Soft Dough Forming Machines

High performance and low cost of ownership characterise the Baker Perkins range of wirecuts, rotary moulders and bar extruders. Precise weight control and fast changeovers keep efficiency levels high across the range while a comprehensive array of sizes and options enables specifications to be tailored precisely to the customer’s requirements. New thinking in hygienic design has led to the introduction of the TruClean™ range of moulders and wirecuts, which set new standards in sanitary performance and ease of cleaning.

The range is diverse but common themes connect every design.

**Easy to Clean**

Quick and thorough cleaning have always been among the benefits of Baker Perkins equipment. All the machines in our soft dough forming range feature product parts that can be removed quickly as well as easy access to all the areas that need cleaning. The TruClean™ range has been designed in accordance with the GMA’s 10 Principles of Equipment Design and raises hygiene standards to new levels.

**Reliable**

Meticulous attention to detail in the design and build of the equipment helps to ensure trouble-free operation. Care is taken to avoid dough build-up and leakage that can cause unplanned stoppages and waste, while all the components are specified to provide many years of reliable service.

**Easy to Operate**

Whether the machine is specified with pushbutton or touch screen controls the operator interfaces are always clear, simple and easy to use. PLC and SCADA systems benefit from recipe control, data capture and intuitive alarm messages. SCADA systems may be connected to factory networks to enable managers to monitor performance remotely.

**Easy to Maintain**

All the routine maintenance items are readily accessible and standard components are used wherever possible.

Unbeatable Soft Dough Performance
**TruClean™ Wirecut**

The TruClean™ Wirecut is the result of an innovative approach to hygienic design with every detail meticulously engineered to minimise cross-contact risks and make effective cleaning very easy. Best-in-class weight control and fast changeovers deliver high efficiency and low production costs.

### Hygienic Design

Designed in accordance with all relevant industry guidelines, cleaning to avoid cross-contact from allergens and pathogens has never been easier.

### Precise Weight Control

Top quality product with minimal giveaway and waste. Weight accuracy is +/-1% on plain dough and +/-2% on dough with inclusions. No other wirecut comes close to this performance.

### Versatile and Efficient

Fast changeovers, minimum waste and outstanding reliability on a wide range of products.

### Easy to Operate and Maintain

Intuitive controls and easy access for cleaning and maintenance make this an exceptionally easy machine for operators and engineers to work with.

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### TruClean™ Angled Overhead Wirecut

The TruClean™ Angled Overhead Wirecut increases output up to 25% by eliminating the space wasted on the oven band when straight rows of round product are laid down. The machine offers the same weight control and hygienic design as the standard TruClean™ Wirecut.

#### Increased Throughput

By laying down rows at an angle to the oven band the products are nested and production is increased by up to 25% without the cost, complexity and disruption of extending the oven.

#### Precise Weight Control

The TruClean™ Angled Wirecut has the same filler block and die arrangement as our other wirecuts and offers the same high accuracy: +/-1% on plain dough and +/-2% on dough with inclusions.

#### Fast Changeover

Baker Perkins’ unique clamshell pivoting head design enables die and filler block changes to be carried out by a single operator from the control side of the machine with no tools in less than five minutes.

#### Easy to Clean

With the filler block and die removed all areas of the machine are easily accessible for cleaning.
TruClean™ Frozen Dough Machine

The TruClean™ Frozen Dough Machine is a specialised unit for making cookie dough pieces used in bake-off operations. Design features relating to weight control, hygiene and ease of operation are shared with the rest of the wirecut range with topping, paper cutting and paper slitting modules being added to suit the special requirements of frozen dough manufacturers.

**Product Range**

The TruClean™ Frozen Dough Machine produces a full range of cookie sizes from mini to large and can incorporate large inclusions for gourmet varieties.

**Toppings**

Extra value can be added to the cookies with topping devices. Recovery systems ensure that excess topping is recovered, even on paper-fed machines.

**Output**

Available in widths from 16” to 48” and with outputs from 500 to 10,000lbs/hr, there is a TruClean™ Frozen Dough Machine to suit every size of manufacturing operation.

**Discharge Options**

Cookie dough pieces can be deposited onto paper or directly onto a band for bulk packing. Paper-fed systems use continuous rolls of paper and include a guillotine and, where necessary, a slitter for sizing the sheets.

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**Dualtex Extruder**

The Dualtex combines high efficiency, high output filled bar production with the utmost versatility and productivity to achieve a remarkably low cost of ownership and rapid payback.

**Easy to Clean**

Intelligent design features give a typical 15 minute cleandown time.

**Quick Changeover**

Clamshell head allows fast removal of die and filler block; retractable nozzles reduce scrap and downtime.

**Precise Weight Control**

Die and filler block technology ensures consistent product quality, with minimum giveaway and waste.

**Versatility**

Produces a wide range of filled breakfast, cereal and health bars with a variety of jackets and fillings. Also two-dough cookies and single-stream bars.
The Baker Perkins 390 Rotary Moulder range includes standard and TruClean™ versions that meet all the latest industry requirements for sanitation while still offering best-in-class performance. Cross-contact risks are minimised and cleaning is simplified while all the process and operational benefits of previous generation equipment are retained.

### Hygienic Design

By following relevant industry guidelines on sanitation, including the GMA’s 10 Principles of Equipment Design, hygiene and ease of cleaning of the standard and TruClean™ versions of this moulder have been raised to new levels.

