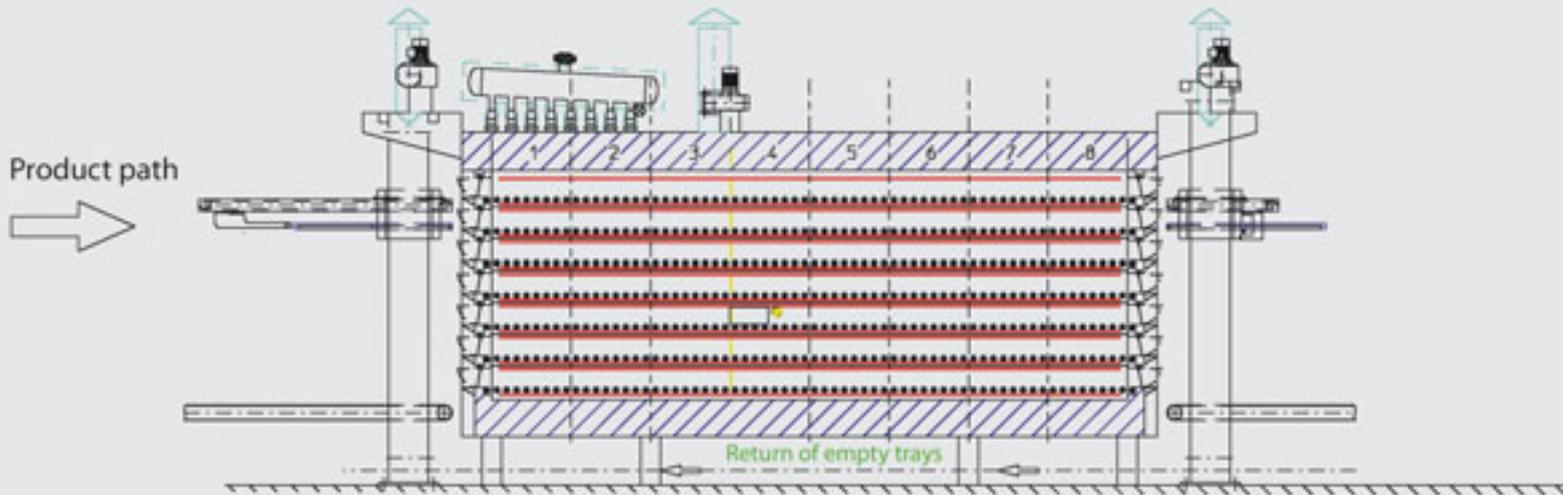


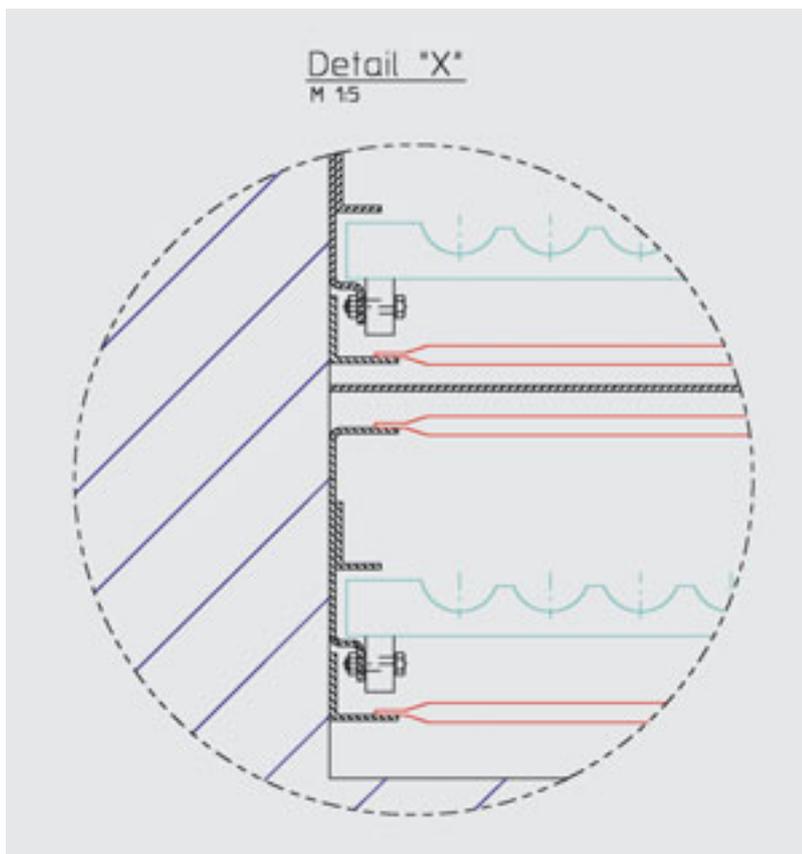
Driving potential

DAUB FROM HAMBURG HAS INTRODUCED A COMPACT OVEN FOR CONTINUOUSLY OPERATING MONO LINES WHERE THE BAKED GOODS ARE CONVEYED ON TRAYS



