and quality inspection of Oranges.

3. GRADES

There shall be three Grades for Orange viz., Grade-A, Grade-B and Grade-C. The size requirement for these grades shall be as follows:

4. SIZE

SIZE	COUNTS	GRADE-A (Dia.in mm)	GRADE-B (Dia.in mm)	GRADE-C (Dia.in mm)
Extra large	96	76-80	76-80	76-80
Large	141	66-75	66-75	66-75
Medium	171	56-65	56-65	56-65
Small	181-191	51-55	51-55	51-55
Extra samll	210	40-50	40-50	40-50

Note: The diameter is measured from the stem end to the blossom end.

Document No.	QSCF /(025)	Date of Issue.	01.02.2021
Date of Revision		Revision No	
Prepared by (Signature)	Approved by (Signature)		

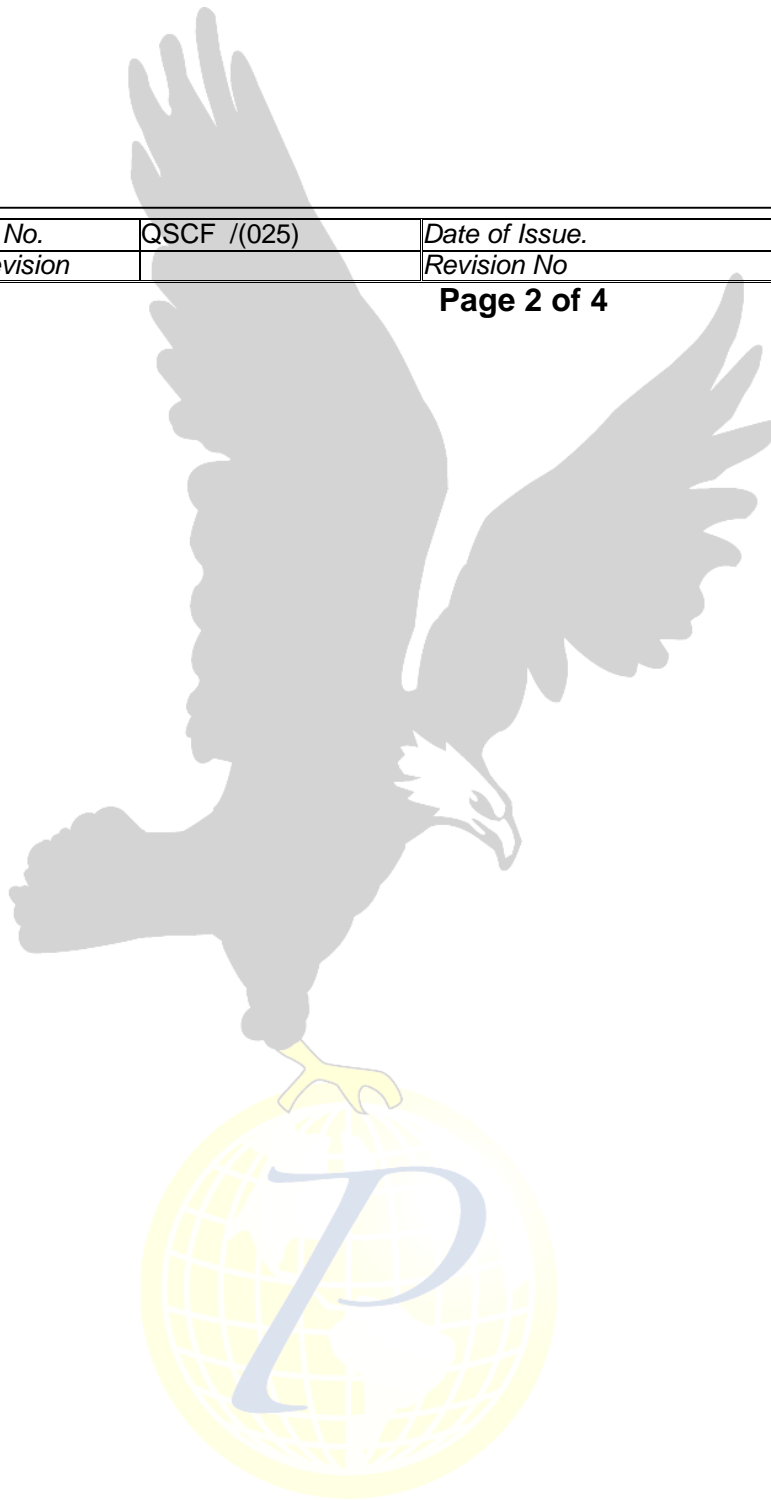
Page 1 of 4

5. QUALITY PARAMETERS

DEFECTS	GRADE-A	GRADE-B	GRADE-C
MISSHAPE	Not allowed	Allowed (slight misshape)	Allowed
GREEN COLOR	Not allowed	Not allowed	Not allowed
IMMATURE	Not allowed	Not allowed	Not allowed
ROUGH/THICK SKIN	Allowed upto 20% surface area	Allowed upto 50% surface area	Allowed
BRUISES	Allowed upto 1 sq.cm surface area	Allowed upto 5% surface area	Allowed
LOOSE JACKET	Not allowed	Allowed (Slight loose jacket)	Allowed
BROWN HEALED STRUCTURE ON SURFACE	Allowed upto 5% surface area	Allowed upto 10% surface area	Allowed
BLACK/BROWN SPOTS ON SKIN	Allowed upto 5% surface area	Allowed upto 10% surface area	Allowed
PUNCTURED SKIN	Not allowed	Allowed if no juice seepage	Allowed
UNEVEN SURFACE	Allowed upto 15% surface area	Allowed upto 10% surface area	Allowed
SUNBURN/ HARD YELLOW BROWN PATCH ON	Allowed up to 1 sq.cm.surface area	Allowed up to 5% surface area	Allowed
CUT/CRACK	Not allowed	Not allowed	Not allowed
HOLLOW STEM END	Not allowed	Not allowed	Allowed
SOFT/ PRESSURE DAMAGE	Not allowed	Allowed up to 10% surface area	Allowed upto 25% surface area
DRY LOOK	Not allowed	Not allowed	Allowed
SHRIVELING	Not allowed	Allowed upto 20% surface area	Allowed
ROTTING/ FUNGAL INFECTED	Not allowed	Not allowed	Not allowed
DISEASED	Not allowed	Not allowed	Not allowed

<i>Document No.</i>	QSCF /(025)	<i>Date of Issue.</i>	01.02.2021
<i>Date of Revision</i>		<i>Revision No</i>	

Page 2 of 4



Panama
Corporation Limited

6. GRADES AND CRITERIA FOR CHECKING

DEFECTS	GRADE-A			GRADE-B			GRADE-C		
	MINOR	MAJOR	SERIOUS	MINOR	MAJOR	SERIOUS	MINOR	MAJOR	SERIOUS
MISSHAPE	Slight misshape	Allowed	N.A.	Allowed	N.A.	N.A.	N.A.	N.A.	N.A.
GREEN COLOR	Allowed	N.A.	N.A.	Allowed	N.A.	N.A.	N.A.	N.A.	N.A.
IMMATURE	Allowed	N.A.	N.A.	N.A.	Allowed	N.A.	N.A.	Allowed	N.A.
