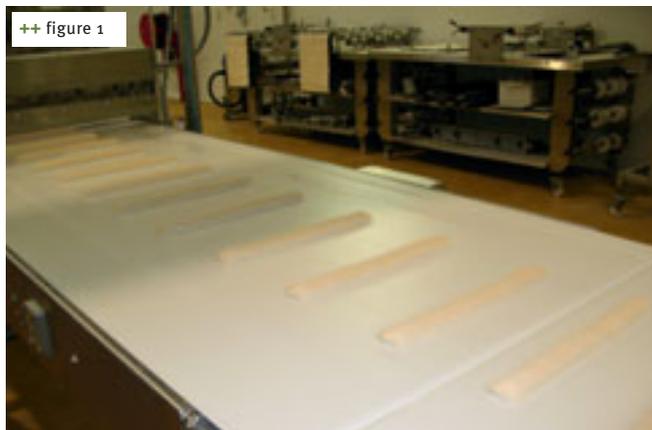


# New building in Maubeuge

THE FRENCH NEUHAUSER GROUP HAS EXPANDED ITS FACILITY IN MAUBEUGE, NORTHERN FRANCE, WHICH WAS TAKEN OVER FROM CSM IN 2007, WITH A NEW BUILDING



++ figure 1

**++ figure 1**  
On the Fritsch line, square dough pieces are cut out from the dough sheet which are then further processed into the desired product, e.g. baguettes with pointed ends



++ figure 2

**++ figure 2**  
Baguettes on peel boards

**++ figure 3**  
The dough pieces are controlled on all three lines with cameras for proper shape, size and position on the belt. If needed, the Homburg cameras can be expanded by a color control device

**++ figure 4**  
The mixer carousel ensures proper dough ripening time in the vat on the line for premium baguettes

**+** The recently inaugurated new building houses the expanded frozen baked goods production of the Neuhauser Group in Maubeuge, France, which has an hourly capacity of 6.5 tons of frozen baked goods. The new building, with a floor space of 250 x 50 m and a frozen storage area holding 4,000 pallet places, is located close to the “Delice de la Tour” production facility that was taken over in 2007 from CSM. The total investment now amounts to 34m Euros.

There are four lines, three for frozen products and one for fresh products, operating in the Delice de la tour production buildings with the new building housing three lines for traditional baguettes, premium baguettes and fine bakery wares. The combined capacity of the three new lines is 6.5 tons per hour.

The traditional baguettes are made on a Mecatherm line which is supplied with dough from a continuous VMI mixer. The dough make-up is done in two parallel Bloc HPII lines. Both lines are combined again for proof-

ing, baking, cooling and freezing in the traditional Mecatherm vertical plants. The products produced on this line include unproofed and pre-baked baguettes. Prior to packaging, a camera ensures the quality of the products by checking the precise length and the shape of the bread sticks. Currently, there is no color control although this can be retrofitted later, if needed. The hourly capacity of this line is maximal 2.5 tons or 7,500 baguettes, on trays 2000 x 800 mm with 25 moulds, frozen either unproofed or par-baked.

The capacity of the second baguette line is only half the one of the first line, but the product quality is artisan. The dough preparation is again by VMI, although it is not in continuous mode but rather uses a mixer carousel with 18 vats. The dough matures in the vats for up to two hours, depending on the product, and it is remixed for a short time every 30 minutes prior to further processing. A Fritsch dough sheet line is used for dough make-up. It deposits either cut baguettes with straight



++ figure 3



++ figure 4



**++ figure 5**  
The position of the croissants' seam is still checked manually; in the long term, the line will be adjustable which will eliminate this workplace



**++ figure 6**  
After the first laminating step, the dough sheet is moved into the second cooling section

ends as well as baguettes with pointed ends onto peel boards. All other equipment – Multi Vertical Proofer, (this is a storage system which accepts the incoming trays vertically, then moves them up and across before bringing them down again in the parallel system) stone plate oven, spiral cooler and CO<sub>2</sub> flash freezer are from Gouet.

In order to transport the baguettes from the peel boards to the oven belt, there is a device which accompanies the product so that it can climb onto the wing of the loader; it is a roll which applies a small amount of pressure to the top of the product when it climbs onto the wing.

Here again, the quality control via camera takes place prior to packaging. This camera device, as the ones on the other two lines, was provided by Homburg.

Line number three is for the production of fine bakery wares and processes about 2 tons of dough per hour. The Rademaker line produces the dough sheets. It operates with two chilled resting stations. The first one is located in section 2; the second one is downstream of the second laminating station. In both stations, the dough is allowed to rest at 2-6 °C for proper flavor development before it is processed into different baked goods. All croissants are made with butter; however, the butter content varies from 18-27%.

The two folding or laminating stations at Neuhauser follow two different principles. In the first folding station, a belt that can swivel is moved above the next transport belt which is arranged at a 90° angle to the transport belt. This results in a zig-zag folding of the dough thus producing the desired number of dough-butter layers. For the second station, Rademaker supplied a different technology which results in slightly varying laminating behavior. Here the dough sheet is cut into pieces of the same length which are deposited slightly offset onto the next transport belt which is also arranged at a 90° angle to the first one. The resulting dough sheet has precisely the same number of dough-butter layers at any point of the dough sheet except for the edges where the layers are open. This is called “pate mort” – dead dough

– in the homeland of croissants. The finished dough pieces, cut and coiled up, are deposited on trays until they reach the freezer. The dough pieces are moved through the freezer on a belt while the trays are transported back into a washing station.

This line is used for the production of croissants, Pain au Chocolate, Pain au Raisins as unproofed or pre-proofed dough pieces. The investment into two cooling stations has a positive effect, in particular, in the production of pre-proofed dough pieces. In both chilled resting stations, a part of the flavor development takes place which otherwise would have happened in the proofing chamber. With the right combination of cooling station and proofer, the subsequent proofing time can be reduced. In this way, it is possible to achieve the desired size of baked good via the oven spring, although the volume of the dough piece is smaller because of the shorter proofing time. This saves space in packaging and reduces the transport costs for the products.

A device for checking the position of the seam is not in place. It was explained that this is not necessary when the line is adjusted correctly. Not yet present, but already planned, are different filling stations. On this line again, shape and dimensions of the products are checked by camera prior to automatic packaging.

The Neuhauser Group has its roots in a small bakery founded in 1906 by Frederic Alfred Neuhauser. His grandson, Alfred expanded the bakery in the 1970s and made the company what it is today. The Group is headquartered in Folschviller/Alsace. The group operates 15 production facilities in France and one in Portugal. Each French production location provides fresh baked goods for the surrounding region. Fresh baked goods contribute with about 30% to the consolidated turnover of 310m Euros; frozen baked goods with 50%. 20% of the sales volume is generated with about 150 sales outlets in Germany. A large portion of the frozen goods production is destined for export so that more than half of the turnover of the group is generated outside of France. +++



**++ Alfred Neuhauser**