

# DINNER ROLLS

BPC# 113542000



North America Retail  
**FOODSERVICE**  
Bakery | Deli | Produce | Wholesale

## STEP-BY-STEP BAKING GUIDE

### 01 Prepare

- Place 24 frozen rolls (6x4) 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
- Allow to floor proof 30-60 minutes
- 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 rolls 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 13-15 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 Requirements for Packaging and Labelling.



## PRODUCT EXPECTATION



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

# DINNER ROLLS

## TROUBLESHOOTING PRODUCT



**Underbaked**



**Just Right**



**Overbaked**

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