

Chapter Ag 82

**BRICK CHEESE, BRICK AND LIMBURGER
CHEESE BOXES**

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Ag 82.01 Definitions. (1) "Department", whenever used in these regulations, shall mean the State Department of Agriculture.

(2) "Grader" is a person authorized by the department to grade cheese.

(3) "Stamps" shall mean stamps for putting factory number and date on cheese and grade mark on cheese.

(4) "Grading unit" means a cheese factory, cheese warehouse, or place where cheese is graded.

(5) "Brick cheese" is known as a sweet curd cheese. It is usually somewhat softer than Cheddar but firmer than Limburger, and when fully cured has a flavor somewhat similar to Limburger but less pronounced. It may be made from milk or pasteurized milk. It may be made with or without a pure culture starter or lactic culture or *Lactobacillus bulgaricus* or a combination of lactic culture and *Lactobacillus bulgaricus* culture.

It is coagulated with the aid of rennet or pepsin or a combination of both. The coagulum is cut with curd knives or similar equipment into cubes from $\frac{1}{4}$ to $\frac{1}{2}$ inch in size—size of cubes desired is determined by the rapidity at which acidity is formed in the coagulum. The curd in the whey is stirred gently and heated to a temperature at which the curd cubes will attain the proper degree of firmness when the desired amount of acid has developed.

After it is heated, part of the whey is drained off and if the proper degree of firmness and the proper amount of acid has developed, the whey may be drawn down to the level of the curd. When the curd is dipped from the vat to the forms, it may be dipped direct from the whey or a certain amount of water of the approximate temperature of the whey may be poured over the curds to rinse out some of the whey just prior to dipping the curd into the forms. Or, a warm salt brine solution may be substituted for the warm water.

Brick cheese is usually pressed in rectangular shaped forms and when finished should weigh from $4\frac{1}{2}$ to $5\frac{1}{2}$ pounds, but is occasionally made in 1, 2 and $2\frac{1}{2}$ pound prints.

Brick cheese is sometimes pressed in a similar manner into larger sizes rectangular in shape weighing from 10 to 11 pounds and is then known as "Jumbo Brick".

Brick cheese is made occasionally by pressing the curd in cylindrical American cheese hoops in an American cheese press and is then known as "American Style Brick".

Brick cheese is salted either by soaking in a salt brine solution or by rubbing it with and packing it in dry salt from 2 to 4 days except

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that where salt brine is poured over the curd before it is dipped into the forms, then soaking in brine or dry salting on the surface of the cheese may not be necessary.

It is usually placed on the shelves from 8 to 14 days or more, where the curing process starts. During this time it is turned every 2 or 3 days and washed with a salt brine solution.

(6) "Flavor and taste practically clean" shall mean a pleasing cheese flavor and taste developed according to the age of the cheese and clean enough to suit our most discriminating markets.

(7) "Good body" means a cheese that is firm and smooth to the touch, is not pasty, sticky, wet, weak, crumbly, mealy or acidic.

(8) "Good texture" means cheese that may have mechanical openings, may also have a few shot holes, but must not be pinholey, bloated or split.

(9) "Mechanical openings" means irregular shaped openings in the cheese due to curd particles not uniting.

(10) "Shot holes" means round shaped holes the size of B.B. shot, to about $\frac{3}{8}$ inch in diameter.

(11) "Weak" means soft, easily deformed by pressure.

(12) "Pasty" means soft and weak; paste-like consistency when massaged with the fingers.

(13) "Mealy" means crumbly, easily reduced to a condition resembling meal.

(14) "Pinholey" means having numerous holes the size of a pin puncture to the size of a pinhead.

Ag 82.02 Holding order. (1) Curing rooms shall be held at a temperature as near as possible to 60 degrees Fahrenheit, but in no case colder than 50 degrees Fahrenheit.

(2) No person shall paraffine, wrap, prepare for shipment or ship any Brick cheese made in Wisconsin unless (a) such cheese, if made during the months of May, June, July, August or September, is at least 7 days old, including the day of manufacture, and (b) such cheese, if made at any other time of the year, is at least 10 days old, including the day of manufacture.

