



## Standard Test Method for Performance of Water-Bath Rethermalizers<sup>1</sup>

This standard is issued under the fixed designation F2473; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon ( $\epsilon$ ) indicates an editorial change since the last revision or reapproval.

### 1. Scope

1.1 This test method covers the energy consumption and rethermalizing performance of floor-model and countertop water-bath rethermalizers. The food service operator can use this evaluation to select a water-bath rethermalizer and understand its energy consumption and production capacity.

1.2 This test method is applicable to floor and countertop model gas and electric units.

1.3 The water-bath rethermalizer can be evaluated with respect to the following (where applicable):

1.3.1 Energy input rate (10.2),

1.3.2 Preheat energy consumption, time, and rate (10.4),

1.3.3 Idle energy rate (10.5),

1.3.4 Pilot energy rate (10.6),

1.3.5 Retherm energy rate (10.8),

1.3.6 Production capacity (10.8), and

1.3.7 Retherm-energy efficiency (10.8).

1.4 This test method is not intended to answer all performance criteria in the evaluation and selection of a water-bath rethermalizer.

1.5 The values stated in inch-pound units are to be regarded as the standard. The values given in parentheses are for information only.

1.6 *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety, health, and environmental practices and determine the applicability of regulatory limitations prior to use.*

1.7 *This international standard was developed in accordance with internationally recognized principles on standardization established in the Decision on Principles for the Development of International Standards, Guides and Recommendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.*

### 2. Referenced Documents

2.1 *ASTM Standards:*<sup>2</sup>

[D3588 Practice for Calculating Heat Value, Compressibility Factor, and Relative Density of Gaseous Fuels](#)

2.2 *ANSI Standard:*<sup>3</sup>

[ANSI Z83.11 Gas Food Service Equipment](#)

2.3 *ASHRAE Documents:*<sup>4</sup>

[ASHRAE Handbook of Fundamentals Chapter 6, Table 2—Thermodynamic; Chapter 6, Table 2—Thermodynamic Properties of Water at Saturation](#)

[ASHRAE Guideline 2-1986 \(RA90\) Engineering Analysis of Experimental Data](#)

2.4 *NSF Standards:*<sup>5</sup>

[NSF Listing-Food Equipment and Related, Components and Material](#)

[NSF/ANSI 4 Commercial Cooking, Rethermalization and Powered Hot Food Holding and Transport Equipment](#)

<sup>1</sup> This test method is under the jurisdiction of ASTM Committee F26 on Food Service Equipment and is the direct responsibility of Subcommittee F26.06 on Productivity and Energy Protocol.

Current edition approved ~~May 1, 2012~~ March 1, 2018. Published ~~July 2012~~ March 2018. Originally approved in 2005. Last previous edition approved in ~~2005~~ 2012 as F2473 – 05-F2473 – 12. DOI: [10.1520/F2473-12](https://doi.org/10.1520/F2473-12); [10.1520/F2473-12R18](https://doi.org/10.1520/F2473-12R18).

<sup>2</sup> For referenced ASTM standards, visit the ASTM website, [www.astm.org](http://www.astm.org), or contact ASTM Customer Service at [service@astm.org](mailto:service@astm.org). For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

<sup>3</sup> Available from American National Standards Institute (ANSI), 25 W. 43rd St., 4th Floor, New York, NY 10036.

<sup>4</sup> Available from American Society of Heating, Refrigerating, and Air-Conditioning Engineers, Inc. (ASHRAE), 1791 Tullie Circle, NE, Atlanta, GA 30329.

<sup>5</sup> Available from NSF International, P.O. Box 130140, 789 N. Dixboro Rd., Ann Arbor, MI 48113-0140.

### 3. Terminology

#### 3.1 Definitions:

3.1.1 *auto-fill, n*—water height sensor device that activates a fresh water fill solenoid when the water level in the rethermalizer drops below a predetermined height.

3.1.2 *energy input rate, n*—peak rate at which a water-bath rethermalizer consumes energy (Btu/h (kJ/h) or kW).

3.1.3 *idle energy rate, n*—average rate of energy consumed (Btu/h or kW) by the rethermalizer while holding or maintaining the water vat at the thermostat(s) set point.

