

BREADS OF THE WORLD

40 recipes for bread lovers

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Graphic design Fanny Duirat

Translation - Translated from English by Elite Traduction

Printed in Poland in January 2024 by Typo'Libris.
Legal deposit 1st quarter 2024

ISBN 978-2-9591152-0-2

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PREFACE

Bread is much more than just food, it is a universal symbol of life and sharing. It is an integral part of our daily lives and cultures around the world. It is rich in meaning and history, part of a shared heritage that deserves to be celebrated.

With this book, created by the passionate bakers of the Baking Center™ Network, we invite you on a journey across all continents. **Our network, rich with 50 years of experience, is a source of know-how and innovation, which reflects the diversity and richness of bakeries around the world.**

Discover 40 delicious recipes carefully chosen for their originality and authenticity. A selection of tasty and traditional recipes, which was very hard to make, considering the infinite original suggestions we had to choose from.

This book is more than just a collection of recipes; it is an invitation to discover and share. **It is a journey alongside our bakers, who are so passionate about their job and the quality of their breads, that they wish to pass it on to all bread lovers out there.**

Gaëtan Jegoux,

Group Baking Center™ director

Bread and the world or the world and its bread?

This is really a subject that has always intrigued me!!

What type of bread do they eat in this country? Is it “used” in the same way as us? What flour? How is it kneaded? How is it cooked? What ingredient gives this little subtle note?...

This is perhaps one of the reasons why I wanted to export our French baking know-how, to share our wealth of recipes and diversity with these civilizations which in return provide us with some answers to these questions.

Creating a book on bread recipes from around the world, what a joy!!

Each page has its own journey, a discovery of techniques or even means of consumption, or ingredients. The challenge was not easy, gathering the recipes, uncovering the little secrets of those who make them.

Thanks to the Baking Center™ facilities which are places of sharing and support for all these bakers in the four corners of the world, it is now a done deal.

Thank you for sharing this passion!!

Enjoy your trip around the world and start flipping the pages!

Gontran Cherrier,

Baker and director of an international bakeries network

THE BAKING CENTER™, SUPPORT FROM BAKER TO BAKER

The pioneering concept of the Baking Center™ Network was launched in 1974 with the motto «from Baker to Baker».

Our primary ambition has always been to understand and meet the needs of all bakers and their consumers.

For 50 years, the Baking Center™ Network has been «the voice of its customers», offering them its international expertise and know-how around bread-making processes and ingredients.

Today, our network extends across every continent, from Mexico to Poland, via China, Turkey and Dubai.

Every day, more than 300 expert baking technicians work with our customers, whether craftsmen or industrials, millers or distributors, to develop the processes and products of today and tomorrow.

Our facilities and our experts give all customer segments the opportunity to work together, hand in hand, to find solutions in terms of processes, products or recipes. We share our know-how at every stage of design and manufacturing: market knowledge, innovation, formulation, sensory analysis, technical assistance and training.

Our teams also work on structuring and making available business data using appropriate tools, an essential phase in our customers' innovation process.



THE SERVICES OF THE BAKING CENTER™ NETWORK

We offer services tailored to the demands of all customer segments to better meet their needs.

THE NETWORK OF 50 BAKING CENTERS™, CLOSE TO OUR CUSTOMERS



Product Expertise

Examples :
Product Development & Innovation
Customer product enhancements
Quality & Regulatory
...

Analysis & Testing

Examples :
Sensory analysis
Breadmaking tests
Final bread product analysis
Raw materials analysis
...

Knowledge Sharing

Examples :
Market trends
Marketing advice
Bakery Business advice
Social media support
...

Process Expertise

Examples :
Process Setup
Process Optimization
Industrial-scale & pilot trials
Equipment selection & advice
...

Training

Examples :
Webinars
E-Learning Courses
Customized Training
...

Customer Empowerment

Examples :
Online Buying
“Lesaffre and Me” Mobile App
Cost optimization Mobile App
“Breads In Words” Website
Lesaffre “Technical Library”
...



CONTENT



ACKNOWLEDGEMENTS

The story begins when we decided to narrow down the incredibly rich world of breadmaking into a book of only 40 recipes. With so many cultures, so much local history and bread variety, the very selection of those 40 breads was not an easy choice to make! Thank you to our regional technicians for helping us make this difficult choice. We hope we have made the right ones, and that this book will offer you a pleasant and surprising trip around the world.

Preparing the recipes, especially the search for certain «exotic» ingredients, was also an important and intense phase of the project. Our warmest thanks go to Antoine Boëlle and Nicolas Delcourt for the time and energy they invested in recreating many of the recipes in this book. Thanks also to Emmanuel Delebarre, Christophe Gautier, Mareile Heitmann, Mike Liu, Clément Nille, Olha Novikova and Svitlana Shynkarenko for their invaluable help in making certain breads and sourcing certain ingredients.

We would also like to thank all the technicians who agreed to share their anecdotes and personal attachments to each of the 40 recipes they were involved in. Your contribution helps to highlight the richness of the Baking Center™ Network worldwide. Thank you for your passion, which drives our bakeries every day!

Special thanks go to Benoit Demiselle and Florence Delchambre, without whose help the recipes would not have been so accurate!

And let's not forget the whole team behind this wonderful project: Fanny Duirat (graphic designer), Inès Millet (culinary photographer), and all those who coordinated the project from idea to printer (Florence Delchambre, Gaëtan Jegoux, Jennifer Savina). Thank you, Fanny and Inès, for your patience and attention during the many corrections!

To match the multicultural extent of our network, this recipe book had to be available in different languages so that it could be shared internationally. Many thanks to our translation team. Jean-François Celuzza, Florence Delchambre, Arnaud Deniaud, Gaëtan Jegoux, Luciana Jimenez, Julie Régner, Jennifer Savina and Viviana Zucatti: thank you for your translations, your proofreading and your bilingual eyes!

And last but not least, a special mention to Charles Billet, Timothée Courtens, Damien Deblander, Alban Depierre, Grégory Hublard and Bruno Pacaud: thanks for your joyfulness, your jokes and the great music during the photo sessions! Thanks to you, these were pleasant and friendly moments. Just what the Baking Center™ «spirit» has always been and how it will continue to flourish.



TECHNICAL NOTE

All the recipes propose indicative dosages and have been designed with flours, equipments and local conditions in France. Some adjustments may be needed for other local facilities.

For example, hydration rate is indicative as it depends on flour types and absorption. Process steps, time and temperature might also need adaptation.

Some recipes contain Lesaffre products such as yeasts, sourdough, natural flavors and improvers. Some references are international but some of them are local brands. Our teams are available to help you identify the equivalence of those products in your country.

Some recipes may require special equipments such as special oven (ex. pita oven). We have adapted those recipes in order to use classical equipments that can be found in all bakery facilities.

Concerning the baking steps, recipes requiring steam are notified. Nevertheless, the quantity of steam has to be adapted according to the product type and your oven steam capacity.

Lastly, some ingredients may not always be easily found (ex. roasted buckwheat flour, bobba, Ube flavor...). For most of them, you will be able to order them on the internet. Otherwise, you can replace them by alternative local ingredients (ex. other flavors, more local flours, etc...) but this might change the original taste.



Africa & Middle East

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Pao Doce



Pao Doce or sweet bread, is a traditional Cape Verdean recipe situated somewhere between bread brioche and sandwich bread. It is found in the form of a ball or elongated loaf glued together to have a minimum crust and retain the softness. It is generally produced at the end of the day to be baked in the oven at falling temperature and sold in bags of 6 to 8 pieces.

Formula

Ingredients

Wheat flour	1 000g	100%
Water	500g	50%
Instant dry yeast Saf Instant® Gold	12g	1,2%
Salt	15g	1,5%
Sugar	100g	10%
Margarine	20g	2%
Eggs	20g	2%
Milk powder	10g	1%
Improver Ibis® blue	5g	0,5%
Total	1 682g	

Process

Mixer type	Spiral
Basic T°	65°C
Mixing	Low 3 + high 10
Final dough T°	30°C +/- 1°C
1st fermentation	-
Dividing	70 to 150g
Resting	5 minutes
Shaping	Long or round shape
Final fermentation	90 minutes / 30°C
Eggwash	Optional
Baking (Rotative oven)	12 to 20 minutes depending on size 180°C / Steam (if no eggwash)



Matlouh



Algeria - Nordine B.

Matlouh or Matlouaa is a bread from the Maghreb region (Algeria ; Morocco ; Tunisia).