✚ Apart from the thermo-oil heating system, which is common place at Daub, and a simplified construction, the most striking features of the new oven are its dimensions. Even though it is not comparable to the measurements of Marilyn Monroe, it is nonetheless impressive. It provides a “normal”

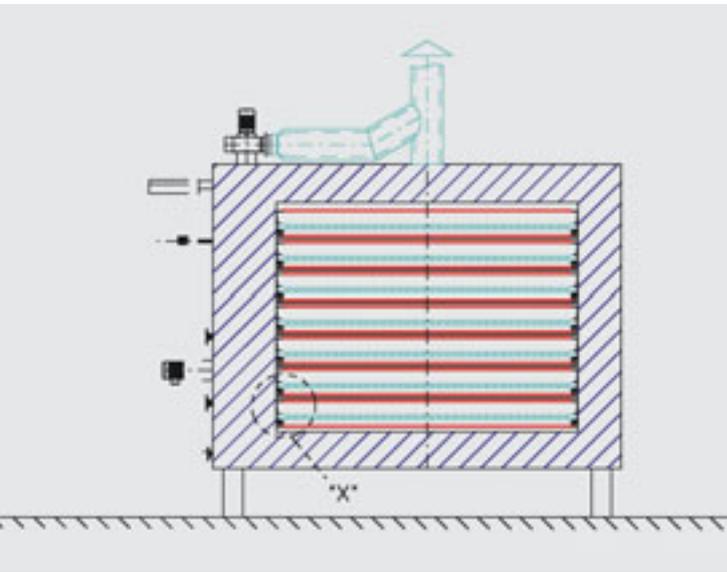
hearth height of 20 cm, with seven decks totaling a height of just 3.30 m. The oven length is only 6 m with an additional space needed for the loader and unloader. This “small” oven offers, for example, an hourly performance of 8,000 baguettes. The automatic loading and unloading systems allow for the use of trays with a width of up to 3 m.



The secret behind this productivity is the oven's conveying system. The trays are not transported on belts or pulled by chains; they simply push each other. In order to achieve this, profiles with rolls were installed at the sides of the oven which support the trays on their way through the oven. The special rolls have ball bearings which are able to withstand temperatures of up to 330 °C and which have only a low resistance to rolling. If the temperatures are to exceed 300 °C, Daub uses graphite bushings instead of ball bearings.

The profiles in combination with the pushing device of the loader also ensure that the trays do not get jammed in the oven and are not pushed on top of each other. The trays, with a thickness of 6 cm, have a special coating that prevents the residues from adhering. The trays, as part of the construction, are provided by Daub's parent company Kaak.

The abandonment of transport belts has other beneficial effects: belts do not need to be ex-



changed and drives do not need to be maintained or even replaced. Added to that, there is also less steel between the product trays and radiators that must be heated. However, one compulsory element is the loader that places the trays into the oven and gives them the necessary momentum to keep them moving. The unloader, at the exit of the oven, just accepts the trays and if the oven should run empty, empty trays must be used to ensure that the last loaded tray arrives safely at the unloader.

The hearths are of course separated from each other; they can be heated individually with top and /or bottom heat and their zones can be set to different temperatures. For the start-up of a new production – the oven is basically designed for continuous production – a special temperature control makes sure that the products on the first trays do not scorch as a result of a heat flashover.

Currently the oven is available with thermo-oil heating. It can be provided with a separate oil vessel or connected to an existing thermo-oil plant. Daub has designed the control of the entire oven for the continuous operation of a mono line and has eliminated all elements not required in this situation. This means that the control cabinet has an almost minimalist design.

The development was orchestrated by the former Daub CEO L. Pasch with the goal of creating a compact oven with similar baking properties to the existing thermo-oil ovens but at only 80-85% of the price. A patent application has already been filed for this oven. It is reported that Daub is also considering offering this type of oven with an electrical heating system. +++

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