

Scoring Line®

- In 2000, MERAND took over Pan'Eiffel, the company manufacturing the Grigne Pains® automatic scorer.
- Since then, MERAND has constantly added new models to what is now its Scoring Line® range of products
- The Scoring Line® range includes all our automatic pre-baking dough piece scoring machines.
- Each machine is specially designed to meet specific requirements in terms of pocket dimensions and number of blade strokes per product.
- The scoring machine can perform diagonal cuts on baguettes, ½-length or 1/3-length baguettes, and straight cuts on rolls.
- The machine is very easy to use and automatic scoring has many advantages, including:
 - Regular scoring, for perfect bread finishes;
 - Time-saving as the grigne Pains scorer can consistently perform up to 1,000 blade strokes per minute.
- A further advantage is that the machine requires no skilled operators, as the only operation involves placing the dough trays in the Grigne Pains machine or on a conveyor belt.



Manual diagonal scoring requires the most skill and takes most time.

Baguettes can often require up to 6-7 blade strokes per dough piece.

Regular scoring is essential for the appearance of the loaves.

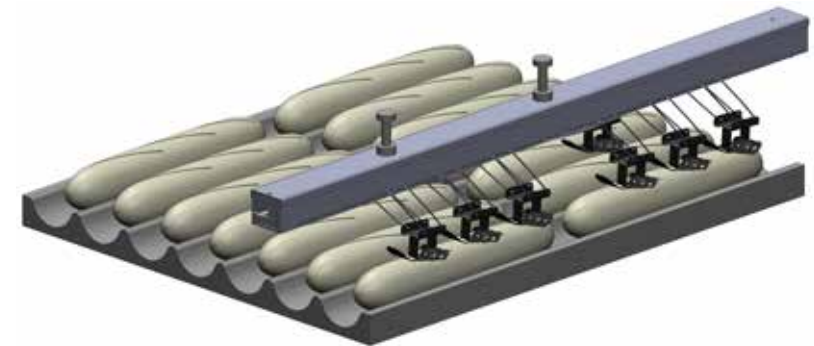
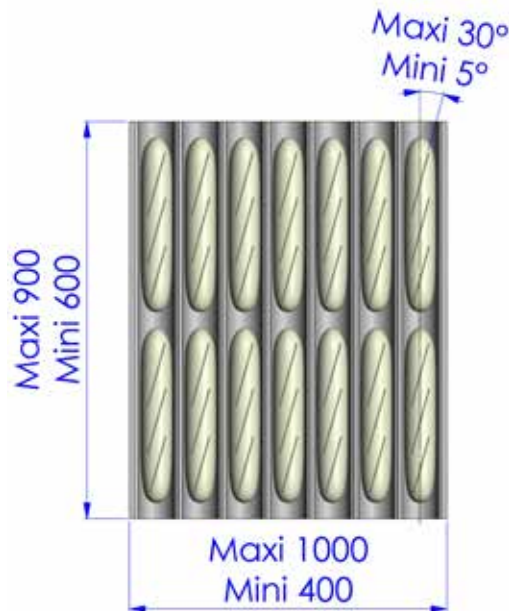
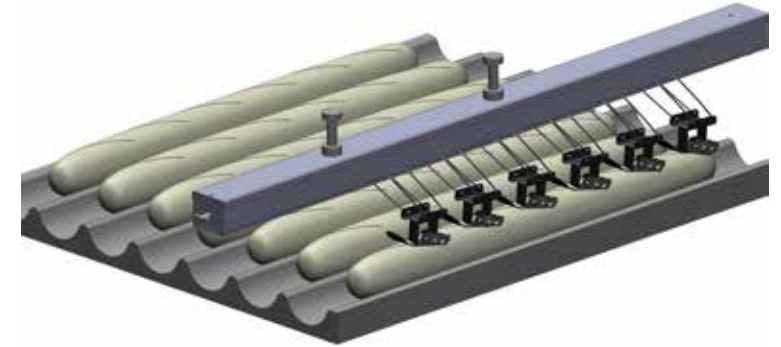
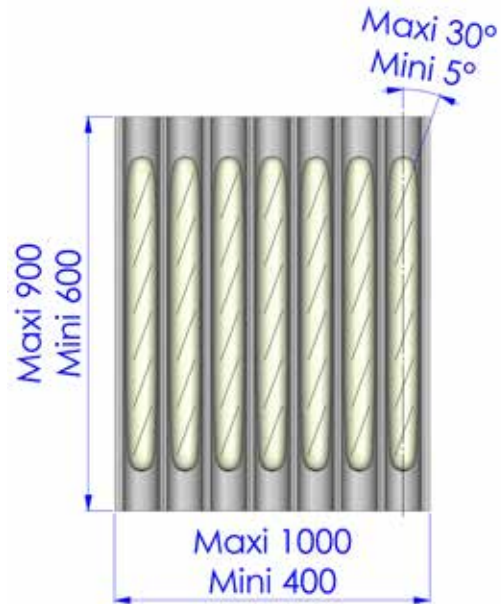
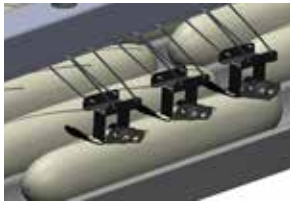
On Scoring Line® machines, diagonal scoring can be performed with standard razor blades.

