

# Recipe book Biscuit machine



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## Preparing the dough

- First mix the cooled butter/margarine with the sugar, then add liquid ingredients at the lowest speed in the planet mixer or dough-kneading machine to a uniform mass.
- Add the flour with the baking powders and dry ingredients. In case ammonium is used, this has to be mixed with the liquid ingredients. Mix till a supple dough has been formed and everything is well mixed (scrape regularly).
- Do not mix longer than necessary, which results in tougher or softer dough because of an increase in temperature.
- When you are using the dough later, store it in a cool place of approx. 15-20°C (not in the fridge!). Before processing, re-mix the dough for a short time.
- Shape big rectangular blocks of dough as wide as the feed hopper unit (25cm). Cut slices of approx. 8-15 cm, depending on the thickness of the dough figure, using a (long) knife. These dough slices can also be made with a sheeting machine.
- Preheat the figure roller in the biscuit machine on 2000 Watt for half a minute. Then put it back on 1000 Watt.
- Supply the dough slices till the feed roller has been completely provided with dough.
- Start the machine up in the right position. Please note the following:
  1. **The right speed;**
    - too fast, means tearing of the dough on the baking tray.
    - too slow, means curling of the dough on the baking tray.
  2. **The height of the conveyor belt;**
    - too high, means falling of the smaller dough figures.
    - too low, means that the bottom of the conveyor belt will touch (the filling on) the biscuit. It is also possible that the conveyor belt becomes filthy because it touches the baking tray.

**3. The desired thickness of the biscuits;**

- too thick, means “tadpoles” or ruffles on the edges of the dough figures.
  - too thin, means deformation of the dough figures.
- 
- Start supplying dough and baking trays.

## Influences of the main ingredients

- Butter

Influences taste and crispiness.

The more butter, the crispier the biscuit.

You can see this at the structure at the bottom of the baked biscuit. The structure is looser when more butter is added. This is one of the advantages by which the baker can distinguish himself from industrial production. The reason is that the industrial baker mostly works with a system, whereby the dough figures are sucked out of the figure roller. This of course is only possible with a solid, which means low fat dough with less than 40% of fat in relation to the flour. With the Kalmeijer biscuit machine we do not use this principle. We cut the dough figure off with a knife. As there is no friction, pressing or sucking of the dough with the Kalmeijer system, it is possible to use dough with a fat content between 30% till 70% in relation to the flour; in some cases even to 80%.

To reduce costs, you can replace the butter by margarine. For the taste and smell however, we prefer real butter.

**Please note:**

- With butter you will have to add 1% of salt in relation to the butter weight.
- In most margarines salt is already included.

- Sugar

Influences colour, taste and crispiness

This depends on the kind and quantity of sugar added.

**1: Castor sugar;**

This sugar is hardly used for biscuits, because the sugar is too coarse. Coarse sugar will partly melt during baking, which will make the structure and colour also very uneven, because of the uneven distribution.

That is why finely ground crystal sugar is better. It has as a disadvantage that it does not hold liquid very well, because of the absence of invert sugar.

## **2: Soft white sugar;**

This is really a very finely ground castor sugar with an addition of 1.5 to 2 % invert sugar. This invert sugar has the property to absorb moisture, so that the product will remain crispy longer. This will also increase the colouring a little. That is the reason why soft white sugar is used to make biscuits. For some products soft brown sugar is used. This actually is a soft white sugar, with a caramel solution added.

## **3: Icing sugar;**

This is very finely ground castor sugar possibly with an anti-coagulant. This very fine sugar produces a very uniform distribution in the dough, which gives the biscuit a very compact character and tenacity. The biscuit will colour less, because of the absence of invert sugar.

|                  |             |                               |                    |
|------------------|-------------|-------------------------------|--------------------|
| Castor sugar     | Very crispy | Irregular colour              | Flows a little bit |
| Soft white sugar | Crispy      | Nice regular colour           | Flows a lot        |
| Soft brown sugar | Crispy      | Browner (darker colour)       | Flows a lot        |
| Icing sugar      | Sandy       | Not such a nice colour (pale) | Flows a little     |

- Flour

Influences the colour and the flow of the biscuit.

This depends on the kind of flour that is used.

### **1. Strong flour;**

With this flour the product maintains its form after baking, because of the presence of the formed gluten. This flour also gives a white and fresh colour to the product.

### **2. Soft flour;**

With this flour the product will flow more because of the lack of the formed gluten, and because of this the biscuit will be crispy. The flour gives paler colour than strong flour.

- Liquid ingredients

How much liquid ingredients are used depends on the quantity and firmness of the fat used, as well as the quality of the flour. The quantity of liquid influences the dough consistency (firmness). When a dough is too “short” more liquid has to be added. The flavour can be adjusted as well by adding more or less liquid ingredients.

**1. water;**

The simplest way to add liquid to your recipe. It will make the biscuit flow.

**2. milk;**

Has the same effect as water; but gives the biscuit more flavour and colour because of the milk sugar.

**4. eggs;**

Make the dough to a consistent mass, because of their binding effect. The lecithin in the egg yolk will enhance the colour on the product. By adding more egg yolk in the recipe the colour will increase.

- Baking powders

Influences the structure, effect and flavour of a biscuit.

It depends on which kind and how much baking powder you use.

**1. sodium bicarbonate;**

The biscuit will partly increase and partly flow. We suggest not to add more than 1% in relation to the flour. With higher quantities the biscuit will get a soapy taste and a greenish colour after a while.

