



Regal Rexnord Products and Solutions for the Bakery Industry

Partner Edition – For Regal Rexnord Preferred Partners

Industry Playbook

Restricted distribution
– Regal Rexnord Preferred Partners

Guided by Our Values



Integrity

Zero-tolerance policy on unethical behavior. We value integrity most. We are honest, transparent, and trustworthy in all situations.



Responsibility

We have a responsibility to safety, sustainability, and our community.



Diversity, Engagement, & Inclusion

We strongly believe that the more diverse minds focused on our purpose, the better the outcomes will be.



Customer Success

Our customer is our main priority. We must understand their needs and develop products, solutions, and services that solve their challenges.



Innovation With Purpose

We innovate to develop products that are valued by our customer and bring profitable growth for Regal Rexnord.



Continuous Improvement

Our responsibility is to make tomorrow better than today. This means a focus on making the work easier, more productive, and more efficient through 80/20 excellence.



Performance

We have a responsibility to our primary stakeholders (customers, associates, and shareholders) to drive profitable revenue growth.



Passion to Win

Passion is the fuel that inspires and drives our associates to achieve top performance and overcome any obstacles in achieving our goals.

...with a Sense of Urgency

Messages for your clients: **Regal Rexnord Bakery Industry Solutions**



Partner with Regal Rexnord – Your Trusted Expert in Bakery Manufacturing

Work with a partner who understands the complex and fast-moving world of bakery production — from dough handling and proofing to baking, cooling, freezing, and packaging. Regal Rexnord combines decades of expertise with a broad portfolio of high-performance power transmission and conveying solutions designed specifically to keep bakery lines running smoothly and efficiently.

Whether you operate industrial bread lines, pastry production, ready-to-eat baked goods, or bake-off facilities, we help you select the right components to maximize uptime, ensure product consistency, and protect food safety.



Support Every Step of the Way

From purchase and installation to monitoring, maintenance, and overhaul, Regal Rexnord delivers exceptional lead times, reliable availability, and industry-leading technical support.

Our robust product quality and application expertise help prevent costly unplanned downtime, extend equipment life, and improve total line productivity—ultimately increasing your return on investment across the entire product lifecycle.

With global sales and service operations and a strong distributor network, you can count on fast response, consistent support, and the right solution exactly when you need it.



Engineered for Reliability in Bakery Production

Regal Rexnord designs mission-critical components that perform under the demanding conditions of bakery environments—where continuous operation, hygiene, temperature changes, and precise product handling are essential.

Our portfolio spans conveying belts, metal and plastic spiral solutions, bearings, couplings, motors, gear drives, and condition-monitoring technologies—all engineered with durability, food safety, and efficiency in mind. Whether you're managing sticky dough transport, high-humidity proofing areas, high-temperature ovens, abrasive pan handling, or delicate cooling and freezing operations, our solutions are built to meet strict performance and hygiene requirements—delivering reliable, consistent results for every application across the bakery line.

OUR VALUE TO THE BAKERY INDUSTRY

At Regal Rexnord, we go beyond supplying high-quality components. We act as a Solution Provider and long-term partner to the industrial bakery industry, supporting customers in improving production performance, reducing maintenance effort, and protecting business continuity.

We understand the demanding conditions of industrial bakery production—where continuous operation, hygiene, temperature variation, accurate dough handling, and consistent product quality are essential. From ingredient handling to mixing, dividing, proofing, baking, cooling, freezing, and packaging, bakeries rely on systems that perform with precision and durability.

Our integrated solutions are engineered to:

- Increase overall equipment effectiveness (OEE)
- Reduce contamination risks
- Extend equipment life
- Minimize unplanned downtime
- Lower total cost of ownership

With robust, low-maintenance systems designed for both dry and washdown environments, we help bakeries maximize uptime, streamline workflows, and achieve sustainable production improvements.

From Product Supplier to Solution Provider

Regal Rexnord is not just a product provider. We deliver **end-to-end solutions** that combine products, application expertise, and services across the entire lifecycle of bakery production lines.

Our approach focuses on:

- **Production improvement** through optimized conveying, power transmission, and spiral solutions
- **Maintenance reduction** via easy to maintain designs, wear-optimized components, and condition monitoring
- **Operational reliability** supported by engineering know-how and global service capabilities

By understanding customer processes and pain points, we help translate component performance into measurable production results.

A Comprehensive Portfolio for Industrial Bakery Production

Regal Rexnord provides a complete range of components, technologies, and engineered solutions that support every stage of the bakery process.

Our portfolio includes hygienic metal and plastic belts, spiral conveyor solutions, bearings, gear drives, couplings, motors, and condition-monitoring tools designed for bread, patisserie, viennoiserie, and savoury products.

OUR VALUE TO THE BAKERY INDUSTRY

Whether moving sticky dough in early processing, managing high-humidity proofing, withstanding extreme baking temperatures, or transporting fragile baked goods through cooling and freezing spirals, Regal Rexnord solutions deliver long-lasting reliability and food-safe performance.

Supporting Throughput, Uptime & High-Volume Production

Industrial bakeries operate under continuous, critical conditions where even minor disruptions can have a significant impact on productivity and profitability.

Regal Rexnord solutions are designed to boost throughput and uptime by:

- Improving product flow and stability
- Reducing belt tension and mechanical stress
- Lowering friction and energy consumption
- Minimizing unplanned downtime

Our conveying technologies—including active drive and low-tension spiral belts, wear-optimized metal belts, and high-stability modular belts—help maintain smooth transitions, prevent jams, and ensure consistent product spacing.

Combined with robust bearings, corrosion-resistant gear drives, washdown-rated motors, and health-monitoring sensors, bakeries can operate at higher speeds with greater confidence while reducing waste, product damage, and maintenance interventions.

Premium Services & Technical Support

To complement our product and solution portfolio, Regal Rexnord offers **premium service and technical support**, both pre- and post-order, ensuring customers are supported throughout the full lifecycle of their equipment.

Our service capabilities include:

- Application engineering and solution design support
- Line audits and production optimization assessments
- Installation guidance and commissioning support
- Preventive and predictive maintenance support
- **24/7 emergency service** to protect critical production operations

This service-driven approach enables customers to reduce risk, respond faster to issues, and maintain continuous production—even in the most demanding environments.

Globally Skilled Teams, Locally Available

With a strong global presence, Regal Rexnord supports bakery manufacturers, OEMs, and engineering teams wherever they operate. Our technical experts understand the nuances across product categories—from high-moisture doughs and laminated pastries to delicate viennoiserie and heavy savoury products.

Our teams help customers:

- Optimize plant productivity
- Implement hygienic improvements

OUR VALUE TO THE BAKERY INDUSTRY

- Adapt to changing consumer trends
- Ensure compliance with food safety standards

This combination of global expertise and local support makes Regal Rexnord a reliable partner for both established producers and rapidly growing bakery operations.

Trusted Brand, Proven Reliability

Regal Rexnord is recognized worldwide for durable, hygienic, and energy-efficient solutions that perform in harsh and variable environments.

In bakery production—where thermal cycling, humidity, abrasive flour dust, sticky dough residues, and frequent sanitation are daily realities—our solutions consistently deliver extended service life, stable operation, and reduced total cost of ownership.

Manufacturers trust Regal Rexnord not only to supply components, but to **keep production lines running, day after day**, supported by engineering expertise and premium service.

Key Messages for the Spiral Initiative

- Regal Rexnord is a **solution partner**, not only a component supplier
- Focus on production improvement and maintenance reduction
- Integrated spiral, conveying, and power transmission expertise
- Premium service, technical support, and **24/7 emergency response**
- Proven reliability in high-volume, hygienic bakery environments

BAKERY INDUSTRY MARKET – EMEA REGION

The European bakery products market remains one of the region's most significant and culturally embedded food sectors, combining centuries-old baking traditions with rapidly evolving consumer expectations.

Recent studies show that the market continues its upward trajectory: the European bakery market reached an estimated USD 264–280 billion in 2025, and is projected to grow to USD 372 billion by 2031 at a CAGR of 5.85%.

Bread continues to be the largest product category, although its share is gradually declining as consumers increasingly shift toward convenience-oriented baked goods, such as pizzas, snacking formats, and single-portion items. Meanwhile, viennoiserie—especially croissants, laminated dough products, and brioche—remains one of the strongest growth segments in Western Europe, driven by premiumization and indulgence trends.

Market dynamics within EMEA show notable regional differences:

Western Europe leads in overall revenue and product innovation, supported by established industrial bakeries, premium artisanal markets, and strong retail infrastructure.

Eastern and Central Europe are emerging as high-growth zones, supported by rising disposable income, urbanization, and strong demand for long-lasting packaged bread formats.



BAKERY INDUSTRY MARKET – EMEA REGION

Convenience-driven channels—especially supermarkets/hypermarkets and rapidly expanding online bakery retail—continue to dominate distribution, supported by consumers' shift toward home delivery and bake-off solutions.

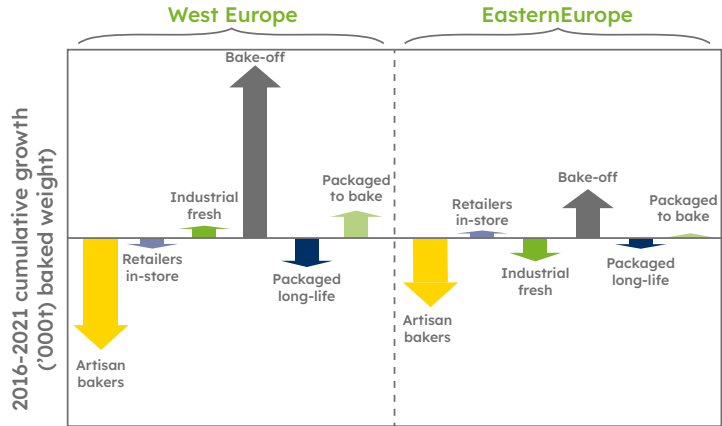
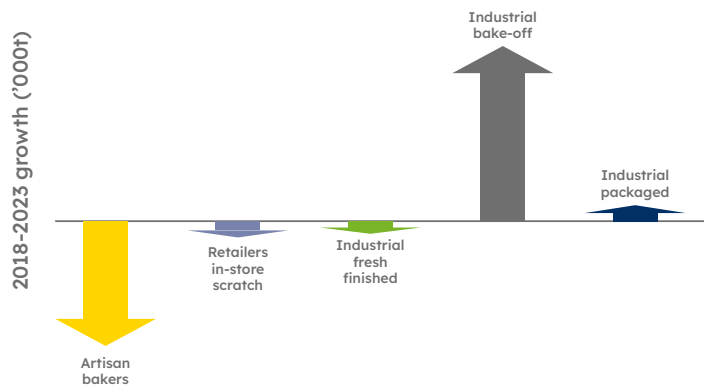
The sector is also undergoing a transformation influenced by health and sustainability trends. Consumers increasingly seek clean-label, whole-grain, organic, and low-sugar products, pushing bakeries to reformulate recipes and adopt ingredients such as alternative grains and sourdough.