The Algerian MATLOUH or Moroccan BATBOUT is one of these breads that incorporate semolina, like the galette. Simple to make, they are traditionally baked in a tajine dish or pan, with no added fat. A soft and tasty table bread, which can be eaten sweet or savory, at any time of the day and is traditionally served during the month of Ramadan. Personally, I prefer to eat this bread with honey & melted butter for breakfast.

Formula

Ingredients

Wheat flour	900g	90%
Wheat semolina	100g	10%
Total flour	1 000g	100%
Water	700g	70%
Sel	13g	1,3%
Oil	20g	2%
Instant dry yeast Saf Instant® Red	20g	2%
Honey	10g	1%
Total	1 763g	

Process

Mixer type	Spiral
Basic T°	68°C
Mixing	Low 3 + high 5
Final dough T°	26°C +/- 1°C
1st fermentation	60 minutes
Dividing	200g
Resting	20 minutes
Shaping	Flaten by hand
Cutting	Before fermentation
Proofing	60 minutes / 28°C / 75% RH
Topping	Semolina
Baking	In a stove





Pide



Pide is a traditional Turkish bread. It has a very ancient history as it dates back to very old times. It is a very important element in the Ottoman cuisine. It has the irreplaceable taste of Iftar and Sehri hours in the month of Ramadan. When the pide smells come out, there is a queue at the bakery and the pides are sold as soon as they come out. This adventure continues until iftar time every day for a month.

Formula

Ingredients

Wheat flour	1 000g	100%
Water	700g	70%
Salt	15g	1,5%
Compressed Yeast Ozmaya®	30g	3%
Improver Pulso® Ces3	1g	0,10%
Total	1 746g	

Process

Mixer type	Spiral
Basic T°	50°C
Mixing	Low 3 + high 10
Final dough T°	22°C +/- 1°C
1st fermentation	15 minutes
Dividing	550g
Shaping	Rounding
Resting	40-45 minutes
Shaping	Pide (manual shaping)
Final fermentation	30 minutes / 30°C / 80% RH
Topping	Sesame seeds
Baking (Deck oven)	15 minutes / 250°C / Steam

Simit



Turkey - Sezgin D.

Simit is a traditional Turkish bread which is covered with grape molasses and sesame. It can be found in different shapes and textures all around the Middle East and Balkans.

It is a very simple recipe, but still offers a magical taste, and remains an irreplaceable part of Turkish breakfast. Interesting thing, seagulls really love it.

Formula

Ingredients

Wheat flour	1 000g	100%
Water	500g	50%
Compressed yeast Ozmaya® standard	25g	2,5%
Salt	20g	2%
Improver Pulso® Ces 3	1g	0,1%
Total	1 546g	

Dipping solution

70% grape molasses
+ 30% water

Topping

sesame

Process

Mixer type	Spiral
Basic T°	55°C
Mixing	Low 3 + high 6
Final dough T°	24°C +/- 1°C
Dividing	2x55g
Resting	5 min
Shaping	<i>Halka simit: shaping it into sticks. Stretch, combine both sticks, rotate them around each other and fold the dough in two. Bring the ends together and shape them into a bagel</i>
Topping	Dip in molasses solution then in sesame seeds
Final fermentation	30 minutes / 30°C / 80% RH
Baking (Deck oven)	15 minutes / 185°C / Steam





Injera



Halfway between bread and pancake, injera is a bread made with Tef flour (local cereal). It is used as a «fork» in Ethiopian meals. This bread is very acidic. It takes several days for the dough to reach the acidity needed to make it, and is cooked in a pan like a crepe. It can either be made at home or by a few specialists who sell it on the street.

Formula

Ingredients

Sourdough

Teff sourdough	1 500g	100%
Water	1 500g	100%
Starter Livendo® LV4	5g	0,33%
Total	3 005g	

Process

Mixing:	Mix starter with flour, then add water at 35°C
Sourdough fermentation	15 hours / 35°C

Formula

Ingredients

Dough

Teff sourdough	3 005g	100%
Water	1 500g	50%
Total	4 505g	

Process

Mixer type	Planetary mixer
Preparation & mixing	After adding the water to the sourdough from the day before and mixing well, take 20% of the preparation (here 900g). Heat this preparation to 70°C, until the starch gelatinizes. Leave to cool, then reincorporate into the rest of the preparation.
Final fermentation	2 hours / 35°C
Weighing	300g
Baking	Cook in a 30cm diameter oiled pan. Cook for 5 minutes on one side, then remove from the heat and cover for 1 minute.
Cooling	Remove from the pan and cover the products well to prevent drying

Arabic Bread

(pita)



Pita (Arabic Bread) originated from the Middle East, and it is known to be the oldest type family of yeast-leavened round flatbreads baked from wheat flour. It has been existing for around 4,000 years now. The name "pita" simply means "flatbread" and Greeks were the first people to use that term. Arabic bread is known by the following names: khubz, shami, mafrood, burr, Beiruti, Lebanese, pita, and pocket. Due to habits and culture, Arabic bread can be eaten with a large variety of dishes. It is also used for many traditional fast-food wraps like falafel and shawarma.

Formula

Ingredients

Wheat flour	1 000g	100%
Water	480g	48%
Salt	2g	0,2%
Instant dry yeast Saf Instant® Red	6g	0,6%
Sugar	30g	3%
Total	1 518g	

Process

Mixer type	Spiral
Basic T°	64°C
Mixing	Low 6 + high 1
Final dough T°	30°C +/- 1°C
Resting	40 minutes / 30°C
Dividing	80 g
Pre-shaping	Rounding
Relaxing	15 minutes
Shaping	Flatten in pita of 26 cm diameter
Final fermentation	10 minutes
Baking (Deck oven)	280°C / 30 seconds each side





Asia Pacific & China

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Mantou



China - Eric Y.

It is impossible to imagine how Chinese would survive without steamed bread in their daily life. Northern or Laomian steamed breads are one of the best choices for every meal. Dipped in condensed milk, Southern style steamed bread is a wonderful dim sum for tea-time. Needless to say, fried, baked or steamed, Mantou is an essential food for midnight snack. Whenever you are hungry, you can eat steamed bread in all sorts of ways without any health concerns. So, just enjoy it!

Formula

Ingredients

Northern mantou

Medium gluten wheat flour	1 000g	100%
Instant dry yeast Danbaoli®	6g	0,6%
DBL® Master improver	3g	0,3%
Water	480g	48%
Total	1 489g	

Process

Mixer type	Spiral
Basic T°	66°C
Mixing	Low 5 + High 3
Final Dough T°C	25°C +/-1°C
Relaxing	5 minutes / Ambient T°
Sheeting	Ten times in dough brake
Dividing	60g
Shaping	Round ball
Proofing	45 minutes / 38% / 80% RH
Steaming	10-12 minutes / 98-100%
Package	Cooling until product core T° = 25 +/- 3%

Formula

Ingredients

Southern mantou

Low gluten wheat flour	1 000g	100%
Instant dry yeast Danbaoli®	10g	1%
Lesaffre Industrie® Blended enzymes 0410 improver	3g	0,3%
Danbaoli® Baking Powder	10g	1%
Sugar	150g	15%
Water	420g	42%
Total	1 593g	

Process

Mixer type	Spiral
Basic T°	66°C
Mixing	Low 5 + High 3
Final Dough T°C	25°C +/-1°C
Relaxing	5 minutes / Ambient T°
Sheeting	Ten times in dough brake
Shaping	Long shaping, 4 cm diameter, cut with knife
Dividing	50g
Proofing	45 minutes / 38% / 80% RH
Steaming	10-12 minutes / 98-100°C
Package	Cooling until product core T° = 25 +/- 3%





Sweet Filled Buns



Thailand - Nigel S.

Without a doubt, sweet breads are the most popular product in most South-East Asian countries. A sweet dough recipe can vary in sugar and fat levels depending on the country and eggs can sometimes be added. Apart from the most common fillings such as chocolate and strawberry, each country will have their own specialty. Pandan in Singapore/Malaysia and Ube in the Philippines. Most industrial bakeries produce these packaged.

Formula

Ingredients

Dough			
Wheat flour	1 000g	100%	
Water	410g	41%	
Eggs	120g	12%	
Salt	7g	0,7%	
Sugar	200g	20%	
Instant dry yeast Saf Instant® Gold	20g	2%	
Improver Magimix® Green	5g	0,5%	
Milk powder	20g	2%	
Butter	180g	18%	
Total	1 962g		

Filling The fillings are either custard, red bean, or any sweet flavored fillings.
Salty fillings can also be used like curry, or spicy meat fillings.