**2. ammonium bicarbonate;**

In the oven this product will react very quickly and gives a maximum of gas forming. This creates a huge volume with an unrefined cell structure, which results in a very crispy product. We suggest not to add more than 0.6% in relation to the flour (this has to be mixed with the liquid ingredients).

**3. potassium carbonate;**

This is also known as potash. To get the best result the biscuit needs to be baked longer. The biscuit will flow and have a fine structure. Because of the strong colouring feature, we suggest to only use this product in dark coloured dough.

#### **4. mixed baking powders**

These products consist of different kinds of baking powders, completed with starch and a chemical acid. Mixed baking powders are preferred because:

- They result in the right development of the sodium bicarbonate, which gives a finer structure.
- The biscuits have a longer shelf life because there are little or no residues left behind.

## Influences of the supplementary ingredients

- Flavouring and colouring

To add more flavour and colour:

Egg yolk  
Lemon  
Fruit compounds  
Cocoa powder  
Mocha

To add more flavour:

Coconut  
Ginger  
Aniseed  
Vanilla

Beside these examples of flavour and colourings, you can also add finely ground nuts, chopped citrus fruit or almond paste. Please note the amount of sugar in your recipe, because there is also 50% of sugar in the almond paste.

The ingredients have to be finely ground; otherwise they cannot be cut by the knife. When using sticky ingredients like chopped citrus fruit, we advice you to use a Teflon knife.

- We wish you good luck and for any questions do not hesitate to call your local agent or contact our office in The Hague.  
Telephone: 00 31 70 3888 950.

## Conversion table

| grams | oz  |  | oz  | grams |
|-------|-----|--|-----|-------|
| 10    | 0,5 |  | 0,5 | 14    |
| 15    | 0,5 |  | 1   | 28    |
| 20    | 0,5 |  | 2   | 57    |
| 30    | 1   |  | 3   | 85    |
| 40    | 1   |  | 4   | 113   |
| 50    | 2   |  | 5   | 140   |
| 60    | 2   |  | 6   | 170   |
| 70    | 2   |  | 7   | 200   |
| 80    | 3   |  | 8   | 225   |
| 90    | 3   |  | 9   | 255   |
| 100   | 4   |  | 10  | 285   |
| 125   | 4   |  | 11  | 310   |
| 150   | 5   |  | 12  | 340   |
| 175   | 6   |  | 13  | 370   |
| 200   | 7   |  | 14  | 400   |
| 250   | 9   |  | 15  | 425   |
| 300   | 11  |  |     |       |
| 350   | 12  |  |     |       |
| 400   | 14  |  |     |       |
| grams | Lbs |  | Lbs | grams |
| 450   | 1,0 |  | 1   | 450   |
| 500   | 1,2 |  | 2   | 900   |
| 1.000 | 2,3 |  | 3   | 1.350 |
| 1.100 | 2,7 |  | 4   | 1.800 |
| 1.200 | 2,1 |  | 5   | 2.270 |
| 1.300 | 2,1 |  | 6   | 2.720 |
| 1.400 | 3,1 |  | 7   | 3.175 |
| 1.500 | 3,5 |  | 8   | 3.630 |
| 1.600 | 3,8 |  | 9   | 4.100 |
| 1.700 | 3,1 |  | 10  | 4.500 |
| 1.800 | 4,0 |  |     |       |
| 1.900 | 4,3 |  |     |       |
| 2.000 | 4,7 |  |     |       |
| 3.000 | 6,1 |  |     |       |

1 oz = 28,3495 grams

1 Lbs = 453,592 grams

1 Lbs = 16 oz

# Assorted biscuits

## Recipe

|                          |       |
|--------------------------|-------|
| 1500 gr butter/margarine | 50 %  |
| 1500 gr sugar            | 50 %  |
| 250 gr whole egg         | 8,3 % |
| 100 gr water             | 3,3 % |
| 3000 gr soft flour       | 100 % |
| 30 gr sodium bicarbonate | 1 %   |
| 90 gr vanilla            | 3 %   |
| salt                     |       |



## Working method

Dough : Make the dough according to the general method of preparation.

Rollers : Flowers roller nr. 1612-900/B.

Fantasy figures roller nr. 1612-910/B.

Brush : If necessary with egg.

Bake : 180 °C.

# Big Easter Bunny and Santa Claus

## Recipe

|                          |        |
|--------------------------|--------|
| 1700 gr butter/margarine | 58,6 % |
| 750 gr soft white sugar  | 25,9 % |
| 750 gr icing sugar       | 25,9 % |
| 500 gr almond paste      | 17,2 % |
| 50 gr lemon              | 1,7 %  |
| 300 gr almond shavings   | 10,3 % |
| 160 gr whole egg         | 5,5 %  |
| 130 gr egg-yolk          | 4,5 %  |
| 2900 gr strong flour     | 100 %  |
| salt                     |        |



## Working method

- Dough : Make the dough according to the general method of preparation.  
Add almond paste/shavings together with the sugar.
- Rollers : Santa Claus roller nr. 1504-900/A.  
Easter bunny roller nr. 1561-900/A.
- Bake : 180 °C.
- Decorate : With glaze (icing sugar with egg white) see photo.

