



1. Purpose

This manual applies to the production of bakery products, namely:

- which undergo a process of incomplete baking before freezing and in the subsequent after defrosting require baking finishing;
- which undergo a complete baking process before freezing and no further need for baking.

2. Scope

This manual (recommendation) is applicable through trading networks (or other clients) that are able to buy the products of Ono Bread LLC.

3. Responsibility

This manual is a reference material and does not assume any responsibility for the process of defrosting and / or baking finishing done in the trade network, as each trade network has its own individual equipment with different technical capabilities.

4. Description of the process

4.1. Defrosting of semi-finished products

Frozen semi-finished products are removed from the freezer, laid out with the required distance on sheets, which are covered with silicone pads or baking parchment, moistened with clean drinking water, placed on a special shelf in the production room and thawed at room temperature.

French Baguette defrosting is possible in two ways:

- in a closed packing in a freezer at (32 - 42) ° F during 12 hours;
- in an open room, in the absence of draft or in a proving chamber at the room temperature and relative humidity (70 - 80)% during 20-40 minutes.

The recommended defrosting conditions for each name of semi-finished products mentioned in Appendixes # 1, # 2.

4.2. Defrosting of ready-to-eat products

The frozen products are removed from the freezer, laid out with the required distance on sheets, placed in a production room and thawed at room temperature.

The recommended defrost conditions for each product name mentioned in Appendixes # 3, # 4.

The duration of defrosting may vary depending on the type of semi-finished product or finished product and the temperature of the production space.

4.3. Baking of semi-finished products

1. Metal or aluminum sheets are covered with parchment or silicone pads.

Silicone pads on which products are baked are not washed with water but wiped with a cloth, crumbs the table shall be done by soft brush. Depending on usage, parchment for baking shall be replaced with a new one.

2. In case of absence of moisture in the oven, the surface of the semi-finished products shall be well moistened with sufficient quantity of drinking water before baking.

3. The oven should be preheated to 430-440 °F.

Baking conditions for each product name mentioned in Appendixes # 1, # 2, # 3.

Wheat products: **Baguettes, Pave, Ciabatta** etc. shall bake until golden brown crust appears.

All baking processes shall be done with mandatory steam supply or with manual moistening with drinking water (subject to no steam in the oven). Damper (if it is made in the oven) shall be opened 1-2 minutes before the end of baking.

The parameters according to the product name mentioned in Appendixes №1, №2, №3 .

Baking of products shall be done by necessity.

It is obligatory to pay attention to the color of the product at the end of the baking process.

Temperature regime and baking time subject to the type of semi-finished /ready-to-eat products, the design features of the equipment and its operating conditions.



4.3. Storage

Shelf life for freshly baked products (list of product mentioned in Appendix # 1) keeping in the retail network at the temperature from 42 to 82 °F shall be:

- for non packed products - no more than 24 hours;
- for packed products - no more than 72 hours.

Shelf life of freshly baked products (list of products mentioned in Appendix No. 2,4) keeping in the retail trade network at the temperature not lower than 42°F and relative humidity not exceeding 75%:

- for non packed products with weight up to 0,7 lb inclusive - not more than 16 hours ;
- for packed products with weight up to 0,7 lb inclusive - not more than 32 hours;
- for non packed products with weight more than 0,7 lb - more than 24 hours;
- for packed products with weight more than 0,7 lb - no more than 48 hours.

Shelf life of freshly baked bread (list of products mentioned in Appendix # 3) keeping in the retail network at the temperature not lower than 39°F and relative humidity not exceeding 75%:

- for not packed no more - 36 hours;
- for packed no more than 72 hours.

WARNING!

FREEZING AFTER DEFROSTING IS NOT ALLOWED!!!

WARM PRODUCT PACKED IN A STRETCH FILM IS NOT ALLOWED!!!