Process

Mixer type	Spiral
Basic T°	60°C
Mixing	Low 3 + High 3 + Butter + Low 3 + High 3
Final dough T°	35 +/- 1°C
1st Fermentation	-
Dividing	50g
Shaping	Round
Resting	10 minutes
Lamination	Flatten the ball
Filling	Place the filling in the middle
Shaping	Seal dough and smoothen out in a round shape
Final fermentation	90 minute / 40°C / 75% RH
Egg wash	Before baking
Baking (Rack oven)	15 minutes / 150°C

Sumsum Porridge

with Bobba Toppings



Sumsum porridge is a traditional Indonesian sweet dessert made by cooking rice flour in coconut milk and palm sugar syrup. It is well known and appreciated by Indonesians. We combine this famous dessert with bread and modernize it with pearl bobba topping. This really delicious bread holds a touch of local pride which makes you want to eat more and more.

Formula

Ingredients

Dough

Strong wheat Flour	1 000g	100%
Water	370g	37%
Sugar	200g	20%
Instant Dry yeast	11g	1,1%
Saf Instant® Red		
Improver Ibis® Blue	10g	1%
Improver Baker's Bonus® A	5g	0,5%
Salt	15g	1,5%
Milk powder	30g	3%
Butter	100g	10%
Cold Liquid Milk	100g	10%
Egg Yolk	100g	10%
Total	1 941g	

Filling

Rice Flour	100g	10%
Coconut Milk	1 000g	100%
Salt	10g	1%
Bubble tea pearls	500g	50%
Total	1 610g	

Process

- *Sumsum Porridge process:**
1. Heat coconut milk from one whole coconut.
 2. Put the rice flour and mix it until smooth.
 3. Stir over with low heat until thick.
- | | |
|-----------------------|---|
| Mixer type | Spiral |
| Basic T° | 56°C |
| Mixing | Low 4 + High 8 |
| Final dough T° | 25 +/- 1°C |
| Resting | 10 minutes |
| Dividing | 15g |
| Shaping | Flatten the dough as disk of 12 cm of diameter |
| Put in a tartlet mold | |
| Final fermentation | 120 minutes / 28°C / 85 %RH |
| Baking
(Deck oven) | 15 minutes / 180°C |
| Filling | Add Sumsum porridge on center* of the bread |
| Topping | Pour the bubble tea pearls sauce on top and pearls on topping, serve it warm. |



Shokupan



Japan - Jean-Louis B

Shokupan is an adaptation from the original loaf bread but with a much longer process. Shokupan in French is: «*pain du repas*». It is said that the first shokupan was invented by a British baker - Robert Clarke, back in 1862 when he opened his own bakery in the city of Yokohama, the 'Yokohama Bakery'. The name has since been changed to 'Uchikipan' Bakery in 1888 (*the shop still exists*). After WW2, importing of American flour began. 'Uchikipan' Bakery started nationwide expansion through school lunches. Shaping of shokupan is in a loaf and can be done either closed or open lid (open top is also called 'Pan Mountain').

Formula

Ingredients

Strong wheat flour	1 000g	100%
Water	700g	70%
Salt	20g	2%
Sugar	60g	6%
Milk powder	30g	3%
Butter	60g	6%
Instant dry yeast Saf Instant® Red	8g	0,8%
Improver Ibis® Yellow	1g	0,1%
Total	1 879g	

Process

Mixer type	Spiral
Basic T°	55°C
Mixing	Low 5 + High 4 + butter + Low 2 + High 2
Final dough T°	28°C +/- 1°C
1st fermentation	60 minutes
Dividing/Rounding (depending on tin size)	250gr
Resting	15 minutes
Shaping	Elongated shape
Resting	5 minutes
Shaping	Second pass through the shaper lengthwise, with maximum spacing between the lengthening rollers (to avoid flattening the snail shape)
Place 2 to 6 dough pieces (depending on the size of the mould), with the spiral turned as shown in the photo	
2nd fermentation	70 minutes / 38°C
Baking (deck oven)	30 minutes / 210°C





Ube Cheese Pan De Sal



If you walk into any bakery in the Philippines, I'm definitely sure that they will be selling Pan de Sal (meaning «salt bread»). It is a staple yeast-raised bread that originates back to the 16th century, when the Spanish colonized the Philippines. Pan de sal is not a salty bread as it is translated but rather it is a sweet, pillowy and versatile Filipino-style roll covered with breadcrumbs. One can eat pan de sal anytime of the day, either dipped in coffee or chocolate, with filling and even ice-cream. Variations of this bread have also emerged like the malunggay pan de sal and the now trending ube-cheese pan de sal. Ube cheese pan de sal is flavored with purple yam (or ube flavor) filled with ube jam (or ube halaya) and cheese. It is so good... you won't want to stop eating it!

Formula

Ingredients		
Wheat flour	1 000g	100%
Water	550g	55%
Ube Flavor	30g	3%
Salt	15g	1,5%
Milk powder	20g	2%
Shortening	70g	7%
Sugar	120g	12%
Instant dry yeast Saf Instant® Gold	11g	1,1%
Improver Magimix® Yellow	5g	0,5%
Total	1 821g	

Filling	
Ube Halaya	300g
Quickmelt cheese (ex. white cheddar)	250g

Topping	
Breadcrumbs	250g

Process

Mixer type	Spiral
Basic T°	50°C
Mixing	Low 5 + High 7
Final dough T°	25 +/- 1°C
1st Fermentation (in an oiled container)	60 minutes
Punch dough and transfer it on an oiled table	
Dividing	30-40g
Resting	5 minutes
Shaping	Flatten the ball
Filling	Place 20-30g ube halaya and 1 cube of cheese (20g) at the center
Shaping	Seal dough and smoothen out in a round shape
Final fermentation	28°C / 45 minutes until double in size
Topping	Roll out in breadcrumbs and line up in a pan
Baking (Rotative oven)	180°C / 20 minutes until golden brown



Mixed Grain Bread



I love mixed grain bread for its delightful blend of flavours and textures. This hearty loaf combines various grains like wheat, oats, barley, and seeds, creating a symphony of tastes in every bite. The diversity of grains offers a complex and nutty profile. Mixed grain bread is a nutritional powerhouse, packed with fibre, vitamins and minerals, making it a wholesome choice for daily consumption. Its slightly chewy crust and soft interior provide a satisfying contrast, making it ideal for both sandwiches and toast.

Formula

Ingredients

Wheat flour	1 000g	100%
Water	550g	55%
Grain soaking water	420g	42%
Linseeds	210g	21%
Sunflower seeds	210g	21%
Salt	18g	1,8%
Compressed Yeast	30g	3%
Improver Fermex® Point 5W	5g	0,5%
White vinegar	15g	1,5%
Wheat gluten	8g	0,8%
Milk powder	60g	6%
Water (addition 2)	110g	11%
Total	2 636g	

Process

Mixer type	Spiral
Pre-soak Grains	60 minutes
Basic T°	65°C
Mixing	Low 2 + High 8
Water Addition 2	Low 1 + High 4
Final dough T°	28°C +/- 1°C
1st fermentation	5 minutes
Dividing	650g
Resting	10 minutes
Moulding	Loaves in tin
Final fermentation	90 minutes / 38°C
Baking (deck oven)	45 minutes / 230°C



Banh Tieu



Similar to Banh Mi straight from the oven, Banh Tieu are the best straight out of the fryer. They are lighter and chewier than a doughnut. The sesame seeds add just the right touch. We call them «the Vietnamese doughnut» and they are excellent with coffee.

Formula

Ingredients

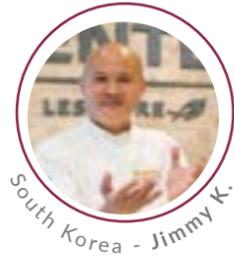
Flour	1 000g	100%
Water	650g	65%
Eggs	50g	5%
Salt	12g	1,2%
Sugar	200g	20%
Instant Dry yeast Saf Instant® Gold	12g	1,2%
Improver Magimix® Green	5g	0,5%
Baking powder	10g	1%
Butter	80g	8%
Total	2 019g	

Process

Mixer type	Spiral
Basic T°	64°C
Mixing	Low 2 + High 5
Final dough T°	28°C +/- 1°C
1st fermentation	5 minutes
Dividing	60g
Resting	15 minutes
Moulding	Round flat with sesame
Final fermentation	90 minutes / 30°C
Frying	2 minutes / 170°C



Korean Garlic Cream Cheese Bread



I love this creation. It is said to be a street food in Korea and has become very popular lately after a viral video made it to the media. Sweet and salty, a good balance of flavour. The pairing of cheese, garlic along with the aroma of the butter and herbs makes this bread WOW for me. The crumb texture of the bread, slightly dense, helps to hold the shape after the second baking. Best served 10 to 30 minutes after baking with a cup of coffee.

