

BISCUIT MANUFACTURING PARAMETERS

PROCESS	PARAMETERS	CHECKER
Raw material & packing material	density,viscosity,protection,moisture content ,color,odour,gsm,bursting strength	Lab officer
Storage of Raw ma	Handling , humidity , temperatures ,palletizing , lights	Store keeper
Ingredients Premixing	Grinding(biscuit,sugar) , weighing ,plasticising , shortening(temp),liquid addition (milk,water)	Mixing man
Dough Mixing	temperature ,Mixing time , order of addition , stages , speed	Mixing man
Dough Forming	temperature , speed , time , web tensions , top up (heat , sugar , milk),gauge rolls speed s,web conditions , dough piece weights , cutter/moulder setting , gap setting ,scrap dough return	Machine Operator
Baking	Dough pieces spacing , band conditions , band preheating , temperature , steeam dampers adjustment ,biscuit dimesions,waste disposal , weight ,size,taste ,	Oven Operator
Cooling	Speed , Temperature , humidity , belt conditions , time	Packing Supervisor
Packing , Wrapping	wrapping m/c lugs setting , speed of packing , temperatures of heater , weights , tolerance , waste measurement ,codes	Packing Supervisor
Cartoning	carton dimensions , strength , variety , packing slips ,weight,pattern of packing	Packing Supervisor
Case Sealing	Manual or Automatic ,speed , tape width , tape strength	Packing Supervisor
Pallet stacking	Pallet size , pack slip , holding bands ,	Logistics Supervisor
Transport and Despatch	Fork lifts , Loading pattern , container size ,load pattern	Logistics Supervisor