

## On the Rise, Part 3

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**A Bun in the Oven**

Gonnella's baking process in its Aurora facility is similar for all its baked products.

The process begins in the scaling area, where dry ingredients — including flour and minor ingredients — are measured according to client-set recipe specifications before being blown through a dry hopper.

The dry ingredients are then added to a mixer, along with the recipe's wet ingredients. Refrigerated jackets help to maintain dough temperature as dough is pumped onto a belt and conveyed to a dough rounder, which portions the dough into the appropriate size for the process application underway.

An intermediate proofing step allows the dough to relax before it is sent to the molder, which shapes the dough before baking.

The molded pieces of dough are put on pans, which are allowed to accumulate before being sent into a tray proofer for about an hour. The proofer has 120 shelves and provides a warm, moist environment in which the dough can rise.

After completing a proofing cycle, the pans of risen dough are sent to a water cutter, which makes rapid, precise cuts, and is used to cut slices into buns or patterns into bread.

Pans are again accumulated and conveyed into a tunnel oven, which holds approximately 1,200 trays of buns at a time.

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After completing the baking process, the trays are conveyed to a depanner, which uses suction to lift the bread from the pans. After the pans and bread are separated, the pans are “blown out” — a process used to remove any bread remnants from the pans — and sent to be cleaned and sanitized.

The newly freed bread is conveyed to a spiral chiller, which lowers the temperature of the product and stops the internal baking process. Gonnella’s quality assurance team checks the sizes of all finished rolls to ensure that any misshapen product is discarded. Data from this step allows the Gonnella team to determine whether tweaks to the recipe or process may be necessary.

After cooling, the products are conveyed through a metal detector in order to ensure product safety and are conveyed to three packing lines. Buns are sliced if client specifications call for it, and they are then sent to be wrapped. Before being wrapped, however, heels are often separated from sliced loaves if customer specifications require heelless loaves. The heels are sold for animal feed.

Gonnella recently added an individual bun wrapper, which allows the company to meet customer demands for single serving packages. Product is either packaged with this machine or with another of Gonnella’s baggers, and bagged product is loaded onto pallet-like trays.

These trays are color-coded for customer specifications. After trays are converged, quality assurance checks the slices for width, and the trays are loaded onto dollies where they are time-stamped, labeled, shrink-wrapped and loaded onto trailers for distribution. All returning trays are sent through a washer for sanitization before being reused.

*Please tune into tomorrow’s Chemical Equipment Daily for part four of this four-part series To read part one of this four-part series, [please click here](#). [1] To read part two of this four-part series, [please click here](#). [2]*

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