ROUGH/THICK SKIN	Covering >20% surface area	N.A.	N.A.	Covering > 50% surface area	N.A.	N.A.	Allowed	N.A.	N.A.
BRUISES (SUPERFICIAL HEALED SKIN/ ALTERATION)	Covering 1-3 sq. cm. surface area	Covering > 3sq. cm. surface area	N.A.	Covering 5-10% surface area	Covering >10% surface area	N.A.	Allowed	N.A.	N.A.
LOOSE JACKET	Allowed	N.A.	N.A.	Allowed	N.A.	N.A.	Allowed	N.A.	N.A.
BROWN HEALED STRUCTURE ON SURFACE	Covering up to 10% surface area	Covering > 10% surface area	N.A.	Covering up to 10 – 15% surface area	Covering > 15% surface area	N.A.	N.A.	Allowed	N.A.
BLACK/BROWN SPOTS ON SKIN	Covering 5-10% surface area	Covering >10% surface area	N.A.	Covering 10-15% surface area	Covering >15% surface area	N.A.	Allowed	N.A.	N.A.
PUNCTURED SKIN	Allowed if no juice seepage	Allowed if there is seepage of juice from hole	N.A.	Allowed	N.A.	N.A.	Allowed	N.A.	N.A.
UNEVEN SURFACE	Covering 5-10% surface area	Covering >10% surface area	N.A.	Covering 10-20% surface area	Covering >20% surface area	N.A.	Allowed	N.A.	N.A.

Document No.	QSCF /(025)	Date of Issue.	01.02.2021
Date of Revision		Revision No	

SUNBURN/ HARD YELLOW BROWN PATCH ON SURFACE	Covering 1-3 sq. cm surface area	Covering >3 sq. cm surface area	N.A.	Covering 5- 10% surface area	Covering >10% surface area	N.A.
CUT/CRACK	Deep cut/ crack Up to 2 cm. long	Deep cut/ crack >2 cm. long	N.A.	Deep cut/ crack up to 2 cm. long	Deep cut/ crack >2 cm long	N.A.
HOLLOW STEM END	Allowed	N.A.	N.A.	N.A.	N.A.	N.A.
SOFT/ PRESSURE DAMAGE	Up to 10% surface area	Covering >10% surface area	N.A.	Covering 10- 25% surface area	Covering >25% surface area	N.A.
DRY LOOK	N.A.	Allowed	N.A.	Allowed	N.A.	N.A.
SHRIVELING	Up to 20% surface area	Covering >20% surface area	N.A.	Allowed	N.A.	N.A.
ROTTING/ FUNGAL INFECTED	N.A.	N.A.	Up to 1% in a lot	N.A.	N.A.	Up to 2% in a lot
DISEASED	N.A.	N.A.	Up to 1% in a lot	N.A.	N.A.	Up to 2% in a lot

N.A. – Not Applicable

NOTE:

1. Percentage of defects allowed or disallowed in a particular grade will be determined based on weight in a sample lot.
2. More than one defect in an individual piece will be considered as major defect.
3. Extent of defect not covered in minor, major & serious categories of Grade A, B & C means it is allowed in that particular grade.

7. DEFECT & SIZE TOLERANCE (BY WEIGHT)

DEFECT TOLERANCE	GRADE-A	GRADE-B	GRADE-C
MINOR DEFECTS	10%	20%	100%
MAJOR DEFECTS	2%	10%	50%
SERIOUS DEFECTS	01%	02%	05%
SIZE TOLERANCE	10%	20%	N.A.

<i>Document No.</i>	QSCF / (025)	<i>Date of Issue.</i>	01.02.2021
<i>Date of Revision</i>		<i>Revision No</i>	