At the same time, the industry is investing in automation, digital quality control, and advanced baking technologies to improve efficiency, reduce waste, and meet rising throughput demands.

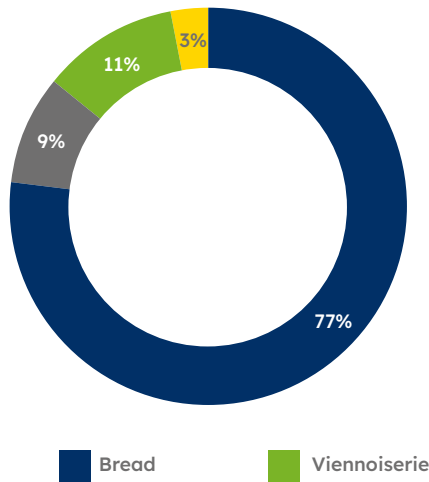
Overall, the EMEA bakery market remains robust, dynamic, and increasingly innovation-driven—balancing tradition with modernization to meet the needs of consumers who expect both authenticity and convenience.

BAKERY INDUSTRY MARKET – EMEA REGION

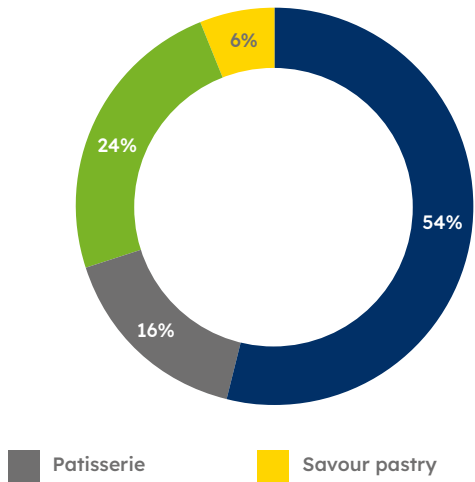
Growth prospect in bakery products supplies
EU14 - 2018/2023f



Total bakery product consumption EU14
By product, 2018 (% Volume)



Total bakery product consumption EU14
By product, 2018 (% Volume)



BAKERY PRODUCTION VALUE PER COUNTRY (2019)

Ranking	Company	Revenue (USD millions)
1.	Mondelez International	25,868
2.	Associated British Foods Plc	20,627
3.	Kellogg Company	13,578
4.	Gruppo Bimbo	13,159
5.	Yamazaki Baking Co Ltd	9,995
6.	Campbell Soup Company	8,107
7.	JAB Holding Company	5,739
8.	Flowers Foods	4,124
9.	Brittania Industries	1,466
10.	Warbuttons Ltd	638

Rank	Country	Value (EUR millions)
1.	Germany	21,569
2.	France	21,223
3.	UK	10,668
4.	Italy	7,711
5.	Spain	5,899
6.	Poland	3,968
7.	Belgium	3,361
8.	Austria	2,220
9.	Sweden	1,710
10.	Greece	1,426
11.	Portugal	1,425
12.	Romania	1,339
13.	Czech Republic	1,101
14.	Denmark	1,078
15.	Norway	1,025
16.	Finland	942
17.	Ireland	810
18.	Hungary	561
19.	Croatia	532
20.	Bulgaria	442

Did you know?



There are over 1,000 industrial bakery plants across Europe.

END USER CHALLENGES AND OBJECTIVES

Everyday, manpower shortages, asset reliability, supply chain woes, production demands, and unplanned downtime plague our customer's desire to serve their customers.

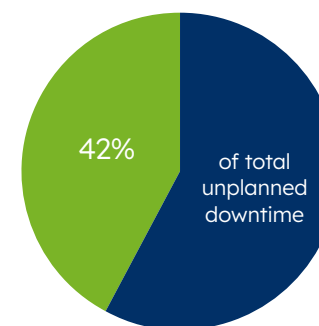
What your customer wants:

- Increase productivity through decreased repair down time and catastrophic events
- Increased production capacity with wider or faster running conveyor belts

Streamline workflow by eliminating the need for multiple checks or adjustments

- Decreased food contamination risk through reducing wear debris, belt fatigue and IP69K electro-mechanical components

**Zero
Unplanned
Downtime
#1 or Hight
Priority for
72% of
customers**



Equipment Failure

42% of total unplanned downtime is due to equipment failure.

Predictive Maintenance Typically:

30-50%

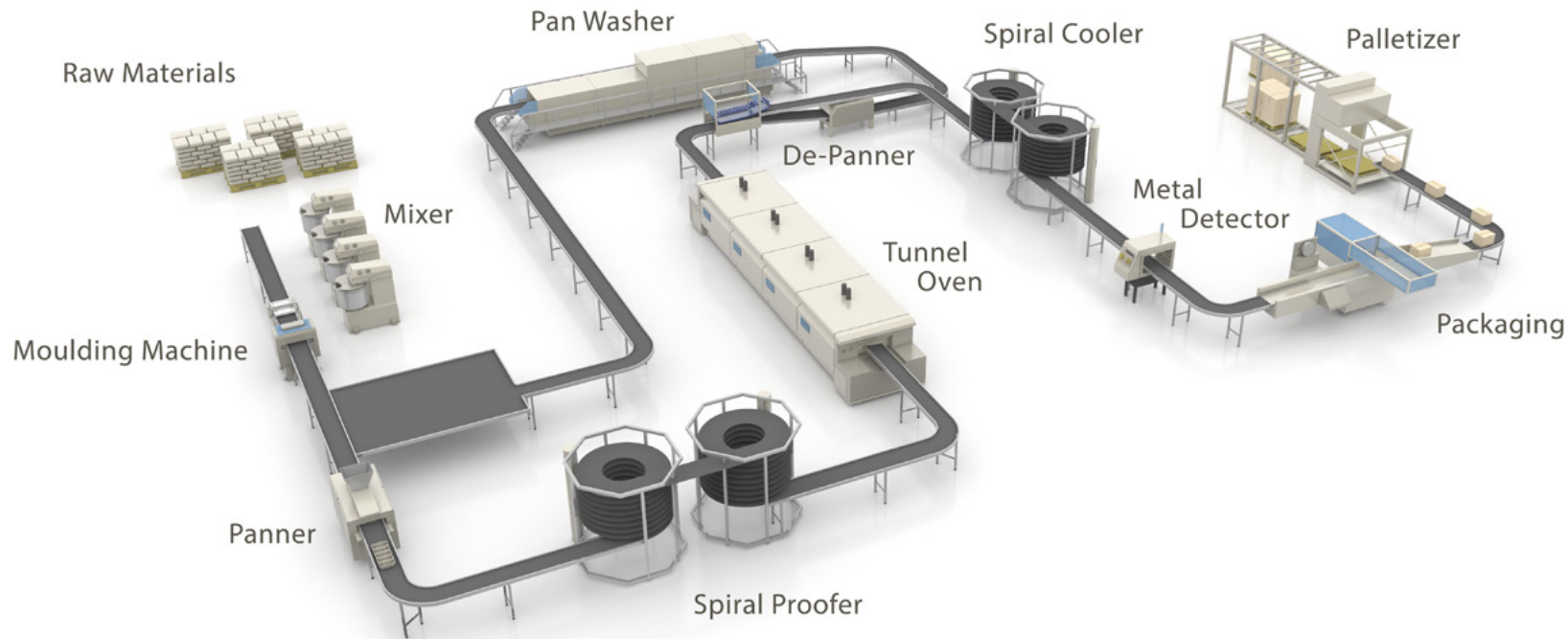
Reduction in Machine Downtime

20-40%

Increase in Machine Life

End User Challenges and objectives

BAKERY PLANT LAYOUT – KEY PROCESS AREAS



1. Storage and weighing

Ingredients are stored in silos to protect them from dust and are sent to mixers through pipes using vacuum or air pressure. Liquids like oil and water are also piped directly to mixers and measured precisely according to the recipe.

2. Mixing

Combining ingredients starts the baking process by blending, hydrating, incorporating air, and developing gluten for the best dough texture.

3. Dividing

Bread dough is moved by screw or conveyor into hoppers, then elevated to

the divider. Conveyors carry dough to pre-sheeters and dividers for portioning and flattening. Rollers thicken, rotary slitters cut dough to size, and scraps are recycled to the hopper.

4. Rounding and Molding

The dough is weighed, cut, and shaped into rounded or egg-shaped pieces. It is

then rolled into cylinders, sealed, and placed in pans automatically for proofing.

5. Proofing

The loaf pans slowly move up and down in a spiral as part of the proofing process.

6. Baking

The proofed loaf is baked in a humid oven, then cooled to

soften the crust. After cooling, it's removed from the pan, which is then cleaned and dried automatically for reuse.

7. De-Panning

De-panning involves quickly taking baked goods out of hot steel or aluminum pans right after baking. This happens before cooling or freezing.

8. Cooling

Once baked, the loaf cools in a humid spiral to soften the crust before being taken from the pans, which are then cleaned and dried for reuse.

9. Freezing

Some baked goods are frozen by rapidly cooling them with a blast of cold air, allowing for longer storage without harm.

10. Packaging and Transportation

Bread is metal-checked, sliced evenly, and bagged. Loaves are packed in groups of 10 or 12, stacked, and moved by conveyor. Stacks are removed by hand, and supermarkets often use their own trucks for deliveries.