3.1.4 *over-flow drain, n*—drain for eliminating the excess foam and starch created during the rethermalizing process.

3.1.5 *pilot energy rate, n*—average rate of energy consumption (Btu/h (kJ/h)) by a water-bath rethermalizer's continuous pilot (if applicable).

3.1.6 *preheat energy, n*—amount of energy consumed (Btu or kWh) by the rethermalizer while heating the water vat from ambient room temperature to the calibrated thermostat(s) set point.

3.1.7 *preheat rate, n*—average rate (°F/min) at which the water vat temperature is heated from ambient temperature to the rethermalizer's calibrated thermostat(s) set point.

3.1.8 *preheat time, n*—time required for the water vat to heat from ambient room temperature to the calibrated thermostat(s) set point.

3.1.9 *production capacity, n*—maximum rate (lb/h (kg/h)) at which water-bath rethermalizer can bring the refrigerated clam chowder to a specified rethermalized condition.

3.1.10 *retherm energy, n*—total energy consumed by the rethermalizer as it is used to reheat bags of refrigerated clam chowder.

3.1.11 *retherm-energy efficiency, n*—quantity of energy required to warm the specified food product (clam chowder soup), expressed as a percentage of the quantity of energy input to the water-bath rethermalizer during the reheating period.

3.1.12 *retherm energy rate, n*—average rate of energy consumed by the rethermalizer while reheating bags of refrigerated clam chowder.

3.1.13 *test method, n*—a definitive procedure for the identification, measurement, and evaluation of one or more qualities, characteristics, or properties of a material, product, system, or service that produces a test results.

3.1.14 *uncertainty, n*—measure of systematic and precision errors in specified instrumentation or measure of repeatability of a reported test result.

3.1.15 *water-bath rethermalizer, n*—appliance, including a rethermalizing vessel, in which water is placed to such a depth that the food is essentially supported by displacement of the water rather than by the bottom of the vessel, which is designed for the purpose of reheating pre-cooked food contained in vacuum-sealed, boilable bags.

### 4. Summary of Test Method

4.1 The water-bath rethermalizer under test is connected to the appropriate metered energy source. The measured energy input rate is determined and checked against the rated input before continuing with testing.

4.2 The water temperature in the rethermalizing zone of the water-bath rethermalizer is monitored at a location chosen to represent the average temperature of the water while the water-bath rethermalizer maintains a specified rethermalizing temperature.

4.3 Preheat energy, time, and rate are determined while the water-bath rethermalizer is operated with the thermostat(s) set to specified temperature.

4.4 The idle energy is determined while the water-bath rethermalizer is operated in a ready-to-use state with the thermostat(s) set to the calibrated temperature. The rate of pilot energy consumption also is determined when applicable to the water-bath rethermalizer under test.

4.5 Energy consumption and time are monitored while the water-bath rethermalizer is used to reheat three full loads of refrigerated, prepackaged clam chowder soup. Retherm-energy efficiency, retherm energy rate, and production capacity are determined from these tests.

### 5. Significance and Use

5.1 The energy input rate test is used to confirm that the water-bath rethermalizer under test is operating in accordance with its nameplate rating.

5.2 The water-bath rethermalizer temperature calibration is used to ensure that the water-bath rethermalizer being tested is operating at the specified temperature. Temperature calibration also can be used to evaluate and calibrate the thermostat control dial(s).

5.3 Preheat energy and time can be useful to food service operators to manage energy demands, and to estimate the amount of time required for preheating a water-bath rethermalizer.

5.4 Idle energy rate and pilot energy rate can be used to estimate energy consumption during non-rethermalizing periods.

5.5 Production capacity is used by food service operators to choose a water-bath rethermalizer that matches their particular food output requirements.

5.6 Retherm-energy efficiency is a precise indicator of the water bath rethermalizer's energy performance under full-load condition. This information enables the operator to consider energy performance when selecting a water-bath rethermalizer.

## 6. Apparatus

6.1 *Analytical Balance Scale*, for measuring weights up to 15 lb (6.8 kg), with a resolution of 0.01 lb (0.004 kg) and an uncertainty of 0.01 lb (0.004 kg).

