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Panificio Italiano bakery

Baked to Perfection

Pappert Bakery

Artisan work
and automation

Swiss special

Market reports
from Switzerland



02
18

Objective: market leadership

The former Heathrow Bakery owners invested GBP 15m. (approx. EUR 17m.) in the newly founded Panificio Italiano bakery. Production at the new, optimized location near London's Heathrow Airport obeys the "Baked to Perfection" principle.



++ The dough pieces are strewn with seeds, automatically scored, then transported into the Heuft tunnel oven

+ Production at the British "Heathrow Bakery" founded in 1991 in Iver, Buckinghamshire near London, has been relocated. The newly founded Panificio Italiano bakery is situated almost directly opposite the former production site, on the other side of the road. The entire workforce together with the plants are now in a freshly renovated production building. Owner Piero Scacco invested around GBP 15m. (approx. EUR 17m.) to restructure the business and introduce new production technology. The bakery's aim includes stronger growth with frozen baked products, as well as further optimization of the quality of the baked goods and production process, and winning new customers.

For this, for example, Scacco invested in new outdoor flour silos, new mixers and a new frozen product warehouse. The new location also has enough space for further growth, because the restructuring is also designed to win new customers, e.g. the food retail.

Production

The company employs around 170 staff. Production is in two shifts, six days a week. In addition to various small baked goods, the Iver bakery also produces breads, ciabatta and other specialties. All from wheat flour, and two in-house product developers ensure a constant stream of new products. The main purchasers nowadays are still food service and catering companies.



++ The newly-founded Panificio Italiano came into existence only a short distance from the Heathrow Bakery site. Employees and plants were taken over for the restructuring

However, General Manager David Taylor and Sales & Marketing Manager Andrew Gibson see growth opportunities, especially in the frozen food area. Owner and Chairman Piero Scacco, whose roots are in Italy, shares this view, and says: "We expect the sector to change, particularly due to Great Britain's planned exit from the European Union, and we are currently adjusting to that. Thus we anticipate a rising demand, especially in the retail, for frozen baked goods produced in England." Consumers will also happily continue to purchase specialties such as ciabatta, focaccia or ciapini produced



++ A Saccasiano mixer carousel automatically supplies wheat doughs to the lines. There is also a mixer for small dough batches



++ Mostly wheat flour is processed. The doughs have a high water content, and high-quality olive oil is used for Italian-style baked specialties



++ There are several König plants, e.g. an Industrie Rex AW with a KGN proofer for sandwich bread rolls



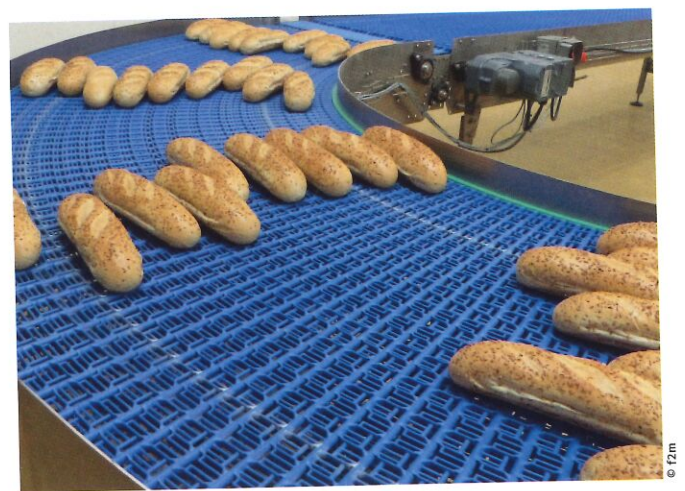
++ The dough pieces are deposited onto Diane coated trays. This is followed by the proofing process, including in a GBT paternoster proofer



++ As well as rack ovens, there is also a Heuft multi-deck tunnel oven with thermo-oil and stone plates



++ Bread rolls coming out of the oven



++ Baked products on their way to the cooler

Italian style with olive oil. The Panificio Italiano bakery's team is confident of this. To produce high-quality baked goods, the company also attaches great importance to various plants, as well as to high-quality raw materials such as extra-virgin olive oil. In this respect, most of the plants are from the Austrian machine constructor König in Graz. Piero Scacco explains that "I have collaborated with König for around 40 years, and I particularly appreciate the good support." But the production facility also contains a mixer carousel from San Cassiano in Italy, ovens from the German thermo-oil oven builder Heuft, and GBT plants.