BAKERY MANUFACTURING PRODUCT SEGMENTATION

		Storage and weighing	Mixing	Dividing	Rounding and Molding	Panning	Proofing	Baking	Cooling	Freezing	Packaging and Transportation
Cambridge	Compound Balanced FlatSeat (CB5)										
	Cambridge Cam-Grid™ Belt										
	Cambridge Cambri-Link™ Belt										
	Cambridge DuraLite™ Belt										
	KleanTop Pac Titan Pro™ Metal Belt										
	Cambridge Precision Belt MTR										
Flattop	Rexnord MR2260										
	Rexnord 395 Series Mattop										
	Rexnord KleanTop 505 Series Mattop										
	Rexnord KleanTop 590 Series Mattop										
	Rexnord KleanTop 1090 Series Mattop										
	Rexnord KleanTop 1600 Series Mattop										
	Rexnord KleanTop 6400 Series										
Bearings	Link-Belt™ & Sealmaster™ Mounted Ball Bearing										
Perceptive	Bauer Gear Motor HiflexDRIVE Stainless Steel Gear Motors										
	Bauer Gear Motor HiflexDRIVE Aseptic Gear Motors										



1. Storage and weighing

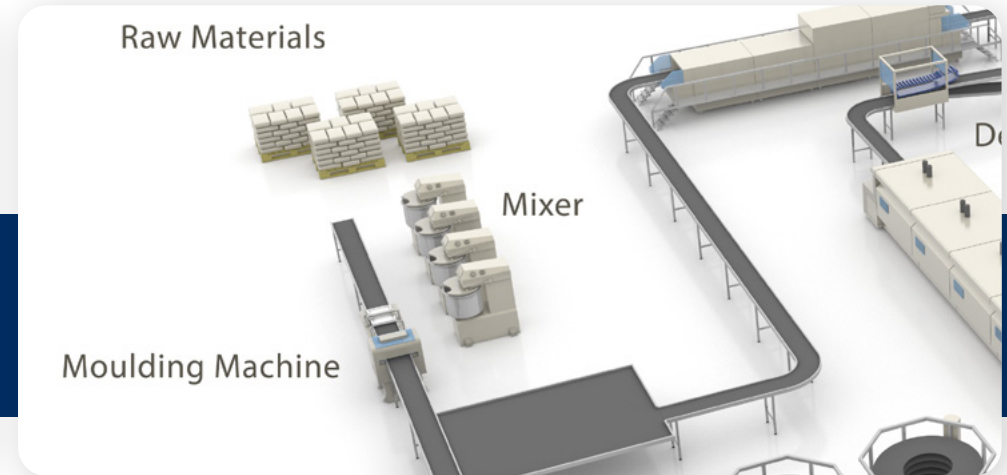
Storage and weighing

“Ingredients are stored and accurately weighed to ensure a clean, controlled, and consistent start of the bakery process. Precise dosing at this stage is critical to product quality and performance in all downstream steps.”

STORAGE AND WEIGHING

Dry and wet ingredients are stored in silos to protect them from dust and environmental exposure. From there, they are transported directly to the mixers through closed piping systems using vacuum or air pressure to ensure a clean and controlled transfer.

Oil, water, and other liquid ingredients are delivered in the same way, with each quantity precisely measured according to the recipe to secure consistent dough quality and accurate formulation.





2. Mixing

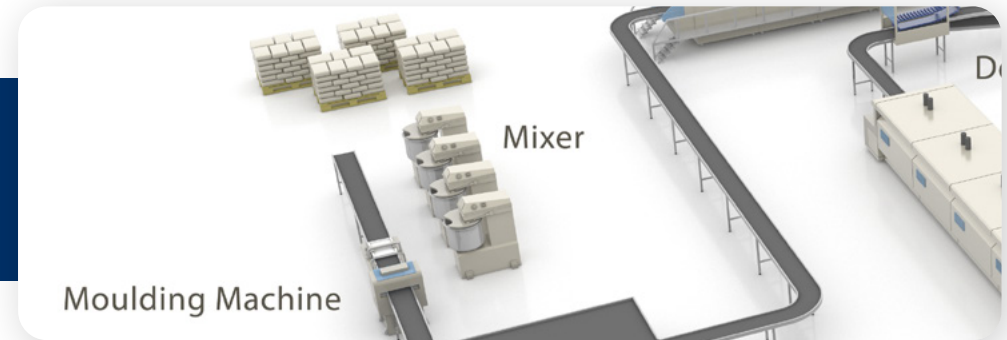
Mixing

“Mixing combines and hydrates ingredients with precision to develop the dough’s structure and quality. Carefully controlled time, energy, and temperature ensure consistent dough performance for every product.”

MIXER

Mixing brings all ingredients together and initiates the chemical processes essential for baking, including the blending and hydration of dry ingredients, air incorporation, and gluten development. This step determines the dough's structure, elasticity, and overall handling properties.

Throughout the process, mixing time, energy input, and dough temperature are carefully measured and controlled to ensure consistent dough quality for every batch.



Mixer

	Product	Features	Customer Benefits
Mixing	 Link-Belt™ & Sealmaster™ Mounted Ball Bearing	• Housing Styles: Pillow Block, Flanges, Hanger, Take Up, and ER • Locking Options: Sets crew and Concentric • Bore diameter Size Range • Imperial: 3/4" to 2 7/16" • Metric: 20 to 60mm • Housing Material Options: 316 Stainless Steel, High Strength Composite	• Enhanced washdown resistance due to material of bearing and high-performance seal resulting in lower total cost of ownership and longer life • Reduced Maintenance/Corrosion • Increased Ease of Sanitation • Increased Sustainability/Rotary Life • Meets IP69K standards with stainless steel housing providing a solution that delivers assurance the system is cleaner/safer/higher performing across the industry
Mixing	 Bauer Gear Motor HiflexDRIVE Stainless Steel Gear Motors	• Protection rating IP67/IP69K designed for very high cleaning intervals • Smooth surfaces • No re-infections • Resistant to cleaning agents • Beveled edges • CIP-capable design • Stainless steel connector plug • Highly robust housing	• Reduced bacterial growth • An extension of the production times by reducing the cleaning intervals • Fewer cleaning agents reduce cost and protect the environment • High chemical resistance • Increased safety in the entire production area
Mixing	 Bauer Gear Motor HiflexDRIVE Aseptic Gear Motors	• Protection rating IP67/IP69K designed for very high cleaning intervals • Special paints protect against aggressive acids, alkalis and salts, as well as aggressive environmental conditions • Smooth surfaces • No re-infections due to fanless design • Resistant to cleaning agents • Beveled edges • CIP-capable design • Stainless steel connector plug	• Easy to clean • No distribution of bacteria • The motors do not spread microorganisms in production areas • When the product is open, no cooling air blows in the direction of the product • Further cost improvement possibilities with highly efficient permanent magnet synchronous motors



3. Moulding machine

Moulding machine

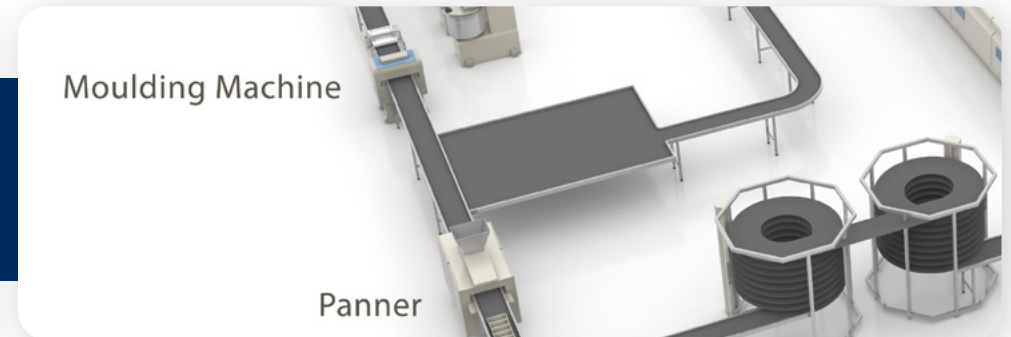
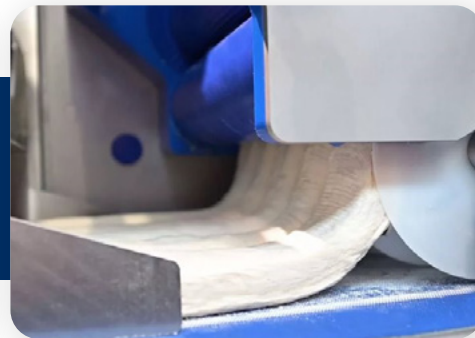
“Moulding shapes each dough piece with precision to create consistent size, structure, and product quality. Through controlled dividing, rounding, and shaping, this step ensures uniformity before the dough enters the proofer.”

MAKE UP-DIVIDING

The bread dough is transferred into dough hoppers via a screw system or a vertical pinch/sandwich conveyor. These elevators move the dough upward and deliver it to a conveyor that feeds the dough divider, eliminating the need for manual dough trough lifts.

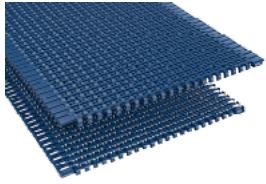
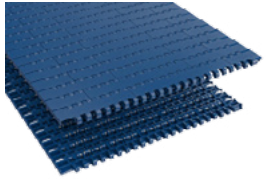
From there, dedicated transport and divider-feed conveyors guide the dough toward pre-sheeters and dividers. The dough is then cut into precise portion sizes based on the required product weight and dimensions. Pre-sheeters flatten the dough to ensure consistency and prepare it for further shaping. Depending on the bread type, either a sheeter or a divider is used.

Rollers gently reduce the dough to its final thickness, after which rotary slitters or cutters trim the dough slabs to the specified width. Any leftover scraps are collected and returned to the dough hopper, where they are reintroduced into the process before passing through the first sheeter or divider again.



