The present law defining and standardizing Process cheese does not define and standardize Process Pimento cheese. The product is, in fact, practically Process American cheese flavored with pimento.

**BROOKSHIRE CHEESE COMPANY'S PLANT**

**Plymouth, Wisconsin**

**General Sanitary Condition**

The plant in which the Brookshire Company manufactures their product is a new, modern building, built for the purpose of manufacturing Process cheese, or other cheese products. The equipment is different from that in any of the other plants engaged in this business, and is designed and arranged so that it can be kept clean and sanitary. The plant was found to be in a clean, orderly and sanitary condition.

**Products Manufactured**

- Process American Cheese;
- Process Brick Cheese;
- Process Swiss Cheese;
- Process Pimento Cheese.

**Process American Cheese**

This product is manufactured from different lots, forms, sizes and grades of American cheese, as produced in cheese factories at the present time, but previously there had been added to the above named product a mixture of cheese curd and whey albumin. The cheese curd would be the ordinary curd obtained in the manufacture of American or Cheddar cheese, and the albumin was obtained by taking the whey from the previous day’s cheese making, heating it to a temperature sufficiently high to coagulate the albumin, which would carry with it some of the fat left in the whey in the process of cheese making, together with some of the milk sugar and milk salts found in the whey. The person interviewed, and with whom the inspection of the plant was made, stated that the use of this mixture of curd and albumin had been discontinued. It was also stated, that sugar
was used at one time in their product, but this has been dis-
continued, so that their Process American cheese, at the
present time, is being manufactured from different lots of
factory-made American cheese. As at other plants of this
kind, the cheese is graded when purchased, stored, and so-
called batches of cheese are assembled, with the end in view
of obtaining a finished product of good quality by selecting
the factory-made cheese going into the finished product. No
admissions were made to the effect that any definite per-
centage of No. 2, or under grade, cheese could be used.

How Prepared

After the cheese selected for the manufacturing process
is assembled, the paraffin is scraped off, bandages removed
and the outer surface of the cheese cleaned, and any defec-
tive portions of the cheese are carefully removed and dis-
carded. The cheese, thus assembled and prepared, is sub-
jected to a different process, whereby the different grades
used are mixed and blended, but not separated into batches
of any definite weight or size. The cheese is introduced
into a heating chamber by means of a worm screw or con-
vveyor, which conducts the cheese through the chamber,
wherein it is subjected to the desired temperature for a
short time. The temperature of the heating chamber is
controlled by a suitable supply of a mixture of steam and
hot air. The temperatures used for Process American
cheese, range from 140 degrees Fahrenheit to 145 degrees
Fahrenheit. The claim was made at this factory, that 99
per cent of the bacteria found in cheese were killed by the
heating process. The temperatures used are only slightly
higher than the temperatures employed for pasteurizing
milk or cream, where the milk or cream is held at pasteur-
izing temperatures for a period of from 25 to 30 minutes.
Whether or not this product can be considered pasteurized,
would depend upon the length of time the temperatures of
140 to 145 degrees Fahrenheit are maintained. If these
temperatures are not maintained for from 25 to 35 minutes,
it is difficult to understand how pasteurization can be
effected. Considerable time was spent at this plant, in
going over the factory-made cheese, with a view to learning
what quality and grade of product was being used. With
the exception of a small lot of fresh, high acid cheese on hand, it is our opinion that cheese of very good quality only, is used at this plant. It is our opinion that the cheese used at this plant, with the exception of the small lot of high acid cheese above mentioned, would sell on the open market for the full price for cheese.

The use of an emulsifying agent was admitted, the claim being made that a small amount, stated to be from 2 to 2 1/4 per cent, of Rochelle salts were being used; from 3/4 of 1 per cent to 1 per cent of dairy or cheese salt was also being used. It is claimed that, in order to produce a smooth bodied finished product of good texture, lending itself well to slicing without crumbling, some sort of an emulsifying agent is necessary. No evidence of the use of skim-milk cheese or skim-milk curd was found, but only cheese of good quality and standard composition was being used.

In the manufacture of Process American cheese this factory was for a time mixing albumin that had been obtained by boiling the whey at cheese factories, which process would precipitate the albumin. The albumin thus precipitated would carry with it quite a little moisture. This practice, however, had been discontinued as had the use of sugar.

**Process Brick Cheese**

In the manufacture of Process Brick cheese, it was admitted that from 25 to 50 per cent of white American was added at times and at times when the Brick cheese used uncured, thus lacking in flavor, about 2 per cent of Limburger cheese was added. It will thus be seen that Brick cheese manufactured at this plant is really a mixture of at least two different types of cheese and, at times, a mixture of three different types of cheese.

**Process Swiss Cheese**

In discussing the subject of manufacturing Process Swiss cheese, it was admitted that there was being used from 25 to 40 per cent of white American and, at times, slightly sour white American was used, it was stated, for the purpose of preserving the delicate flavor of the Swiss. The product, like Process Brick cheese, in at least those instances where white American is used, appears to be a mix-
ture or compound. The dry, inner rind from Swiss cheese was ground finer than it was the usual practice to grind the cheese for other varieties, and this finely ground product was mixed with American cheese to be made into American Pimento. The inner rind used, however, was clean and edible and should not be confused with the rind of cheese removed without the cheese having first been cleaned.

**Emulsifier and Additional Salt Added**

The emulsifying agent used at this plant was Rochelle salts and it was used in from two to two and one-quarter per cent amounts and the claim was made that the use of an emulsifying agent is essential in the production of a Process cheese with uniform texture and of such body that the Process cheese can be readily sliced for table use.

**Temperature to Which Cheese is Heated**

The Process American is heated to a temperature of from 140 degrees Fahrenheit to 145 degrees Fahrenheit. The Process Brick and Swiss are heated to 150 degrees Fahrenheit. The claim was made at the factory that 99 per cent of the bacteria found in the raw product was killed by the heating process. If their statement is true, the conditions of pasteurization must be met.

**Examination of Cheese in Storage**

Considerable time was spent examining the cheese in storage with a view to forming a judgment as to the quality and grade of the cheese. It is our judgment that the cheese used is of good quality and with the exception of a small lot of uncured but high acid cheese purchased for the manufacture of Process Brick and Process Swiss, was of such quality that it would readily sell for full market price as cheese on the open market.