**Appendix №1**

Product name	Defrosting time, minutes	Defrosting temperature, °F	Starting baking temperature, °F	Main Baking temperature, °F	Steam supply	Baking time, minutes
Wheat Bun 40 g	15-30	65-77	410	390	average	5-10
Malt Bun 40 g	15-30	65-77	410	390	average	5-10
Bun with cheese 40 g	15-30	65-77	410	390	average	5-10
Bun «Fitness» 40g	15-30	65-77	410	390	average	5-10
Light whole grain Bun 40g	15-30	65-77	410	390	average	5-10
Buckwheat Bun 40g	15-30	65-77	410	390	average	5-10
Dark Multigrain Bun 40g	15-30	65-77	410	390	average	5-10
Bun with tomato 40r	15-30	65-77	410	390	average	5-10
Ciabatta 60 g	15-30	65-77	410	390	average	5-10
Dark Ciabatta 60 g	15-30	65-77	410	390	average	5-10
Mini Pave «Fitness» 60 g	15-30	65-77	410	390	average	5-10
Panini 80 g	15-30	65-77	410	390	average	5-10
Pave with sesame seeds 80 g	15-30	65-77	410	390	average	5-10
Ciabatta 90 g	15-30	65-77	410	390	average	5-10
Dark Ciabatta 90 g	15-30	65-77	410	390	average	5-10
Baguette «Ciabatta» 125 g	20-40	65-77	410	390	average	8-12
Baguette «Fitness» 125 g	20-40	65-77	410	390	average	8-12
Ciabattini 140 g	20-40	65-77	410	390	average	8-12
Dark Ciabattini 140g	20-40	65-77	410	390	average	8-12
Ciabatta 160 g	20-40	65-77	410	390	average	8-12
Dark Ciabatta 160 g	20-40	65-77	410	390	average	8-12
Pave Multigrain 160 g	20-40	65-77	410	390	average	8-12
Pave with cheese 180 g	20-40	65-77	410	390	average	8-12
Ciabatta with tomatoes 180 g	20-40	65-77	410	390	average	8-12
Buckwheat Ciabatta 180 g	20-40	65-77	410	390	average	8-12
Ciabatta with cheese 180 g	20-40	65-77	410	390	average	8-12
Ciabatta 200 g	30-60	65-77	410	390	average	10-15
Dark Ciabatta 200 g	30-60	65-77	410	390	average	10-15
Buckwheat Baguette 250 g	30-60	65-77	410	390	average	10-15
Baguette «Ciabatta » 250 g	30-60	65-77	410	390		10-15
Baguette «Fitness» 250 g	30-60	65-77	410	390	average	10-15
Light whole grain Baguette 250 g	30-60	65-77	410	390	average	10-15
Dark Multigrain Baguette 250 g	30-60	65-77	410	390	average	10-15
Pumpkin Pave 250 g	30-60	65-77	410	390	average	10-15
Pave «Fitness» 300 g	30-60	65-77	410	390	average	10-15
Light whole grain Pave 300 g	30-60	65-77	410	390	average	10-15
Dark Multigrain Pave 300 g	30-60	65-77	410	390	average	10-15
Wheat Pave 300 g	30-60	65-77	410	390	average	10-15
Pave with tomatoes 300 g	30-60	65-77	410	390	average	10-15
Bread "Compagne" 400 g	30-60	65-77	410	390	average	10-15

**Appendix №2**

Product name	Defrosting time, minutes	Defrosting temperature, °F	Starting baking temperature, °F	Main Baking temperature, °F	Steam supply	Baking time, minutes
Baguette «French» 125 g	12 hours.* 20-40 min**	From 32 till 42* ambient**	410	390	average	8-12
Baguette «French» 250 g			410	390	average	10-15

Notes: *

- in a closed packing in a freezer
- in an open room, in the absence of draft or in a proving chamber

Appendix №3

Product name	Defrosting time, minutes	Defrosting temperature, °F	Humidity, %	Optional			
				Starting baking temperature, °F	Main Baking temperature, °F	Steam supply	Baking time, minutes
‘Borodinskiy ‘bread 400 g	Min. 4	ambient	70-80	280-350	280-350	Average or in required volume	Min.14
Rye grain bread 400g							
Rye bread ‘Chanta’ 400g							
Custard honey bread 400 g							

Appendix №4

Product name	Defrosting time, minutes	Defrosting time, °F	Starting baking temperature, °F	Main Baking temperature, °F	Steam supply	Baking time, minutes
Hot Dog Baguette (French Hot Dog) 60 g	4-6	42±2*	baking is not required products after defrosting are ready for use			
Dark Hot Dog Baguette (French Hot Dog) 60g						

Notes: *- defrosting and storage before use shall be done in packing (PE packing)