Moulding machine

MAKE UP-DIVIDING PRODUCT MATRIX

	Product	Features	Customer Benefits
Transport	 Rexnord KleanTop 590 Series Mattop	• Headless rod design enables easy rod removal with a screwdriver • Sprockets optimisations reduce product damage • Open hinge area improves cleaning access, efficiency, and minimises water/chemical use • Rod retention system securely holds the rod in place • Reinforced edges help prevent belt breakage and contamination • Open hinge increases abrasion resistance, reducing rod wear	• Maintenance interruption are minimized • Production output and product quality are higher • Sanitation processes require less downtime • Water and chemicals use is reduced • Food safety measures are optimized to prevent contamination • Early belt failures are less likely to occur
Transport	 Rexnord KleanTop 1090 Series Mattop	• Headless rod design enables easy rod removal with a screwdriver • Uses a single rod per beltrow • Sprockets optimisations reduce product damage • Open hinge area improves cleaning access, efficiency, and minimises water/chemical use • Rod retention system securely holds the rod in place • Reinforced edges help prevent belt breakage and contamination • Open hinge increases abrasion resistance, reducing rod wear	• Maintenance interruption are minimized • Production output and product quality are higher • Sanitation processes require less downtime • Water and chemicals use is reduced • Food safety measures are optimized to prevent contamination • Early belt failures are less likely to occur
Divider/Cutter	 Link-Belt™ & Sealmaster™ Mounted Ball Bearing	• Housing Styles: Pillow Block, Flanges, Hanger, Take Up, and ER • Locking Options: Sets crew and Concentric • Bore diameter Size Range • Imperial: 3/4" to 2 7/16" • Metric: 20 to 60mm • Housing Material Options: 316 Stainless Steel, High Strength Composite	• Enhanced washdown resistance due to material of bearing and high-performance seal resulting in lower total cost of ownership and longer life • Reduced Maintenance/Corrosion • Increased Ease of Sanitation • Increased Sustainability/Rotary Life • Meets IP69K standards with stainless steel housing providing a solution that delivers assurance the system is cleaner/safer/higher performing across the industry

MAKE UP-DIVIDING PRODUCT MATRIX

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Divider/Cutter	 Bauer Gear Motor HiflexDRIVE Stainless Steel Gear Motors	• Protection rating IP67/IP69K designed for very high cleaning intervals • Smooth surfaces • No re-infections • Resistant to cleaning agents • Beveled edges • CIP-capable design • Stainless steel connector plug • Highly robust housing	• Reduced bacterial growth • An extension of the production times by reducing the cleaning intervals • Fewer cleaning agents reduce cost and protect the environment • High chemical resistance • Increased safety in the entire production area
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MAKE UP-ROUNDING

The bread dough is transferred into dough hoppers via a screw system or a vertical pinch/sandwich conveyor. These elevators move the dough upward and deliver it to a conveyor that feeds the dough divider, eliminating the need for manual dough trough lifts.

From there, dedicated transport and divider-feed conveyors guide the dough toward pre-sheeters and dividers. The dough is then cut into precise portion sizes based on the required product weight and dimensions. Pre-sheeters flatten the dough to ensure consistency and prepare it for further shaping. Depending on the bread type, either a sheeter or a divider is used.

Rollers gently reduce the dough to its final thickness, after which rotary slitters or cutters trim the dough slabs to the specified width. Any leftover scraps are collected and returned to the dough hopper, where they are reintroduced into the process before passing through the first sheeter or divider again.



Moulding Machine

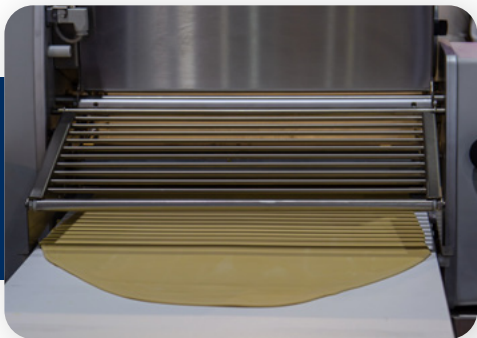
Panner

Moulding machine

MAKE UP-SHEETING AND MOULDING

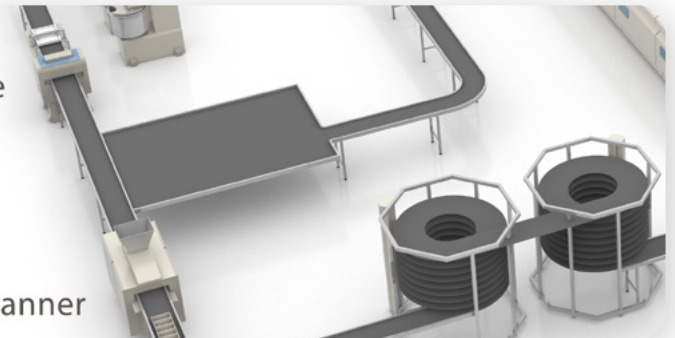
The final sheeter flattens the rounded dough to the required thickness, creating a uniform sheet that prepares it for the moulding stage. The dough is then rolled into a cylinder, and the ends are sealed to ensure it bakes as a single, cohesive loaf without splitting or tearing during oven expansion.

Once shaped, the dough pieces are transferred to automated bread panners, which place each loaf accurately into pans to ensure consistent orientation and spacing before entering the proofing stage.



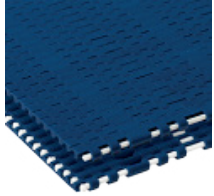
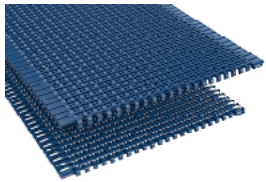
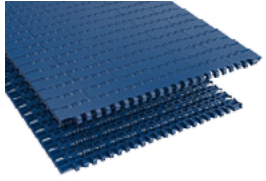
Moulding Machine

Panner



Moulding machine

MAKE-UP ROUNDING, SHEETING AND MOULDING PRODUCT MATRIX

	Product	Features	Customer Benefits
Transfer/ Transport	 Rexnord 395 Series Mattop	- The innovative headless rod retention design enables straightforward removal using a screwdriver and ensures rod positioning throughout conveyance - The belt supports extended conveyor lengths, minimizing the number of components required for maintenance. Longer conveyor spans reduce the frequency of required transfers and efficient utilization of components such as drives and bearings further enhances operational performance.	- The headless rod retention system lets rods be removed quickly with a screwdriver, reducing maintenance time and downtime. Its secure design keeps rods in place, lowering stress and extending belt life by minimizing wear and breakage - Supporting longer conveyor spans, the belt reduces components and misalignment risks. The 395 KleanTop Belt creates smoother product flow with fewer transfers, lessening product damage and improving throughput and quality. Fewer components also limit debris buildup, making cleaning easier and helping maintain hygiene-essential for food applications.
Transport	 Rexnord KleanTop 590 Series Mattop	- Headless rod design enables easy rod removal with a screwdriver - Uses a single rod per beltrow - Sprockets optimisations reduce product damage - Open hinge area improves cleaning access, efficiency, and minimises water/chemical use - Rod retention system securely holds the rod in place - Reinforced edges help prevent belt breakage and contamination - Open hinge increases abrasion resistance, reducing rod wear.	- Maintenance interruption are minimized - Production output and product quality are higher - Sanitation processes require less downtime - Water and chemicals use is reduced - Food safety measures are optimized to prevent contamination - Early belt failures are less likely to occur.
Transport	 Rexnord KleanTop 1090 Series Mattop	- Headless rod design enables easy rod removal with a screwdriver - Uses a single rod per beltrow - Sprockets optimisations reduce product damage - Open hinge area improves cleaning access, efficiency, and minimises water/chemical use - Rod retention system securely holds the rod in place - Reinforced edges help prevent belt breakage and contamination - Open hinge increases abrasion resistance, reducing rod wear.	- Maintenance interruption are minimized - Production output and product quality are higher - Sanitation processes require less downtime - Water and chemicals use is reduced - Food safety measures are optimized to prevent contamination - Early belt failures are less likely to occur.

MAKE-UP ROUNDING, SHEETING AND MOULDING PRODUCT MATRIX

	Product	Features	Customer Benefits
Rounder/Molder	 Link-Belt™ & Sealmaster™ Mounted Ball Bearing	• Housing Styles: Pillow Block, Flanges, Hanger, Take Up, and ER • Locking Options: Sets crew and Concentric • Bore diameter Size Range • Imperial: 3/4" to 2 7/16" • Metric: 20 to 60mm • Housing Material Options: 316 Stainless Steel, High Strength Composite	• Enhanced washdown resistance due to material of bearing and high-performance seal resulting in lower total cost of ownership and longer life • Reduced Maintenance/Corrosion • Increased Ease of Sanitation • Increased Sustainability/Rotary Life • Meets IP69K standards with stainless steel housing providing a solution that delivers assurance the system is cleaner/safer/higher performing across the industry
Rounder/Molder	 Bauer Gear Motor HiflexDRIVE Stainless Steel Gear Motors	• Protection rating IP67/IP69K designed for very high cleaning intervals • Smooth surfaces • No re-infections • Resistant to cleaning agents • Beveled edges • CIP-capable design • Stainless steel connector plug • Highly robust housing	• Reduced bacterial growth • An extension of the production times by reducing the cleaning intervals • Fewer cleaning agents reduce cost and protect the environment • High chemical resistance • Increased safety in the entire production area
Rounder/Molder	 Bauer Gear Motor HiflexDRIVE Aseptic Gear Motors	• Protection rating IP67/IP69K designed for very high cleaning intervals • Special paints protect against aggressive acids, alkalis and salts, as well as aggressive environmental conditions • Smooth surfaces • No re-infections due to fanless design • Resistant to cleaning agents • Beveled edges • CIP-capable design • Stainless steel connector plug	• Easy to clean • No distribution of bacteria • The motors do not spread microorganisms in production areas • When the product is open, no cooling air blows in the direction of the product • Further cost improvement possibilities with highly efficient permanent magnet synchronous motors



4. Spiral Proofer

Spiral Proofer

“During proofing, dough pans move slowly through the spiral system to develop volume, structure, and uniform fermentation before baking.”

SPIRAL PROOFER PRODUCT MATRIX

During spiral proofing, the dough-filled pans travel slowly through a vertical spiral system where controlled temperature and humidity allow the dough to ferment and rise evenly.

