

White

White

Portioner:  
Bun Head  
**37 lbs**

3 Portions/Head  
8 Heads/Batch  
**4.8 lbs\*/Round**

Submarine Buns

Rounder  
(partial)  
**5 for ~2s**

Dough Tray  
Two balls/Bun  
5 x 6

Former  
Small Plate  
Roller **3** Plate **2.5**

Screen Tray  
6 x 3

1 Head = 1 Trays  
1 Tray = 3 Packs  
  
Normal: 3 Heads = 3 Trays

Dinner Buns

Rounder  
**5 for ~3s**

Bulk  
3 x 4  
or  
3 x 6  
(staggered)

Solid Tray

12-Packs  
4 groups of 6

1 Head = 1.5 Trays  
(3 12-packs)  
  
Normal: 5 heads for  
12 bulk +  
7 trays (14 12-packs)

Keiser Bun  
Round  
**6.8 lbs/Round**

Keiser Buns

Rounder  
**8 for 8s**

Solid Tray  
3 x 4

Cover and  
let Proof

Keiser Stamp  
  
For Cheese Keiser,  
sprinkle with  
cheese

1 Head = 3 Trays  
1 Tray = 2 Packs

Portioner:  
Bread  
**29 lbs**

Dough Pan  
3 x 4  
**1.3 lbs/Loaf**

White Bread Loaf  
or  
Butter Crust Loaf

Former  
Medium Plate  
Roller **6**, Plate **4**

Loaf Pans

Former  
Medium Plate  
Roller **6**, Plate **4**

Sesame-topped Bread

Roll in Sesame  
Seeds

Loaf Pans

1 Portion = 24 Loaves

Small Mixer:  
**12 lbs** dough +  
**1 Pound**  
Cheese

**2 min**  
Speed **3**

Dough Pan  
3 x 4  
**1.3 lbs/Loaf**

Cheese Bread

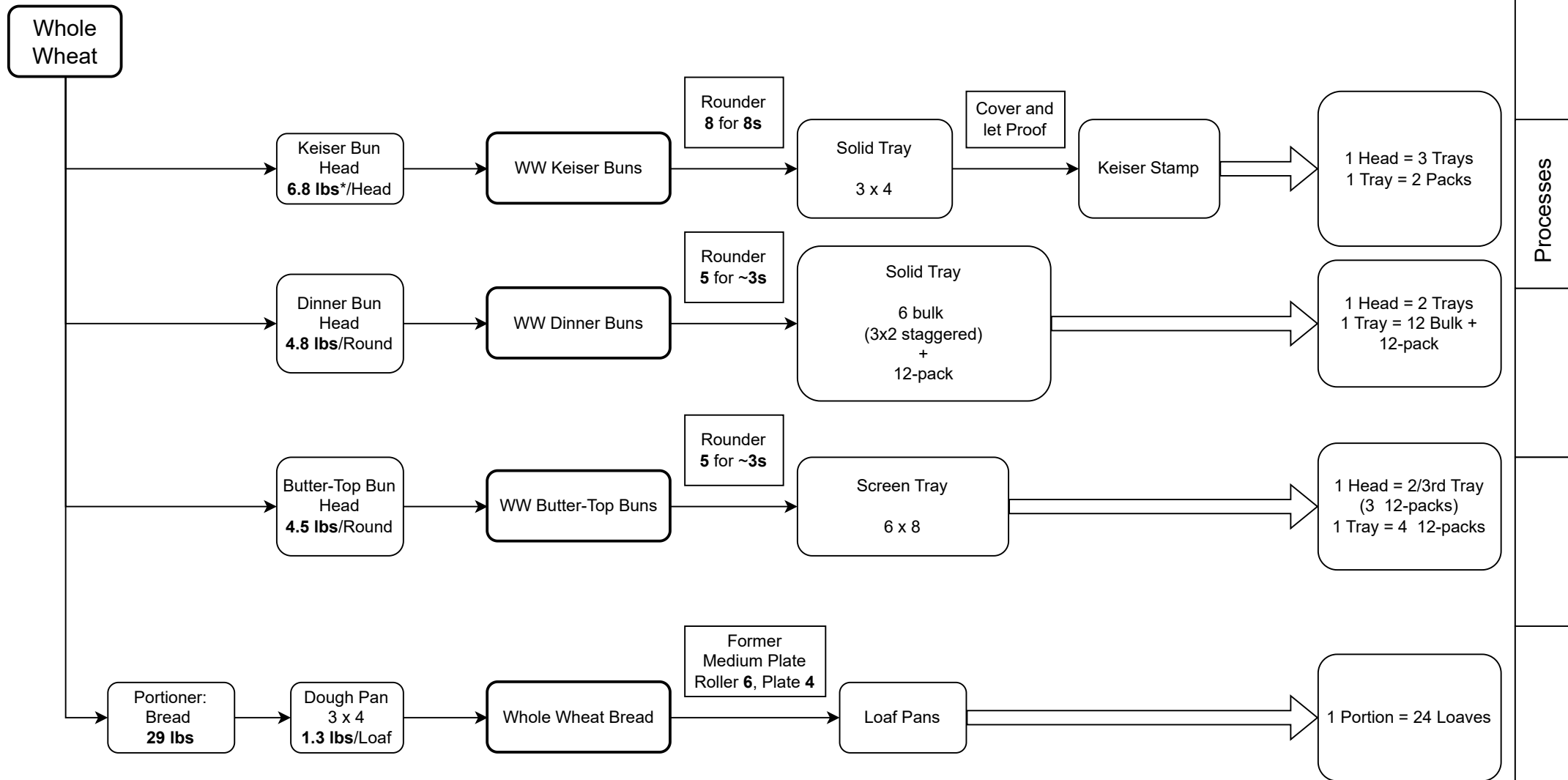
Former  
Medium Plate  
Roller **7**, Plate **4**

