

# Soft dough forming machines

Reliability, versatility, ease of use and low cost of ownership characterise Baker Perkins' rotary moulders, wirecuts and bar extruders. The rotary moulder and wirecut ranges cover low, medium and high output alternatives and the family is completed by the Dualtex extruder for high output, high accuracy production of filled bars and cookies.

The range is diverse, but a common theme connects every design – reliable, easy to clean, maintain and operate units that deliver high quality, products with low production costs.

## Reliable

Meticulous attention to detail in the design of all our forming machines ensures trouble-free operation. Care is taken to avoid dough build up and leakage that can cause unplanned stoppages and waste, while all components are chosen to provide many years of trouble free operation.

## Easy to operate

Whether a 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, while SCADA systems may be connected to factory networks to enable remote performance monitoring.

## Easy to maintain

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

## Easy to clean

All machines are designed to enable the quick and thorough cleaning that is essential for rapid changeover. Product parts are quickly removed for cleaning off the machine, leaving all other critical areas readily accessible.



# HS World wirecut

Profit enhancing weight control is achieved through unique die and filler block technology. Intelligent design features optimise ease of cleaning, even to allergen standards; higher utilisation levels with less giveaway ensure low cost of ownership.

## Precise weight control

Top quality product with minimal giveaway and waste: +/-1% piece weight variance on plain dough, +/-2% on dough with inclusions.

## Easy to operate and clean

Choice of controls to suit your operation, from simple pushbuttons to PLC or SCADA with full recipe control. Intelligent design features give a typical cleandown time of 15 minutes.

## Minimum downtime

Patented clamshell head allows fast removal of die and filler block during changeover. Key adjustments can be made on the run to maximise uptime.

## Versatility

The full range of cookie doughs and inclusions can be handled.

|                   |   |
|-------------------|---|
| <b>Products</b>   | Cookies, folded cookies, bars, filled bars                                    |
| <b>Speed</b>      | Up to 300 cuts per minute   |
| <b>Widths</b>     | 1016 – 1525mm   |
| <b>Choose for</b> | Highest output; highest accuracy; widest product range; greatest productivity |



|                   |  |
|-------------------|--|
| <b>Products</b>   | Cookies  |
| <b>Speed</b>      | Up to 200 cuts per minute  |
| <b>Widths</b>     | 812 – 1220mm   |
| <b>Choose for</b> | Medium output; highest accuracy; standard product range; fast delivery |

# SM World wirecut

Designed for low to medium outputs, but with the same level of accuracy as the HS World wirecut. This is a competitive package, with a short delivery time, and rapid payback.

## Precise weight control

Minimal giveaway and waste contribute to fast payback: typically +/-1% piece weight variance on plain dough, +/-2% on dough with inclusions.

## Easy to operate and clean

Simple, intuitive and low maintenance controls. Rapid cleaning to allergen standards.

## Minimum downtime

Patented clamshell head allows rapid cleaning and replacement of product parts during changeover. Reproducible settings and consistent process stability promote fast start up.

## Versatility

A wide variety of different inclusion types and sizes, such as chocolate chunks, raisins and nut pieces.



# Werner wirecut

Designed for specialist and lower volume manufacturers, the Werner wirecut provides greater reliability, lower running costs and a better rate of return than basic, used or rebuilt equipment. By comparison, the Werner wirecut offers easier operation, easier cleaning and less maintenance, plus a 12-month warranty.

## Precise weight control

The latest die technology addresses weight control problems that adversely affect the profitability of existing machines – even after rebuilding.

## Low running costs

Uncomplicated design uses modern components and materials to keep operating, cleaning and maintenance costs to a minimum.

## Minimum downtime

Fast changeovers with no need for tools offer maximum productivity and flexibility.

## Short lead times

A build-for-stock programme means that we can be ready to ship in as little as two weeks.

|                   |   |
|-------------------|---|
| <b>Products</b>   | Cookies   |
| <b>Speed</b>      | Up to 140 cuts per minute   |
| <b>Widths</b>     | 812 – 1220mm  |
| <b>Choose for</b> | Low outputs; high accuracy; standard product range; fast delivery |



# EM390 rotary moulder

The EM390 is a simple, reliable and durable rotary moulder. Precise weight control, fast changeovers and easy cleaning keep running costs low and minimal maintenance requirements ensure the lowest total cost of ownership. A wide range of optional features allow the EM390 to be tailored to suit more demanding applications.

## Low cost of ownership

Fast cleaning and easy maintenance reduce labour costs to a minimum; on-the-run knife adjustment improves weight control. Fast changeovers and unbeatable reliability keep downtime to a minimum.

## Easy to use

Rapid and error-free changeover with easy moulding roll change. Fast start-ups reduce downtime and waste. Optional PLC control system with recipe function.

