



The second step

ARTISAN DELICATE DOUGH HANDLING IS THE MOTTO FOR BENIER AT THIS YEAR'S IBA. THE DUTCH COMPANY WILL PRESENT A NEW LONG MOULDER

++ figure 1



++ figure 1
The new long moulder by Benier:
A servo-controlled pressure board
moves along with the belt

+ In Tokyo, Chicago or Barcelona – the picture is the same. Bread that is juicy, full of flavor and has large pores is following the trend and generates better prices. The sales market is turning to artisan or natural bread, partly due to the fact that dough sheeting plants have lost their attraction in bread production.

Producers of classical make-up lines such as Benier of 's-Hertogenbosch in the Netherlands have responded to this challenge. The company's developments focus on handling the dough – as gently as a dough sheeting plant could do – as well as producing high tension within the dough so that the baked goods will develop a vivid oven spring for much more height. Furthermore, according to Roger Rom-som, Marketing & Sales Director at 's-Hertogenbosch, this traditional way of dough make-up

with dough dividers, rounders and long moulders does not produce waste dough that has to be returned as reworked dough. This provides for an economical advantage and also avoids the use of additional units which are prone to malfunctions within the line.

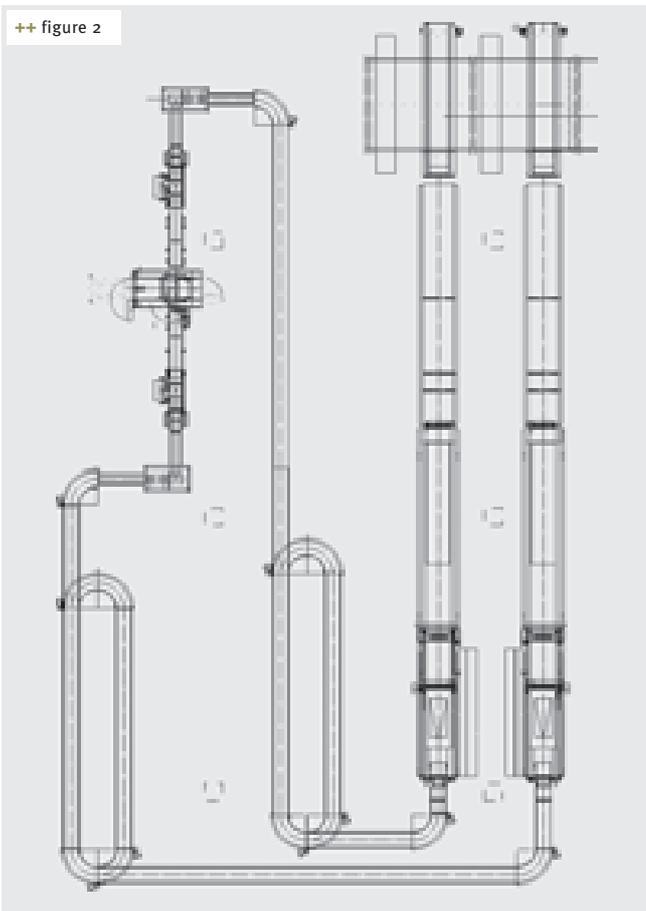
Following the introduction of the Dough Master dough divider a few years ago, Benier will present in October at iba in Munich for the first time the new long moulder which follows this philosophy: It is at least as gentle on the dough as sheeting equipment but also as precise as classical dough plants. When the dough pieces which come from the dough divider are placed in front of the long moulder, the orientation of the gluten strands inside the dough are already pointing in the right direction because they are positioned at right angles to the belt and aligned to the middle.

The next station is the common roller-rolling net combination which can be turned off, as well as a stationary pressure board as an optional station. The roller head is also of new design. It rolls out the dough directly onto the belt instead of against a second roller.

The innovative core parts of the line are the new pressure boards that can move along with the belt. While doing this, the pressure board moves gently back and forth, and the time and intensity of the movement can be adjusted. The board has a specific shape depending on the product to be processed. A slightly bent board for example makes sure that the baguettes have pointed ends. The pressure to be applied during moulding is adjustable as are the duration and intensity of the movement required to bring the dough to the correct length. Romsom says: "Most important is the combina-

tion of preciseness and gentle processing closely followed by the consideration to introduce much tension into the dough and to produce no waste." Compared to the stationary pressure board with a moulding path of 1.5 m, the new board is double this length, being 3 m. The first prototype of this new long moulder has been designed for an hourly capacity of 3,000 pieces. In combination with a Dough Master, two moulders can be mounted, and the line is capable of producing 6,000 pieces/ hour. With this variation, Benier may not only fulfill the requirements of craft bakers but also meet industrial requirements. Of course, the line is also able to handle stiff dough, and with the recipe communication the divider settings as well as the moulder settings can be adapted so that the line will be suitable for four piece depositing.

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++ figure 2
Delicate Dough Line is Benier's latest development. This line handles dough with a hydration of up to 75% and a dough resting time of four to five hours. It does this gently and precisely without any problems. An integral part of the line are the new long moulders which were developed as an alternative to baguette production on dough sheet lines

++ figure 3
A trend all over the world: Moist and tasty bread that looks like it has been shaped by hand. The Delicate Dough Line including the new long moulders produces up to 3,000 pieces per hour with each long moulder.

++ figure 4
Baguettes produced on the new line have a loose, open pore pattern