

From Morocco to Hamburg

SANDRO STACCHIOTTI AUTOMATED HIS PRODUCTION EARLY. TODAY, FOUR BAKERS PROCESS 3 TONS OF FLOUR EACH NIGHT INTO BREAD AND ROLLS



++ figures 1+2
Three generations: Sandro Stacchiotti, his sons Paolo, Simone and Sergio and two grandsons Alessandro and Stefano



++ figure 3
Alignment after the long moulding process

++ figure 4
Turning the dough pieces after moulding by 90°

++ figure 5
Second long moulding process for Mantovani

++ figure 6
Mantovani in the proofer

+ The Stacchiotti bakery is not an industrial bakery. However, in terms of productivity it need not hide behind larger companies. During a 10 hour night shift, about 3 tons of flour is processed into rolls and bread. This job is performed by a well-rehearsed team of four young men who activate programs, refill topping materials or change a dusting template, all in a professional routine. No bustle, no shouting, no malfunction. “You will not find another bakery of our size between Morocco and Hamburg with such performance”, Sando Stacchiotti is proud of this achievement and not only because two of the young men are his sons.

The foundation for this production was laid down by him and would also not be possible without his raw material knowledge – he grew up in a mill, and had the technical understanding and willingness to try new approaches.

Many of the details are of his own development, with special devices such as the weighing and dosing equipment for minor components by UTEC and the distribution equipment of the dough from the mixers onto the lines specially constructed for his bakery.

The premises, in the commercial area, on the fringe of Ancona began operation in 2005. A combination of equipment, made by various Italian suppliers includes a continuous stone plate oven which produces the bread range. The roll producing plant with a plate circulating oven by Austrian bakery equipment manufacturer Koenig produces 40,000 rolls per night of 12 variations (18 variations are possible in total). A pastry shop and a pasta production supply a small additional product range, produced semi-automatically, for eleven of its own sales outlets which Stacchiotti operates in and around Ancona.



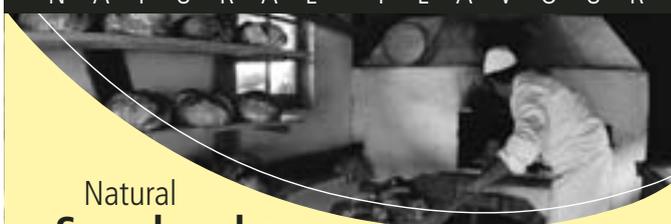


Sandro Stacchiotti can look back on 53 years of his professional career. The investment for his sixth bakery was in the range of 7m Euro – each bakery has increased in the degree of automation – and there is sufficient space in the production area for two more production lines. Production, administration and distribution with six of its own trucks are handled by 15 employees, among them his three sons Paolo, Simone, and Sergio. The eleven sales outlets offer some kind of protection from too much dependency on individual customers. About three-quarters of the production quantity is delivered to retailers from Carrefour to the shop around the corner, to hospitals, jails, barracks, and schools. The regional administration has ruled that each child is entitled to get one slice of organically produced bread each day. This bread is supplied by Stacchiotti. For that purpose, an organic product range was introduced which however has no further importance today. Food service and campgrounds are not served; the amounts are hard to calculate and payment is uncertain. The company uses its own trucks to distribute the products once a day within a 100 km range. Everything is delivered at seven a.m. The main parts of sales are rolls which are also the flagship products. 40,000 rolls are delivered each morning. Part of the daily product range are 40 and 80 g Kaiser and Rosetta rolls which are exclusively available in the region from Stacchiotti; 100 g Panino all olio, 40 and 60 g Sigarette as well as 80 g Mantovani. One Mantovano – made with 56.9 % water, 3.2% oil and 46.7% biga (strong wheat sponge) referred to the amount of flour (baker’s percent) – is moulded twice after rounding, then sheeted, rolled up, automatically turned by 90°, sheeted and rolled up a second time. This way, the rolls have a lot of tension and a fine crumb as well as their typical appearance. After baking, the “coiling” can be clearly seen. In addition to that, the Mantovani are automatically slashed and proofed upside down. The making of Mantovani takes time. The dough is allowed to rest for 7 minutes between dough division and make-up, the pre-proofing takes

15 minutes while the final proofing lasts 90 minutes. After that, the dough is baked for 36 minutes, with initial baking at 280 °C with 8% steam in zone 1 which is approximately 2/3 of the up-movement in the Imperial plate circulating oven, while in zone 2 the temperature is only 220 °C. This way the product develops a sturdy but not too dark a crust which is common in this region and considered to be a quality feature. The crumb underneath is soft and stays this way for several hours. Alongside some other small baked goods, Mantovani is the key product for Stacchiotti. The owner and his three sons are proud of their products’ quality and the streamlined production. “Up to now, the production of Mantovani was only possible with a ’gruppo,’” explains Sandro Stacchiotti, “unloading as well as slashing had to be done manually.” He considers that there is no other machine besides his Koenig equipment which is capable of producing Mantovani in this consistency, high quality and hourly output fully automatically from mixing to packaging. The batches for the various types of rolls differ. Recipes and processes are not always the same but nonetheless four ▶

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++ figure 7
Stacchiotti sales outlet

different types are sometimes processed on the line at the same time, one after the other. This is made possible by a highly sophisticated adjustment and control process. The equipment is arranged in a straight line (often plants of this size are arranged in L-shape) and would produce 24,000 rolls/hour when using a mono-line. Depending on the types of product to be produced, the programs at Stacchiotti operate with less rows and each station runs at a speed adequate for the respective product. As a result, the hourly performance upstream of the cutting station can differ from the downstream speed. The separate speeds of the various modules allows for different processing times.

The baked rolls are then transported via belt into a TecnoPol spiral cooler and then to the automatic packaging.

The roll production is started in five overhauled spiral mixers by a manufacturer who has gone out of business. The mixers are vigorously guarded because spare parts can only be found via the internet. Sandro Stacchiotti has a strong conviction about these mixers which process the dough with a central arm with a diameter of at least 15 cm clockwise and

counter-clockwise: "The thick central arm is responsible for ensuring that the dough does not heat up during the 8 minutes of mixing time". Biga, the wheat sponge, is produced by a double-armed mixer which imitates manual processing.

At Stacchiotti, automation is not the enemy of quality. Saving time is not the reason for automation. The dough still gets all the time it needs for proper development. The reason for Stacchiotti is to save labor, partly because the number of young people in Ancona who want to work in a bakery at night is decreasing, and partly because he started working in the bakery connected to his father's mill at the age of 15 and knows how exhausting the job is.

"Where there is bread, there is Stacchiotti" – this family motto describes today's market significance within the region. The next projects are frozen products for bake-off stations. Large supermarket chains have made this form of sale acceptable in all of Italy and their market share is growing. This is the right time for Sando Stacchiotti to jump on the band wagon. There is no doubt that he will be competitive with his production thanks to the high level of automation. +++



++ figure 8



++ figure 9

++ figure 8
Mantovani ready to eat

++ figure 9
On a "small" Koenig machine, overhauled recently, a specialty of the region is produced which used to be made only for Eastern markets. This product is available around the year. Grated cheese and lots of pepper are added to the dough. During the winding of the dough, larger chunks of young pecorino (cheese from sheep) are incorporated. The cheese melts during the baking process. The name of the differently sized baked pieces: Crescia di formaggio

On the fork, ready to go...

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Unifine Food & Bake Ingredients GmbH
Riedstrasse 6 • D-64295 Darmstadt
Telefon +49 6151 3522-90 • Telefax +49 6151 3522-9339
mailbox@unifine.de • www.unifine.de