There are as many blade skates as there are blade strokes per product, and for each tray channel.

This is why the scoring process is so fast.

The scoring skates slide across the dough to ensure proper scoring however irregular the dough pieces may be

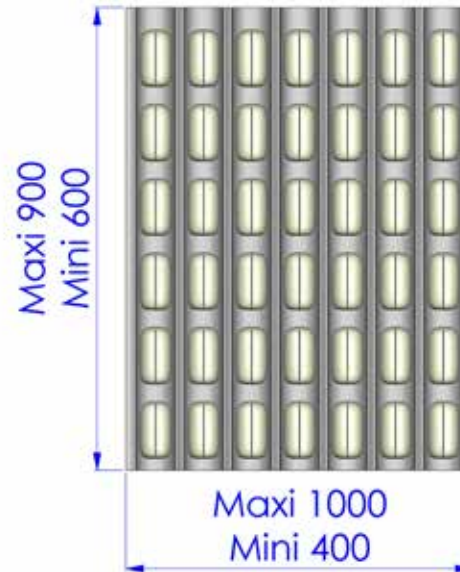
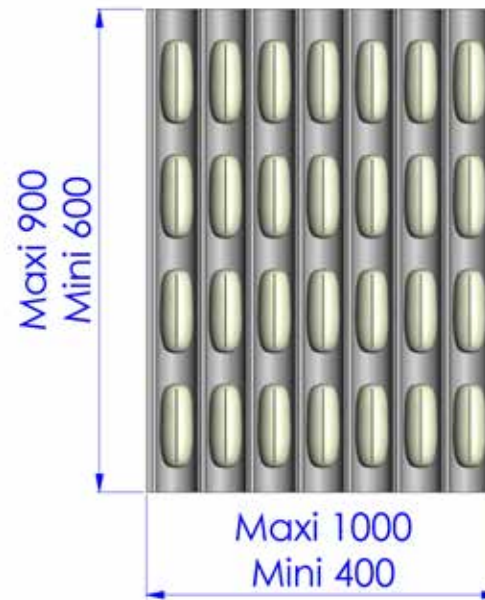
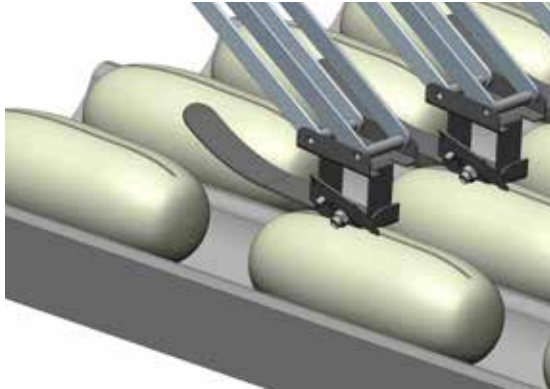
Diagonal scoring can be adapted to full-length, 1/2-length and 1/3-length baguettes