# Chocolate cracknel

## Recipe

|                          |        |
|--------------------------|--------|
| 2100 gr butter/margarine | 70 %   |
| 1200 gr icing sugar      | 40 %   |
| 370 gr whole egg         | 12,3 % |
| 3000 gr strong flour     | 100 %  |
| 250 gr cocoa powder      | 8,3 %  |
| salt                     |        |



## Working method

|          |   |
|----------|---|
| Dough    | : Make the dough according to the general method of preparation.<br>Add the cocoa powder at the same time as the sugar. |
| Rollers  | : Cracknel, large roller nr. 1383-910/B.<br>Cracknel, small roller nr. 1383-912/A.                                      |
| Brush    | : If necessary with egg.  |
| Bake     | : 180 °C.   |
| Decorate | : Possibly with soft white sugar.   |

# Christmas figures

## Recipe

|                            |     |   |
|----------------------------|-----|---|
| 1800 gr butter/margarine   | 60  | % |
| 1200 gr soft white sugar   | 40  | % |
| 120 gr whole egg           | 4   | % |
| 450 gr almond paste (fine) | 15  | % |
| 3000 gr strong flour       | 100 | % |
| 90 gr vanilla              | 3   | % |
| salt                       |     |   |



## Working method

|          |   |
|----------|---|
| Dough    | : Make the dough according to the general method of preparation.<br>Mix the almond paste through the sugar. |
| Rollers  | : Christmas figures roller nr. 1123-910/A.  |
| Brush    | : If necessary with egg.  |
| Decorate | : With half almonds, coarse sugar, and so on.   |
| Bake     | : 180 °C.   |

# Cracknel

## Recipe

|                          |       |
|--------------------------|-------|
| 1800 gr butter/margarine | 60 %  |
| 1800 gr soft white sugar | 60 %  |
| 200 gr whole egg         | 6,7 % |
| 3000 gr strong flour     | 100 % |
| 20 gr cinnamon           | 0,7 % |
| 30 gr sodium bicarbonate | 1 %   |
| salt                     |       |



## Working method

|          |  |
|----------|--|
| Dough    | : Make the dough according to the general method of preparation.                 |
| Rollers  | : Cracknel large roller nr. 1383-910/B.<br>Cracknel small roller nr. 1383-912/A. |
| Brush    | : If necessary with egg.   |
| Decorate | : If necessary with cinnamon.  |
| Bake     | : 180 °C.  |
| Complete | : Possibly dip partly in chocolate   |

# Easter figures

## Recipe

|                          |        |
|--------------------------|--------|
| 2000 gr butter/margarine | 62,5 % |
| 850 gr soft white sugar  | 26,6 % |
| 850 gr icing sugar       | 26,6 % |
| 100 gr whole egg         | 3,1 %  |
| 50 gr lemon              | 1,6 %  |
| 3200 gr strong flour     | 100 %  |
| 7 gr sodium bicarbonate  | 0,2 %  |
| 96 gr vanilla            | 3 %    |
| salt                     |        |



## Working method

|          |  |
|----------|--|
| Dough    | : Make the dough according to the general method of preparation. |
| Rollers  | : Easter figures roller nr. 1600-910/C.                          |
| Brush    | : If necessary with egg.   |
| Decorate | : A piece of coarse sugar on the eye.                            |
| Bake     | : 180 °C.  |

# Jam biscuit

## Recipe

|                          |        |
|--------------------------|--------|
| 1600 gr butter/margarine | 53,3 % |
| 1600 gr soft white sugar | 53,3 % |
| 200 gr whole egg         | 6,7 %  |
| 50 gr lemon              | 1,7 %  |
| 3000 gr strong flour     | 100 %  |
| 90 gr vanilla            | 3 %    |
| salt                     |        |



## Working method

|          |  |
|----------|--|
| Dough    | : Make the dough according to the general method of preparation.                             |
| Rollers  | : Jam cookie roller nr. 1120-930/A (Ø 45 mm).<br>Jam cookie roller nr. 1120-931/A (Ø 50 mm). |
| Bake     | : 180 °C.  |
| Decorate | : The tops with icing sugar.   |
| Filling  | : With jam and stick both sides together.  |

# Nut cookies

## Recipe

|                                |       |
|--------------------------------|-------|
| 2100 gr butter/margarine       | 70 %  |
| 1050 gr icing sugar            | 35 %  |
| 450 gr finely ground hazelnuts | 15 %  |
| 150 gr egg yolk                | 5 %   |
| 100 gr water                   | 3,3 % |
| 3000 gr strong flour           | 100 % |
| 90 gr vanilla salt             | 3 %   |



## Working method

|          |  |
|----------|--|
| Dough    | : Make the dough according to the general method of preparation.   |
| Rollers  | : Nut strips roller nr. 1263-930/B.<br>Crescent, small roller nr. 1380-910/B.<br>Crescent, thick roller nr.1380-912/B. |
| Brush    | : With egg.  |
| Decorate | : Sprinkle with chocolate flakes or broken hazelnuts before baking.  |
| Bake     | : 180 °C.  |

# Round biscuits

## Recipe

|                          |        |
|--------------------------|--------|
| 1700 gr butter/margarine | 56,7 % |
| 1700 gr castor sugar     | 56,7 % |
| 160 gr whole egg         | 5,3 %  |
| 3000 gr flour            | 100 %  |
| 15 gr sodium bicarbonate | 0,5 %  |
| 90 gr lemon salt         | 3 %    |



