

CONSISTENTLY FRESH

Nothing beats fresh Italian bread with its crispy crust and tender crumb for making the sub, hoagie, grinder and cheese-steak sandwiches that define "good eats" to residents of Philadelphia, New York City and New Jersey. The key attributes of the bread are being "fresh" and "crispy"...and consistently so.



Thus, when partners James Liscio and Charles (Chad) Vilotti considered a bigger location and more productive equipment for Liscio's Italian Bakery, consistent quality topped their list of expectations.

At Easter 2004, Liscio's transferred its production operations to the new facility. "When we moved into the new plant, we planned to grow 20% each year for the next five, but we accomplished 100% growth in two years," said Mr. Vilotti, the bakery's vice-president and general manager.

INTO AUTOMATION

Having outgrown two smaller locations in eight years, Liscio's owners knew they had to step up from mostly manual production to more automated systems, especially for the bakery's core products: Italian bread and rolls. This led them to add a bulk flour storage and handling system, a computer-sequenced and automatically supplied twin-spiral mixer, a sheeting-style dough makeup line, a 60 ft. tunnel oven and an ambient-temperature spiral cooling system.



"Telescoping" up and down mixing head, the spiral mixer's bowl also uses a release tool to drop finished dough into a mobile trough positioned below.



A 60 ft. tunnel oven now bakes the majority of Liscio's signature Italian bread and rolls, creating a crispy outer crust and tender inside crumb.

With the new equipment, production could double in volume immediately, but continuity of basic methods was also important. "In technology, we tried to duplicate the methods we always used but with higher capacity machinery," Mr. Vilotti said.

NEW DYNAMICS

The bakery uses 20,000 sq. ft. for processing, 10,000 sq. ft. for packaging, 6,000 sq. ft. for warehouse and 600 sq. ft. for offices. It is laid out in zones, with sweet goods production in a separate bay and cake decorating in an enclosed, climate-controlled room.



POWER MIXER

W&P Power Mixer, dual spiral mixer with automated dough discharge and delivery system which can produce from 4,000 to 12,000 lbs per hour.

**"GREAT DOUGH DEVELOPMENT
IN HALF THE TIME."**

— James Liscio

Liscio's transferred its two existing horizontal mixers to the Glassboro plant, but the company added a new Werner & Pfleiderer/Gemini Power Mixer. The plc-controlled, twin-spiral vertical mixer receives flour automatically. The mixer head "telescopes" up and down to allow operators to add in the "minor" ingredients. The bowl remains in an elevated position throughout operation, allowing a dough trough or transfer belt to be positioned under it. When mixing finishes, the unique bowl discharge drops the dough into the trough automatically.

"With two spiral arms, this mixer uses half the time of a same-size horizontal mixer," Mr. Liscio observed. "We chose spiral mixing because it gives our doughs more development in less time. I would eventually like to go with all spiral mixers. This method gives us a good consistent mix, which is crucial to our products."

"Extracting the dough is simple," Mr. Vilotti added. "Operators do not need to cut it out in slabs as they do with the horizontal mixers."



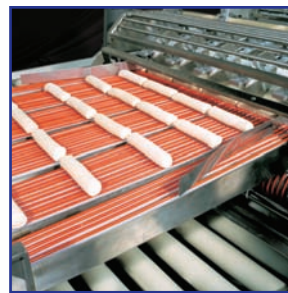
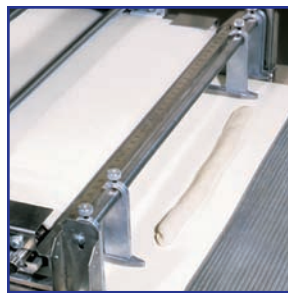
The bakery's new bread forming line employs the latest advances in sheeting and pressure board technology.

Bread and roll production requires different production lines. The newest, a Gemini CraftMaster system, is fed by a W&P Tewimat dough divider. This line receives dough balls and runs them through sheeters and pressure boards to form the long rolls of dough that are the basis for Italian bread, torpedo, hoagie, sub and dinner rolls. The system takes advantage of recent advances in sheeting technology to handle dough in gentle fashion. "The CraftMaster sheeting line is more consistent, more productive." Mr. Liscio said.

Most of Liscio's bread and rolls bake in the new W&P/Gemini NUN 60 ft. tunnel oven. The indirect-fired oven produces a light, crispy crust while assuring a tender, moist crumb for these products.

GEMINI CRAFTMASTER

This low stress variety bread and roll shaping line is one of the newest additions to Gemini's range of bakery equipment. This line was developed with the medium to large specialty wholesale bakery in mind and the growing need to produce higher quality artisan-style breads and rolls, including French and Italian loaves.



- Italian and French bread up to 32 inches
- Round rolls from 1 to 6 ounces
- Club rolls from 5 to 13 inches
- Individually moulded dinner rolls from 5 to 13 inches

GEMINI
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