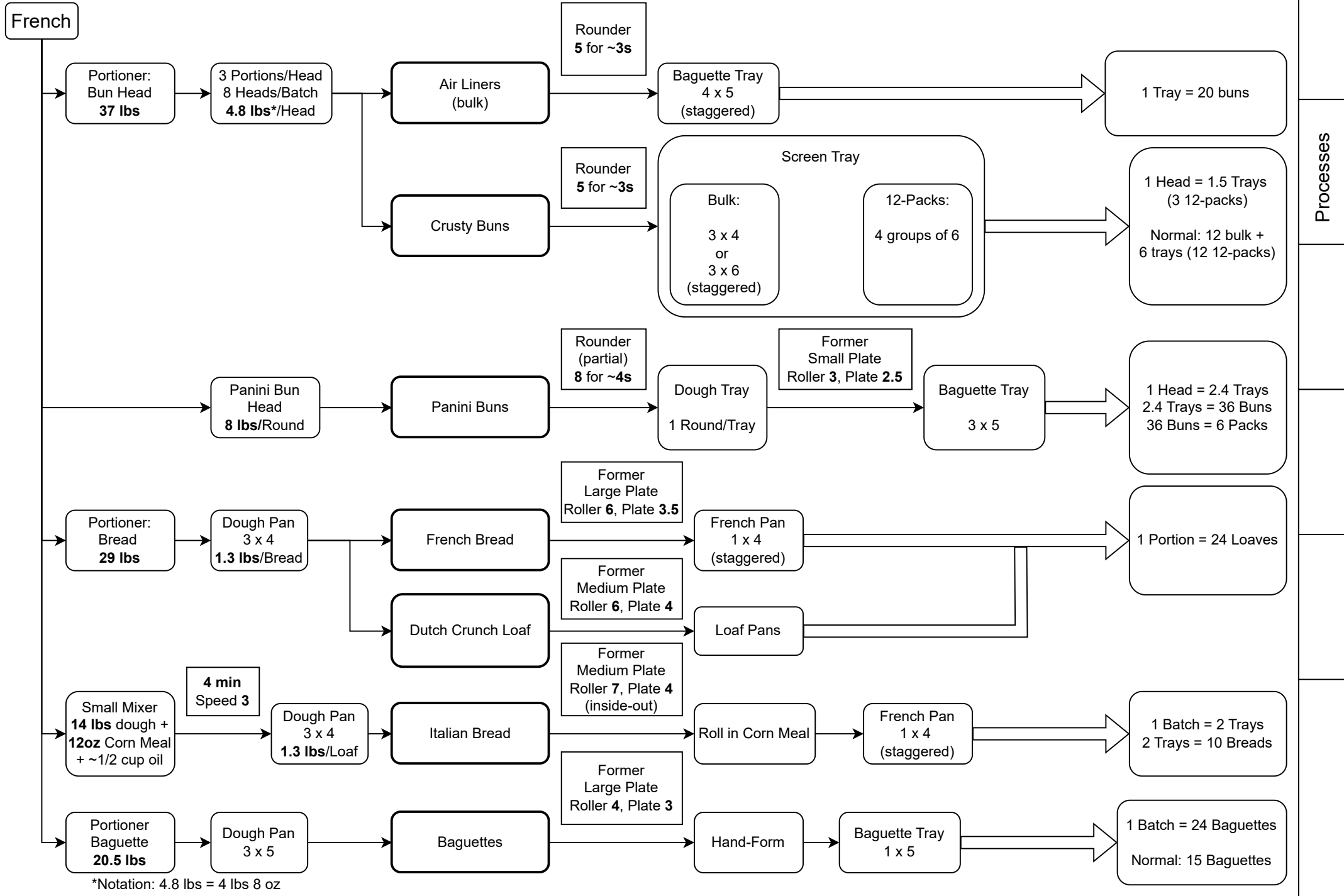
Loaf Pans

1 Batch = 10 Loaves

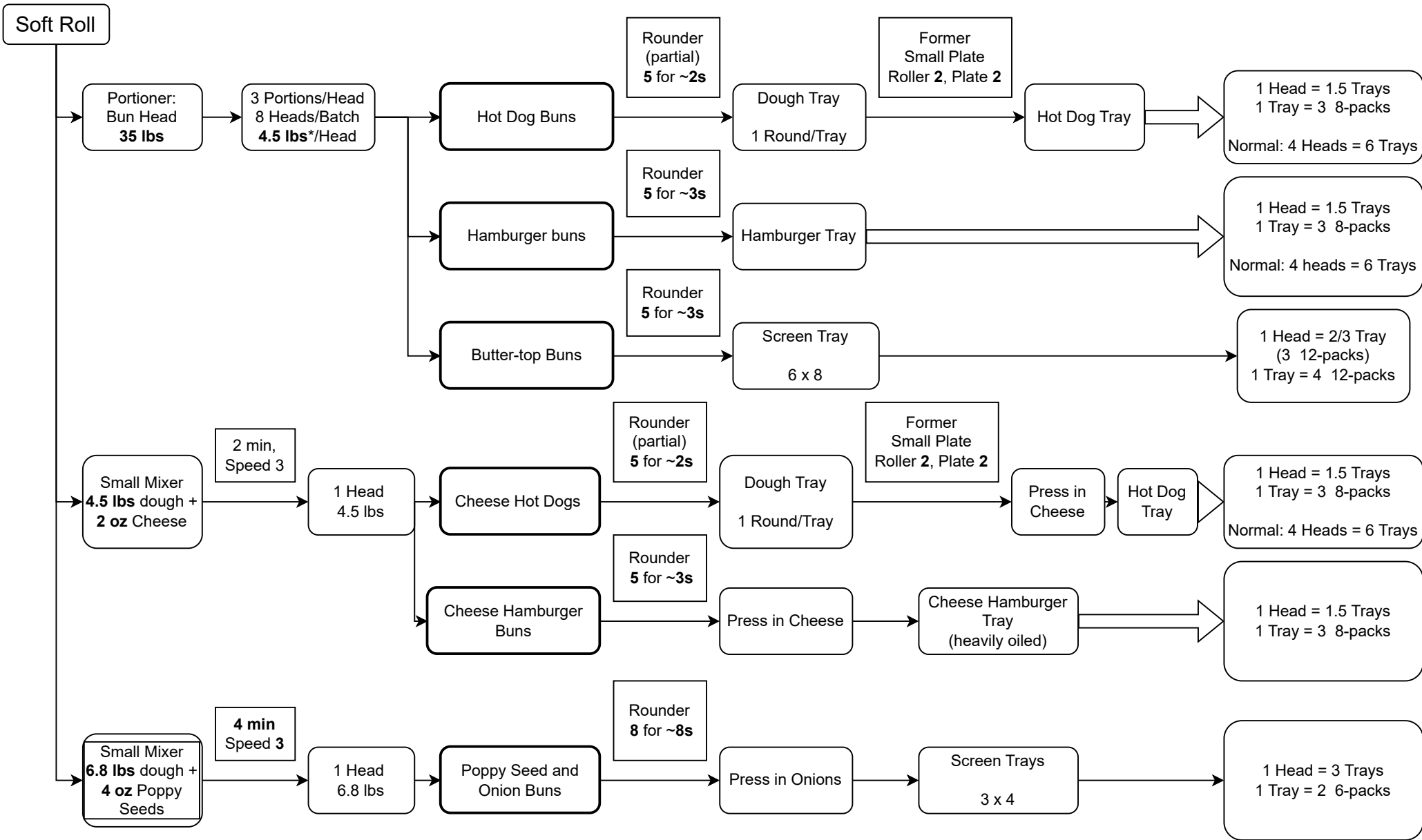
Processes

\*Notation: 4.8 lbs = 4 lbs 8 oz





Soft Roll



Processes

\*Notation: 4.5 lbs = 4 lbs 5 oz

Mixer Recipes Per Bag

**White**

Yeast: **7 oz**

Water: **24 lbs**

Time  
Slow: **4 min**  
Fast: **9 min**

**Whole Wheat?**

Yeast: **7 oz**

Water: **24 lbs**

Time  
Slow: **4 min**  
Fast: **9 min**

**French**

Yeast: **7 oz**

Water: **26 lbs**

Time  
Slow: **4 min**  
Fast: **6 min (remove Italian)**  
Fast: **2.2 min**

**Soft Roll**

Yeast: **10 oz**

Water: **20 lbs**

Time  
Slow: **4 min**  
Fast: **9 min**

Inventory Management

Conversions

# Bags of Flour = Total weight of dough / 68

Portioner = 24 Portions = 8 Heads

Rounder = 36 Balls

White		
Product	Target Inventory (avg)	Portioning
White Bread	50	29 lbs = 24 loaves
Dinner Buns Bulk	12	1 Tray = 12 buns
Dinner Buns 12-packs	20	4.8 lbs Head = 3 Trays = 2 12-packs
Submarine Buns	12	4.8 lbs Head = 1 Tray = 3 6-packs
White Keiser	?	6.8 lbs Head = 3 Trays = 2 6-packs
Cheese Keiser	?	6.8 lbs Head = 3 Trays = 2 6-packs
Butter Crust Loaf	5	From White Bread
Sesame-topped Loaf	5	From White Bread
Cheese Bread Loaf	5	12 lbs dough = 10 loaves

Inventory