## Easy to clean

Intelligent design features allow easy access and fast cleaning; optional washdown facility.

|                   |  |
|-------------------|--|
| <b>Products</b>   | Biscuits and sandwich cookies  |
| <b>Speed</b>      | Up to 17m/min  |
| <b>Widths</b>     | 812-1525mm   |
| <b>Choose for</b> | Flexible specification; portability; standard product range; fast delivery |

## Flexible specification

Quickly upgraded for more challenging production environments, different end products enhanced performance or ease of use.



## Series2 rotary moulder

The Series2 is a high output rotary moulder with a full range of adjustments. These allow product quality and weight control to be maintained at the highest possible speeds.

### Quick changeover

Easy removal and replacement of the moulding roll, plus excellent access for cleaning and automatic set up, cut changeover time to a minimum.

### Easy to Use

Clear and intuitive PLC controls with touch screen HMI or SCADA operator interfaces. All major process variables can be controlled to optimise quality and productivity.

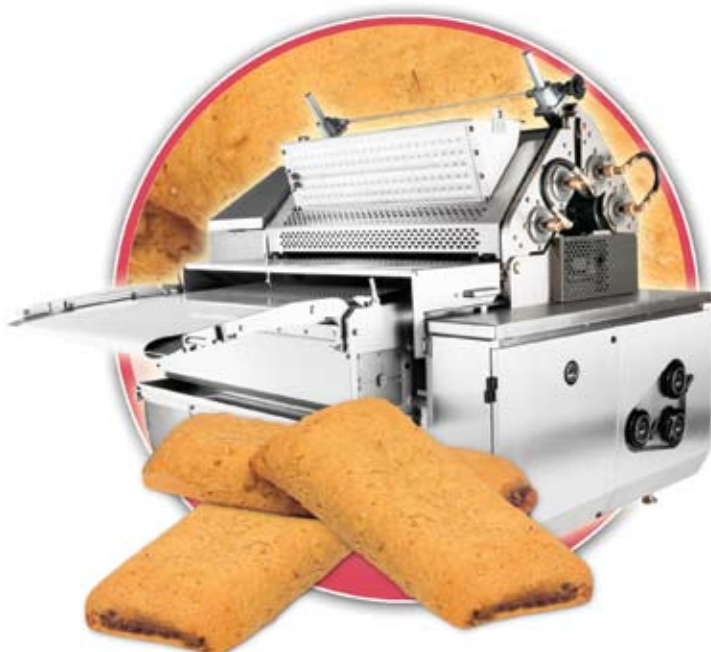
### High quality product

Independent roll drives mean that relative speeds are variable to achieve optimum product characteristics such as thickness and dough texture.

|                   |   |
|-------------------|---|
| <b>Products</b>   | Biscuits and sandwich cookies   |
| <b>Speed</b>      | Up to 40m/min   |
| <b>Widths</b>     | 812 – 1525mm  |
| <b>Choose for</b> | Highest speed, maximum width, maximum adjustability, difficult products |



|                   |  |
|-------------------|--|
| <b>Products</b>   | Filled bars and cookies                                    |
| <b>Speed</b>      | 3,800kg/hour   |
| <b>Widths</b>     | 1016 – 1525mm  |
| <b>Choose for</b> | Choose for high output, versatility, piece weight accuracy |



## 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 less 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 moulding roll experts

**Baker Perkins is the only equipment manufacturer with an in-house roll design and manufacturing capability. This brings to the design process a unique understanding of how dough and forming machine characteristics affect the performance of each roll. We know how to produce rolls that retain their dimensional accuracy under even the most arduous production conditions and deliver absolute consistency over the life of the roll.**

Rolls are a critical part of the forming process and by combining imaginative design with true process insight and manufacturing expertise we are able to supply rolls that are right first time, run cleanly and reliably – and make a significant contribution to line efficiency and profit.