## Working method

|          |  |
|----------|--|
| Dough    | : Make the dough according to the general method of preparation.   |
| Rollers  | : Round biscuits roller nr. 1120-910/A (Ø 55 mm).<br>Round biscuits roller nr. 1120-925/A (Ø 80 mm).<br>Round biscuits roller nr. 1120-922/A (Ø 90 mm).<br>Round biscuits roller nr. 1120-914/A (Ø 95 mm). |
| Brush    | : With egg.  |
| Decorate | : Before baking with chocolate flakes, half almonds, chopped hazelnuts, coarse sugar, and so on.   |
| Bake     | : 180 °C.  |

# Short bread and Viennese cookies

## Recipe

|                          |        |
|--------------------------|--------|
| 2000 gr butter/margarine | 66,7 % |
| 675 gr castor sugar      | 22,5 % |
| 675 gr icing sugar       | 22,5 % |
| 150 gr whole egg         | 5 %    |
| 100 gr water             | 3,3 %  |
| 3000 gr soft flour       | 100 %  |
| 60 gr baking powder      | 2 %    |
| 30 gr lemon              | 1 %    |
| 90 gr vanilla            | 3 %    |
| salt                     |        |



## Working method

|           |  |
|-----------|--|
| Dough     | : Make the dough according to the general method of preparation.                         |
| Important | : Drop dough figures on well greased baking trays to obtain a nicer shape during baking. |
| Rollers   | : Short bread roller nr. 1120-920/C.<br>Viennese cookies roller nr. 1270-900/C.          |
| Decorate  | : If necessary with jam in the middle, before baking.                                    |
| Bake      | : 180 °C.  |
| Cut       | : Cut at desired length (7-9 cm) directly after baking.                                  |
| Complete  | : Possible dip in chocolate.   |

# Shrewsbury biscuits

## Recipe

|                          |        |
|--------------------------|--------|
| 2000 gr butter/margarine | 66,7 % |
| 1600 gr soft white sugar | 53,3 % |
| 150 gr whole egg         | 5 %    |
| 100 gr lemon (grated)    | 3,3 %  |
| 3000 gr strong flour     | 100 %  |
| 15 gr sodium bicarbonate | 0,5 %  |
| salt                     |        |



## Working method

|          |   |
|----------|---|
| Dough    | : Make the dough according to the general method of preparation.  |
| Rollers  | : Playing cards roller nr. 1120-900/A (Ø 50 mm).<br>Miscellaneous biscuits roller nr. 1120-901/A (Ø 45 mm). |
| Brush    | : 2x with egg.  |
| Decorate | : With chocolate flakes, broken hazelnuts, half almonds,<br>coarse sugar, and so on.                        |
| Bake     | : 180 °C.   |

# Sugar rings

## Recipe

|                          |        |
|--------------------------|--------|
| 2000 gr butter/margarine | 66,7 % |
| 2000 gr soft white sugar | 66,7 % |
| 150 gr whole egg         | 5 %    |
| 3000 gr strong flour     | 100 %  |
| 15 gr baking powder      | 0,5 %  |
| 45 gr vanilla            | 1,5 %  |
| 45 gr lemon salt         | 1,5 %  |



## Working method

|          |  |
|----------|--|
| Dough    | : Make the dough according to the general method of preparation.   |
| Rollers  | : Sugar ring, small roller nr. 1123-900/A (Ø 55 mm).<br>Sugar ring, large roller nr. 1123-905 (Ø 90 mm). |
| Brush    | : With egg.  |
| Decorate | : With coarse sugar and shaved almonds.  |
| Bake     | : 180 °C.  |

# Tart-shells

## Recipe

|                          |        |
|--------------------------|--------|
| 1500 gr butter/margarine | 50 %   |
| 1200 gr icing sugar      | 40 %   |
| 400 gr whole egg         | 13,3 % |
| 3000 gr strong flour     | 100 %  |
| 90 gr lemon salt         | 3 %    |



## Working method

|         |   |
|---------|---|
| Dough   | : Make the dough according to the general method of preparation.        |
| Rollers | : Tart-shell roller nr. 1120-919/C.                                     |
| Filling | : Possibly with jam, almond paste, coconut paste, frangipane and so on. |
| Bake    | : 200 °C.   |

# Tea biscuits

## Recipe

|                          |       |
|--------------------------|-------|
| 2100 gr butter/margarine | 70 %  |
| 1500 gr sugar (fine)     | 50 %  |
| 100 gr water             | 3,3 % |
| 75 gr eggs               | 2,5 % |
| 3000 gr flour            | 100 % |
| 90 gr vanilla<br>salt    | 3 %   |



## Working method

|         |   |
|---------|---|
| Dough   | : Make the dough according to the general method of preparation.                |
| Rollers | : Varied biscuits roller nr. 1612-910/B.<br>Tea biscuits roller nr. 1100-910/B. |
| Brush   | : If necessary with egg.  |
| Bake    | : 180 °C.   |

# Wafers

## Recipe

|                          |       |
|--------------------------|-------|
| 1500 gr butter/margarine | 50 %  |
| 1500 gr soft white sugar | 50 %  |
| 300 gr water             | 10 %  |
| 150 gr whole egg         | 5 %   |
| 3000 gr soft flour       | 100 % |
| 30 gr baking powder      | 1 %   |
| salt                     |       |



## Working method

Dough : Make the dough according to the general method of preparation.  
Rollers : Wafer roller nr. 1123-940/B.  
Bake : 180 °C.  
Filling : Heat 1000 gr. (brown) syrup up to 80 °C, then add 100 gr. brown soft sugar and 150 gr. butter. Cool the syrup before use. When the syrup is too soft add a little bit more butter.