Formula

Ingredients

Dough

Bread Flour	1 000g	100%
Water	550g	55%
Salt	15g	1,5%
Milk powder	30g	3,0%
Shortening	70g	7%
Sugar	150g	15%
Instant Dry yeast	11g	1,1%
Saf Instant® Gold		
Improver Magimix® Red	4g	0,4%
Total	1 830g	

Filling

Cream cheese, softened	226g
Sugar	50g
Heavy Cream	120g

Topping

Melted butter	228g
Whole egg	110g
Milk	10g
Parsley	8g
Minced garlic	20g
Parmesan cheese (optional)	100g

Process

Mixer type	Spiral
Basic T°	64°C
Mixing	Low 5 + Fat + High 5
Final dough T°	24' +/- 1°C
Resting	5 minutes
Dividing	100g
Final Fermentation	27°C/45-60 minutes until double in size
Egg wash	Before baking
Baking (Deck oven)	180°C / 15 to 20 minutes
Cooling	Let it cool
Cutting	Cut baked rolls into 6-8 wedges (do not cut all the way)
Filling	Mix all filling ingredients, transfer into a piping bag, set aside
Topping	Add parsley and minced garlic
Baking (Deck oven)	5 minutes / 180°C





Central & Eastern Europe

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Corn Bread



Slovakia/Croatia - Marko B.

Characteristics: Yellow, crispy on the outside, soft on the inside, tasty, aromatic and little sweet. It goes well with all sweet and salty food. Corn bread has a high content of vitamins and minerals, a large amount of fiber and low calories.

Formula

Ingredients

Wheat flour	700g	70%
Extruded corn flour	300g	30%
Total flour	1 000g	100%
Water	560g	56%
Compressed yeast Fala®	30g	3%
Salt	18g	1.8%
Gluten	15g	1,5%
Improver Magimix® Royal	5g	0,5%
Total	1 628g	

Process

Mixer type	Spiral
Basic T°	60°C
Mixing	Low 3 + High 8
Final dough T°	27°C +/- 1°C
1st fermentation	20 minutes
Dividing	550g
Resting	10 minutes
Shaping	Rounding
Final fermentation	45 minutes (upside down)
Baking (Deck oven)	220°C / 25 minutes / Steam



Vánočka



Czech Republic/
Austria/Slovakia
Stanislav K.

Vánočka is named after Vánoce (which means Christmas in Czech). It is a typical sweet product and very famous in Central Europe. It is said that its shape resembles little Jesus wrapped in a blanket. You can find it in every Czech bakery. Originally it was baked during Christmas time but now it is popular during the whole year. With butter (maybe with jam on top of it) and coffee, it is the best breakfast ever! Taste of roasted almonds outside and raisins inside remind me of Christmas all year round.

Formula

Ingredients

Strong wheat flour	1 000g	100%
Water	350g	35%
Sugar	170g	17%
Butter	120g	12%
Eggs	50g	5%
Raisins	100g	10%
Milk powder	30g	3%
Compressed Yeast Perfekta® Gold	50g	5%
Salt	14g	1,4%
Improver Soft'n Fresh® HT	20g	2%
Total	1 854g	

Process

Mixer type	Spiral
Basic T°	56°C
Mixing	Low 10 + High 6
Final dough T°	27°C +/- 1°C
1st fermentation	30 minutes
Dividing	3 x 200g
Shaping	3 braided brioche
Final fermentation	55 minutes / 26°C
Eggwash	Before baking
Baking (Deck oven)	170°C / 30 minutes

Borodinsky



Russia - Vitaly L.

Borodinski bread is a Russian trademark. The appearance of this bread is surrounded by many legends. Officially, the name «Borodinski Bread» appeared in 1933. Originally, the bread was baked on the hearth, weighing around 2 kg. Its formula included 100% rye flour, malt, sugar, salt and spices (cumin, aniseed). Over time, the formula evolved a little. From the 1940s to the present day, this bread is baked in molds and cumin and aniseed were permanently replaced by coriander. Borodinski bread is a true embodiment of rich taste and aroma. The moderate acidity of the bread is complemented by a light sweetness and a discreet aroma of coriander. It can be eaten for breakfast, lunch or dinner. Sliced, it is perfect to make sandwiches.

Formula

Ingredients	Sourdough	Zavarka	Sponge	Dough	Total
Rye flour	180g	100g	260g	260g	80%
Wheat flour				150g	15%
Rye malted flour		50g			5%
Salt				10g	1%
Starter Livendo LV5®	1,8g				0,18%
Water	180g	300g	130g	220g	83%
Sugar				60g	6%
Molasse (syrup)				40g	4%
Coriander in powder		5g			0,5%
Zavarka			455g		
Sourdough			361,8g		
Sponge				1 206,8g	
Total	361,8g	455g	1 206,8g	1 946,8g	194,7%

Process

Mixer type	Spiral			
Mixing	Low 10 + High 1			
Final T°C	28±0,5°C	64±0,5°C	29±0,5°C	28-30°C
Fermentation	24 h	3 to 3,5 h	3 to 3,5 h	1 h
Dividing	510g			
Shaping	in tins			
Topping	Coriander seeds on the top			
Final fermentation	50-60 minutes / 35°C			
Baking	30-35 minutes / 190°C			

Zavarka :
Add boiling water to all the ingredients of the zavarka step. Mix it well until the zavarka T° reaches about 65°C. Leave it for 3,5 hours at ambient T°C.

Sourdough :
Mix starter with water at 35°C. Let it rest for 5 minutes. Than add flower and then mix.



Buckwheat Bread



Buckwheat bread has recently become very popular in Ukraine. Firstly, Ukrainians love buckwheat and they grow buckwheat widely, and secondly, Ukrainians like a strong and pronounced taste of bread. That's what this buckwheat bread has. Moreover buckwheat grain crop benefits are undeniable and contain a great variety of vitamins and microelements. Soft, aromatic, with a crispy dark golden crust, this vitamin-rich bread is also valued as a product with unique nutritional properties.

Formula

Ingredients

Wheat flour	850g	85%
Roasted buckwheat flour	150g	15%
Total flour	1 000g	100%
Water	640g	64%
Zavarka Inventis® «Multigrain»	150g	15%
Compressed yeast Record red®	20g	2%
Salt	12g	1.2%
Sugar	20g	2%
Dried onion	1g	0.1%
Improver Magimix® Light Blue	10g	1%
Sunflower oil	30g	3%
Total	1 883g	

Process

Mixer type	Spiral
Basic T°	50°C
Mixing	Low 5 + High 7
Final dough T°	25°C +/- 1°C
1st fermentation	20 minutes / Ambient
Dividing	670g
Pre-shaping	Rounding
Resting	10 minutes
Shaping	In basket
Final fermentation	50 minutes / 35°C
Baking (Deck oven)	30-40 minutes / 240 to 200°C / Steam



Baltonowski



BALTONOWSKI BREAD is one of the most popular types of light bread on our tables. It owes its name and origin to the region, that is the area of the Baltic countries. The recipe is a typical bread recipe, with all the usual ingredients - wheat flour, rye sour dough, water, rye flour, yeast, salt. There is not a single unnecessary addition here. Depending on the region, it may slightly differ in composition or ratio of wheat and rye flour. Baltonowski bread is produced based on sourdough, a mixture of rye flour and water that has been fermented. Thanks to this, it obtains a better aroma and taste and is suitable for consumption longer. This bread is eaten with virtually all meals.

Formula

Ingredients

Wheat flour	700g	70%
Rye Flour	300 g	30%
Total flour	1 000g	100%
Water	640g	64%
Compressed yeast Perfekta®	30g	3%
Salt	20g	2%
Improver Top Fresh®	10g	1%
Devitalized Sourdough Livendo® Ritesa	8g	0,8%
Total	1 708g	

Process

Mixer type	Spiral
Basic T°	55°C
Mixing	Low 7 + High 5
Final dough T°	28°C +/- 1°C
1st fermentation	20 minutes
Dividing	580g
Pre-shaping	Rounding
Resting	10 minutes
Shaping	Loaf shape
Final fermentation	45-60 minutes
Cutting	Before baking
Baking (<i>Deck oven</i>)	220°C / 25-35 minutes / Steam



Fehér kenyér



This white wheat bread is the most popular for consumers in Hungary. It is a big loaf, normally 1KG, but also available with 500gr weight. It can be fresh or sliced and packed with 3 days shelflife. This product cannot be made without the combination of fresh yeast and sourdough. It has a light acidity level, thin but crispy crust, soft and fluffy crumb. We like sandwiches made with this bread but it can be a side dish for traditional meals like stew, goulash and others as well.