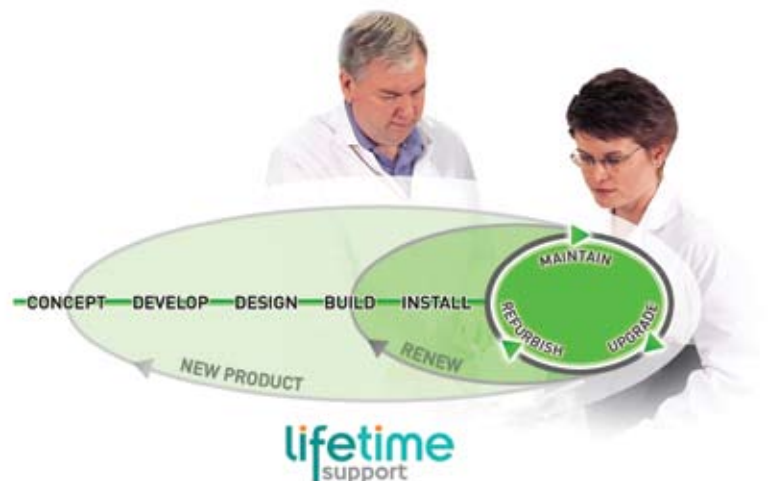
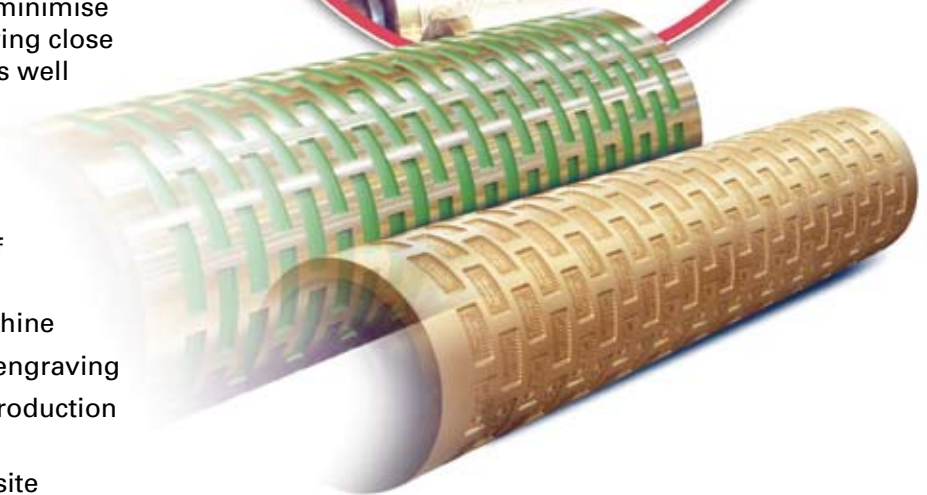
Moulding rolls consist of a one-piece lead-free bronze tube, with a steel through-shaft to minimise deflection. Good release is ensured by paying close attention to draft angles and corner radii as well as the choice of either a plain or coated surface finish.

## Why choose Baker Perkins?

- Custom design service plus a library of thousands of standard designs
- Rolls to suit every kind of forming machine
- Fast and accurate 3D CAD design and engraving
- Test sleeves and flat samples for pre-production review and testing
- Help and advice over the phone or on site
- Best in class weight control

## Lifetime Support

Old machinery can reduce productivity and increase costs through poor weight control, slow changeovers, decreased uptime and extended cleaning: the overall effect is a severe hit on the bottom line. All of these can be addressed by purchasing a new machine, but when this is not possible, Baker Perkins offers upgrades and rebuilds for existing equipment, bringing many of the benefits of a new machine at a fraction of the cost.



## Range chart

| Machine                       | Products                                   | Speed        | Features                                       | Widths      |
|-------------------------------|--|--------------|--|-------------|
| <b>HS World Wirecut</b>       | Cookies, folded cookies, Bars, filled bars | 300 cuts/min | High output, wide product range                | 1016-1525mm |
| <b>SM World Wirecut</b>       | Cookies                                    | 200 cuts/min | Medium output, standard product range          | 812-1220mm  |
| <b>Werner Wirecut</b>         | Cookies                                    | 140 cuts/min | Low output, standard product range             | 812-1220mm  |
| <b>EM390 Rotary Moulder</b>   | Biscuits, sandwich, cookies                | 17m/min      | Flexible specification, standard product range | 812-1525mm  |
| <b>Series2 Rotary Moulder</b> | Biscuits, sandwich, cookies                | 40m/min      | High speed, maximum output, difficult products | 812-1600mm  |
| <b>Dualtex Extruder</b>       | Filled bars and cookies                    | 3800 kg/hour | High output, versatility filled bars           | 1016-1525mm |

## Innovation centre

Test facilities are available in the Baker Perkins Innovation Centre, equipped with a range of pilot scale mixing, forming and baking equipment for new product and process development trials. They are used by many customers for confidential experiments with new product and process concepts.



**Baker Perkins Ltd**  
Manor Drive  
Paston Parkway  
Peterborough  
PE4 7AP  
United Kingdom

**Baker Perkins Inc**  
3223 Kraft Ave SE  
Grand Rapids  
MI 49512-2027  
USA

T: +44 1733 283000  
F: +44 1733 283004

T: +1 616 784 3111  
F: +1 616 784 0973

E: [bp ltd@bakerperkinsgroup.com](mailto:bp ltd@bakerperkinsgroup.com) E: [bp inc@bakerperkinsgroup.com](mailto:bp inc@bakerperkinsgroup.com)

I: [www.bakerperkinsgroup.com/biscuit](http://www.bakerperkinsgroup.com/biscuit)