# Cheese biscuits

## Recipe

|   |       |
|---|-------|
| 1800 gr butter/margarine                          | 60 %  |
| 1200 gr golden syrup                              | 40 %  |
| 120 gr egg-yolk                                   | 4 %   |
| 300 gr powder cheese                              | 10 %  |
| 600 gr parmesan cheese                            | 20 %  |
| 3000 gr strong flour                              | 100 % |
| 30 gr salt  | 1 %   |
| 12 gr season (savory, thyme,<br>pepper, marjoram) | 0,4 % |



## Working method

|          |  |
|----------|--|
| Dough    | : Mix the butter, syrup and egg-yolk. Secondly mix the dry ingredients and add this to the butter mixture. |
| Rollers  | : Tea biscuits roller nr. 1100-910/B.<br>Varied biscuits roller nr. 1612-910/B.                            |
| Decorate | : With parmesan cheese.  |
| Bake     | : 175 °C, with open damper (appr. 15 min).   |

# Corn biscuits

## Recipe

|                           |        |
|---------------------------|--------|
| 1700 gr butter/margarine  | 42,5 % |
| 1700 gr castor sugar      | 42,5 % |
| 300 gr whole egg          | 7,5 %  |
| 70 gr olive oil           | 1,8 %  |
| 170 gr honey              | 4,3 %  |
| 3000 gr flour             | 75 %   |
| 1000 gr corn-flour (fine) | 25 %   |
| 15 gr baking powder       | 0,4 %  |
| salt                      |        |



## Working method

|         |  |
|---------|--|
| Dough   | : Make the dough according to the general method of preparation.<br>Add oil and honey at the same time as the sugar. |
| Rollers | : Grill wafer roller nr. 1263-920/C.<br>Round wafer roller nr. 1123-940/B.   |
| Bake    | : 180 °C.  |

# Dry biscuits

## Recipe

|                             |       |
|-----------------------------|-------|
| 900 gr butter/margarine     | 30 %  |
| 1200 gr sugar               | 40 %  |
| 450 gr whole egg            | 15 %  |
| 225 gr water/milk           | 7,5 % |
| 150 gr honey                | 5 %   |
| 3000 gr flour               | 100 % |
| 60 gr baking powder<br>salt | 2 %   |



## Working method

|           |   |
|-----------|---|
| Dough     | : Mix the butter, flour and baking powder until a fine crumbly powder has been formed.<br>Put sugar, whole egg, water/milk, honey and salt into a separate bowl and mix the ingredients with a rod.<br>Add sugar/water mix to the fine crumbly powder mix in the kneading- or planet mixer till a consistent dough is formed. |
| Rollers   | : Ladies finger roller nr. 1383-901/B.<br>Heart shape roller nr. 1340-900/A.  |
| Brush     | : with egg.   |
| Bake      | : 180 °C.   |
| Important | : As this dough contains a lot of baking powder, we advice you not to make more dough than you can process in 30-45 min.  |

# Dutch speculaas

## Recipe

|                                     |     |   |
|-------------------------------------|-----|---|
| 1500 gr butter/margarine            | 50  | % |
| 1800 gr soft sugar                  | 60  | % |
| 600 gr buttermilk                   | 20  | % |
| 600 gr finely ground biscuit crumbs | 20  | % |
| 3000 gr soft flour                  | 100 | % |
| 90 gr cinnamon                      | 3   | % |
| 30 gr sodium bicarbonate            | 1   | % |
| salt                                |     |   |



## Working method

**Dough** : Make the dough according to the general method of preparation.  
Soak crumbs for 2 hours in the buttermilk.  
Process soaked crumbs together with the butter.

**Rollers** : Assorted shapes roller nr. 1505-900/B (11 gram).  
Assorted shapes roller nr. 1505-902/B (15 gram).  
Little men roller nr. 1502-931/B.

**Baking trays**: If necessary supply with almond shavings.

**Bake** : 170 °C.

# Ginger bread 1

## Recipe

|                       |        |
|-----------------------|--------|
| 750 gr margarine      | 25 %   |
| 1700 gr golden syrup  | 56,7 % |
| 550 gr castor sugar   | 18,3 % |
| 200 gr whole egg      | 6,7 %  |
| 200 gr chopped ginger | 6,7 %  |
| 50 gr ground ginger   | 1,7 %  |
| 3000 gr bread flour   | 100 %  |
| 200 gr baking powder  | 6,7 %  |



## Working method

|           |  |
|-----------|--|
| Dough     | : Make the dough according to the general method of preparation.<br>Store the dough 4-6 hours before processing (not in the refrigerator). |
| Rollers   | : Use the possibility to have a special roller made according to your own model (see chapter special rollers).                             |
| Attention | : The biscuit machine should have a Teflon knife.  |
| Bake      | : 165 °C for 12-15 min.  |
| Decorate  | : With glaze.  |

# Ginger bread 2

## Recipe

|                      |        |
|----------------------|--------|
| 625 gr margarine     | 20,8 % |
| 1500 gr golden syrup | 50 %   |
| 1500 gr castor sugar | 50 %   |
| 780 gr water         | 26 %   |
| 55 gr ground ginger  | 1,8 %  |
| 60 gr milk powder    | 2 %    |
| 3000 gr bread flour  | 100 %  |
| 200 gr baking powder | 6,7 %  |



## Working method

- Dough** : Make the dough according to the general method of preparation. Store the dough 4-6 hours before processing (not in the refrigerator).
- Rollers** : Use the possibility to have a special roller made according to your own model (see chapter special rollers).
- Attention** : The biscuit machine should have a Teflon knife.
- Bake** : 165 °C for 12-15 min.
- Decorate** : With glaze.