Straight cut scoring is suitable for rolls (1/4-length baguettes and smaller)

There is one blade holder per tray channel

The scoring process starts as soon as the tray is introduced
Straight scoring can also be performed on other types of bread.



The standard Grigne Pains® scorer is entirely made of stainless steel and mounted on brake-fitted castors so it can easily be moved during operation.

The machine is very easy to use: the operator simply takes a tray from the mobile rack after fermentation and introduces it at the top level of the Grigne Pains® scorer.

The skates then slide over the dough pieces and score them before the tray automatically drops down to the lower level to be recovered by the operator.

Using the Grigne pains® scorer eliminates RSIs (repetitive strain injuries) particularly carpien tunnel syndrome (manual scoring requires the wrist to be continually bent)

Scoring can easily be adjusted for each machine by setting:

- Scoring depth
- Scoring angle

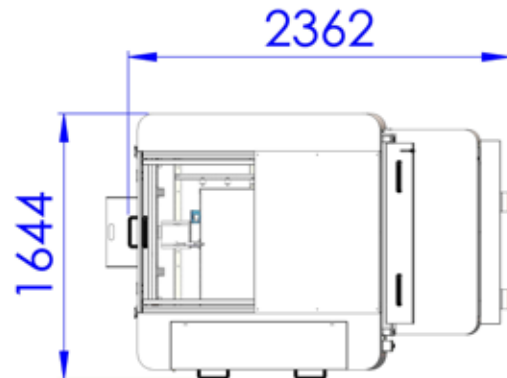
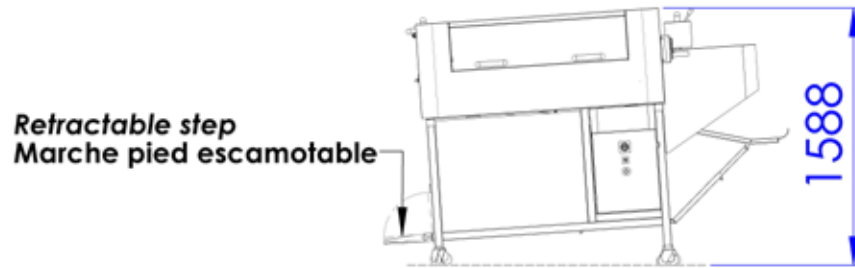
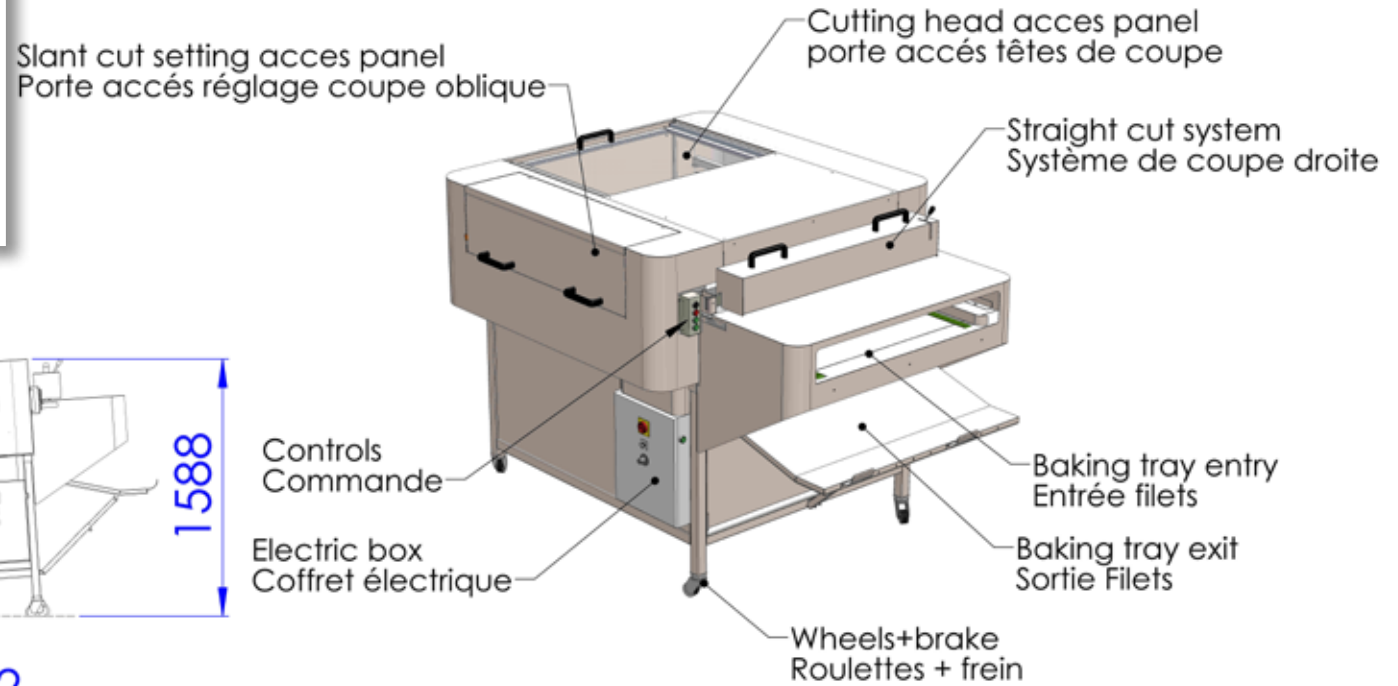