Formula

Ingredients

Sourdough

Wheat flour Type T800	194g	100%
Water (35°C)	106g	55%
Starter Livendo® LV2	0,9g	0,46%
Total	300g	

Process

Mixer type	Spiral
Basic T°	70°C
Mixing	Low 5
Final sourdough T°	28°C +/- 1°C
Sourdough fermentation	16 hours / 24°C

Formula

Ingredients

Dough

Wheat flour Type T800	1 000g	100%
Water	600g	60%
Compressed yeast Budafok®	20g	2%
Salt	20g	2%
Improver Magimix® brown	3g	0,3%
Sourdough from 1st step	300g	30%
Total	1 943g	

Process

Mixer type	Spiral
Basic T°	62°C
Mixing	Low 4 + High 3
Final dough T°	24°C +/- 1°C
1st fermentation	45 minutes
Dividing	500g
Pre-shaping	rounding
Resting	10 minutes
Shaping	Loaf bread
Final fermentation	50 minutes / 28°C / 80% RH
Baking (deck oven)	230°C / 35 minutes / Steam





Latin America

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Marraqueta



Chile - Gabriela P.

I like Marraqueta because it is a traditional bread and you can find it from North to South, but the center of the country is the place where the best is made. Chileans love bread and Marraqueta, whether for its shape, taste, attractive golden color, crunchiness and freshness. It is light & fluffy, it accompanies all our meals - breakfast, lunch and dinner. Only 4 ingredients are enough to prepare it: flour, water, salt and yeast, plus the baker's expertise. Whatever the filling - cheese, butter, avocado, jam, chorizo, pebre - it is part of our Chilean identity.

Formula

Ingredients

Wheat flour	1 000g	100%
Water	580g	58%
Salt	20g	2%
Improver Masas Francesas®	4g	0,4%
Compressed Yeast Lefersa®	20g	2%
Total	1 624g	

Process

Mixer type	Spiral
Basic T°	60°C
Mixing	Low 4 + High 6
Final dough T°	25°C +/- 1°C
1st fermentation	10 minutes
Dividing	100g
Resting	10 minutes
Shaping	<i>Spread the surface with flour, use a floured rolling pin and flatten each dough longitudinally, resulting in 4 parts joined together</i>
2nd fermentation	Upside down / 90 minutes / 26°C / 85% RH
Baking (deck oven)	210°C / 18 minutes / Steam



Concha



Mexico - Betzabé L.

The concha is one of the most representative and beloved sweet breads in Mexico for its shape, flavor and the many ways it can be eaten; making it one of my favorite breads. Whether day or night, I really like to accompany my coffee or hot chocolate with a sweet bread and if it is a shell, even better, because I like to dip it in my hot drink and put the piece in my mouth... Oh, what a delicious experience! I also really enjoy eating the shells stuffed with chilaquiles or with cream and strawberries. Alone or with a filling, the shell is the best.

Formula

Ingredients

Dough

Strong wheat flour	1 000g	100%
Water	350g	35%
Eggs	200g	20%
Instant dry yeast		
Saf Instant® Gold	15g	1,5%
Salt	10g	1%
Improver Pluspan®	5g	0,5 %
Sugar	270g	27 %
<i>(Half the sugar delayed after 1st speed)</i>		
Butter	200g	20 %
<i>(End of mixing)</i>		
Total	2 050g	

Pasta topping

Vegetal fat	220g
<i>(Mix shortening + Margarine)</i>	
Sugar	225g
Wheat flour	230g

Process

Mixer type	Spiral
Basic T°	52°C
Mixing	Low 4 + High 8 + Butter + Low 5 + High 1
Final dough T°	27 +/- 1°C
Fermentation	45 minutes / 28°C / 70 % RH
Dividing	65g dough + 20g pasta topping for each pieces
Shaping	Rounding + fat on the top + pasta topping
Proofing	75 minutes / 35°C / 70% RH
Baking	15 minutes / 180°C
<i>(Rotative oven)</i>	





Medialuna



Argentina - Viviana Z.

Medialunas, those golden and fluffy delights, are the true jewel of Argentina bakery! You can find them everywhere! From cafes and bars, to the aisles of neighborhood supermarkets and bakeries.

When to enjoy them? The answer is simple: always! But let me tell you a secret: the ones that really make the difference are the ones that have good quality butter. For me, the ideal time is when I gather friends and family on a sunny afternoon or on weekends. There, we share laughter, stories and anecdotes, while we enjoy medialunas and traditional Argentina talks.

Formula

Ingredients

Strong wheat flour	1 000g	100%
Milk	320g	32%
Shortening	30g	3%
Salt	20g	2%
Instant dry yeast Saf Instant® Gold	12g	1,2%
Eggs	150g	15%
Sugar	200g	20%
Vanilla	5g	0,5%
Honey	10g	1%
Total	1 747g	
Butter (lamination fat)	500g	50%

Process

Mixer type	Spiral	
Basic T°	55°C	
Mixing	Low 3 + High 9	
Final dough T°	24°C +/-1°C	
Resting	5 minutes	
Incorporation of lamination fat		
x3	Sheeting	1 single fold
	Resting	40 minutes / 5°C
	Lamination	3,5 mm
Cutting	9 x 12 cm (50grs/60grs)	
Shaping	Croissant	
Final fermentation	120 minutes / 26°C / 70% RH	
Eggwash	before baking	
Baking (rotative oven)	180°C / 15 minutes	
Brushing	Brush over the hot medialuna with syrup	

Panettone



Whether with its typical black raisins and candied fruits or with delicious chocolate chips, Panettone has always held a special place in Peruvian culture, as it is a symbol of family unity, mainly at Christmas time. Choosing which Panettone to buy among the different varieties, flavors and presentations is usually complicated. However, it all comes down to the following question: what attributes do consumers appreciate? Externally we look for a good size, with a cylindrical shape and a brown/golden dome. Internally, a long strand or crumb, usually yolk yellow in color, airy in appearance, soft in texture and with a fruity aroma.

Formula

Ingredients

Sponge

Strong wheat flour	1 000g	40%
Water	620g	62%
Sugar	40g	4%
Improver Nucleo® panetonero	10g	1%
Instant dry yeast Saf Instant® Gold	18g	1,8%
Total	1 688g	

Process

Mixer type	Spiral
Basic T°	68°C
Mixing	Low 5 + High 5
Dough T°	25°C +/- 1°C
Resting	90 minutes / 35°C / 80% RH

Formula

Ingredients

Dough

Strong wheat flour	1 500g	60%
Sponge	1 688g	112,5%
Improver Nucleo® panetonero	135g	9%
Egg yolk	180g	12%
Calcium propionate	3,6g	0,24%
Sugar	480g	32%
Water	720g	48%
Shortening	150g	10%
Butter	240g	16%
Panettone flavor	12g	0,8%
Dry raisins	510g	34%
Candied fruits	510g	34%
Total	6 128,6g	

Process

Mixer type	Spiral
Basic T°	72°C
Mixing	Low 20
Final dough T°	28°C +/- 1°C
Dividing	950g
Pre-shaping	Rounding
Resting	20 minutes
Shaping	Rounding
Final fermentation	3 hours / 35°C / 85% RH
Baking	120°C 10 minutes and 140°C 45 minutes
Cooling	Upside down just after baking





Sopaipilla



When talking about sopaipillas, it is impossible not to be impregnated with evocations of moments full of the warmth of home, of smiles and friendship. This typical bread from Chile (of Arabic origin) is a guest of honor in every house at the moment the first drops of rain fall on any day of the year... just that sign is enough to immediately go buy flour, butter, yeast, pumpkin and of course the corresponding fraction of block sugar to sweeten the end of the ritual. Sopaipillas and tea... a tasty banquet in any home!

Formula

Ingredients

Wheat flour	1 000g	100%
Water	450g	45%
Compressed yeast Lefersa®	25g	2,5%
Shortening or margarine	60g	6%
Salt	20g	2%
Optional : bread improver	4g	0,4%
Optional : cooked pumpkin	150g	15%
Total	1 709g	

Process

Mixer type	Spiral
Basic T°	56°C
Mixing	Low 4 + High 6
Final dough T°	24°C +/- 1°C
Resting	10 minutes
Lamination	0,5 to 1 cm
Shaping	Cut in round pieces
Final fermentation	20 minutes / Ambient
Frying	180°C / 3-4 min each side

Pan de Muerto



Sugar heart, poem to the bread of the dead

Kneaded with ingredients of Spanish origin, he has a Mexican soul for a heart. Awaited each year and rightly so, It is a pillar of such colorful tradition. Bread with soft and spongy crumbs, Its fragrant perfume is like orange blossom. Sugar or sesame, you are crowned with shins and bones, Being a delicacy for the living and the dead.