# Glutenfree flowers

## Recipe

|                          |        |
|--------------------------|--------|
| 1000 gr butter/margarine | 44,4 % |
| 850 gr soft white sugar  | 37,8 % |
| 850 gr icing sugar       | 37,8 % |
| 2250 gr glutenfree flour | 100 %  |
| 150 gr whole egg         | 6,7 %  |
| 250 gr honey             | 11 %   |
| 68 gr vanilla<br>salt    | 3 %    |



## Working method

- Dough** : Make the dough according to the general method of preparation.  
Mix the honey through the butter and sugar.
- Rollers** : Flowers roller nr. 1612-900/B.
- Brush** : Twice with egg yolk.
- Bake** : 180 °C (on baking paper).
- Attention** : **All tools like kneader, scales, etc. including the machine and rollers must be absolutely free of flour.**

# Glutenfree rabble

## Recipe

|                          |      |   |
|--------------------------|------|---|
| 1000 gr butter/margarine | 50   | % |
| 1000 gr glutenfree flour | 50   | % |
| 1000 gr rice-flour       | 50   | % |
| 1500 gr soft brown sugar | 75   | % |
| 250 gr molasses          | 12,5 | % |
| 20 gr salt               | 1    | % |
| 20 gr cinnamon           | 1    | % |



## Working method

- Dough : Make the dough according to the general method of preparation.  
Mix the molasses through the sugar and butter.
- Rollers : Continuous roller nr. 1263-900/B.
- Brush : With strong egg yolk
- Decorate : Sprinkle with almond shavings and coarse sugar.
- Bake : 180 °C.
- Cut : Straight after baking (3 by 8 cm).
- Attention : All tools like kneader, scales, etc. including the machine and rollers must be absolutely free of flour.**

# Marzipan



## Working method

- Dough** : Marzipan type 1:1, 1:2 of 1:3 (relation almonds:sugar)  
Others types of marzipan or sugar-paste need to be tested in advance.
- Processing** : Take out the feeding roller and moisten it a little (!) with a shaken out brush and put a rolled out marzipan sheet with a thickness of 2 cm round the feed roller and press it firmly. Put everything back in its place.  
**SWITCH-OFF THE HEATING UNIT**  
Feed the machine with rolled out sheets of Marzipan with a thickness of 4 to 6 mm, depending on the thickness of the Marzipan figure.
- Rollers** : Cracknel, small roller nr. 1383-912/A.  
Ladies finger roller nr. 1383-901/B.  
Special roller with rose petals or other figures.
- Attention** : Machine should have a Teflon knife and a feed roller with burled profile.

# Rice biscuits

## Recipe

|                           |        |
|---------------------------|--------|
| 1700 gr butter/margarine  | 42,5 % |
| 1700 gr castor sugar      | 42,5 % |
| 300 gr whole egg          | 7,5 %  |
| 70 gr olive oil           | 1,8 %  |
| 170 gr honey              | 4,3 %  |
| 3000 gr flour             | 75 %   |
| 1000 gr rice-flour (fine) | 25 %   |
| 15 gr baking powder       | 0,4 %  |
| salt                      |        |



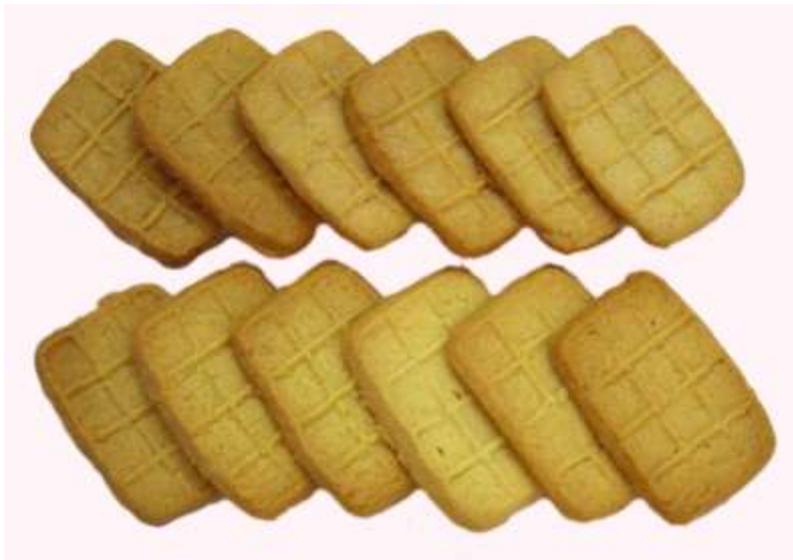
## Working method

|         |  |
|---------|--|
| Dough   | : Make the dough according to the general method of preparation.<br>Mix oil and honey at the same time as the sugar.                       |
| Rollers | : Playing cards roller nr. 1120-900/A.<br>S and O biscuits, small roller nr. 1600-905/C.<br>S and O biscuits, thick roller nr. 1600-900/C. |
| Bake    | : 180 °C.  |

