

KAISER ROLLS

BPC# 113543000



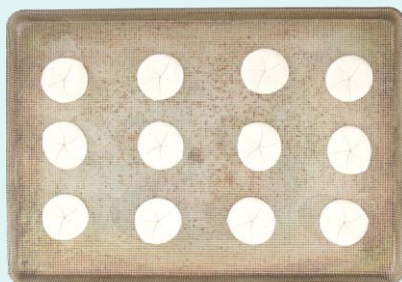
General Mills Retail
FOODSERVICE
Bakery | Deli | Produce | Wholesale

STEP-BY-STEP BAKING GUIDE

PRE-SHAPED AND PRE-STAMPED

01 Prepare

- Place 12 frozen rolls (3x4) star side up on a screen pan prepared with nonstick pan spray.



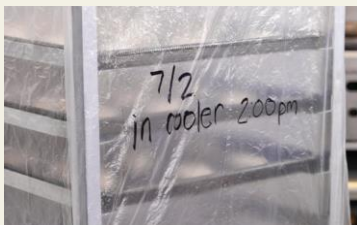
02 Mist

- Mist frozen dough with water.
- Place on a 10-12 shelf baking rack.



03 Cover

- Cover rack with a labeled rack cover. Include:
 - Date/Time in cooler
 - Min 16 hr
 - Time Pulled
- Place covered rack in cooler for 16-24 hrs.



04 Proof

- Remove rack from cooler.
- Mist dough with water.
- Cover rack and allow to floor proof 30 – 60 minutes. Keep rack covered until ready to score and bake.
- After 30 minutes, test with proof tool.
- If dough does not touch the top of proof tool, continue to floor proof.
- When dough touches top of proof tool, the hoagies are ready to bake.



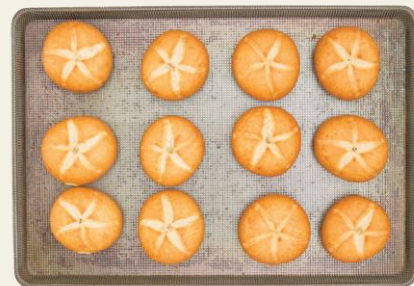
05 Mist

- Before placing in oven to bake, mist the dough with a light mist of water.



06 Bake

- Place rack in oven, bake at 350F with 20 sec steam for 15-17 minutes or until golden brown.



07 Package

- Once product is cool (45mins-60mins), package as a sell unit.
- Label product with printed labels.

Adhere to store-specific packaging and labeling requirements.



product expectation



CHANGING THE PROCESS CAN RESULT IN POOR QUALITY PRODUCT AND DISSATISFIED CUSTOMERS.

KAISER ROLLS

TROUBLESHOOTING PRODUCT



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Underbaked



Just Right



Overbaked



Under proofed



Proofed



Over proofed

Problem	Possible Causes	Solutions
<ul style="list-style-type: none"> • Small rolls that may not fit properly in bag. • Rolls are likely to have voids, blowouts, or side splitting. • Pale color. 	<ul style="list-style-type: none"> • Under proofed dough with not enough floor time. • Not following proper misting procedure. 	<ul style="list-style-type: none"> • Allow product to proof covered on floor until it reaches proper size. • Product should completely fill proof tool cavity before baking. • Follow the build sheet for recommended floor time. • Mist at least 3 times before putting into the oven.
<ul style="list-style-type: none"> • Large roll size that may not fit properly in bag. • Rolls are likely to be flat in shape or sag in the middle. • Scores on rolls may not open. 	<ul style="list-style-type: none"> • Over proofed dough with too much floor time. • Product is under baked. • Pans are clogged with carbon buildup not allowing the heat to flow through the pan. • Not using proper pan. • Not using proper baking rack. • Too much steam in the oven. 	<ul style="list-style-type: none"> • Allow product to proof covered on floor until it reaches proper size. • Product should completely fill proof tool cavity before baking. • Follow the build sheet for recommended floor time. • Clean pans on a regular basis to prevent carbon buildup. • Use proper screen pan. • Use proper 12 slot baking rack.
<ul style="list-style-type: none"> • Areas of the bread where physical defects such as holes and tearing occur. 	<ul style="list-style-type: none"> • Blowouts, voids, or side splitting. • Under proofed dough with not enough floor time. • Incorrect scoring or use of a non-approved scoring knife (not applicable for Kaiser Rolls as roll is stamped and does not require scoring). • Lack of steam or no steam at all in the oven. • Not following proper misting technique. 	<ul style="list-style-type: none"> • Allow product to proof covered on floor until it reaches the proper size. • Product should completely fill proof tool cavity before baking. • Follow the build sheet for recommend floor time. • Only use approved scoring tool. • Check to ensure steam is working properly. • Mist at least 3 times before putting into the oven.
<ul style="list-style-type: none"> • Incorrect Color. 	<ul style="list-style-type: none"> • Too light – not enough time in the oven or oven temperature is inaccurate. • Too dark – too much time in the oven or oven temperature is inaccurate. • Incorrect handling of product prior to baking. 	<ul style="list-style-type: none"> • Follow directions on build sheet for proper product handling. • Have oven technician check and recalibrate oven.