(3) No person shall paraffine, wrap, prepare for shipment or ship any Brick cheese in Wisconsin even after the conclusion of the holding period required in paragraph (2), above unless such cheese is sound and has closed surfaces on all sides which, unless maintained with surface culture, are free of moisture and suitable for paraffining.

(4) Cheese may be moved from the shelves of the factory where made to another curing room within this state before the expiration of the holding time as provided in paragraph (2), for the purpose of completing the curing process to meet the requirements of this order, but it shall not be graded or put into the channels of trade until it meets the requirements of paragraph 3.

(5) The holding period provided in paragraph (2) shall not apply to cheese of unquestionable undergrade quality.

(6) Every person packing Brick cheese which is not individually paraffined or wrapped shall protect such cheese from contamination during storage and shipment by lining the boxes and cartons used for that purpose with moisture-resistant, grease-proof liners.

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Ag 82.03 Wisconsin state brand. Cheese labeled or sold as Wisconsin State Brand must conform to the following standards:

- (1) **FLAVOR.** Flavor and taste shall be practically clean.
- (2) **BODY AND TEXTURE.** Cheese of this grade shall have good body and texture.
- (3) **COLOR.** Cheese of this grade shall have a clear and uniform color. A plug when held up to the light should appear translucent.
- (4) **SALT.** Cheese of this grade shall show uniform distribution of salt according to the age of the cheese.
- (5) **APPEARANCE.** Cheese of this grade shall be clean, well shaped, surfaces well closed and practically smooth, free from checks and mold, and the various cheese in a box shall be practically uniform in size.
- (6) **MOISTURE CONTENT.** Cheese of this grade shall contain not more than 43 per cent of moisture, with an allowance or tolerance of not to exceed 1 per cent in excess, so that in no case shall the moisture content of said cheese exceed 44 per cent.

Ag 82.04 Wisconsin junior. Cheese labeled or sold as Wisconsin Junior must conform to the following standards:

- (1) **FLAVOR.** Flavor and taste shall be fairly clean, and may have distinct but only moderate off or undesirable flavor.
- (2) **BODY AND TEXTURE.** Cheese of this grade shall have fairly good body and texture, but must be free from cracked or split centers, and must not be crumbly or mealy.
- (3) **COLOR.** Cheese of this grade may have slightly uneven or defective color but shall not be faded, dull or chalky white.
- (4) **SALT.** Cheese of this grade shall show even distribution of salt according to its age.
- (5) **APPEARANCE.** Cheese of this grade may have slight defects as compared with State Brand cheese such as less uniformity in size and shape, and slight surface defects, but must be clean and free from checks and mold.
- (6) **MOISTURE CONTENT.** Cheese of this grade shall contain not more than 43 per cent of moisture, with a tolerance or allowance of not to exceed 1 per cent in excess, so that in no case shall the moisture content of said cheese exceed 44 per cent.

im **Ag 82.05 Undergrade.** All Brick cheese having a moisture content not in excess of 44 per cent which does not meet the standards above prescribed for either of the two grades, Wisconsin State Brand or Wisconsin Junior, shall be classified as Undergrade and shall be so marked.

Ag 82.06 American style brick. (1) Brick cheese made in cylindrical hoops shall be known as American Style Brick and shall be made in the following sizes:

- (a) Brick cheese may be made in hoops which shall measure $13\frac{1}{2}$ inches in diameter and $4\frac{1}{2}$ inches high, and said cheese shall weigh

from 20 to 22 pounds and in no case shall weigh over 23 pounds. Brick cheese made in such forms shall be known as "Daisy Brick".

(b) Brick cheese may be made in hoops which shall measure $1\frac{1}{2}$ inches in diameter and 6 inches high, and said cheese shall weigh not less than 32 pounds nor more than 37 pounds. Brick cheese made in such forms shall be known as "Brick Flats".