Scoring speed is around 5 seconds per tray (according to how fast the operator can introduce and remove the trays). (up to 1,000 blade strokes/minute)

Straight or diagonal cuts can be selected very quickly on all the models

Automatic cleaning frequency is available as an option: the machine stops after so many strokes, until the operator inserts a foam blade-cleaning tray.

The machine must be connected to the compressed air supply.



When fitted with a conveyor system, the Grigne Pains® scorer works in the same way as with standard system. Only the flows are different.

In this case, the operator takes the trays from the mobile rack and places them one after the other on the conveyor, while another operator recovers the trays at the other end after the scoring process.

The conveyor length can be adjusted according to need, in particular if the trays need to be nearer the baking room.



Fitting the scoring machine with a conveyor and TopSeeds® unit is the ideal configuration when applying seeds on the dough pieces before baking.

It works in the same way as the conveyor system, but with the TopSeeds® unit added upstream to deposit the seeds automatically.

The dough pieces are first sprayed with water by nozzles before the seeds are deposited on the dough pieces in the trays (adjustable flow rate).

The trays then pass under the scoring unit as in the other line configurations. The operator then recovers the trays at the other end of the conveyor.

The TopSeeds® seeding unit can be disengaged so that seeds are not applied on all the trays. The TopSeeds® system can be replaced (or completed) with a dough piece glazing unit.