It is together with mole, tequila and mezcal, living tradition in the world without equal! Icon of the Day of the Dead and All Saints, everyone is amazed by its flavor and charms. Standing out among the chopped paper, the marigold flower and the incense. When November approaches I think of you. My dear bread of the dead.

Formula

Ingredients

Wheat flour	1 000g	100%
Sugar	250g	25%
Margarine	180g	18%
Improver Pluspan®	10g	1%
Instant dry yeast Nevada® Oro	20g	2%
Salt	20g	2%
Egg	380g	38%
Milk	170g	17%
Nut	100g	10%
Total	2 130g	

Process

Mixer type	Spiral
Basic T°	53°C
Mixing	Low 3 + High 11 + nuts + Low 3
Final dough T°	29°C +/- 1°C
Resting	20 minutes / Ambient
Dividing	200gr for main ball + 20 gr for each branch + 10gr for small top ball
Shaping	Round shape for main and top ball + shape each branch as shown on the picture
1st fermentation	45 minutes / 28°C / 85% RH (Main ball)
Shaping	Add each branch on the top of the main ball + add the top ball
Final fermentation	45 minutes / 28°C / 85% RH
Egg wash	Before baking
Baking (deck oven)	35 minutes / 200°C
Finishes	Dip the brioche in melted butter, dip in the sugar





North America

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Sandwich Bread



In the United States, sandwich bread is one of the most popular items on the bakery shelf and is a main staple for many diets. Beyond just being a common household food, sandwich bread was also one of the first products that was industrialized in the 1920's and 1930's.

Often sandwich bread is used as a carrier for many different types of sandwiches or it can be eaten as individual slices that are toasted for breakfast.

Over the years, sandwich bread has evolved from the classic white to specialty types that might have seed inclusions or honey as the source of sugar.

Formula

Ingredients

Wheat flour	1 000g	100%
Milk	275g	27,5%
Water	275g	27,5%
Salt	18g	1,8%
Sugar	60g	6%
Compressed yeast Red Star®	30g	3%
Butter	150g	15%
Saf Pro® Softness 3.1+V	2,5g	0,25%
Total	1 810,5g	

Incorporation

Squid ink	25g
-----------	-----

Process

Basic T°	50°C
Mixer type	Spiral
Mixing	Low 3 + High 8
Final dough T°	23°C +/- 1°C
Incorporation	Take 900g of paste and mix it with the squid ink
1st fermentation	60 minutes / 24°C / 80% RH
Dividing	900g plain dough + 900g colored dough
Pre-shaping	Rounding
Resting	20 minutes
Shaping	<i>Degas the 2 pieces of dough in the rolling mill. Stack them, then roll them up. Cut the sausage in two lengthwise and braid it</i>
Final fermentation	90 minutes / 28°C / 80% RH
Baking (deck oven)	60 minutes / 170°C



Bagels



United States - Peter A.

Bagels, the ubiquitous bread roll introduced to the world by Jewish bakers from Poland, are fascinating. Their explosion from a food primarily of the Jewish diaspora to mainstream staple; their production method, as one of the very few doughs that are cooked twice; and the speed at which a skilled bagel maker can shape them are all intriguing. But what's more intriguing than any of that? Eating them! Make mine a fresh, untoasted, New York everything bagel with cream cheese, lox, capers, and red onion. That and a cup of coffee make the perfect Sunday breakfast.

Formula

Ingredients

Wheat flour	1 000g	100%
Water	500g	50%
Salt	20g	2%
Compressed yeast Red Star®	25g	2,5%
Sugar	30g	3%
Vegetable oil	40g	4%
Devitalized dry sourdough Livendo® S400	20g	2%
Improver Ibis® Top Green	10g	1%
Total	1 645g	

Process

Mixer type	Spiral
Basic T°	62°C
Mixing	Low 3 + High 5
Final dough T°	24°C +/- 1°C
1st fermentation	20 minutes / Ambient
Dividing	80g
Resting	0 minutes
Shaping	bagels
Final fermentation	40 minutes / 35°C / 80% RH
Boiling	2 minutes in boiling water
Topping	sesame seeds
Baking (deck oven)	20 minutes / 230°C





Buns



Buns, Buns, Buns... what is there not to like about Buns...!! Sweet or savory, ...livendo, or glazed ; -as long as they're Tasty!! Love me some buns!! Brioche, chocolate, whole grain or plain, love me some buns, toasted, different, delicious the same...!! Hamburger, hot dog, cinnamon or sweet. Scrumptious as always. Great to eat...!! Japanese milk bread, keeps me well fed... Best is warm with butter and honey just before bed. I like big buns and I can't deny...!! Baby got Buns...!!

Formula

Ingredients

Sponge	Wheat flour	1 200g	100%
	Water	648g	54%
	Compressed yeast Red Star®	60g	5%
	Saf Pro® Yeast Food 3.1	3g	0,25%
	Total	1 935g	

Process

Prefermentation	Mixer type	Spiral
	Basic temperature	62°C
	Mixing	Low 5
	Dough T°	25°C +/- 1°C
	Fermentation	3 hours / 26°

Formula

Ingredients

Dough	Wheat flour	800g	100%
	Water / Ice (dough)	552g	69%
	Compressed yeast Red Star®	24g	3%
	Gluten	24g	3%
	Sugar	240g	30%
	Shortening	144g	18%
	Calcium propionate	8g	1%
	Salt	36g	4,5%
	Saf Pro® Softness 3.1+V	8g	1%
	Sponge	1 935g	242%
Total	3 771g		

Process

Basic T°	62°C
Mixing	Low 3 + High 6
Final dough T°	26°C +/- 1°C
1st fermentation	5 minutes
Dividing	65/90g
Shaping	Rounding
Last fermentation	70 minutes / 38°C
Spread surface with	water
Topping	sesame seeds
Baking (deck oven)	9 minutes / 240°C / Steam

Crackers



American crackers first came into existence in Newburyport Massachusetts - or so the history goes - in the bakery of Theodore Pearson in 1792. Fresh bread was not easy to buy in North America, and there was need for a type of bread which provided a shelf life of many months and traveled well with pioneers and sailors. Today there are three basic crackers in North America: soda crackers, graham crackers and sprayed snack crackers. We hope you enjoy our soda cracker recipe.