6.2 *Barometer*, for measuring absolute atmospheric pressure, to be used for adjustment of measured gas volume to standard conditions. Shall have a resolution of 0.2 in. Hg (670 Pa) and an uncertainty of 0.2 in. Hg (670 Pa).

6.3 *Canopy Exhaust Hood*, 4 ft (1.2 m) in depth, wall-mounted with the lower edge of the hood 6 ft, 6 in. (1.98 m) from the floor and with the capacity to operate at a nominal net exhaust ventilation rate of 300 cfm per linear foot (460L/s per linear metre) of active hood length. This hood shall extend a minimum of 6 in. (152 mm) past both sides and the front of the rethermalizing appliance and shall not incorporate side curtains or partitions. Makeup air shall be delivered through face registers or from the space, or both.

6.4 *Data Acquisition System*, for measuring energy and temperatures, capable of multiple temperature displays updating at least every 2 s.

6.5 *Flow Meter*, for measuring total water consumption of the appliance. Shall have a resolution of 0.01 gal (0.04 L) and an uncertainty of 0.01 gal (0.04 L) at a flow rate as low as 0.2 gpm (0.8 lpm).

6.6 *Gas Meter*, for measuring the gas consumption of a water-bath rethermalizer, shall be a positive displacement type with a resolution of at least 0.01 ft<sup>3</sup> (0.0003 m<sup>3</sup>) and a maximum uncertainty no greater than 1 % of the measured value for any demand greater than 2.2 ft<sup>3</sup> (0.06 m<sup>3</sup>) per hour. If the meter is used for measuring the gas consumed by the pilot lights, it shall have a resolution of at least 0.01 ft<sup>3</sup> (0.0003 m<sup>3</sup>) and a maximum uncertainty no greater than 2 % of the measured value.

6.7 *Pressure Gage*, for monitoring gas pressure. Shall have a range of 0 to 15 in. H<sub>2</sub>O (0 to 3.7 kPa), a resolution of 0.5 in. H<sub>2</sub>O (125 kPa), and a maximum uncertainty of 1 % of the measured value.

6.8 *Stop Watch*, with a 1-s resolution.

6.9 *Thermocouple Probe(s)*, industry standard type T or type K thermocouples capable of immersion, with a range of from 50 to 400°F (10 to 204°C) and an uncertainty of ±1°F (±0.5°C).

6.10 *Temperature Sensor*, for measuring natural gas temperature in the range of 50 to 100°F (10 to 38°C) with an uncertainty of ±1°F (±0.5°C).

6.11 *Watt-Hour Meter*, for measuring the electrical energy consumption of a water-bath rethermalizer, shall have a resolution of at least 10 Wh and a maximum uncertainty no greater than 1.5 % of the measured value for any demand greater than 100 W. For any demand less than 100 W, the meter shall have a resolution of at least 10 Wh and a maximum uncertainty no greater than 10 %.

## 7. Reagents and Materials

7.1 *Water* used shall have a maximum hardness of three grains per gallon. Distilled water may be used.

7.2 *New England Clam Chowder Soup*, refrigerated, ready to use, in nominal 1-gal (3.8-L) vacuum packed bags or “chubs,” weighing 6.0 ± 0.2 lb (2.72 ± 0.09 kg) per bag. The clam chowder shall be stabilized in a refrigerator at 38 ± 2°F (3 ± 1°C).

NOTE 1—Generic brand New England Clam Chowder has been proven to be an acceptable product for testing by the Food Service Technology Center.

## 8. Sampling and Test Units

8.1 *Water-Bath Rethermalizer*—Select a representative production model for performance testing.

## 9. Preparation of Apparatus

9.1 Measure the water-bath rethermalizer's vat's rethermalizing capacity. The water-bath rethermalizer's rethermalizing vat may be shaped in such a way that simple measurements do not yield the true rethermalizing capacity. In this case, fill the water-bath rethermalizer with water till the bottom edge of the rethermalizing capacity is reached. Then, measure the volume of water required to fill the rethermalizing capacity to the top.