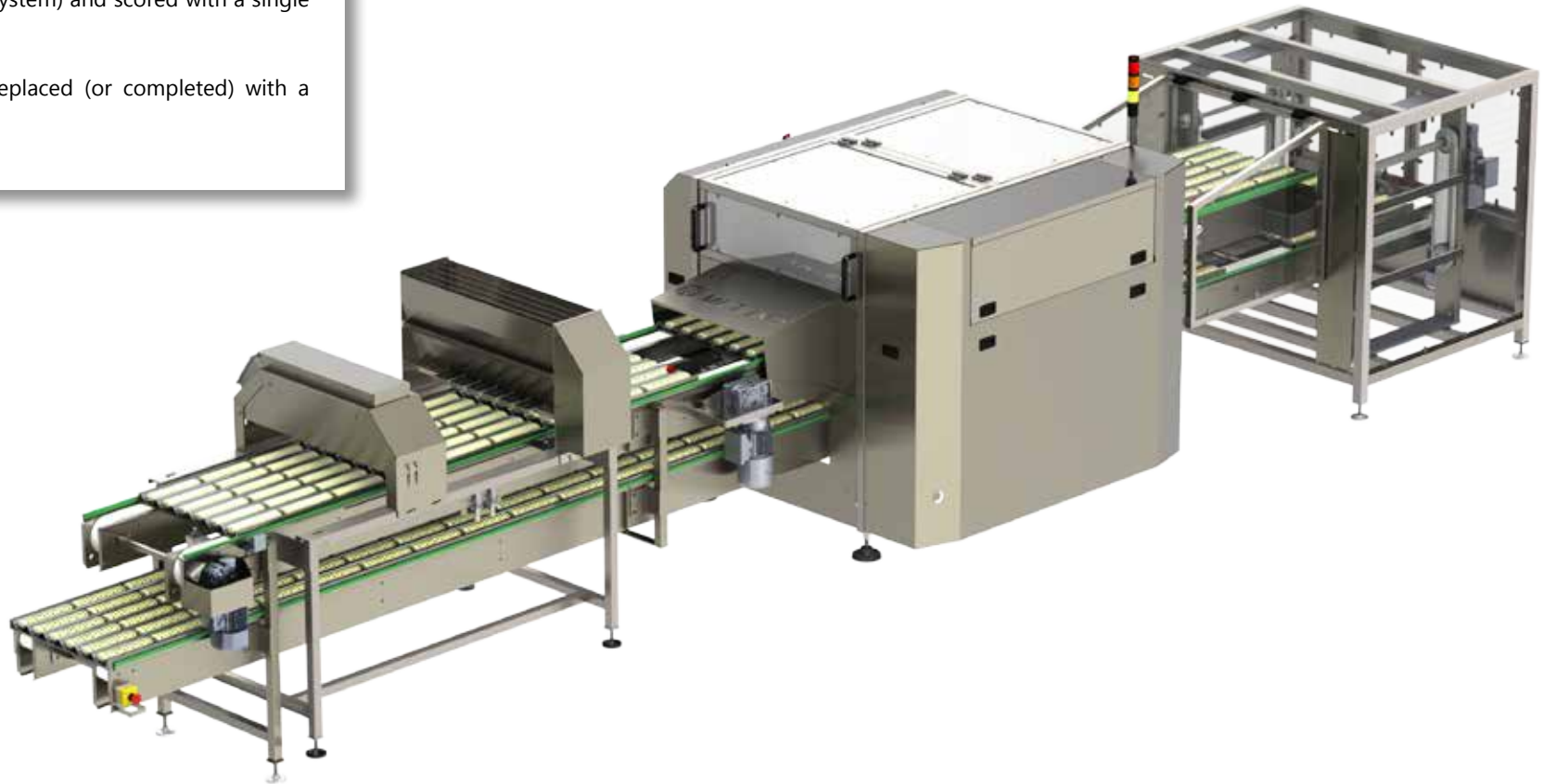


This configuration is identical to the previous one, but instead of requiring two operators, it can be operated single-handedly.

In this system, the conveyor is fitted with an elevator at the rear and with a second conveyor belt beneath the first to return the seeded and scored dough pieces to the operator.

This configuration allows the trays to be seeded as required (with the disengageable TopSeeds® system) and scored with a single operator.

The TopSeeds system can be replaced (or completed) with a dough piece glazing unit.



The ScariCool system is designed to eliminate RSIs (Repetitive Strain Injuries).

There is no longer any need for an operator to insert the trays in the Grigne Pains scorer and to recover them and replace them in the mobile rack.