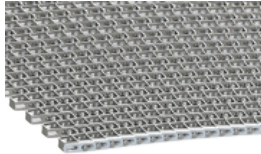
As the pans move up and down through the spiral, the dough develops the volume, structure, and gas retention needed for optimal oven performance.

The spiral configuration provides extended, consistent proofing time within a compact footprint, ensuring each loaf receives the same environmental conditions. This controlled environment stabilizes the dough, improves product uniformity, and prepares each pan for the transition into the baking stage.

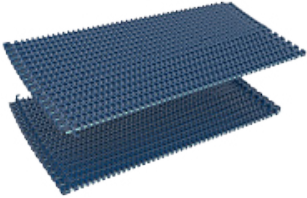
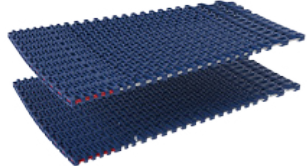


Spiral Proofer

SPIRAL PROOFER PRODUCT MATRIX

	Product	Features	Customer Benefits
Proofer Spiral	 Cambridge Cam-Grid™ Belt	This belt, made for drum-driven spiral cage systems, comes in pitches from 3/4" to 1,5". Featuring spring-temper stainless steel mesh overlays. It resists fatigue and damage, is fully collapsible for easy cleaning, and can be flipped to extend life in radius setups. Mesh options include tight openings for delicate items and open areas for better airflow. The belt can run straight or turn, offers several collapsibility choices, and has optional side-link attachments for product retention.	The spiral belt's stainless-steel, flip-able design maximizes durability and lifespan, reducing downtime. Its collapsible structure makes cleaning quick and lowers operational costs. Various mesh overlays improve handling and support, even for delicate products, while open areas boost airflow for better thermal processing. Optional side-link attachments maintain product placement and cut losses. It handles straight runs and turns, offering flexibility for diverse spiral applications.
Proofer Spiral	 Cambridge Cambri-Link™ Belt	This belt suits both spiral cage and straight-line setups with a wide mesh for better airflow. Its collapsible design and oblong slot pickets make cleaning easier and reduce bacteria build-up. The positive-drive system keeps product flow steady and smooth, while the flat surface boosts stability. Efficient and cost-effective, ideal for tough processing needs.	This durable, hygienic belt boosts airflow for efficient cooling, freezing, or drying, and its collapsible design reduces sanitation time and bacterial risks. The positive-drive system prevents jams, keeps products stable, and offers high tension capacity for reliable, cost-efficient operation with less maintenance and more uptime.
Proofer Spiral	 Cambridge Duralite™ Belt	DuraLite is designed for spiral cage applications, offering the highest strength-to-weight ratio. It's twice as strong as rods-only belts and 35% stronger than standard 1" x 1" types. The 3" x 1" mesh provides twice the open area of plastic belts for better airflow and cooling, while DuraLite remains up to 40% lighter than conventional options—reducing energy use and mechanical stress. The open mesh also improves hygiene and cleaning.	The belt offers high performance and durability with increased load capacity and no added weight, leading to longer belt life and less maintenance. Its larger open area boosts airflow for faster, more consistent cooling or freezing. Reduced weight lowers energy use and equipment wear, extending system life. The easy-to-clean mesh pattern saves time on sanitation and helps meet food safety standards efficiently.

SPIRAL PROOFER PRODUCT MATRIX

	Product	Features	Customer Benefits
Proofer Spiral	 Rexnord KleanTop 1600 Series MatTop	• Rexnord KleanTop 1600 Series is stronger and stiffer than leading competitors' belts • Increased throughput from a flat belt matched with higher strength • 38% open area and plug-less rod retention • Friction top belt maintains the product's position on belt inclines, indexes and side-flexing conveying applications	• Extended belt life • Lower conveyor runs reduce drives, supporting components and associated maintenance • Reduces downtime with easy installation, maintenance and repair
Proofer Spiral	 Rexnord KleanTop 6400 Series	• The patented PowerKey™ allows tension to be carried by more of the belt • Improved belt strength, thanks to Stainless Steel rods • 45% open area design allows for airflow • Easy-to-replace cam rollers to reduce maintenance and installation times • New "BSE" flame retardant material increases plant and employee safety	• Increased productivity and useful life of the belt • Stronger belt enables greater carrying capacity • Reduced building costs with broader spans and less infrastructure • Reduces food safety and product release • Reduces maintenance time and cost
Proofer Spiral	 Link-Belt® Seamaster™ Mounted Ball Bearing	• Housing Styles: Pillow Block, Flanges, Hanger, Take-Up, and ER • Locking Options: Setscrew and Concentric • Bore Diameter Size Range: • Imperial: 3/4" to 2-7/16" • Metric: 20 to 60 mm • Housing Material Options: 316 Stainless Steel, High Strength Composite	• Enhanced washdown resistance due to material of bearing and high performance seal resulting in lower total cost of ownership and longer life • Reduced maintenance/corrosion • Increased ease of sanitation • Meets IP69K standards with stainless steel housing providing a solution that industry assumes the system is cleaner and safer / higher performing across the industry

SPIRAL PROOFER PRODUCT MATRIX

	Product	Features	Customer Benefits
Proofer Spiral	 Bauer Gear Motor HiflexDRIVE Stainless Steel Gear Motors	• Protection rating IP67 / IP69K designed for very high cleaning intervals • Smooth surfaces • No re-infections • Resistant to cleaning agents • Beveled edges • CIP-capable design • Stainless steel connector plug • Highly robust housing	• Reduced bacterial growth • An extension of the production times by reducing the cleaning intervals • Fewer cleaning agents reduce costs and protect the environment • High chemical resistance • Increased safety in the entire production area
Proofer Spiral	 Bauer Gear Motor HiflexDRIVE Aseptic Gear Motors	• Protection rating IP67 / IP69K designed for very high cleaning intervals • Special paints protect against aggressive acids, alkalis and salts, as well as aggressive environmental conditions • Smooth surfaces • No re-infections due to flawless design • Resistant to cleaning agents • Beveled edges • CIP-capable design • Stainless steel connector plug	• Easy to clean • No distribution of bacteria • The motors do not spread microorganisms in production areas • When the product is open, no cooling air blows in the direction of the product • Further cost improvement possibilities with highly efficient permanent magnet synchronous motors



5. Tunnel oven

Tunnel oven

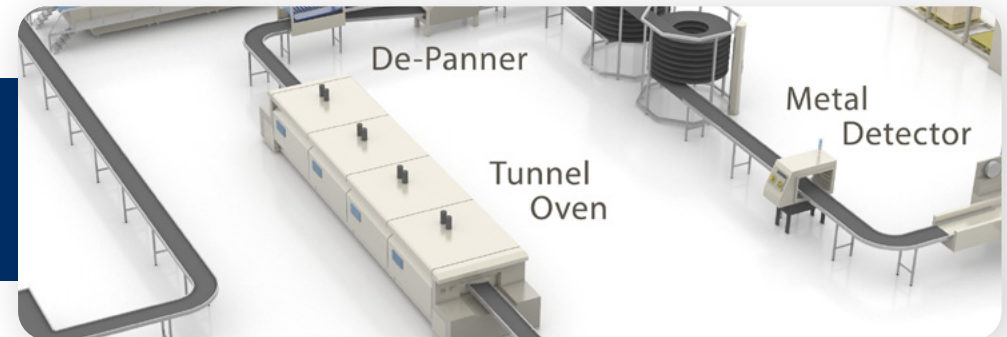
“During baking, the proofed dough moves through controlled heat and humidity—whether on spiral conveyors or deck systems—to develop the loaf’s final structure, color, and crust.”

TUNNEL OVEN

During the baking stage, the proofed dough enters the tunnel oven, where controlled heat and humidity transform it into a fully developed loaf. As the pans move continuously through the oven—either on a large spiral conveyor or across multiple deck levels—the dough undergoes oven spring, starch gelatinization, and crust formation.

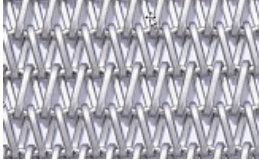
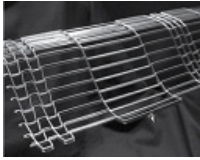
Temperature, humidity, and airflow are carefully regulated throughout the oven to ensure even heat distribution and consistent product quality across the entire batch. This controlled environment stabilizes the loaf's internal structure, develops its characteristic

volume and crumb texture, and produces the desired crust color. Once baking is complete, the hot pans exit the oven and move directly toward the de-panning stage, where the product is released and prepared for cooling.



Tunnel oven

TUNNEL OVEN PRODUCT MATRIX

	Product	Features	Customer Benefits
Oven	 Compound Balanced FlatSeat (CB)	- Cambridge CB baking bands are constructed with thicker, stronger wires than those used by other manufacturers. - CB belts have a smooth, flat surface that offers excellent product stability.	CB belts have a smooth, flat surface that offers excellent product stability.
Infeed / Outfeed	 Cambridge Precision Belt MTR	- Cambridge MTR® belts use durable metal hinges and heat-resistant tension rods for strong structural integrity and load capacity. - Their open-area design ensures efficient airflow, drainage, and easy cleaning, making them ideal for high-temperature tasks like baking, drying, and cooling. - Offered in various pitches, wire diameters, apertures, and finishes, the MTR series can be customized for specific applications. - The positive drive system keeps the belt aligned and evenly distributes drive tension.	- Cambridge MTR® belts provide longer belt life, reduced maintenance, and improved production uptime. - Their durable construction minimizes stretching and deformation, helping maintain consistent belt tracking and reducing unplanned stoppages. - The hygienic, easy-to-clean design supports food safety standards while lowering cleaning time and costs. - Overall, MTR® belts help customers achieve higher process efficiency, lower total cost of ownership, and dependable conveying performance over the long term.
<u>Infeed / Outfeed</u>	 Duraflex Metal Belt	- DURAFLEX® is known for its open structure and strong, food-safe stainless steel build. - Its splice design allows fast, tool-free side splicing that matches the belt's strength. - Available in 3/8" and 1/2" pitches and widths from 4 to 144 inches, it offers easy cleaning with unobstructed openings. - Innovative drive sprocket openings and lighter weight improve performance and capacity.	- DURAFLEX® is lightweight, reducing energy use and wear for longer belt life and less maintenance. - Its hinge design and reinforced drive sprocket openings improve durability and support heavier loads. - The open design allows easy cleaning and meets food safety standards. - Tight transfers with small rolls or sprockets prevent product damage and loss, making DURAFLEX® ideal for high-demand conveyor applications.
<u>Infeed / Outfeed</u>	 KleanTop PacTitan Pro® Metal Belt	- Reduced pinch and snag hazards avoid pinch points and cuts for employee safety. - Full hinge design reduces metal fatigue for longer life, mitigating product contamination risk. - Designed to last, belts can be flipped for extended wear. - Robust, reusable rods decrease the need for stockroom inventory. - Easy assembly, installation, maintenance, and repair increase uptime.	- Maximum for specific applications with greater design flexibility. - Improve surface contact to support product/process flow. - Reduce risk of metal fragments to avoid food contamination. - Splice belt at any pitch location for efficient assembly and repair. - Belt action helps maintain dryer oil temperature and manage sediment.



