

Procedure for Recording Temperature Profiles in a Commercial Oven - Bread

Carry out the steps below in the coolest zone of the oven. If the coolest zone has been pre-determined, then proceed with steps outlined in this document. If the coolest zone is unknown, refer to **Appendix A: Identifying the Coolest Oven Zone** below for guidance.

Step 1: Format the Data Logging Device

- Prepare the data logging device for use by setting to record temperatures at a frequency of every 15 seconds or adjust the time interval as per the baking time.
- Select either °F or °C for recording temperatures; the final calculator is equipped to convert between these values.
- Refer to your device's quick start manual for detailed instructions on preparing your specific logging device.

Step 2: Placement of Data Logger

- Select a strap pan of bread dough that has just completed the proofing cycle and is ready to enter the oven and travel in the cool zone.
- Hold the strap pan for placement of the data logger.
- Place the data logger directly in the center bread loaf position of the strap pan (see Figure 1).
- Stretch the thermocouple wires to the pan placement noted to cover a minimum of one thermocouple per bread loaf space. (see Figure 1)
- Begin by inserting probe 1 in the bread loaf in the farthest left space and working through, probe-by-probe, until reaching the bread loaf in the space to the farthest right.
- For pans containing fewer than 5 loaf positions, place probes in the loaf closest to the center line of the pan and to other loaf positions.
- When inserting the probes, pierce through the top center point of the loaf, being careful to insert the tip of the probe as close to the geometric center of the loaf as possible.

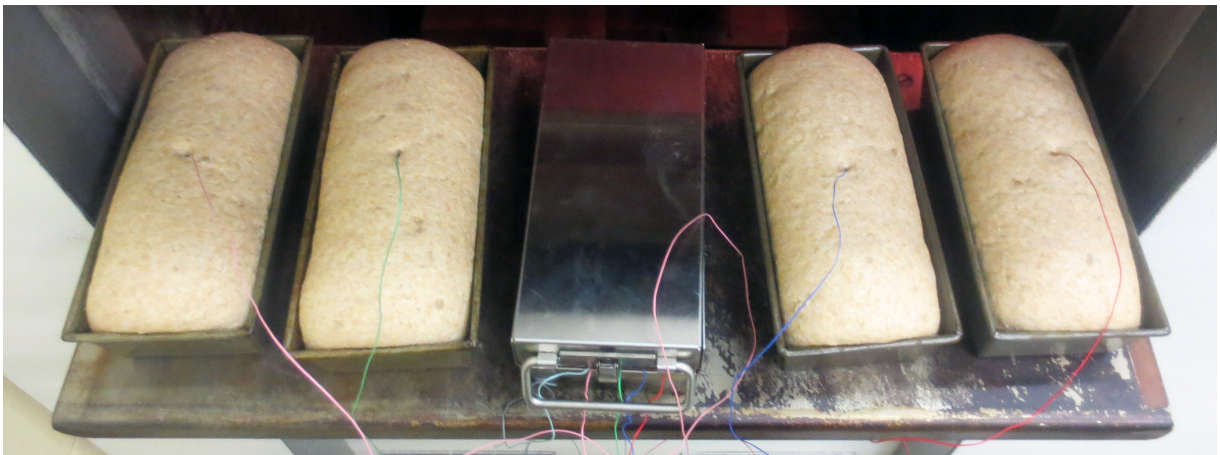
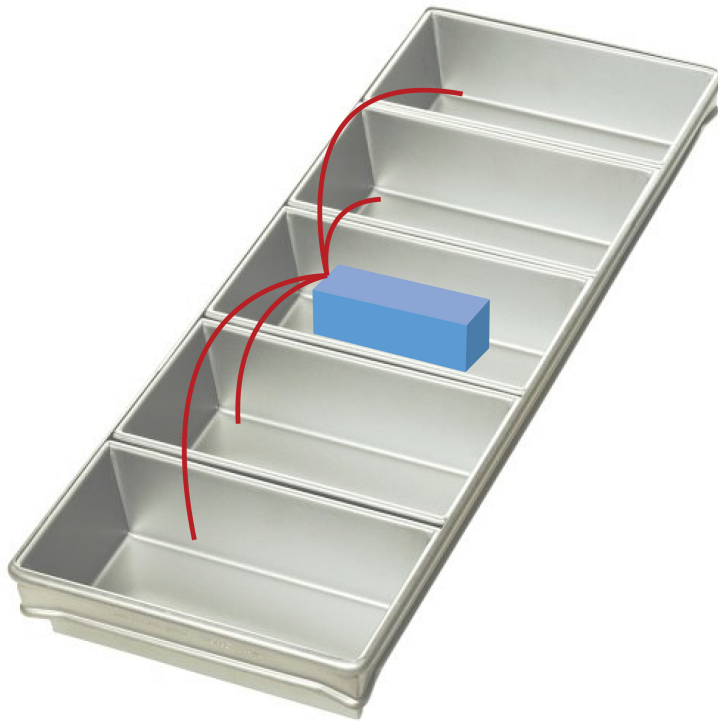


Figure 1

- Once the probes have been set, follow your data logger device's specific procedures to start recording and close the box lid.
- Let the pan continue to travel through the coolest oven zone and retrieve after the baking cycle is complete.
- Follow the device instructions for removing probes and ending recording.
- Download the recorded data to a computer and prepare the data logger for another run.
- Export the data from each run into Excel format and save for later use. For quick reference, save each run under a new tab in the same Excel worksheet.
- Repeat this process until data from a total of five product runs has been recorded.

Step 3: Data Compilation and Oven Validation

- Using the Excel files from the five completed runs, determine which probes took the longest amount of time to reach 170°F (77°C) for each run.

- Converting the Excel data into graphical format allows for easier selection of the coolest probes. In Excel, highlight the entire data series for all six probes, select the **Insert** tab and click on **Insert Line Chart** icon. A graph will display next to the data columns on the worksheet. The lowest line represents the coolest sensor (time along x-axis, temperature along y-axis).
- Copy and paste the column of data for the coolest sensor across all five runs into the appropriate Baking Process Kill Step Calculator tab.

Appendix A: Identifying the Coolest Oven Zone

- Using a data logger, setup a test run following the protocol outlined in Step 2 of the **Procedure for Recording Temperature Profiles in a Commercial Oven**.
- Rather than running five replicates, run three replicates for each position in the oven.
 - Example 1: If there are four lanes of pans, then three replicates will be run at each of the lanes.
 - Example 2: In a revolving oven on Shelf 1 with six pan positions, run three replicates at each of the six pan positions.
- The cool zone would be the position that requires the longest time to reach an internal loaf temperature of 170°F (77°C).
- Data generated from the three runs to determine the coolest oven zone counts toward the total of five runs required for oven kill step validation.

* Note: Temperature data from the selected probes must all fall within a range of +/- 10% of the time to reach 170°F. (i.e. if the average time to 170°F is 9 minutes then the range that all temperatures must be in is +/- 0.9 min. or 8.1-9.9 minutes). If temperatures do not fall within this range corrective action should be taken to modify the baking profile until data falls within this range.