



The bakery Adelka produces approx. 200,000 pieces of Rohliky per day using a thermo-oil heated tunnel oven.

Adapted oven concepts

The Czech bakery Adelka produces its wide range of products in different types of oven delivered by the plant construction firm Kornfeil.

In addition to the two large-scale providers of baked goods in the Czech market, Penam and United bakeries, there are many regional providers, for instance the Adelka bakery a.s. from Pelhřimov that supply the market with their products. This company has established a strong market position to the south of Prague that is supported by three similarly strong mainstays. First, there are 20 own shops that are connected with a café, if possible, and offer lunch emphasizing the artisan

character of the company. The company founder's son and present managing director, Roman Teisler, wants to widely expand this area during the next years to sharpen the own profile and to promote the independency of delivery business. The delivery to big supermarket chains, i.e. Tesco or Penny, forms the second mainstay. This market is highly competitive, especially because the delivered products closely resemble each other and for this reason, there is a strong competition. The supply

of the small, regional markets is the third mainstay of the business model. More than 600 customers are counted as purchasers. Overall, the company supplies to customers within a radius of 60 kilometres around the company headquarters.

Tunnel oven

The wide range of products and the different production quantities for the individual sections of the company require differentia-



Left photo: Before the oven, the Rohliks are moistened over the whole width of the line, i.e. 30 products per row.
Right photo: A variable switch feeds the upper and the bottom part of the oven by turns. If necessary, it can also feed only one hearth with products.

ted oven concepts. For the large number of pieces, Adelka has invested in a tunnel oven. In this oven, the bakery mainly produces Rohliky, longish wheat buns that are very popular in the Czech Republic. More than 200,000 pieces are leaving the factory every day and therefore, this item is the absolute A-item compared with the German cut or Kaiser rolls. The products are fed into the tunnel oven in rows of 30 pieces. It includes two decks that are fed by turns by a common preceding transfer

conveyor belt. In the oven, heated by thermo oil, the products bake for about 14 minutes. The two-year old continuous oven itself is divided into three zones that are assigned to the individual baking phases. The individual sections can easily be controlled using baking diagrams and the employees can immediately react on possible changes in quality. By the way, this has been improved again with the installation of the new oven. Roman Teisler not only values the smooth heat of the sys-

tem that provides for a very soft baking result, but also the increased water absorption of the dough pieces which has a positive effect on conservation. At the end of the continuous oven, the buns slide on a conveyor belt that transports the finished products to the packaging area. Here, the products can cool down for a moment before they are automatically counted and tipped into the prepared boxes. Overall, the tunnel oven has 62 square metres of baking surface. It is possible to switch off an oven, if



Left photo: A conveyor belt, where the products can cool down, guides the products to the counter where they are put in baskets. Middle photo: The quality of the products has been improved clearly with the purchase of the new tunnel oven.
Right photo: A kneader carousel with three bowls made by the Italian manufacturer Mixer feeds the bread line with dough.



Left photo: The automatic bread line also includes a fermentation cabinet in which the dough can relax and ferment. Middle photo: The pre-fermented breads are put on a transfer table which forms the interface to the oven loader. Right photo: Five multi-deck ovens with a baking surface of 26 square metres each are available for the production of the range of breads.

not required. So, the company can save energy. A further advantage for the bakery resulted from the new design of the production line that was provided by the compa-

ny Kornfeil. More than ten metres of length could be saved that now are of benefit to the shipping department. The whole concept is also integrated in a heat recovery system. Here, the waste heat that is generated when heating up the thermo oil, is used by the so-called Eco Block to produce hot water for the fermentation rooms and for the vapour devices. In addition to the already mentioned Rohliky, the bakery also produces simple rolls and Kaiser rolls in the continuous oven.

on an oven loader. It feeds the five gas-driven multi-deck ovens with their seven hearths each. Already with the sideward movement, the so-called assistant made by Kornfeil moves up and down to reduce the cycle times for loading and unloading. The ovens that are equipped with a heating circuit, have a baking surface of 26 square metres each. Thanks to a good thermal flexibility of the baking oven, it is possible to ensure adapted temperature characteristics. The base surface on which the oven is placed is about 1,800 mm wide and 2,000 mm deep.

Photo: Backtechnik



Facts

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Founded: 1989
Chief executive officer: Ladislav Teisler

General Manager: Roman Teisler
Number of staff: 300
Flour consumption: 500 tonnes / month

Baking surface: 300 square metres
Tunnel oven: 120 square metres
Multi-deck oven: 130 square metres
Delivery fleet: 50 pcs
Certificates: HACCP, Tesco-Siegel, ISO 9001

Multi-Deck Oven

The range of bread products of the Adelka bakery is produced on an own line. The dough is kneaded in a kneader carousel made by the Italian manufacturer Mixer. Then, the dough goes via a lifting tipper into a dough separator and then to the fully-automatic bread line. After the reprocessing, the loaves of bread are put into fermenting baskets arranged in a row. Here, the dough can relax and develop the desired volume. Then, the breads are transferred to a transport table that places the breads

Summary

More than 20 years ago, Ladislav Teisler started his own business and founded his own bakery. Starting with the production of cream rolls in a garage, he established a company that he can proudly pass to the next generation. At our visit at the bakery, we could recognize some success factors. On the one hand, there is the relationship to the own mill. „With our own mill, we have the possibility to specify the quality of our most important



The assistant of Kornfeil can load and unload five ovens with seven hearths each.

raw material and to check it", says Roman Teisler. Furthermore, the company arranges it so that the regional people as the potential customers can identify with the product because the grain comes from the region. A further plus is the diversification of the company which refers to the products as well as to the markets. The extremely wide range of products and the orientation to three different sales markets does not seem to be a disadvantage for Adelka. Finally, we want to emphasize a further advantage: According to its own statements, Adelka always set great value upon a high level of mechanisation and automation of the processes. This also becomes apparent especially in the described lines for Rohliky and bread that have been established on site together with the long-term partner Kornfeil.

Gregor Vogelpohl



The founder of the bakery, Ladislav Teisler (left), and his son, Roman Teisler, with the Holy St. Vit.

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