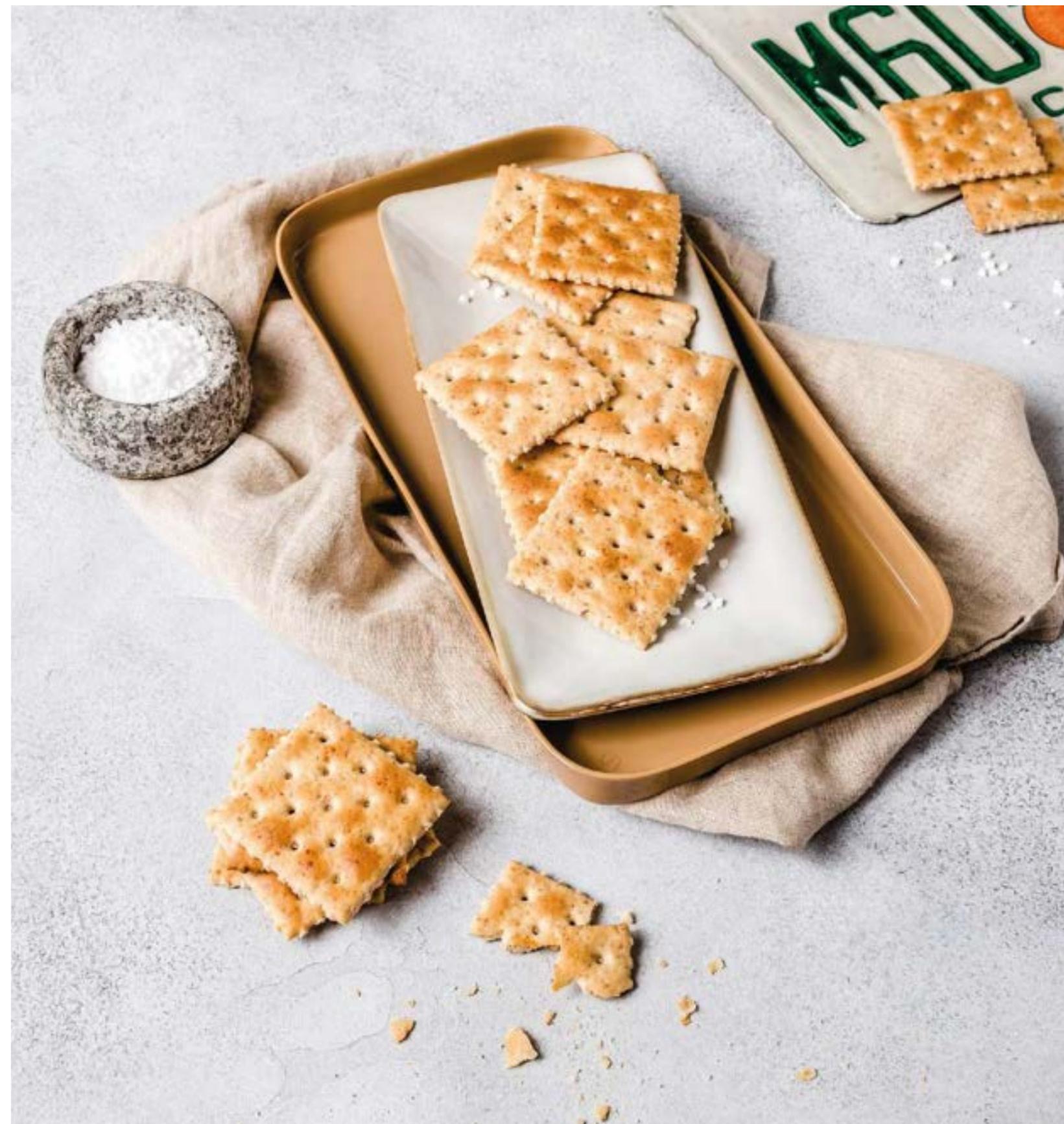
Formula

Ingredients

Sponge	Whole Wheat Flour <i>(extra fine milled)</i>	650g	65%
	Instant Dry yeast Saf Instant® Red	3g	0,3%
	Saf Pro® Yeast Food 3.1	0,3g	0,03%
	Citric Acid	1g	0,1%
	Alpha Amylase	0,01g	0,001%
	Water (30°C)	370g	37%
	Total sponge	1 024,3g	
Dough	Whole Wheat Flour <i>(extra fine milled)</i>	350g	35%
	Sea Salt	20g	2%
	Baking Soda	4,4g	0,44%
	Devitalized yeast Saf Pro® Relax 200	1g	0,1%
	Shortening	140g	14%
	Total	1 539,71g	

Process

Mixer type	Spiral
Mixing - Sponge	Dry Ingredients 30 seconds + Add water + Low 3'30 + water + Low 3'30
Sponge fermentation	18 hours / 25° C
Mixing - Dough	Dry Ingredients 30 seconds + sponge & shortening + Low 1 + High 3
Sheeting (in mm)	
Step 1:	Sheet the crackers at 16 mm, 8 mm, 6 mm
Step 2:	Fold crackers into a tri-fold
Step 3:	Sheet the crackers at 16 mm, 8 mm, 6 mm
Step 4:	Fold crackers into a tri-fold and then turn 90 degrees
Step 5:	Sheet the crackers at 12 mm, 10 mm, 8 mm
Step 6:	Turn the crackers 90 degrees + sheet crackers at 4 mm, 3 mm, 2 mm, 0.5 mm
Baking	205°C / 3 minutes / impingement oven 95°C / 15 to 18 minutes / rotative oven
	Target moisture 2-3 % Final <i>(adjust temperature and baking time accordingly)</i>



Donuts



A doughnut or donut (the simplified spelling invented in the 1920's) is a sweet snack made from leavened fried dough. Why I like donuts is because they bring big smiles to people all over the world.

Donuts are popular in many countries and come in a variety of forms such as rings, filled spheres, twists and balls. In America, we enjoy ring-shaped yeast-risen, cake and old-fashioned donuts accompanied with coffee or milk. Once fried, donuts are glazed with icing or chocolate or topped with cinnamon, powdered or granulated sugar. They can be topped with coconut, chopped nuts or sprinkles.

Formula

Ingredients

Wheat Flour	1 000g	100%
Water	540g	54%
Instant dry yeast		
Saf Instant® gold	13g	1,3%
Inventis® Premix donut	150g	15%
Shortening	100g	10%
Baking powder	15g	1,5%
Total	1 818g	

Process

Mixer type	Spiral
Basic T°	65°C
Mixing	Low 4 + High 3
Final dough T°	25°C +/- 1°C
1st fermentation	25 minutes
Lamination	1 cm
Resting	5 minutes
Dividing	35g
Cutting	Donut shape with cookie-cutter
Final fermentation	55 minutes / 35°C
Frying	60 seconds each side / 190°C





Western Europe

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Tradition Baguette



Recently listed as a World Heritage Site by UNESCO, the Baguette de Tradition Française is a world-renowned emblem of our country. With just flour, yeast, water, salt, a long fermentation and ancestral know-how, we obtain a unique product with a crispy crust and a soft crumb. Buying bread is a real social and heart-warming habit that punctuates French life. My pleasure: cut the baguette lengthwise and spread a light layer of butter with a thin slice of white ham - the French art of living!

Formula

Ingredients

Wheat flour <i>(without additive)</i>	1 000g	100%
Water	670g	67%
Salt	17g	1,7%
Compressed yeast Hirondelle® bleue	7g	0,7%
Total	1 694g	

Process

Mixer type	Spiral
Basic T°	55°C
Autolysis	30 minutes
Mixing	Low 3 + High 5
Final dough T°	25°C +/- 1°C
1st fermentation	16 hours / 5°C
Dividing	350g
Resting	90 minutes
Shaping	Baguette shape 45 cm
Final fermentation	45 minutes / 24°C
Cutting	5 cuts
Baking <i>(deck oven)</i>	22 minutes / 250°C / Steam



Pretzel



Germany - Andreas G.

How did the pretzel come about? In 1477 the Urach baker Frieder was sentenced to death for embezzlement. The Count of Urach promised him pardon if he baked bread within three days through which the sun would shine three times. Inspired by his wife's entwined arms, Frieder invented the shape of the pretzel. When I was 9 years old, I was in the bakery for the first time and was allowed to help make pretzels. Later I brought the pretzels to people in a wicker basket. Even today, with its smell and taste, it is still one of the best bread in our bakeries.

Formula

Ingredients

Strong wheat flour	1 000g	100%
Water	500g	50%
Salt	25g	2,5%
Compressed yeast Fala®	50g	5%
Margarine	50g	5%
Milk powder	50g	5%
Dyastasic Malt	3g	0,3%
Total	1 678g	

Process

Mixer type	Spiral
Basic T°	52°C
Mixing	Low 3 + High 6
Final dough T°	24°C +/-1°C
1st fermentation	10 minutes
Dividing	80g
Resting	15 minutes
Shaping	50 cm + twist
Final fermentation	30 minutes / 28°C
Freezing	20 minutes / -20°C
Dip in soda	40g soda + 1,5L water
Baking (deck oven)	10 to 12 minutes / 230°C





Pan Candéal



Let me introduce «La Fabiola», a long loaf of bread from Palencia, with a thin crust and tight white crumb, made by Campillo and Mendiguchía baker families.

In 1960, King Baudouin of Belgium married Fabiola de Mora y Aragón, a Spanish aristocrat, an event which was widely covered by the media in Spain at the time. To celebrate this marriage, a group of women from Palencia came up with the idea of this commemorative bread, which now has a large presence in Castilla-León.

Formula

Ingredients

Wheat flour	1 000g	100%
Water	470g	47%
Salt	18g	1,8%
Improver Pulso® Proa	5g	0,5%
Liquid acidifier Livendo® AF200L	3g	0,3%
Devitalized dry sourdough Livendo® BD100	12g	1,2%
Compressed Yeast Hirondele® 1895	25g	2,5%
Total	1 533g	

Process

Mixer type	Spiral mixer
Basic T°	65°C
Mixing	Low 3
Dough Brake	6 minutes
Final dough T°	24°C +/-1°C
Dividing/scaling	350g
Resting/relaxing	10 minutes
Molding/Shaping	Batard
Cutting	Polka cut
Proofing	90 minutes / 26°C / 85% RH
Baking (rack oven)	200°C / 30 minutes / Steam

Hot Cross Bun



United Kingdom - Sofiane H.