The ScariCool system performs the scoring operation in parallel with other tasks. The operator simply slots the mobile rack into the machine and walks away.

Once the whole rack has been scored (it takes around 2 minutes per rack), a beeper warns the operator that the rack is ready to be removed and taken to the baking oven.

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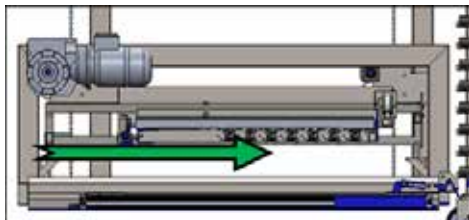
A mobile arm removes each tray in turn from the mobile rack and slides it under the Grigne Pains® scoring unit, which operates as in the standard machine.

The mobile arm then replaces the tray in the rack and removes the next one
The scoring unit rises by one increment and so on until the rack has been entirely processed.

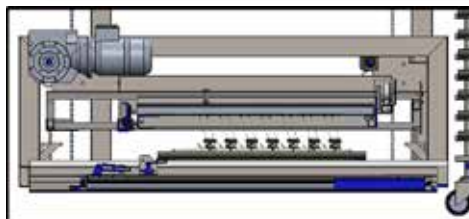
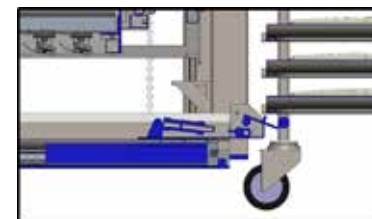
The ScariCool system uses the same scoring units as the standard Grigne Pains® model and does not need robotics.

The cycle time is much faster than with a robot system (around 2 minutes per rack) as there is one scoring unit per tray channel, fitted with as many blades as there are blade strokes on the baguettes.

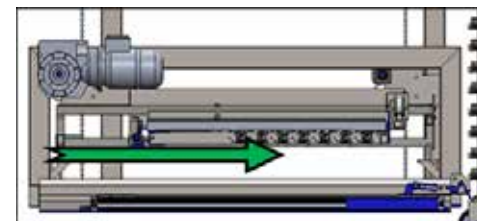
For example, a ScariCool system configured for 12-channel tray racks and 7 blade strokes per baguette, will be fitted with 84 blade holders.



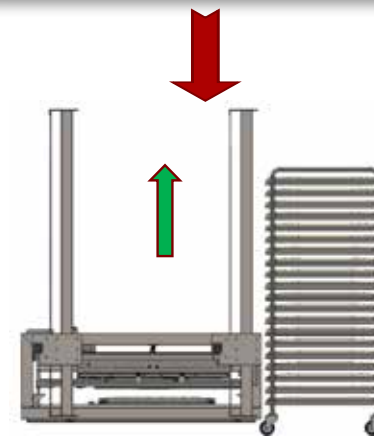
The machine will come take the tray.



The machine will apply the number of cuts wanted on the dough pieces



The machine will put the trays back in place.