9.2 Install the appliance according to the manufacturer's instructions under a 4-ft (1.2-m) deep canopy exhaust hood mounted against the wall, with the lower edge of the hood 6 ft, 6 in. (1.98 m) from the floor. Position the water-bath rethermalizer with the front edge of the water in the rethermalizing vat inset 6 in. (152 mm) from the front edge of the hood at the manufacturer's

recommended working height. The length of the exhaust hood and active filter area shall extend a minimum of 6 in. (152 mm) past the vertical plane of both sides of the water-bath rethermalizer. In addition, both sides of the water-bath rethermalizer shall be a minimum of 3 ft (0.9 m) from any sidewall, side partition, or other operating appliance. The exhaust ventilation rate shall be 300 cfm per linear foot (460 L/s per linear metre) of hood length. The associated heating or cooling system shall be capable of maintaining an ambient temperature of  $73 \pm 3^{\circ}\text{F}$  ( $22 \pm 2^{\circ}\text{C}$ ) within the testing environment when the exhaust ventilation system is operating.

9.3 The testing environment during energy tests shall be maintained in accordance with the section on performance for open top hot food holding equipment room specifications of NSF/ANSI 4. NSF/ANSI 4 test room conditions are ambient temperature of  $73 \pm 3^{\circ}\text{F}$  ( $22 \pm 2^{\circ}\text{C}$ ), no vertical temperature gradient exceeding  $1.5^{\circ}\text{F}/\text{ft}$  ( $2.5^{\circ}\text{C}/\text{m}$ ), and maximum air current velocity of 50 ft/min (0.25 m/s).

9.4 Connect the water-bath rethermalizer to a calibrated energy test meter. For gas installations, install a pressure regulator downstream from the meter to maintain a constant pressure of gas for all tests. Install instrumentation to record both the pressure and temperature of the gas supplied to the water-bath rethermalizer and the barometric pressure during each test so that the measured gas flow can be corrected to standard conditions. For electric installations, a voltage regulator may be required during tests if the voltage supply is not within  $\pm 2.5\%$  of the manufacturer's "nameplate" voltage.

9.5 For an electric water-bath rethermalizer, confirm (while the water-bath rethermalizer elements are energized) that the supply voltage is within  $\pm 2.5\%$  of the operating voltage specified by the manufacturer. Record the test voltage for each test.

NOTE 2—It is the intent of the testing procedure in this test method to evaluate the performance of a water-bath rethermalizer at its rated electric voltage. If the unit is rated dual voltage (that is, designed to operate at either 240 or 480 V with no change in components), the voltage selected by the manufacturer or tester, or both, shall be reported. If a water-bath rethermalizer is designed to operate at two voltages without a change in the resistance of the heating elements, the performance of the unit (for example, preheat time) may differ at the two voltages.

9.6 For a gas water-bath rethermalizer, adjust (during maximum energy input) the gas supply pressure downstream from the appliance's pressure regulator to within  $\pm 2.5\%$  of the operating manifold pressure specified by the manufacturer. Make adjustments to the water-bath rethermalizer following the manufacturer's recommendations for optimizing combustion. Proper combustion may be verified by measuring air-free CO in accordance with ANSI Z83.11.

9.7 Make the water-bath rethermalizer ready for use in accordance with the manufacturer's instructions. Clean the water-bath rethermalizer's vat by "boiling" with the manufacturer's recommended cleaner and water and then rinsing the inside of the rethermalizing-vat thoroughly before starting each test procedure.

9.8 To prepare the water-bath rethermalizer for temperature calibration, attach an immersion type thermocouple in the rethermalizing vat before beginning any test. The thermocouple used to calibrate the water-bath rethermalizer shall be located in the back of the rethermalizing vat, about  $\frac{1}{2}$  in. (13 mm) from the back edge of the rethermalizing vat,  $\frac{1}{2}$  in. (13 mm) above the heat transfer area or elements, or both, and located in the centered in relation to the sides of the rethermalizing vat.

9.9 Fresh water supply to water-bath rethermalizer should be monitored to ensure that water temperature is  $65 \pm 5^{\circ}\text{F}$  ( $18 \pm 3^{\circ}\text{C}$ ).