Although there are many variations today, the traditional hot cross buns are the ones that contain raisins and spices. Originally, we eat it at Easter but ultimately, I like to eat it all year round! It is best eaten hot, or cut in half and grilled, with butter or marmalade.

Formula

Ingredients

Dough	Strong wheat flour	1 000g	100%
	Water	620g	62%
	Compressed yeast DCL Craft Bake® High Activity	40g	4%
	Salt	15g	1,5%
	Sugar	100g	10%
	Gluten	20g	2%
	Shortening	100g	10%
	Improver Fermex® Point 5W	10g	1%
	Golden/Dark raisins	250g	25%
	Cinamon powder	8g	0,8%
Total	2 163g		
Crossing mix	Wheat Flour	150g	75%
	Corn flour	50g	25%
	Total flour	200g	100%
	Water	150g	75%
	Oil	50g	25%
	Baking powder	12,5g	6,25%
Total	412,5g		

Process

Mixer type	Spiral
Basic T°	65°C
Mixing	Low 3 + High 6
Final dough T°	26°C +/-1°C
1st fermentation	10 minutes
Dividing	80g
Pre-shaping	Round
Resting	5 minutes
Shaping	Round
Final fermentation	90 minutes / 32°C / 80% HR
Pipe with a piping bag the crossing mixture before baking	
Baking (<i>deck oven</i>)	10 minutes / 220°C
Brush over the top of the warm buns with syrup	





Pizza Romana (Pinsa)



Pizza romana is surely the must-have product of the moment. This pizza, made with a highly hydrated dough (85%), is very crispy. It is a traditional product that has been made by Rome's bakers for a long time, and is now a worldwide must. It is usually eaten with freshly cut mortadella, but it can also be found with more elaborate toppings such as pesto, grilled vegetables, salmon, cod, truffles and many others.

Formula

Ingredients

Wheat flour	1 000g	100%
Water	850g	85%
Compressed yeast L'hirondelle®	10g	1%
Salt	22g	2,2%
Improver Ibis® Blue	10g	1%
Devitalized Dry sourdough Livendo® F100	10g	1%
Total	1 902g	

Process

Mixer type	Spiral
Basic T°	45°C
Mixing	Low 3 + High 15
Final dough T°	25°C +/- 1°C
1st fermentation	60 minutes
Dividing	800g
Resting	0 minute
Shaping	Long shape
Final fermentation	min.2 hours / 28°C / 80% HR
Shaping	On a well-floured table, make impressions in the same way as for focaccia and stretch the dough.
Baking (deck oven)	12 to 15 minutes / 245°C

Tsoureki



Tsoureki is a Greek traditional sweet bread, that is made by Greeks during the whole year. It is rich in butter and sugar and very tasty with notes of different spices like mahlepi, mastic et cardamom. It is considered as Easter bread, Christmas bread or New Year's Eve bread. It is also consumed in Turkey, Armenia and other Middle Eastern countries.

Formula

Ingredients

Strong wheat flour	1 000g	100%
Water	300g	30%
Eggs	140g	14%
Compressed Yeast L'hirondelle® Gold	60g	6%
Salt	15g	1,5%
Sugar	300g	30%
Butter	380g	38%
Greek spices (mastic, mahlep, cardamom)	5g	0,5%
Liquid sourdough Livendo® Deluxe	50g	5%
Improver Ibis® Red	5g	0,5%
Total	2 255g	

Process

Mixer type	Spiral mixer
Basic T°	50°C
Mixing	Low 5 + High 6 + Butter + Low 6 + High 2
Final dough T°	28°C +/- 1°C
1st fermentation	60 minutes
Dividing	250g
Resting	15 minutes
Shaping	2 braided brioche
Final fermentation	90 minutes / 30°C / 85% HR
Egg wash	Before baking
Baking (Deck oven)	35 minutes / 180 °C





Danskt Rågbröd



Denmark - Anna G.

In my region, specially Denmark, this bread has a strong tradition back in history, but even today. The Rågbröd exist at both retail and craft bakeries, it is very popular since it is healthy with high amount of wholegrain - but at the same time tastes full in respect of the sourdough content. But it is mostly famous connected together with the classic Danish 'Smørrebrød'. This means Rågbröd served with salmon, scrimps and other nice toppings as a meal. It is very delicious, I would say.

Formula

Ingredients

Soaking	Crushed rye	500g	30,7%*
	Sunflower Seeds	250g	15,3%*
	Millet seed	110g	6,7%*
	Devitalized dry sourdough Livendo® S400	140g	8,6%*
	Water	1 100g	67,5%*
*The percentages of the soaking mix are based on the total flour percentage of the recipe			
Dough	Wheat flour	230g	14,1%
	Rye flour (<i>gentle crush</i>)	1 400g	85,9%
	Total Flour	1 630g	100%
	Water	950g	58,3%
	Compressed Yeast Zymarom® FT	60g	3,7%
	Improver Pulso® Firmita	15g	0,9%
	Liquid dark malt	40g	2,5%
	Salt	50g	3,1%

Process

Soaking	Overnight (<i>min. 8 hours</i>)
Mixer type	Spiral
Basic T°	72°C
Mixing	Low 3 + High 12 (<i>with soaking mixture</i>)
Final dough T°	35°C +/- 1°C
Resting	30 minutes
Brush the baking table with water	
Dividing	500g
Shaping	In tin
Add seeds on the top of the breads	
Final fermentation	60 minutes / 35°C / 80% RH
Baking (<i>deck oven</i>)	240 to 190°C / 40 minutes / Steam

Liège Waffle



The Liège Waffle, originating in Belgium's Liège city in the 18th century, boasts a simple recipe: flour, milk, eggs, salt, butter, pearl sugar, and yeast. However, its true magic emerges during cooking as the sugar caramelizes, crafting the waffle's signature blend of crispiness and tenderness. Craftsmanship is crucial in its preparation. These waffles can be found on the shelves of local bakeries, artisanal markets, and street-side stalls. The best way to eat a Liege waffle is hot from the cart on a cold winter day, to bite in the crispy exterior and tender interior... heaven!

Formula

Ingredients

Wheat flour	1 000g	100%
Eggs	300g	30%
Milk	300g	30%
Salt	18g	1,8%
Invert sugar	80g	8%
Butter	500g	50%
Pearl sugar	500g	50%
Compressed Yeast Bruggeman®+	80g	8%
Liquid sourdough Livendo® LVBD3000	50g	5%
Mix Ennallin® Malto	4g	0,4%
Total	2 832g	

Process

Mixer type	Spiral
Basic T°	48°C
Mixing	Low 3 + High 5 + Butter + Low 3
Final Dough T°	23°C +/- 1°C
1st fermentation	20 minutes
Incorporation	Pearl sugar
2nd fermentation	60 minutes
Dividing	100g
Shaping	Rounding
Final fermentation	60 minutes
Baking (waffle irons)	3 minutes / 180°C



Ticino Bread



Ticino bread is one of the most popular breads in Switzerland. It has a mild aroma and a fine-pored crumb. It is particularly appreciated because it is so easy to divide. Ideal with savory, as well as sweet bread toppings.

Formula

Ingredients

Wheat flour	1 000g	100%
Water	520g	52%
Compressed Yeast Hirondelle® Blue	30g	3%
Salt	19g	1,9%
Pulso Croustilis® Red	10g	1%
Sunflower Oil	60g	6%
Liquid sourdough Livendo® LVBD3000	50g	5%
Total	1 689g	

Process

Mixer type	Spiral
Basic T°	52°C
Mixing	Low 6 + High 4
Final dough T°	24°C +/- 1°C
1st fermentation	10 minutes
Dividing	5 x 90g
Resting	5 minutes
Shaping	Round, then long
Final fermentation	45 minutes / 28°C / 80% RH
Egg wash	Before baking
Baking (Deck oven)	20 minutes / 220°C





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This recipe book is one of the gifts we have created to mark our anniversary. It perfectly illustrates the richness of our network and invites you to discover all the flavours of our expertise.

40 recipes to celebrate our 50th anniversary, from Baker to Baker!

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Are you a bread lover and curious about foreign cultures? This book is made for you! By flipping through it, you will discover a selection of 40 recipes tested and validated in one of our 50 Baking Center™ facilities around the world.

This book is an opportunity to celebrate the richness and variety of bread, such an important food, but also to pass on to you some of the expertise and passion of our baking technicians.

We hope that by making these recipes, you will enchant and transport everyone who tastes your creations!

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ISBN 978-2-9591152-0-2