

Boulangerie in San Francisco

With two lines from the WP Bakerygroup, Bay Bread of San Francisco produces a wide, handcrafted range of baked goods.



Pascal Rigo makes experience french baking tradition in San Francisco.

You can now experience french baking tradition in San Francisco. Not only french baked goods, but also an assortment of other european and international handcrafted products eg an italian ciabatta which can be found at the warm and cosy Cafe' & Bakery 'La Boulange', part of the Bay Bread Group.

Pascal Rigo came over to the USA from France 18 years ago and bought a bakery in Los Angeles – here began his success story. Today Pascal Rigo runs a production in Los Angeles and a further

two in San Francisco, employing around 500 workers. The turnover of thirty million US dollars is not reached however, solely through its stores, the company primarily supplies its specialities to hotels, restaurants as well as supermarkets which stock pre-baked goods.

To ensure a high and consistent quality of baked good, Rigo pays particular attention to the quality of raw materials, the use of sour dough as well as wheat pre-dough and simple processes. The lines used for processing as

well as the ovens both play an important role. "It's the interaction between the machine's possibilities, the quality of the baked goods and the profitability that plays a part when investing. The most important factor is the return, not the cost price. Key to this is the efficiency of the line: its performance and application possibilities." Explains Rigo. "For our company, we require a broad flexibility to enable us to adapt quickly to the market, to integrate and develop products respectively. Overall, we keep the process simple, but the machines are not allowed to be a limiting factor."

In his production in San Francisco, Rigo works with a Crustica bread line and a Quadro Round bread roll line – both from the Werner & Pfleiderer Bakery-group. The process is completed in the dough preparation area, using two kneaders from the President series and three MDV multi-deck ovens with a Steward feeding line.

Bread line

The Crustica is a bread line for wheat and mixed wheat doughs, which can also process highly

hydrated doughs. These products include ciabatta, baguettes and other mediterranean baked goods. Dough protection begins with division: the centrepiece of the line is therefore the dough divider V500, which can also process soft doughs with a long dough rest and a higher water absorption rate. In addition the divider possesses a pressure regulator and compensator called a Voluminator. The Voluminator regulates the applied pressure of the suction piston. The pressure can be adjusted, dependent on a dough consistency between 70% and 110%, and continuously regulated (compared with the standard applied pressure of a traditional suction dough divider).

This is how it is possible to divide a soft dough carefully and with weight accuracy. With the slightest adjustment in applied pressure, it is possible to divide a soft dough with a longer rest period. Even the texture of a ciabatta dough is retained.

How does it work? That lies in the elasticity of the dough texture. As with every dough divider, the dough is compressed during portioning. If very little pressure is applied, the dough pores relax again. If however, too much pressure is applied, some of the pores will not withstand



One component for the success at Bay Bread's are the pre-doughs. They rest in bins in a temperature controlled room.



The dough is the base for the quality of the finished baked goods. For the preparation of the dough Bay Bread uses a kneader by WP Kemper.

the pressure. The adjustment of the optimal applied pressure is possible with the Voluminator, which is controlled and operated via a convenient touch screen.



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Removal of the rustic baguettes from the wire-mesh belt.



Automatic loading and unloading: The loader Steward for the feeding of the three WP deck ovens with five hearths each. In the loader completely made of stainless steel all the three axis are motor driven. The lifting work, the setting and also the removal off the oven are controlled by a frequency inverter, a fact allowing for the gentle starting and the jerk-free stopping in the desired position. The stop points at the deck oven are individually adjustable and the overhead parking position always allows for free access to the ovens.

The next step in processing the dough pieces takes place using the round moulder and then, depending on the product, through a proofer or directly into a long roller.

Bread roll line

In keeping with its European heritage, Bay Bread has a wide

selection of handcrafted bread rolls. For processing, a Quadro Round line was chosen, with its highly efficient, consistent performance results and high degree of flexibility. The line consists of many modules configured in rows: a Relaxer dough strip machine, a Quadro Round head machine, as well as a discharge belt for the fast and automatic allocation of baking trays or peel board supports.

The distinctive feature of the Relaxer is instead of the usual coated hopper, the Relaxer has two angled vertically running belts, feeding the dough slowly into a special star roller. The star roller gently divides the dough without harming the pore structure and therefore portions a dough strip which is flattened at the ends and falls onto the conveyor belt below. The belt is cycled in such a way that each



The Relaxer gently produces dough strips which are fed to the bread rolls line Quadro-Round.

divided strip overlaps the end of the preceding one. The flattened ends form an even, continuous dough strip.



The Steward has an own control panel provided also with a display unit for the oven control and the recipe management for each oven.

Round and Square

Even before the infeed into the dough dividing and moulding machine, a calibrator forms a uniform sheet from the continuous dough strips – a prerequisite for the weight accuracy of the dough pieces eg a bread roll.

Cutting rollers divide the sheet into strips. The number of rollers that can easily be exchanged, depending on the number of rows, can vary between four and six. Then a guil-

lotine divides the strips into rectangular dough pieces. The weight of these pieces is determined by the length or cycle of the guillotine and



The specialist for soft dough as well as for round and square shapes: the Quadro Round.

can be infinitely configured between 40g and 150g.

After portioning, the Quadro Round shows us its real strengths. Its capacity to 'square the circle', because optionally the guillotine divided

it allows you to call up a program in which all parameters (weight, process, round or square etc) can be entered. The machine then proceeds automatically. Only the cutting rollers must be manually changed.



Square bread rolls. Shape and weight are determined by means of a guillotine.

dough pieces can then be round moulded using a moulding drum, comparable with a belt round moulding system, which is situated below the spreading belt. This allows the possibility of both round and square dough pieces to be produced. In order to keep the set up times of a product change to a minimum,



As many working steps as possible are automated. Also the dough is transported into the dough strip machine by means of a lift tipper.



European flair: „La Boulange“ is the name of the branches that are famous throughout the city for their baked goods.

Andreas Ranft

