

# Roll Faults

## THE PERFECT ROLL



*Collapsed roll*

CAUSES	CORRECTION
Prover too hot	Reduce the prover heat to 40°C
Oven too cold	Increase/check the oven temperature
Not enough premix	Check recipe
Proofing time too long	Should only be ±50 minutes



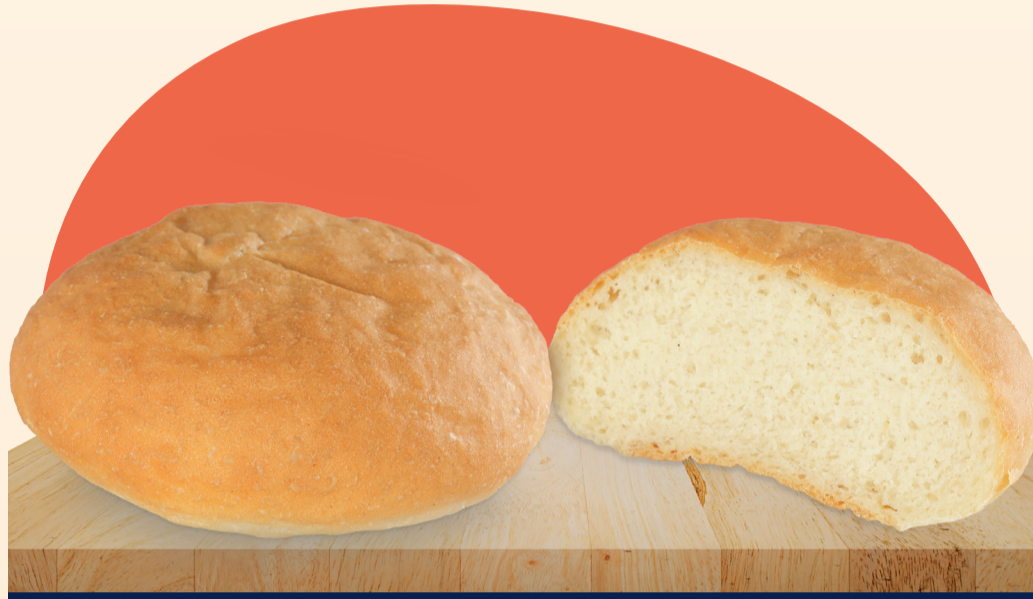
*Uneven crumb texture*

CAUSES	CORRECTION
Dough temperature too high	Ensure final dough temperature is 29°C
Not enough yeast	Increase yeast to 4 or 5% of flour weight
Dough too stiff	Check the amount of water in the recipe
Dough over mixed	Reduce mixing time



*Uneven rolling*

CAUSES	CORRECTION
Dough too stiff	Check recipe
Lack of resting before final moulding	Cover and rest dough for 10 minutes before final moulding
Too much dusting flour	Apply dusting flour sparingly
Dough skinning before final moulding	Cover with a dough sheet
Incorrect seam placement	Place the roll on the tray, seam down



*Close crumb texture*

CAUSES	CORRECTION
Too little yeast	Increase yeast to 4 or 5% of flour weight
Dough too cold after mixing	Ensure final dough temperature is 29°C
Not enough premix	Increase amount according to premix recommended recipe
Too much salt	Check recipe and correct the amount
Dough undermixed	Increase mixing time to ensure the gluten is properly developed



*Dull crust colour*

CAUSES	CORRECTION
Dough skinning	Check humidity level in the prover
Too little premix	Check recipe
Inconsistent oven heat distribution	Check oven vents
No steam in the oven	Check solenoid valve/water supply



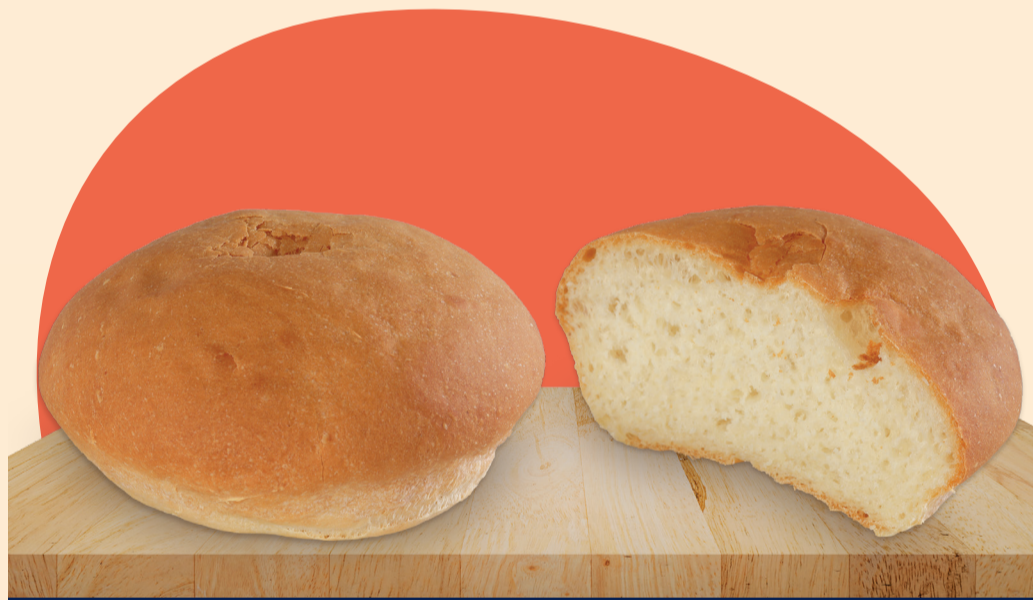
*Badly shaped crust*

CAUSES	CORRECTION
Prover too hot	Reduce the prover heat to 40°C
Poor moulding techniques	Ensure correct moulder settings
Intermediate proof too long	Cover and rest dough for 10 minutes before final moulding
Prover humidity too high	Check humidity level in the prover, it should be ±85% Rh



*Lack of oven spring*

CAUSES	CORRECTION
Too much water in the dough	Check the amount of water in the recipe
Not enough yeast	Increase yeast to 4 or 5% of flour weight
Too much oven steam	Reduce the time for steam injection
Dough left too long on the table	The Intermediate proof should only be 10 minutes before final moulding



*Blisters on crust*

CAUSES	CORRECTION
Prover too hot	Reduce the prover heat to 40°C
Poor moulding techniques	Ensure correct moulder settings
Intermediate proof too long	Cover and rest dough for 10 minutes before final moulding
Prover humidity too high	Check humidity level in the prover, it should be ±85% Rh



*Dark thick crust*

CAUSES	CORRECTION
Oven too cold	Check/increase oven temperature
Too much sugar in recipe	Reduce/check recipe
Baking time too long	Reduce baking time/increase oven temperature



*Crust cracking at the base*

CAUSES	CORRECTION
Dough too stiff	Check the amount of water in the recipe
Incorrect retarding	Check retarding process
Dough skinning	Cover dough on the table
Proofing time too short	Should be ±50 minutes



*Holes under the crust*

CAUSES	CORRECTION
Excessive top oven heat	Reduce deck oven top heat
Prover too dry	Check humidity level in the prover, should be ±85% Rh
No intermediate proof	Cover and rest dough for 10 minutes before final moulding
Dough temperature too high	Use colder water



*Wrinkled crust*

CAUSES	CORRECTION
Oven temperature too low	Check/increase oven temperature
Baking time too short	Checking baking time and recipe recommendations