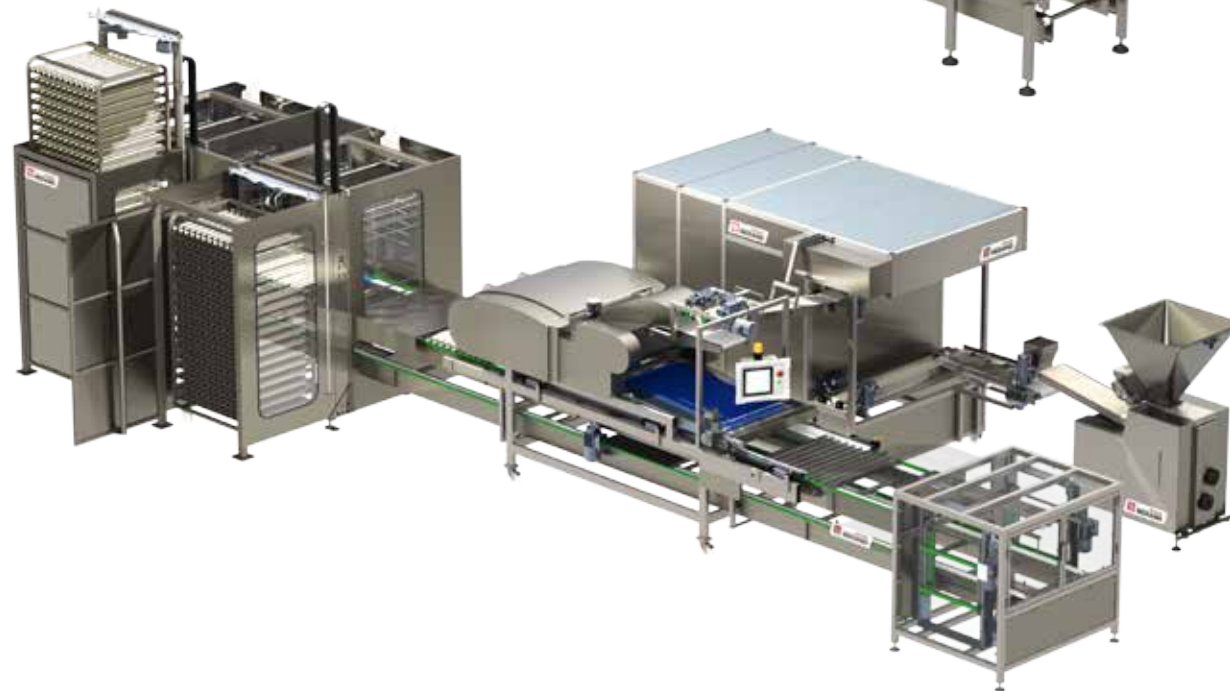
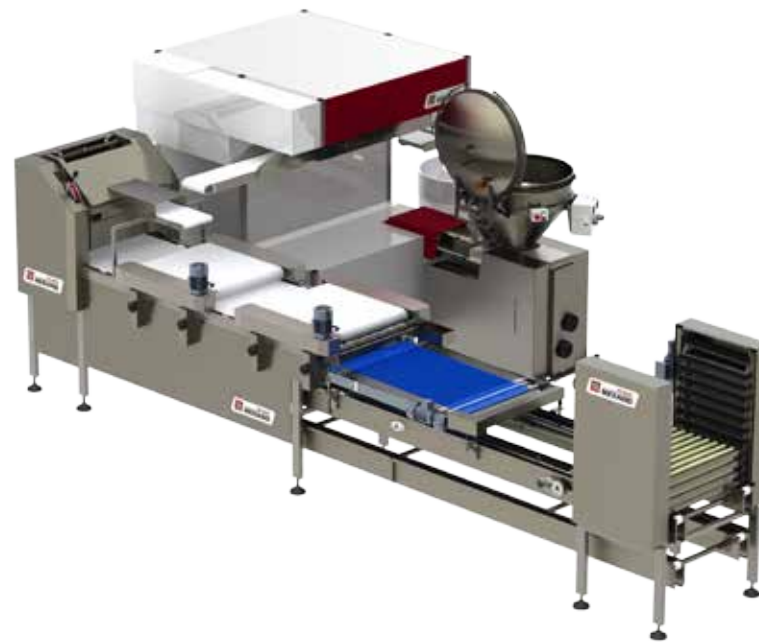
The operation will be repeated until the top of the carriage.

Scoring line range automatic scoring machines are particularly suitable for long loaves like baguettes and part baguettes (1/2;1/3;1/4, etc.) in baking trays.

For information purposes, here are some of our FlexiLine models for the production of baguettes and rolls.

The FlexiLine 1.8 and FlexiLine 2.5 models are designed for high output baguette production while preserving traditional bakery processes and dough quality.