### Rapid Payback

Exceptional reliability and fast changeovers combined with low cleaning and maintenance overheads keep operating and other costs to a minimum.

### Easy to Operate

A single drive and push button control means operation is simple, with minimum adjustments. Die roll changes can be accomplished quickly and without the use of tools.

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**Series2 Rotary Moulder**

The Series2 is a high output rotary moulder suitable for every type of soft dough moulded cookie, from thick bars to delicate bite-size pieces. A full range of drives and adjustments enable product quality and weight control to be maintained at even the highest speeds.

### High Output

Three independent roll drives plus adjustability of all the process parameters enable the machine to be set up to extract cleanly at belt speeds up to 40m/min (130ft/min).

### Quick Changeover

Easy removal and replacement of the die roll, excellent access for cleaning and automatic set up allow changeovers in the shortest possible time.

### Easy to Use

Clear and intuitive PLC controls with touch screen HMI or SCADA operator interfaces, compliment handwheel control of the main weight control and extraction adjustments. All major process variables can be controlled to maximise quality and productivity.
The TruClean™ 590 Rotary Moulder is primarily used for moulding large, difficult products, such as energy bars and pet food. The machine is stronger and more powerful than a standard moulder to cope with the extra work required to form these products and is designed to meet the latest industry guidelines on hygiene.

**Heavy Duty Design**

Heavy-duty construction and components are necessary to handle difficult products at high speed. For this reason the die and feed rolls are large diameter and the knife assembly robust and fully adjustable.

**Hygienic Standard**

Good access, few and readily removed guards, and rapid dismantling for cleaning without tools results in minimum accumulation of debris, as well as easy and effective cleaning.

**Low Cost of Ownership**

High efficiency and precise weight control minimise waste and giveaway. Ease of cleaning, ease of use and fast changeover reduce downtime and labour, while reliability and easy maintenance keep running costs down.

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The Laboratory Rotary Moulder brings a completely reproducible rotary moulding process into product and process development environments. Although narrow, the roll and die diameters and geometry of the machine exactly match that of full size Baker Perkins moulders so results can be accurately and reliably scaled up for full production.

**Process Accuracy**

The machine replicates exactly the arrangement of rolls, scraper and extraction web used on other Baker Perkins rotary moulders. It removes all uncertainty and inaccuracy associated with small-scale machines.

**Flexibility**

New product development, ingredient testing and process troubleshooting are all accomplished with the minimum of time, effort and money.

**Low Cost Multiple Trials**

Multiple trials can be carried out quickly and at low cost. A single ring of impressions can be engraved on the die roll and additional rings added later for subsequent trials.
Range Chart

<table>
<thead>
<tr>
<th>MACHINE</th>
<th>PRODUCTS</th>
<th>SPEED</th>
<th>WIDTHS</th>
</tr>
</thead>
<tbody>
<tr>
<td>TruClean™ Wirecut</td>
<td>Cookies, bars, filled bars</td>
<td>200 cuts/min</td>
<td>812mm - 1,525mm</td>
</tr>
<tr>
<td>TruClean™ Angled Overhead Wirecut</td>
<td>Cookies</td>
<td>200 cuts/min</td>
<td>1,016mm - 1,220mm</td>
</tr>
<tr>
<td>TruClean™ Frozen Dough Machine</td>
<td>Cookies</td>
<td>200 cuts/min</td>
<td>400mm - 1,220mm</td>
</tr>
<tr>
<td>Dualtex Extruder</td>
<td>Filled bars and cookies</td>
<td>3,810kg/hr</td>
<td>1,016mm - 1,525mm</td>
</tr>
<tr>
<td>390 &amp; TruClean™ 390 Rotary Moulder</td>
<td>Biscuits, sandwich cookies</td>
<td>16.8m per min</td>
<td>990mm - 1,220mm</td>
</tr>
<tr>
<td>Series2 Rotary Moulder</td>
<td>Biscuits, sandwich cookies</td>
<td>40m per min</td>
<td>812mm - 1,600mm</td>
</tr>
<tr>
<td>TruClean™ 590 Rotary Moulder</td>
<td>Pet food, energy bars</td>
<td>7.6m per min</td>
<td>990mm - 1,651mm</td>
</tr>
<tr>
<td>Laboratory Scale Rotary Moulder</td>
<td>Cookies</td>
<td>Hand driven</td>
<td>203mm or 305mm</td>
</tr>
</tbody>
</table>

Die Roll and Wirecut Die Services

As a long-established world leader in cookie and cracker equipment design and manufacture, Baker Perkins has developed a unique understanding of the interface between the machine, its die and the product.

At Baker Perkins we understand that rolls and dies are not simple commodity components - they are critical parts of the forming process that have a fundamental effect on plant performance and product quality.

Rolls and dies that run cleanly and reliably make a significant contribution to line efficiency. Successful rolls and dies start with a good design based on a clear understanding of the customer’s requirements, while manufacturing using the latest design software and machine tools keeps quality high and lead times down.

Why choose Baker Perkins?

- Process insight from OEM
- Library of thousands of designs
- Custom design service
- Full range of roll and die types
- Available to suit all makes of forming machine
- Fast and accurate 3D CAD design and engraving
- Hand samples and test sleeves for pre-production review or testing
- Fully equipped test lab
- Help and advice over the phone or on site
- Fast track manufacture
- Repair, recoating and reconfiguration of worn, damaged or obsolete dies

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