

# TECHNICAL DATA SHEET

## D-LIMONENE



### DESCRIPTION

Our d-Limonene is extracted from the fresh fruit using distilling methods that preserve the essential aromatic compounds. This high-quality oil is intended for further manufacturing use only.

**Country of Origin:** United States of America, 100% Texas

### Technical Data

#### ORGANOLEPTIC

Aroma	Good, typical of citrus fruits.
Color	Good. Clear to slightly yellow liquid.
Defects	Practically Free

#### PHYSICAL

	Target	Min	Max
Refractive Index (20°C)	1.47	1.485	1.49
% d-Limonene	60	55	70

### Compliance

- ✓ FDA Compliance
- ✓ HACCP System
- ✓ GFSI accredited
- ✓ Kosher Certified
- ✓ Fully Traceable Product
- ✓ 100 % Natural
- ✓ Gluten Free
- ✓ Allergen Free

### Packaging and Storage

#### Drums

**Packaging:** 55 gallon, 52 gallon net fill, epoxy phenolic lined 1A1 steel drums. Net weight ~ 390 lbs. (177 kgs)

#### Storage/Shelf Life:

- When unrefrigerated, >55°F (13°C) and <80°F (26°C), in the original unopened container, shelf-life is 24 months.
- When chilled, 33-55°F (0.5-13°C), in the original unopened container, shelf-life is 36 months.
- When frozen, <32°F (0°C), in the original unopened container, shelf-life is 60 months.

**Labeling:** Label is placed on top of the drum using an adhesive label to stick to the drum. Labels comply with international labeling regulations.

Bulk Tankers can be an option as well.

### Product Numbers

This technical data sheet applies to the following Product Numbers:

**BP4700-D – W1042216**

**BP4700-T– W1042218**

**BP4700-S – W1042217**

## Lot Code Explanation

Our bulk products are assigned a unique code at the time of manufacturing. Each batch will be identified by a code that looks like "A23310-01 or P23319-01 or S22333-09".

These codes are assigned by the quality assurance lab. The letters designate the origin of the batch:

- P- Production
- T- Tanker
- S- Sales Blend
- A- By-products

The numeric portion is composed of the last two numbers of the year (23), the Julian day (310), and after the hyphen the batch number for the day (-01).

The format follows: PYYDDD-BB where P represents the origin, YY the year, DDD the Julian day, and BB the batch number.

## COA Example



Product Identification  
Lot Number  
Production Date:  
Expiration Date

### Quality Assurance Department Certificate of Analysis

W1042216-BP4700-D Citrus d-Limonene Drum

A25097-02

04/07/2025

04/07/2030

Analysis	RGJC Laboratory Analysis	UOM	Specifications	
			Min	Max
Country of Origin	United States of America			
Refractive Index (AOAC 921.141)	1.4728	EA	1.4710	1.4750
Specific Gravity (AOAC 920.140)	0.846	EA	0.8410	0.8500
% d-Limonene	92.08	PCT	94.00	99.00

Customer Remarks: Compo of 48 drums season  
2024/2025

Designated Supplier Signature:

Title:

Issue Date:

Rio Grande Juice Company - 702 E. Interstate Hwy 2, Mission, TX 78572 - (956) 598-6800

FSQA Supervisor

10-15-2025 14:58:10

## Customer Acceptance of Specifications

Rio Grande Juice Company has presented the supplier with specifications for D-LIMONENE, and this Agreement formalizes the acceptance of these specifications. Both parties acknowledge that they have reviewed and approved the specifications.

### RIO GRANDE JUICE COMPANY

Approver Signature:



Approver Printed Name: LUIS HERNANDEZ

Approver Position: FSQA SUPERVISOR

Date: 10/15/2025

### CUSTOMER

Customer Name: \_\_\_\_\_

Approver Signature: \_\_\_\_\_

Approver Printed Name: \_\_\_\_\_

Approver Position: \_\_\_\_\_

Date: \_\_\_\_\_

**\*\*Any modifications or amendments to the approved specifications must be agreed upon in writing by both parties\*\***

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