

**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 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

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 acidy.

(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 BB 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.

**History:** 1-2-56; am. (1), Register, April, 1969, No. 160, eff. 5-1-69.

**Ag 82.02 History:** 1-2-56; r. Register, October, 1960, No. 58, eff. 11-1-60.

**Ag 82.03 Wisconsin State Brand or Wisconsin Grade A.** Cheese labeled or sold as Wisconsin State Brand or Wisconsin Grade A 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 AND FAT CONTENT.** Cheese of this grade shall contain not more than 44% moisture and the solids shall contain not less than 50% milk fat.

**History:** 1-2-56; am. intro. par. Register, April, 1969, No. 160, eff. 5-1-69; am. (6), Register, September, 1972, No. 201, eff. 10-1-72.

**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.

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(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 AND FAT CONTENT.** Cheese of this grade shall contain not more than 44% moisture and the solids shall contain not less than 50% milk fat.

**History:** 1-2-56; am. (6), Register, September, 1972, No. 201, eff. 10-1-72.

**Ag 82.05 Undergrade.** Brick cheese which has been graded which does not meet the standards prescribed for any of the grades in sections Ag 82.03 and Ag 82.04 shall be classified as Undergrade and shall be so marked.

**History:** 1-2-56; am. Register, October, 1960, No. 58, eff. 11-1-60; am. Register, April, 1969, No. 160, eff. 5-1-69.

**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 13½ inches in diameter and 4½ 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 14½ 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".

(3) In grading American Style Brick cheese the same standards shall be used as for other Brick cheese.

**History:** 1-2-56; r. (2); am. (3), Register, October, 1960, No. 58, eff. 11-1-60.

**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 to the cheese or its wrapper or container, or to a tag attached thereto, before it leaves the factory. Such marking 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 ½ inch high:

000—10—20—A

(Factory number, month, day, vat)

**History:** 1-2-56; am. Register, October, 1960, No. 58, eff. 11-1-60.

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**Ag 82.08 Grade marks.** (1) **APPLICATION OF MARKS.** Brick cheese which has been graded 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 to the cheese or its wrapper or container, or to a tag attached thereto, 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.

(2) **AGING.** Cheese that is to be held for aging 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-M  
or WISCONSIN  
GRADE A  
117

(b) A diamond-shaped border containing:

B-M  
WISCONSIN  
JUNIOR  
CHEESE  
117

(c) Dept. of Agric.

UNDERGRADE  
B-M 117

(4) **NOT GRADED.** Cheese which has not been graded shall be plainly marked "Not Graded" in letters at least  $\frac{1}{2}$  inch high. Such mark shall be applied to the cheese, its wrapper or container, or a tag attached thereto. Marking shall be done at the factory or at the warehouse where it is first delivered in this state.

(5) **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  $\frac{1}{2}$  inch high.

**History:** 1-2-56; am. (1), (2) and (5), r. (6) and (8), Register, October, 1960, No. 58, eff. 11-1-60; am. (3) (a), Register, April, 1969, No. 160, eff. 5-1-69; r. (4); renum. (5) to be (4) and (7) to be (6), Register, September, 1972, No. 201, eff. 10-1-72.

**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

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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. |
|----------------|--------|--------|--------|

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 ⅛ inch from this height.

(b) Brick Flat boxes shall be 15 inches in diameter; height of said boxes shall be 6½ inches, with a permitted tolerance of ⅛ 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".