6. De-panner

De-panner

“De-panning gently removes freshly baked products from hot pans, ensuring a clean release and smooth transition to the cooling stage.”

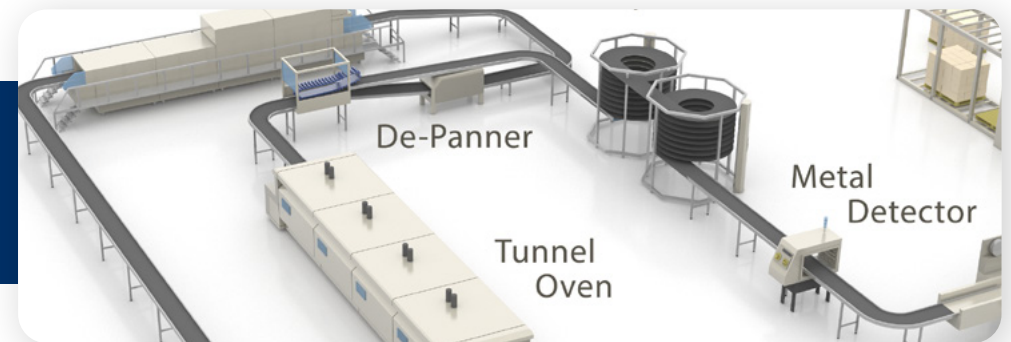
DE-PANNER

De-panning is the process of removing baked products—such as loaves, buns, cakes, or pastries—from their pans immediately after they exit the oven. Since the pans are still extremely hot and retain significant thermal mass, this step must be carried out with precision to protect both product quality and operator safety.

Depending on the product characteristics and production setup, bakeries use mechanical depanners, gravity-based systems, or cup-and-vacuum depanners to lift or release the baked goods

cleanly from the hot pans. Each method ensures that the product maintains its shape and surface integrity as it transitions out of the baking stage.

Once the products are removed, the empty pans continue downstream toward the pan-cleaning system, while the baked goods move on to cooling conveyors or spiral coolers for controlled temperature reduction. This separation of product and pan flow keeps the line efficient and prepares both streams for the next stages of production.



De-Panner

DE-PANNER PRODUCT MATRIX

	Product	Features	Customer Benefits
Pand Conveyor	 • 1873 Gripper	• The 2260 has the robustness that is required to deal with heavy steel baking pans and the high resulting impact forces. • The 8 mm stainless steel pins ensure a high chain stiffness and long wear life. • This Matl Resistant Black (Polyamide) material can resist temperatures up to 375°F (190°C). • It is formulated to be used in applications where conveying hot products might cause more common materials to melt at the top surface.	• With this MR2260 chain our customers in the Bakery industry have a proven robust solution for conveying (hot) baking pans.



7. Spiral cooler

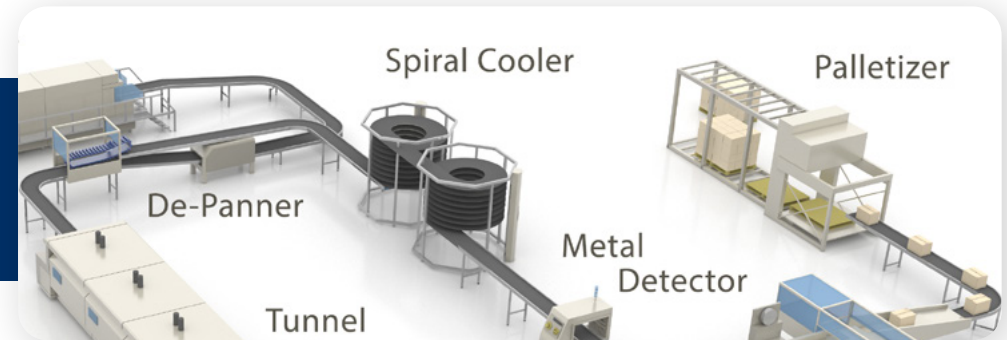
Spiral cooler

“In spiral cooling, baked products travel through a controlled airflow system that gradually reduces temperature, stabilizing structure and preparing each loaf for packaging or further processing.”

SPIRAL COOLER

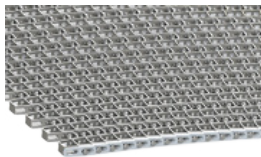
After de-panning, the baked products enter the spiral cooler, where their temperature is reduced gradually and uniformly. As the loaves travel through the vertical spiral structure, controlled airflow removes heat from the product without compromising texture or crust quality. This slow, consistent cooling process helps stabilize the internal crumb structure, prevents moisture loss, and prepares the product for slicing, freezing, or packaging.

Meanwhile, the empty pans are transported away on tabletop or modular conveyors toward the pan-washing system. Here, pans are cleaned and dried in an automated in-line washer before being returned to the panning stage for reuse. Keeping the cooling process and pan-handling loop separate maintains production efficiency and ensures continuous flow along the bakery line.

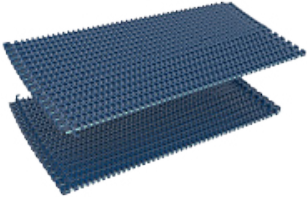
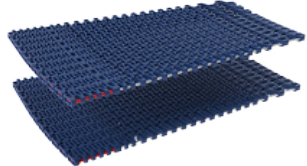


Spiral cooler

SPIRAL COOLER PRODUCT MATRIX

	Product	Features	Customer Benefits
Proofer Spiral	 Cambridge Cam-Grid™ Belt	This belt, made for drum-driven spiral cage systems, comes in pitches from 3/4" to 1,5". Featuring spring-temper stainless steel mesh overlays. It resists fatigue and damage, is fully collapsible for easy cleaning, and can be flipped to extend life in radius setups. Mesh options include tight openings for delicate items and open areas for better airflow. The belt can run straight or turn, offers several collapsibility choices, and has optional side-link attachments for product retention.	The spiral belt's stainless-steel, flip-able design maximizes durability and lifespan, reducing downtime. Its collapsible structure makes cleaning quick and lowers operational costs. Various mesh overlays improve handling and support, even for delicate products, while open areas boost airflow for better thermal processing. Optional side-link attachments maintain product placement and cut losses. It handles straight runs and turns, offering flexibility for diverse spiral applications.
Proofer Spiral	 Cambridge Cambri-Link™ Belt	This belt suits both spiral cage and straight-line setups with a wide mesh for better airflow. Its collapsible design and oblong slot pickets make cleaning easier and reduce bacteria build-up. The positive-drive system keeps product flow steady and smooth, while the flat surface boosts stability. Efficient and cost-effective, ideal for tough processing needs.	This durable, hygienic belt boosts airflow for efficient cooling, freezing, or drying, and its collapsible design reduces sanitation time and bacterial risks. The positive-drive system prevents jams, keeps products stable, and offers high tension capacity for reliable, cost-efficient operation with less maintenance and more uptime.
Proofer Spiral	 Cambridge Duralite™ Belt	DuraLite is designed for spiral cage applications, offering the highest strength-to-weight ratio. It's twice as strong as rods-only belts and 35% stronger than standard 1" x 1" types. The 3" x 1" mesh provides twice the open area of plastic belts for better airflow and cooling, while DuraLite remains up to 40% lighter than conventional options—reducing energy use and mechanical stress. The open mesh also improves hygiene and cleaning.	The belt offers high performance and durability with increased load capacity and no added weight, leading to longer belt life and less maintenance. Its larger open area boosts airflow for faster, more consistent cooling or freezing. Reduced weight lowers energy use and equipment wear, extending system life. The easy-to-clean mesh pattern saves time on sanitation and helps meet food safety standards efficiently.