# Whole meal biscuits

## Recipe

|                          |        |
|--------------------------|--------|
| 1200 gr butter/margarine | 44,4 % |
| 1000 gr sugar            | 37 %   |
| 375 gr whole egg         | 13,9 % |
| 200 gr water/milk        | 7,4 %  |
| 2700 gr flour            | 100 %  |
| 300 gr bran (extra fine) | 11,1 % |
| 75 gr baking powder      | 2,8 %  |



## Working method

|           |  |
|-----------|--|
| Dough     | : Mix the butter, bran, flour and baking powder until a fine crumbly powder has been formed.<br>Put sugar, whole egg, water and salt into a separate bowl and mix the ingredients with a rod.<br>Add sugar mix to the fine crumbly powder mix in the kneading machine. Mix until a consistent dough is formed. |
| Attention | : The whole meal flour or bran is more or less gritty and this causes resistance to the knife in the biscuit machine during the cutting of the dough figures. If this happens, clean the knife in the biscuit machine (with a plastic scraper) after $\pm$ 10 baking trays.                                    |
| Rollers   | : Grill wafer roller nr. 1263-920/C.   |
| Brush     | : With egg.  |
| Bake      | : 180 °C.  |

# Apple pie

## Recipe

|                          |        |
|--------------------------|--------|
| 1200 gr butter/margarine | 40 %   |
| 2000 gr soft white sugar | 66,7 % |
| 30 gr lemon              | 1 %    |
| 250 gr milk              | 8,3 %  |
| 200 gr whole egg         | 6,7 %  |
| 3000 gr strong flour     | 100 %  |
| 15 gr baking powder      | 0,5 %  |
| 500 gr biscuit crumbs    | 16,7 % |

## apple filling

|                          |
|--------------------------|
| 4600 gr apples           |
| 300 gr raisins           |
| 300 gr sugar             |
| 100 gr lemon             |
| 50 gr cold binding agent |
| 2 gr cinnamon            |

Amount of pies depends on size.



## Working method

|          |  |
|----------|--|
| Dough    | : Make the dough according to the general method of preparation.<br>Add crumbs (soaked in milk) together with the sugar.   |
| Rollers  | : Bottom dough slice roller nr. 1100-936/A (Ø 182 mm).<br>Bottom dough slice roller nr. 1100-932/A (Ø 205 mm).<br>Bottom dough slice roller nr. 1100-931/A (Ø 235 mm). |
| Filling  | : With the apple filling (if necessary put in some almond paste on bottom dough slice).  |
| On top   | : Top network roller nr. 1100-935/C (Ø 170 mm).<br>Top network roller nr. 1100-940/C (Ø 235 mm).   |
| Brush    | : With egg.  |
| Bake     | : 200 °C.  |
| Complete | : With apricot jam.  |

# Apricot pie

## Recipe

|                          |        |
|--------------------------|--------|
| 1200 gr butter/margarine | 40 %   |
| 2000 gr soft white sugar | 66,7 % |
| 30 gr lemon              | 1 %    |
| 250 gr milk              | 8,3 %  |
| 200 gr whole egg         | 6,7 %  |
| 3000 gr flour            | 100 %  |
| 15 gr baking powder      | 0,5 %  |
| 500 gr biscuit crumbs    | 16,7 % |

## filling

almond paste  
apricots

Amount of pies depends on size.



## Working method

|          |  |
|----------|--|
| Dough    | : make the dough according to the general method of preparation.<br>Add crumbs (soaked in milk) together with the sugar.   |
| Rollers  | : Bottom dough slice roller nr. 1100-936/A (Ø 182 mm).<br>Bottom dough slice roller nr. 1100-932/A (Ø 205 mm).<br>Bottom dough slice roller nr. 1100-931/A (Ø 235 mm). |
| Filling  | : With thin layer of almond paste and cover with apricots.   |
| On top   | : Top network roller nr. 1100-935/C (Ø 170 mm).<br>Top network roller nr. 1100-940/C (Ø 235 mm).<br>Top network roller with your own logo, see photo.                  |
| Brush    | : With egg.  |
| Bake     | : 185 °C.  |
| Complete | : With apricot jam   |

# Filled butter pie

## Recipe

|                          |       |
|--------------------------|-------|
| 2100 gr butter/margarine | 70 %  |
| 1050 gr soft white sugar | 35 %  |
| 150 gr egg-yolk          | 5 %   |
| 3000 gr strong flour     | 100 % |
| 90 gr vanilla            | 3 %   |
| salt                     |       |

## filling

almond paste

Amount of pies depends on size.



## Working method

- Dough : Make the dough according to the general method of preparation.
- Rollers : Bottom dough slice roller nr. 1100-936/A (Ø 182 mm).  
Bottom dough slice roller nr. 1100-932/A (Ø 205 mm).  
Bottom dough slice roller nr. 1100-931/A (Ø 235 mm).
- Filling : With almond paste.
- On top : Supply with dough slice.
- Brush : With egg.
- Decorate : With almonds and spread with egg again.
- Bake : Filled with almond paste on 190 °C.  
Only two layers of dough on 220 °C

# Honey-almond pie

## Recipe

|                          |        |
|--------------------------|--------|
| 1200 gr butter/margarine | 40 %   |
| 2000 gr soft white sugar | 66,7 % |
| 30 gr lemon              | 1 %    |
| 250 gr milk              | 8,3 %  |
| 200 gr whole egg         | 6,7 %  |
| 3000 gr strong flour     | 100 %  |
| 15 gr baking powder      | 0,5 %  |
| 500 gr biscuit crumbs    | 16,7 % |

## Honey almond filling

|                        |
|------------------------|
| 250 gr sugar           |
| 250 gr butter          |
| 140 gr honey           |
| 500 gr almond shavings |

Amount of pies depends on size.