(2) American Style Brick cheese made during the months of May, June, July, August and September shall not be removed from the curing room shelves or paraffined until it is at least 10 days old, including the day of manufacture, and until it is sufficiently dry on all surfaces to be fit for paraffining. All American Style Brick cheese produced at any other time of the year shall be held for a period of at least 14 days and until it is dry on all surfaces. Cheese may be moved from the shelves and from the factory where made to another curing room in the state earlier than herein provided, where the curing process shall be completed to meet the requirements of this order, and it shall not be graded or put in channels of trade until it has developed the characteristic Brick cheese flavor, body and texture.

(3) In grading American Style Brick cheese the same standards are to be used as for other Brick cheese. Before leaving the factory and before it is paraffined, it shall be marked with the factory stamp to show the serial number of the factory, the vat designation, and the day, month and year on which it was made, these marks to appear on the hoop side of the cheese.

Ag 82.07 **Factory marks.** All Brick cheese made in Wisconsin and receptacles for the same shall be plainly marked with a factory stamp using dark colored ink, which marking shall be applied on one face or side of each cheese before it is paraffined and before it leaves the factory. Each factory shall always apply such markings to the same respective face or side of each cheese. Said markings shall also be applied on the receptacles and shall include the factory serial number as designated by the department, the number of the month, number of the day that it was manufactured, and a designation by letters: "A", "B", "C", etc., in any case where more than one vat was used for making cheese. The following stamp mark illustrates the factory marking to be applied on Brick cheese and receptacles in letters at least $\frac{1}{2}$ inch high:

000—10—20—A

(Factory number, month, day, vat)

Ag 82.08 **Grade marks.** (1) **BRICK CHEESE.** All Brick cheese made Wisconsin and receptacles for the same shall be plainly marked by or under the direction of an authorized Brick cheese grader or a state grader, by use of rubber stamps and dark colored ink, to indicate its grade. Such marks shall be applied on the same side or face of each cheese that bears the factory stamp mark and must be applied before the cheese is paraffined, and before it enters retail channels, leaves the state or is converted into another food product, and before it shall be delivered to any person, firm or corporation, unless such person, firm or corporation represents an authorized Brick cheese grading unit located in the state. Said marking shall also be applied on the outside of each box containing such cheese.

am (2) AGING. Cheese that is to be held for further aging after the holding order is complied with may be paraffined or not paraffined and stored without grade marks, but it must later be graded and marked for grade as herein provided before it leaves the state.

(3) STAMP MARKS. The stamp marks for grade identification shall be in substantially the following form:

(a) Miniature map of Wisconsin containing:

B-M
WISCONSIN
STATE
BRAND
117

(b) A diamond-shaped border containing:

B-M
WISCONSIN
JUNIOR
CHEESE
117

(c) Dept. of Agric.

UNDERGRADE
B-M 117

(4) MOISTURE CONTENT LABEL. Brick cheese containing more than 44 per cent of moisture shall be plainly marked or branded in one or more places by using for identification the proper moisture content label, as listed below, which label shall be in type at least ½ inch high. Said marking shall also be applied on the outside of each box containing such cheese. Such marking shall be applied before such cheese shall be delivered for sale to any person, firm or corporation, before it shall be converted into another food product or leave the state. Such cheese shall not bear the grade marks fixed by the department.

(Factory No. 000)
(Moisture 44 to 46%)
(Moisture over 46%).

am (5) NOT GRADED. Every operator who does not intend to market all of his cheese in conformity with the grade standards herein established shall mark all of his cheese "Not Graded" in type at least ½ inch high before it is paraffined and before it leaves the factory.

n (6) UNDERGRADE. Whenever any state-employed grader inspects and tests any cheese for grade and finds that such cheese does not conform to the standards for the grade "Wisconsin State Brand" or for the grade "Wisconsin Junior", he shall identify and mark such cheese with an "Undergrade" stamp, whether or not such cheese has been previously marked "Not Graded" or "high moisture". The "Not Graded" stamp marking may be removed.

(7) BRICK CHEESE FROM OTHER STATES. Brick cheese assembled in Wisconsin from other states and the receptacles therefor shall be branded or marked in two conspicuous places with the name of the

state of its origin, the grader's number and the unit applying the brand or mark, the size of type to be used to be not less than one-half inch high.

