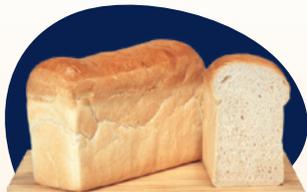




BAKERY INGREDIENTS SINCE 1904

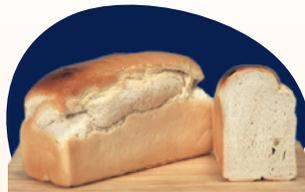
# Bread Faults

## THE PERFECT LOAF



### Too much volume

CAUSES	CORRECTION
Over proofed	Check proofing height
Too much yeast	Check correct yeast level
Over scaling	Scale according to recipe
Incorrect premix level	Check correct premix percentage
Incorrect flour used	Check if bread flour was used
Too much improver	Reduce improver percentage



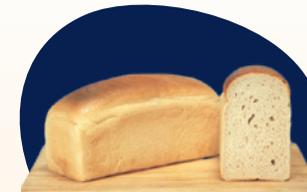
### Flying Top

CAUSES	CORRECTION
Under proofed	Proof the correct height
Cold dough	Increase water temperature
Too much yeast	Check correct yeast level
Flour too strong	Check flour quality
Over mixed	Mix shorter time
Too much premix	Check premix level
Too much improver	Decrease improver level



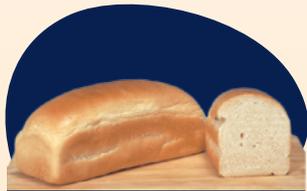
### Too dark crust colour

CAUSES	CORRECTION
Oven temperature too high	Set correct baking temperature
Too much premix	Check correct premix level
Flour with high enzyme activity	Check flour quality
Too much sugar	Add less sugar
Too much salt	Check correct salt level (1.48% of flour weight)



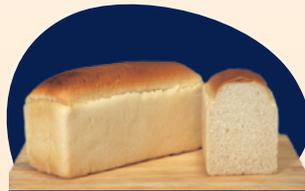
### Uneven crumb texture

CAUSES	CORRECTION
Too soft dough	Check dough consistency
Dough too cold	Increase water temperature
No resting time	Give short resting time
Bad moulding	Mould correctly
Too little fat or improver	Add more fat or improver
Too little premix	Check premix level



### Too low volume

CAUSES	CORRECTION
Under mixed	Mix the correct time
Under proofed	Proof the correct height
Weak flour	Check flour quality
Too little yeast	Add more yeast
Incorrect premix level	Add correct premix level
Too little improver	Add more improver



### Blisters on crust

CAUSES	CORRECTION
Under fermented dough	Rest dough on table
Over proofed	Proof the correct height
Excessive steam in proofer	Reduce steam in proofer
Over mixed	Mix according to recipe
Under mixed	Mix according to recipe
Too little improver	Add more improver
Too little premix	Check premix level
Too little salt	Add correct salt level (1.48% of flour weight)



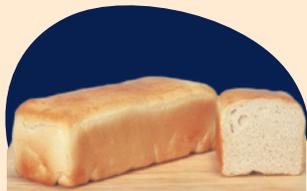
### Pale crust colour

CAUSES	CORRECTION
Too low baking temperature	Increase baking temperature
Too warm dough	Add colder water
Dough over fermented	Work dough off faster
Too little salt	Add correct salt level
Too little premix	Check correct premix level



### Lack of oven spring

CAUSES	CORRECTION
Dough over fermented	Rest dough shorter
Over proofed	Check proofing height
Excessive oven steam	Reduce steaming time
Weak flour	Check flour quality
Too low premix level	Increase premix level
Too low improver level	Increase improver level
Too low fungal amylase level	Increase fungal amylase level



### Collapsed bread

CAUSES	CORRECTION
Incorrect recipe	Check recipe formulation
Under mixed	Increase mixing time
Over proofed	Check proofing height
Weak flour	Check flour quality
Too little yeast	Add more yeast
Incorrect premix level	Add correct premix level
Too little improver	Add more improver



### Sides collapsing

CAUSES	CORRECTION
Too much premix	Add correct premix level
Too much improver	Reduce improver dosage
Too high fungal amylase level	Reduce fungal amylase dosage
Bread left too long in pans	Remove bread from pan
Too much yeast	Reduce yeast level
Too much Malt flour	Reduce Malt flour dosage
Flour with high enzyme activity	Check flour quality



### Badly shaped loaf

CAUSES	CORRECTION
Careless moulding	Mould correctly
Seam not on the bottom	Place seam at the bottom
Incorrectly placed into pan	Place dough evenly in pan
Too stiff dough	Increase water level
Bad rounding and/or end moulding technique	Set round moulder and end moulder correctly



### Hole in crumb centre

CAUSES	CORRECTION
By moulding pan oil folded into dough	Avoid excessive pan oil by moulding
Moulding pressure too high or low	Set round and oblong moulder correctly
Strong flour	Check flour quality
Dough skinning during moulding	Cover dough on table with plastic



### Close crumb texture

CAUSES	CORRECTION
Too stiff dough	Add more water
Too little proofed	Increase proofing time
Too much premix	Check correct premix level
Too much improver	Decrease improver level
Too warm dough	Add colder water



### Mould and rope

CAUSES	CORRECTION
No anti-rope agent used	Check if premix or improver contains anti-rope agent
Under baked	Bake longer
Unhygienic bakery condition	Clean bakery daily
Old dough or bread added	Reduce old dough or Rework bread
Bread not cooled down	Cool bread down rapidly after baking
Too low improver level	Increase improver level
Bread stored in hot and damp conditions	Store bread at 19-20°C in a dry place