9.10 Install flow meter to the water-bath rethermalizer water inlet such that total water flow to the appliance is measured.

9.11 *Food Racks*, for holding food packages upright during the test shall be used. If the manufacturer does not have food racks specifically designed for the water bath rethermalizer, then stainless steel wire racks conforming to the specifications in **Fig. 1** may be used. Food racks must have clamps that will securely fasten the food and also have pins that will pierce food bags keeping them from floating.

9.12 Use the cooking racks to determine the maximum number of 6-lb clam chowder chubs to be placed inside each vat. Use one chub per rack and place it vertically inside the vat and place as many racks as possible until the vat is full. Record this value and use this amount for testing.

## 10. Procedure

### 10.1 General:

10.1.1 For gas appliances, record the following for each test run:

10.1.1.1 Higher heating value,

10.1.1.2 Standard gas pressure and temperature used to correct measured gas volume to standard conditions,

10.1.1.3 Measured gas temperature,

10.1.1.4 Measured gas pressure,

10.1.1.5 Barometric pressure, and

10.1.1.6 Energy input rate during or immediately prior to test.

NOTE 3—The preferred method for determining the heating value of the supplied to the water-bath rethermalizer under test is by using a calorimeter of gas chromatograph in accordance with accepted laboratory procedures. The use of "bottled" natural gas with a certified heating value within the specified  $1025 \pm 25 \text{ Btu}/\text{ft}^3$  ( $38\ 160 \pm 930 \text{ kJ}/\text{m}^3$ ) range is an acceptable alternative.

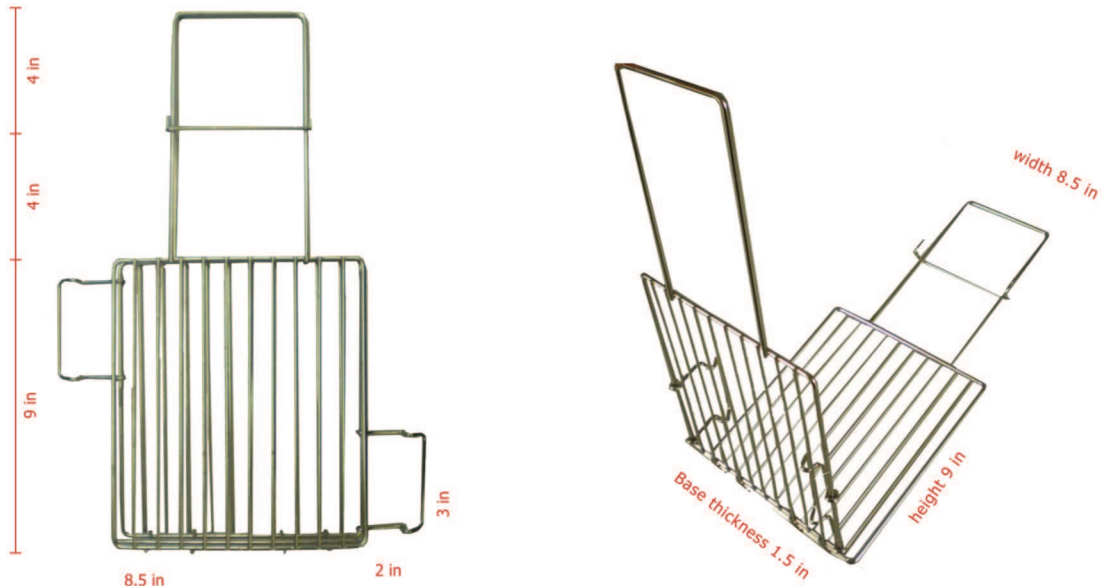


FIG. 1 Food Racks in Rethernalizer Used for Efficiency Tests

10.1.2 For gas water-bath rethermalizers, add electric energy consumption to gas energy for all tests, with the exception of the energy input rate test (10.2).

10.1.3 For electric water-bath rethermalizers, record the following for each run of each test run:

10.1.3.1 Voltage while elements are energized, and

10.1.3.2 Energy input rate during or immediately prior to test run.

10.1.4 For each test run, confirm that the peak input rate is within  $\pm 5\%$  of the rated nameplate input. If the difference is greater than  $5\%$ , terminate testing and contact the manufacturer. The manufacturer may make appropriate changes or adjustments to the water-bath rethermalizer.