Please contact us for further information on these production lines



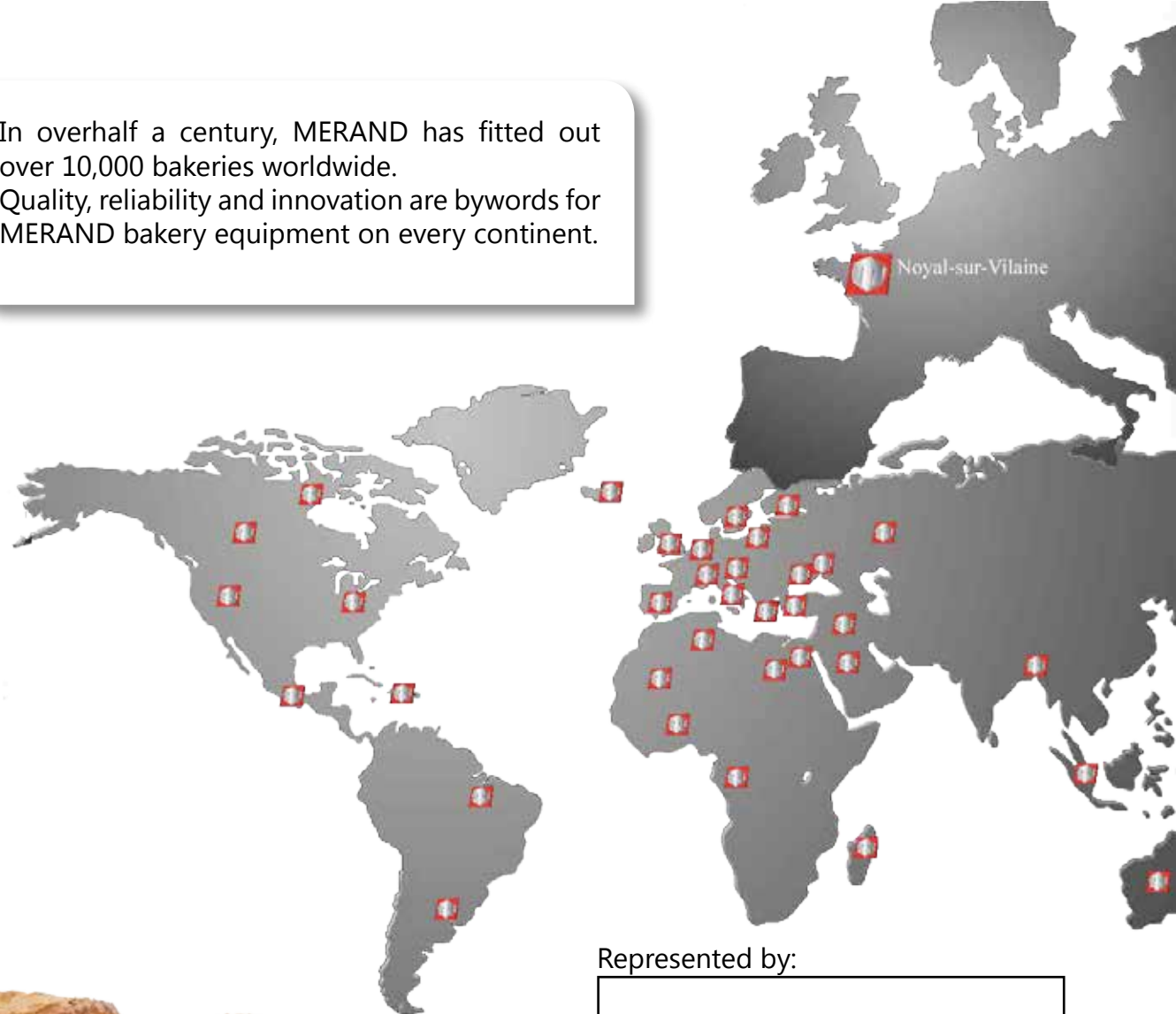


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