SPIRAL COOLER PRODUCT MATRIX

	Product	Features	Customer Benefits
Proofer Spiral	 Rexnord KleanTop 1600 Series MatTop	• Rexnord KleanTop 1600 Series is stronger and stiffer than leading competitors' belts • Increased throughput from a flat belt matched with higher strength • 38% open area and plug-less rod retention • Friction top belt maintains the product's position on belt inclines, indexes and side-flexing conveying applications	• Extended belt life • Lower conveyor runs reduce drives, supporting components and associated maintenance • Reduces downtime with easy installation, maintenance and repair
Proofer Spiral	 Rexnord KleanTop 6400 Series	• The patented PowerKey™ allows tension to be carried by more of the belt • Improved belt strength, thanks to Stainless Steel rods • 45% open area design allows for airflow • Easy-to-replace cam rollers to reduce maintenance and installation times • New "BSE" flame retardant material increases plant and employee safety	• Increased productivity and useful life of the belt • Stronger belt enables greater carrying capacity • Reduced building costs with broader spans and less infrastructure • Reduces food safety and product release • Reduces maintenance time and cost
Proofer Spiral	 Link-Belt® Seamaster™ Mounted Ball Bearing	• Housing Styles: Pillow Block, Flanges, Hanger, Take-Up, and ER • Locking Options: Setscrew and Concentric • Bore Diameter Size Range: • Imperial: 3/4" to 2-7/16" • Metric: 20 to 60 mm • Housing Material Options: 316 Stainless Steel, High Strength Composite	• Enhanced washdown resistance due to material of bearing and high performance seal resulting in lower total cost of ownership and longer life • Reduced maintenance/corrosion • Increased ease of sanitation • Meets IP69K standards with stainless steel housing providing a solution that industry assumes the system is cleaner and safer/higher performing across the industry

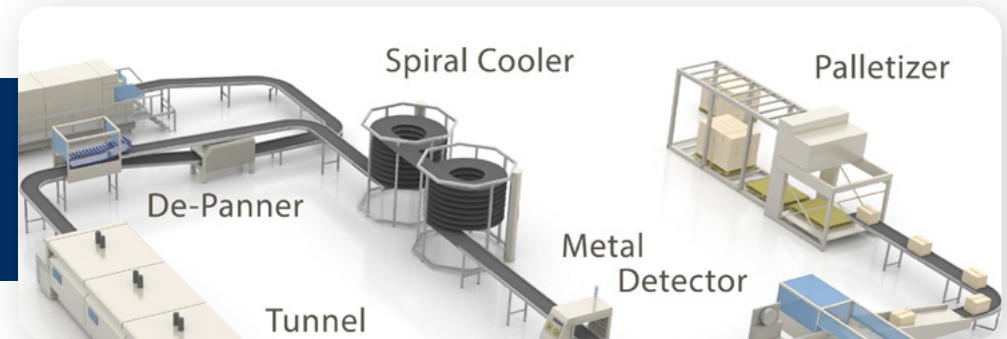
SPIRAL COOLER PRODUCT MATRIX

	Product	Features	Customer Benefits
Proofer Spiral	 Bauer Gear Motor HiflexDRIVE Stainless Steel Gear Motors	• Protection rating IP67 / IP69K designed for very high cleaning intervals • Smooth surfaces • No re-infections • Resistant to cleaning agents • Beveled edges • CIP-capable design • Stainless steel connector plug • Highly robust housing	• Reduced bacterial growth • An extension of the production times by reducing the cleaning intervals • Fewer cleaning agents reduce costs and protect the environment • High chemical resistance • Increased safety in the entire production area
Proofer Spiral	 Bauer Gear Motor HiflexDRIVE Aseptic Gear Motors	• Protection rating IP67 / IP69K designed for very high cleaning intervals • Special paints protect against aggressive acids, alkalis and salts, as well as aggressive environmental conditions • Smooth surfaces • No re-infections due to flawless design • Resistant to cleaning agents • Beveled edges • CIP-capable design • Stainless steel connector plug	• Easy to clean • No distribution of bacteria • The motors do not spread microorganisms in production areas • When the product is open, no cooling air blows in the direction of the product • Further cost improvement possibilities with highly efficient permanent magnet synchronous motors

SPIRAL FREEZER

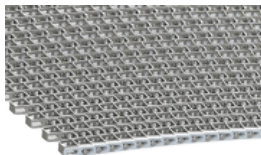
Some baked goods are frozen directly after cooling to extend shelf life and support downstream logistics such as storage, transport, or bake-off preparation. In the freezing stage, the products are exposed to a controlled stream of cold air that rapidly lowers their core temperature. This quick-freeze method prevents moisture migration, protects the structure of the crumb, and preserves product quality without causing damage or deformation.

Rapid freezing also helps maintain freshness by locking in the product's texture, aroma, and shape. Once the required temperature is reached, the goods exit the freezer and continue to the next stage of the process, such as metal detection, packaging, or long-term storage.

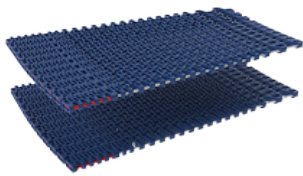


Spiral freezer

SPIRAL FREEZER PRODUCT MATRIX

	Product	Features	Customer Benefits
Freezing Spiral	 Cambridge Cam-Grid™ Belt	This belt, made for drum-driven spiral cage systems, comes in pitches from 3/4" to 1,5". Featuring spring-temper stainless steel mesh overlays. It resists fatigue and damage, is fully collapsible for easy cleaning, and can be flipped to extend life in radius setups. Mesh options include tight openings for delicate items and open areas for better airflow. The belt can run straight or turn, offers several collapsibility choices, and has optional side-link attachments for product retention.	The spiral belt's stainless-steel, flip-able design maximizes durability and lifespan, reducing downtime. Its collapsible structure makes cleaning quick and lowers operational costs. Various mesh overlays improve handling and support, even for delicate products, while open areas boost airflow for better thermal processing. Optional side-link attachments maintain product placement and cut losses. It handles straight runs and turns, offering flexibility for diverse spiral applications.
Freezing Spiral	 Cambridge Cambri-Link™ Belt	This belt suits both spiral cage and straight-line setups with a wide mesh for better airflow. Its collapsible design and oblong slot pickets make cleaning easier and reduce bacteria build-up. The positive-drive system keeps product flow steady and smooth, while the flat surface boosts stability. Efficient and cost-effective, ideal for tough processing needs.	This durable, hygienic belt boosts airflow for efficient cooling, freezing, or drying, and its collapsible design reduces sanitation time and bacterial risks. The positive-drive system prevents jams, keeps products stable, and offers high tension capacity for reliable, cost-efficient operation with less maintenance and more uptime.
Freezing Spiral	 Cambridge Duralite™ Belt	DuraLite is designed for spiral cage applications, offering the highest strength-to-weight ratio. It's twice as strong as rods-only belts and 35% stronger than standard 1" x 1" types. The 3" x 1" mesh provides twice the open area of plastic belts for better airflow and cooling, while DuraLite remains up to 40% lighter than conventional options—reducing energy use and mechanical stress. The open mesh also improves hygiene and cleaning.	The belt offers high performance and durability with increased load capacity and no added weight, leading to longer belt life and less maintenance. Its larger open area boosts airflow for faster, more consistent cooling or freezing. Reduced weight lowers energy use and equipment wear, extending system life. The easy-to-clean mesh pattern saves time on sanitation and helps meet food safety standards efficiently.

SPIRAL FREEZER PRODUCT MATRIX

	Product	Features	Customer Benefits
Freezing Spiral	 Rexnord KleanTop 6400 Series	• The patented PowerKey™ allows tension to be carried by more of the belt • Improved belt strength, thanks to Stainless Steel rods • 45% open area design allows for airflow • Easy-to-replace cam rollers to reduce maintenance and installation times • New “BSE” flame retardant material increases plant and employee safety	• Increased productivity and useful life of the belt • Stronger belt enables greater carrying capacity • Reduced building costs with broader spans and less infrastructure • Reduces food safety and product release • Reduces maintenance time and cost
Freezing Spiral	 Bauer Gear Motor HiflexDRIVE Stainless Steel Gear Motors	• Protection rating IP67 / IP69K designed for very high cleaning intervals • Smooth surfaces • No re-infections • Resistant to cleaning agents • Beveled edges • CIP-capable design • Stainless steel connector plug • Highly robust housing	• Reduced bacterial growth • An extension of the production times by reducing the cleaning intervals • Fewer cleaning agents reduce costs and protect the environment • High chemical resistance • Increased safety in the entire production area
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8. Packaging & Palletizer

Packaging & Palletizer

“After slicing and inspection, baked goods are packaged, consolidated, and palletized to ensure protected, efficient handling and distribution.”

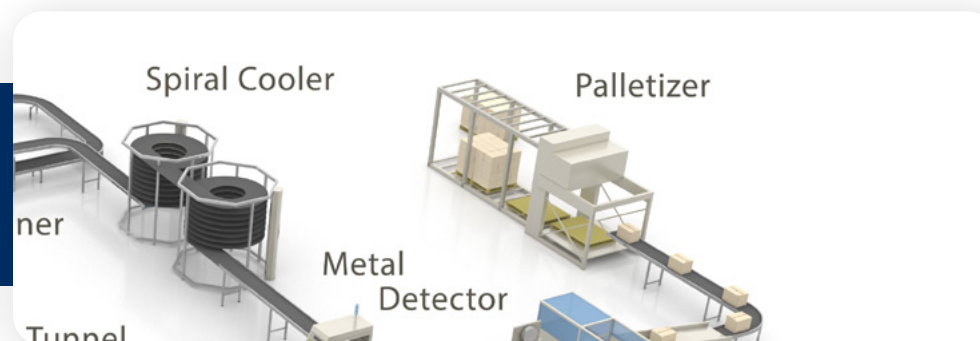
PACKAGING / PALLETIZER

After cooling or freezing, baked products pass through a metal detection system to ensure that no metal contaminants are present from earlier stages in the production line. Once cleared, items such as bread loaves may be sliced using high-speed band blades, which are set to the required spacing to achieve consistent and even slices in high-volume operations.

Following slicing, each product is packaged according to its specifications—typically bagged, sealed, and labeled to maintain freshness and support downstream logistics. Packaged loaves are then conveyed to the consolidation area, where they are grouped

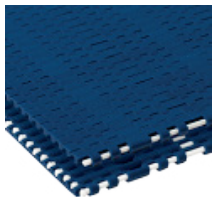
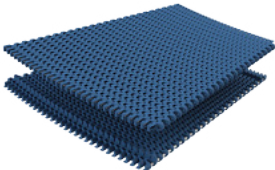
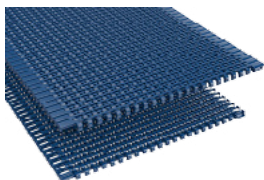
into totes, often in sets of 10 or 12. These totes are stacked to the required height and transported along live roller or modular belt conveyors to the palletizing zone.

In the palletizer section, the stacked totes or packaged goods are organized for stable pallet formation and prepared for transport. Depending on the setup, pallets may be manually removed or automatically transferred. For supermarket-owned bakeries or integrated retail operations, dedicated trailers often pick up the palletized goods for distribution to central warehouses before being routed to individual stores.