10.1.5 For all tests, record the altitude of the testing facility.

10.1.6 For all tests, maintain water level at the indication line. If the water-bath rethermalizer has no indication line, then maintain water level to the manufacturer's recommended capacity at all times.

### 10.2 Measured Energy Input Rate:

10.2.1 Load the water-bath rethermalizer to the indicated fill line with fresh water and turn the water-bath rethermalizer on with the temperature control(s) set to the maximum setting.

10.2.2 Let the water-bath rethermalizer run for a period of 15 min, then monitor the time required for the water-bath rethermalizer to consume  $5 \text{ ft}^3$  ( $0.14 \text{ m}^3$ ) of gas. Adjustments to the appliance's input rate may be made by adjusting gas manifold pressure (gas water-bath rethermalizer).

10.2.3 For electric water-bath rethermalizers, monitor the energy consumption for 15 min with the controls set to achieve maximum input.

10.2.4 In accordance with 11.4, calculate the measured energy input rate for the water-bath rethermalizer under test. Report and compare the measured input to the "nameplate" energy input rate in Btu/h or kW. Confirm that the measured input rate is within  $\pm 5\%$  of rated "nameplate" energy input rate. If the difference is greater than  $\pm 5\%$ , testing shall be terminated and the manufacturer contacted. The manufacturer may make appropriate changes or adjustments to the water-bath rethermalizer. Also, the power supply may be changed, if necessary, to conform to manufacturer's specifications. It is the intent of the testing procedures in this test method to evaluate the performance of a water-bath rethermalizer at its rated energy input rate.

### 10.3 Calibration:

NOTE 4—The manufacturer may have a calibration procedure that may give some insight into their thermostatic control strategy. The manufacturer's calibration procedure may be used initially to help in the calibration of the rethermalizing temperature. After applying the manufacturer's calibration procedure, confirm calibration with 10.3.

10.3.1 Fresh water temperature supplied to the water-bath rethermalizer shall be  $65 \pm 5^\circ\text{F}$  ( $18 \pm 3^\circ\text{C}$ ).

NOTE 5—If the fresh water temperature is not within the specified temperature, mix the supply water with hot or cold sources to meet the desired temperature. The supply water can be tempered to obtain the proper supply water temperature.

10.3.2 Ensure that the water-bath rethermalizer water is loaded to the indicated fill line or manufacturer's recommended water level. Preheat and allow the water-bath rethermalizer to stabilize for 30 min before beginning temperature calibration.



10.3.3 The water-bath rethermalizer water temperature shall be measured by attaching a calibrated immersion thermocouple type in the rear of the rethermalizing zone as detailed in 9.9. Adjust the water-bath rethermalizer temperature control(s) to maintain an average water vat temperature of  $195 \pm 5^\circ\text{F}$  ( $91 \pm 3^\circ\text{C}$ ). Record the water temperature over a 1-h period to verify temperature of the water at  $195 \pm 5^\circ\text{F}$  ( $91 \pm 3^\circ\text{C}$ ). The water temperature recorded over a 1-h period shall be considered as the average temperature for the water-bath rethermalizer.

10.4 *Preheat-Energy Consumption, Time, and Rate:*

10.4.1 Ensure that the water-bath rethermalizer is filled to the indicated fill line. If there is no indication line, then fill to the manufacturer's recommended water level. Record water temperature, barometric pressure, and ambient kitchen temperature at the start of the test (water temperature shall be  $65 \pm 5^\circ\text{F}$  ( $21 \pm 3^\circ\text{C}$ ) at the start of the test).

NOTE 6—The preheat test should be conducted prior to appliance operation on the day of the test. If another preheat is to be conducted after the appliance has been preheated earlier, the water-bath rethermalizer mass temperature will need to be stabilized. Fill water-bath rethermalizer with fresh water and allow the water in the rethermalizing vat to stabilize at room temperature for at least 30 min. Drain the water from the water-bath rethermalizer and begin testing with 10.4.1.