(8) CHEESE UNFIT FOR HUMAN FOOD. Cheese which contains any added substance or ingredients which are poisonous, injurious or deleterious to health or any deleterious substance not a necessary ingredient in its manufacture shall not be graded or bear a grade mark, but shall bear a stamp in letters at least one-half inch high the words, "Not fit for human consumption".

Ag 82.09 Arbitration. In case of disagreement between producers, buyers or supervisors, or any of them, as to the grade of cheese, a neutral party shall be called in to check the findings. In case of further disagreement, each party shall select a competent person as an arbitrator and such 2 arbitrators shall select a third competent person. All 3 must be present to determine the final grade jointly. The decision of the majority of such arbitrators as to the grade of cheese shall be final and any person who has bargained for such cheese shall make settlement according to the findings of said committee. Failure to make such settlement on this basis shall be deemed a violation of this order and shall subject the person guilty of such violation to the penalties provided by law. Such arbitrators shall be selected from the list of competent persons compiled by the department from a list submitted by producers and dealers of Brick cheese. The party requesting the arbitration committee shall pay the cost thereof.

Ag 82.10 Brick and limburger cheese boxes.

(1) BRICK CHEESE BOXES

Style of Box	Outside Length of Box	Inside Width of Box	Inside Depth of Box
Full size.....	32 in.	21 in.	5½ in.
Half size.....	32 in.	10½ in.	5½ in.
Quarter size.....	18 in.	10½ in.	5½ in.

(2) LIMBURGER CHEESE BOXES

Full size.....	32 in.	22 in.	5½ in.
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In sections where both Brick and Limburger cheese is produced, the use of the Limburger box is permissible for both varieties of cheese.

(3) AMERICAN STYLE BRICK CHEESE BOXES

(a) Daisy Brick boxes shall be 14 inches in diameter; height of said boxes shall be 4¼ inches, with a permitted tolerance of ½ inch from this height.

(b) Brick Flat boxes shall be 15 inches in diameter; height of said boxes shall be 6¾ inches, with a permitted tolerance of ½ inch from this height.

Ag 82.11 Used cheese boxes. (1) All cheese boxes that have been used as containers for cheese, before being used again in the marketing or transporting of cheese, shall be reconditioned so as to be clean and sanitary, and free from adhering material, objectionable odors and mold; and shall be marked by the reconditioner on the lower

band; and marked on the end piece, in case of rectangular shaped boxes; and on the side where other markings are usually applied, with the used box stamp as herein provided.

(2) Before such used cheese boxes are again used in the marketing or transporting of cheese, all markings on such boxes shall be removed excepting the marking used to designate the original manufacturer of each box and except that all marks for used boxes herein provided for shall be left thereon.

(3) Any person desiring to recondition used cheese boxes shall make application to the department for a used box marking stamp. Every such stamp shall remain the property of the department and shall include the words, "Used Boxes" and letters or figures, or both, identifying such reconditioner.

(4) Every person who uses a used cheese box as a container for marketing or transporting cheese shall cancel it with a heavy indelible pencil mark in the form of an X through the last reconditioner's identifying letters and figures in the used box marking thereon as soon as he has placed cheese in the same.

(5) Every person who buys or receives any used cheese boxes shall keep available for inspection by the department all invoices of all used cheese boxes bought or received by him.

(6) No person shall buy, receive, use or have in possession with intent to use for marketing or transporting cheese, and no person shall sell, offer for sale, or deliver, or have in possession with intent to sell, or to offer for sale, or deliver, for use in marketing or transporting cheese, any used cheese box which does not conform to these standards or which does not bear the used box markings identifying all the reconditioners thereof as herein required, one of which markings shall be uncanceled; provided that such boxes coming from outside the state of Wisconsin may be so used or possessed if each such box is plainly and conspicuously marked with the name and address of the manufacturer on the body of the box in type at least one-quarter inch high, and if each such box which does not conform to these standards is plainly and conspicuously marked on the body of the box in type at least one-quarter inch high with the words: "Used box not up to Wisconsin standards".