Thus the staff use several König plants for dough production, including an Industrie Rex AW with a KGN proofer plant for sandwich rolls. The Industrie Rex AW (accurate weight) has a weight range from 22 to 160 g and is used for dough dividing and round molding. The weighing and molding system that was developed, and the continuously adjustable uniform pusher plate pressure, ensure high weight accuracy, even with a variety of dough consistencies. Panificio Italiano operates it at a maximum rate of 18,000 pieces/hour.

After dividing and molding the dough, the dough pieces go into a proofer with 340 swing trays and a proofing time of approx. 8 minutes. Next the dough pieces are pressed flat in

a shaping station, and folded to create sandwich bread rolls. After another proofer with a 6-minute proofing time and 250 swing trays, they are then deposited and carried after rounding onward for final proofing and baking.

Dough sheeter

A König Certo Pan M dough sheeter is used to manufacture various specialty baked products. A rotation principle in the system guarantees weight accuracy with no scrap dough. To avoid joints and associated irregularities in the dough, the dough feed is rotated in a drum. Oscillating cutting blades are then used to shape the rotating dough into a continuous endless dough sheet. The Panificio Italiano bakery has a Certo Pan M plant with interchangeable cutting rollers for 1- to 5-row operation. The number of rows can be changed by manually repositioning the belts. In 5-row operating mode, for example, the plant's capacity is 6,000 pieces/hour. For greater weight accuracy, there is also a weighing device upstream of the punch to cross-cut the dough strands. The plant also includes crosscutting tools for various baked product shapes, e.g. lozenges.

The plant also has an additional round molding station for circular baked products, a three-belt poppy-seeder/strewer with automatic strewing material recycling, a water-bath to

moisten the dough pieces from below and an overhead spray unit for additional top moistening. This is followed by a scrabbler with a 600-mm working width.

Bread roll plant

The bakery also depends on Austrian plants to manufacture small baked products. The König KGV Combi has a 6-, 5- and 4-row Industrie Rex I dough divider-molder that is continuously adjustable for 10 to 50 strokes/minute. The plant also has a 30 – 100 g weight range. The associated KGV Combi proofer has more than 400 loadable swing-trays and integrated long rollers. The plant can manufacture both split-top rolls and stamped Kaiser rolls. A direct feed route can be selected to bypass the proofer for products without any proofing time. The air-conditioning has a heater and humidification, controlled via a thermostat and a constant humidity device. There is also a sterilization plant with cold-cathode UV lamps for empty swing-trays, and a drying zone with a blower, again for empty swing-trays. The proofer is followed by a shaping station to long-roll and fold the dough pieces and press them flat. Finally, this is followed by an Industrie-type scrabbler with a maximum scrabbling length of 950 mm that can be operated on three sides.

The dough pieces are deposited onto Diane baking sheets and trays. General Manager David Taylor explains that “Our



++ Left: Owner and Chairman Piero Scacco. Right: General Manager David Taylor accompanies the bakery's restructuring

experience with the French tray coating and pans has been good.” Taylor is also satisfied with the GBT paternoster proofer and loading/unloading technology. Products are baked either in Heuft thermo-oil rack ovens or in a 5-deck tunnel oven with stone plates, also from the oven builder Heuft. The bakery also invested in a new spiral freezer at the new site. Another bread roll plant is being installed. A new line for bread production is also planned. In addition to the planned new frozen products warehouse, the packaging section is also currently being automated to achieve the aim of market leadership with the motto “Baked to Perfection. +++

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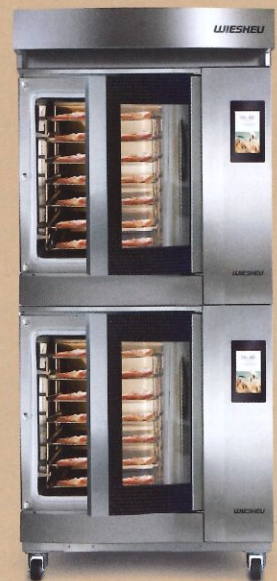


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