10.4.2 Turn the water-bath rethermalizer on with the temperature controls set to attain the rethermalizing temperature calibrated in 10.3.

NOTE 7—It is the intent of this procedure to test the appliance at the rethermalizing temperature calibrated in 10.3. If the appliance is unable to achieve the rethermalizing temperature, then the manufacturer needs to be contacted. The manufacturer may make appropriate changes or adjustments to the water-bath rethermalizer.

10.4.3 Begin monitoring energy consumption and time as soon as the water-bath rethermalizer is turned on. The preheat period is measured from  $75$  to  $195^\circ\text{F}$  ( $24$  to  $91^\circ\text{C}$ ). Use the preheat energy consumption and time from  $75$  to  $195^\circ\text{F}$  ( $24$  to  $91^\circ\text{C}$ ) for preheat energy consumption and elapsed time.

10.5 *Idle Energy Rate:*

10.5.1 Ensure that the water-bath rethermalizer is filled to the indicated fill line or manufacturer's recommended water level. If the manufacturer provides a cover, then make sure that the cover is in place over the rethermalizer vat.

10.5.2 Allow the water-bath rethermalizer water to stabilize at calibrated idle temperature for at least 30 min after the last thermostat has commenced cycling about the thermostat set point.

10.5.3 Record the water-bath rethermalizer water temperature, barometric pressure, and ambient temperature at the start of the test.

10.5.4 Proceed to monitor the elapsed time and the energy consumption of the water-bath rethermalizer while it is operated under this idle condition for a minimum of 2 h.

10.6 *Pilot Energy Rate (Gas Model with Standing Pilots):*

10.6.1 Where applicable, set the gas valve controlling the gas supply to the appliance to the "pilot" position. Otherwise set the temperature controls to the "off" position.

10.6.2 Light and adjust pilots according to manufacturer's instructions.

10.6.3 Record gas reading, gas temperature, gas pressure, ambient temperature, barometric pressure, electric energy consumed, and time before and after a minimum of 8 h of pilot operation.

10.7 *Rethermalization Time Determination:*

10.7.1 Ensure that water-bath rethermalizer water is loaded to the indicated fill line. If there is no fill line, then fill to manufacturer's recommended water level.

10.7.2 Preheat the rethermalizer and allow the unit to stabilize for 30 min after being preheated.

10.7.3 Ensure that water-bath rethermalizer water is loaded to the indicated water-bath rethermalizer fill line. If there is no fill line, then fill to manufacturer's recommended water level. Confirm that the water-bath rethermalizer-water temperature is at its rethermalizing temperature as calibrated in 10.3.3.

10.7.4 Ensure that the soup chubs are  $38 \pm 2^\circ\text{F}$  ( $3 \pm 1^\circ\text{C}$ ).

10.7.5 Load the water-bath rethermalizer with the number of refrigerated soup chubs as determined in 9.12. Load time shall be no greater than 5 s per chub. If the manufacturer provides a cover, then make sure that the cover is in place over the rethermalizer vat. Begin monitoring rethermalization time and rethermalizer energy consumption.

10.7.6 Determine an approximate doneness of the soup ( $165 \pm 5^\circ\text{F}$  ( $74 \pm 3^\circ\text{C}$ )) by randomly selecting a chub and removing it from the water vat at predetermined time intervals. Shake the soup chub for 15 s to mix the soup, then fold the bag over a thermocouple probe. This will approximate the temperature of the chub.

10.7.7 If the average surface temperature of the soup chub is below  $165 \pm 5^\circ\text{F}$  ( $74 \pm 3^\circ\text{C}$ ), then put the soup chub back into the water vat and continue to rethermalize. Repeat this process, randomly selecting a different chub, until the approximate surface temperature of all the soup chubs reaches  $165 \pm 5^\circ\text{F}$  ( $74 \pm 3^\circ\text{C}$ ).

10.7.8 If the average internal temperature of all the soup chubs is greater than  $170^\circ\text{F}$  ( $77^\circ\text{C}$ ), the soup is overheated. Terminate the cook time determination test and repeat 10.7.1 – 10.7.7.