## Working method

|          |  |
|----------|--|
| Dough    | : Make the dough according to the general method of preparation.<br>Add crumbs (soaked in milk) together with sugar.   |
| Rollers  | : Bottom dough slice roller nr. 1100-936/A (Ø 182 mm).<br>Bottom dough slice roller nr. 1100-932/A (Ø 205 mm).<br>Bottom dough slice roller nr. 1100-931/A (Ø 235 mm). |
| Filling  | : Boil the sugar, butter and honey and add the almond shavings.<br>Fill the pies with it after the filling cooled down.  |
| Bake     | : 190 °C.  |
| Complete | : With coarse sugar and jelly.   |

# Tamarillo pie

## Recipe

|                          |       |
|--------------------------|-------|
| 1650 gr butter/margarine | 55 %  |
| 1500 gr soft white sugar | 50 %  |
| 300 gr whole egg         | 10 %  |
| 120 gr water             | 4 %   |
| 3000 gr strong flour     | 100 % |
| 6 gr baking powder       | 0,2 % |
| 30 gr salt               | 1 %   |

## filling

frangipane  
tamarillo (tropical fruit)

Amount of pies depends on size.



## Working method

Dough : Make the dough according to the general method of preparation.

Rollers : Bottom dough slice roller nr. 1100-936/A (Ø 182 mm).

Bottom dough slice roller nr. 1100-932/A (Ø 205 mm).

Bottom dough slice roller nr. 1100-931/A (Ø 235 mm).

Filling : With thin layer of frangipane and cover with pieces tamarillo (strip the skin by boiling the tamarillo briefly).

Tip : Try also carambola.

Bake : 180 °C.

# Special rollers

It is also possible to make a special roller with your own logo or design. First we will make a drawing of your proposition. When you return a copy signed for approval, the roller will be taken in production.

The following information that has to be known before we can make you a drawing:

Dimensions;

Square, round, oval, etc.

Dough weight;

Maximum 400 gram.

Recipe;

Sweet pastry dough, Gingerbread dough, etc.

Example of the figure;

Logo, design, etc.

Thickness;

Maximum 10% of the diameter.

This information can be send by post, fax or e-mail to Kalmeijer or your agent.



## Trouble shooting

| Problem  | Cause  | Advice   |
|--|--|--|
| <b>Dough sticks to the figure roller.</b>                                | Recently made dough.                                       | Store the dough in a cool place (15-18 °C) for 6-12 hours.   |
|  | Dough temperature is too low.                              | Do not store the dough in the refrigerator or take it out earlier and re-mix the dough for a short time.   |
|  | Figure roller is not warm (enough).                        | Preheat the figure roller on 2000 Watt for the maximum of 1 minute, before supplying the dough into the biscuit machine. Put it back on 1000 Watt when working with the machine. Turn of the heater when working with marzipan or some gingerbread doughs. |
|  | Dough is too soft.   | Add less butter or liquid ingredients.   |
| <b>Dough figures get smaller or get an oval shape when cutting.</b>      | Dough is too soft.   | Re-mix the dough adding another 10% of flour, or make a new dough with 25 tot 35 % less liquid ingredients or fat.   |
| <b>Dough figures are deformed at the top (irregular on baking tray).</b> | Dough is too solid.  | Re-mix the dough adding a little more eggs or water, or make a new dough with more liquid ingredients (water, milk or eggs).   |
|  | Build up and too much dough in front of the figure roller. | Make thinner dough slices (thickness 8 mm) using, if necessary, the dough sheeting machine.  |
|  | Dough is too short and crumbly.                            | Add more liquid.   |
| <b>Dough figures are deformed at the sides.</b>                          | Dough slices are not wide enough.                          | Insert wider dough slices.   |
| <b>“Tadpole” or raffles on the edges of the dough figures.</b>           | The knife is set on more than the maximum thickness.       | Turn the thickness knob 1 or 2 settings back nearer to the 0.  |

| <b>Problem</b>   | <b>Cause</b>   | <b>Advice</b>   |
|--|--|---|
| <b>Biscuit shape crumbles near the figure roller.</b>          | Dough feed unit is loose when the figure roller is secured with the roller hook. | Adjust the gap between the dough feed unit and the figure roller with the support shaft.                                |
|  | Dough feed unit is worn or points have been damaged.                             | Replace dough feed unit.  |
| <b>Dough figures break when falling on the baking tray.</b>    | Conveyor belt is too high.   | Position the conveyor belt lower.   |
|  | Dough is too stiff.  | Re-mix the dough with some extra liquid.  |
| <b>Too much dough on the knife.</b>                            | Dough is too warm.   | Cool down the dough, re-mix it and try again.   |
|  | The knife is not suitable for this kind of dough.                                | For certain doughs as for example a gingerbread dough or a dough with molasses, honey or garnishing use a Teflon knife. |
| <b>Dough figures break during cutting.</b>                     | Dough is too stiff.  | Re-mix the dough with some extra liquid.  |
|  | Butter has been too soft.  | Use cooled butter, soft butter makes a “short” dough.   |
| <b>Dough figures fall over when the reach the baking tray.</b> | Conveyor belt is too high.   | Lower the conveyor belt.  |
|  |  | Put on the tray elevator bracket (for smaller biscuits).  |