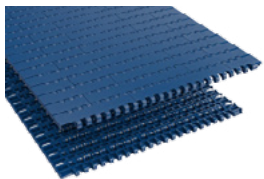
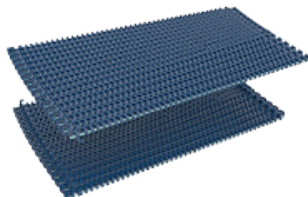


Packaging/palletizer

PACKAGING / PALLETIZER PRODUCT MATRIX

	Product	Features	Customer Benefits
Transfer/ Transport	 Rexnord 395 Series Mattop	- The innovative headless rod retention design enables straightforward removal using a screwdriver and ensures rod positioning throughout conveyance - The belt supports extended conveyor lengths, minimizing the number of components required for maintenance. Longer conveyor spans reduce the frequency of required transfers and efficient utilization of components such as drives and bearings further enhances operational performance.	- The headless rod retention system lets rods be removed quickly with a screwdriver, reducing maintenance time and downtime. Its secure design keeps rods in place, lowering stress and extending belt life by minimizing wear and breakage - Supporting longer conveyor spans, the belt reduces components and misalignment risks. The 395 KleanTop Belt creates smoother product flow with fewer transfers, lessening product damage and improving throughput and quality. Fewer components also limit debris buildup, making cleaning easier and helping maintain hygiene-essential for food applications.
Transport	 Rexnord KleanTop 505 Series Mattop	- Reinforced belt edges improve durability for challenging conveyor conditions. 10% open surface area enhances wash-through and sanitation access. - Plug-free retention mechanism streamlines assembly and disassembly. - Structural upgrades, including stronger edges and plug-less retention, support hygiene. - Designed for easier installation, maintenance, and repair. - NoseOver bars as small as 19.05 mm (3/4") allowing integration with tight-transfer conveyors. - BSE V2 class flame-retardant material is now standard for increased safety.	- Stronger edges and plug-less rods minimize contamination risk and aid food safety compliance. - Open area supports better cleaning and simpler hygiene practices. - Simplified design reduces downtime during installation and repairs. - Compatibility with small nose-over profiles enables smoother product handling in limited spaces. - Flame-retardant materials boost safety and extend service life.
Transport	 Rexnord KleanTop 590 Series Mattop	- Headless rod design enables easy rod removal with a screwdriver - Uses a single rod per beltrow - Sprockets optimisations reduce product damage - Open hinge area improves cleaning access, efficiency, and minimises water/chemical use - Rod retention system securely holds the rod in place - Reinforced edges help prevent belt breakage and contamination - Open hinge increases abrasion resistance, reducing rod wear.	- Maintenance interruption are minimized - Production output and product quality are higher - Sanitation processes require less downtime - Water and chemicals use is reduced - Food safety measures are optimized to prevent contamination - Early belt failures are less likely to occur.

PACKAGING / PALLETIZER PRODUCT MATRIX

	Product	Features	Customer Benefits
Transport	 Rexnord KleanTop 1090 Series MatTop	• Headless rod design enables easy rod removal with a screwdriver • Uses a single rod per beltrow • Sprockets optimisations reduce product damage • Open hinge area improves cleaning access, efficiency, and minimises water/chemical use • Rod retention system securely holds the rod in place • Reinforced edges help prevent belt breakage and contamination • Open hinge increases abrasion resistance, reducing rod wear.	• Maintenance interruption are minimized • Production output and product quality are higher • Sanitation processes require less downtime • Water and chemicals use is reduced • Food safety measures are optimized to prevent contamination • Early belt failures are less likely to occur.
Transport	 Rexnord KleanTop 1600 Series MatTop	• Rexnord KleanTop 1600 Series is stronger and stiffer than leading competitors' belts • Increased throughput from a flat belt matched with higher strength • 38% open area and plug-less rod retention • Friction top belt maintains the product's position on belt inclines, indexes and side-flexing conveying applications	• Extended belt life • Lower conveyor runs reduce drives, supporting components and associated maintenance • Reduces downtime with easy installation, maintenance and repair
Transport	 Link-Belt® Seamaster™ Mounted Ball Bearing	• Housing Styles: Pillow Block, Flanges, Hanger, Take-Up, and ER • Locking Options: Setscrew and Concentric • Bore Diameter Size Range: • Imperial: 3/4" to 2-7/16" • Metric: 20 to 60 mm • Housing Material Options: 316 Stainless Steel, High Strength Composite	• Enhanced washdown resistance due to material of bearing and high performance seal resulting in lower total cost of ownership and longer life • Reduced maintenance/corrosion • Increased ease of sanitation • Meets IP69K standards with stainless steel housing providing a solution that industry assumes the system is cleaner and safer/ higher performing across the industry

PACKAGING / PALLETIZER PRODUCT MATRIX

	Product	Features	Customer Benefits
Transport	 Bauer Gear Motor HiflexDRIVE Stainless Steel Gear Motors	• Protection rating IP67 / IP69K designed for very high cleaning intervals • Smooth surfaces • No re-infections • Resistant to cleaning agents • Beveled edges • CIP-capable design • Stainless steel connector plug • Highly robust housing	• Reduced bacterial growth • An extension of the production times by reducing the cleaning intervals • Fewer cleaning agents reduce costs and protect the environment • High chemical resistance • Increased safety in the entire production area
Transport	 Bauer Gear Motor HiflexDRIVE Aseptic Gear Motors	• Protection rating IP67 / IP69K designed for very high cleaning intervals • Special paints protect against aggressive acids, alkalis and salts, as well as aggressive environmental conditions • Smooth surfaces • No re-infections due to flawless design • Resistant to cleaning agents • Beveled edges • CIP-capable design • Stainless steel connector plug	• Easy to clean • No distribution of bacteria • The motors do not spread microorganisms in production areas • When the product is open, no cooling air blows in the direction of the product • Further cost improvement possibilities with highly efficient permanent magnet synchronous motors

A background image showing two bakery workers. On the left, a man wearing a grey cap with the 'RegalRexnord' logo, safety glasses, and a yellow high-visibility vest is smiling. On the right, a woman wearing a black cap and an orange high-visibility vest is seen from the side. The image is overlaid with a dark blue and green geometric design.

PREMIUM SERVICES FOR BAKERY

Premium Services for Bakery

“Our Premium Services package delivers expert on-site spiral system assessments to ensure safe operation, correct belt selection, and reliable performance across bakery proofing, cooling, and freezing applications.”

PREMIUM SERVICES FOR BAKERY

Premium Services for Spiral Cage Systems in the Bakery Industry

Keeping spiral cage conveyor systems operating at peak performance is essential for bakeries where uptime, food safety, and product quality directly impact output and profitability. Our Premium Services offering provides a structured, expert-driven approach to evaluate, optimize, and future-proof your spiral systems—regardless of whether they operate in freezing, cooling, proofing, cooking, or ambient environments.

Purpose: Expert Assessment for Maximum Performance & Safety

Our Premium Services program is designed to deliver a comprehensive and accurate evaluation of your spiral cage conveyor systems. By combining advanced measurement techniques with deep application expertise, we assess system health, safety risks, and mechanical performance. This results in clear recommendations for optimal belt selection, tensioning, and long-term reliability. Through this process, bakeries gain:

Higher system uptime

- Improved product handling and reduced waste
- Lower maintenance burden and fewer unplanned interventions
- Verified safety compliance and reduced operational risk

These benefits are validated by industry data showing significant cost avoidance and lifecycle savings for bakeries using optimized spiral systems (as demonstrated in Food Application Spotlight - Spiral Conveyors in Bakery).

Where Premium Services Are Used

Our services support spiral systems across the full spectrum of bakery and food-processing applications, including:

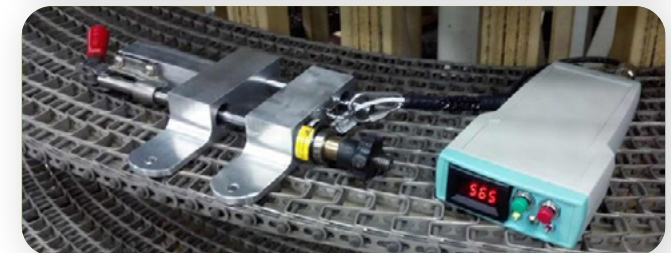
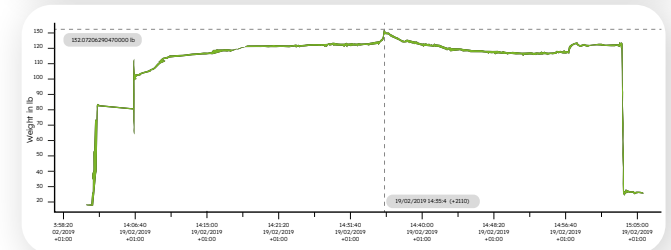
- Freezers & Coolers – ensuring stable low-tension operation, clean belt engagement, and minimal wear debris.
- Proofers – securing consistent belt tracking and product orientation stability.
- Cookers & Thermal Spirals – validating material suitability, drive load behavior, and long-term component durability.
- Ambient Systems – optimizing layout efficiency and ensuring dependable continuous flow.

These processes support bakery, protein, fruit & vegetable, and ready-to-eat production environments.

Spiral System Types Covered

Our engineers are trained to inspect and optimize all major spiral configurations:

Tension point	Belt strength	Units	Type	Tensions	pass/fail	Type	Tensions	pass/fail
Tangential Tension	250	lb	Clean	237	PASS	Dirty	395	FAIL
T1	400	lb	Clean	31	PASS	Dirty	31	PASS
T2 (Entering Wrap)	400	lb	Clean	36	PASS	Dirty	40	PASS
T3 (Wrap EXit)	400	lb	Clean	36	PASS	Dirty	40	PASS
T4	400	lb	Clean	45	PASS	Dirty	55	PASS
T5 (Infeed)	250	lb	Clean	71	PASS	Dirty	95	PASS
T6	400	lb	Clean	262	PASS	Dirty	436	FAIL
T7 (Discharge)	400	lb	Clean	268	PASS	Dirty	445	FAIL



Characteristic	Value		
Belt Weight	5.71 lb		
Belt Length	1570 ft		
Belt Life Assessment	Years	Hours	Cycle
	5.67	35400	40000
	8.51	53101	60000
	11.35	70801	80000
	14.18	88501	100000
	17.02	106201	120000

PREMIUM SERVICES FOR BAKERY

Low Tension Spirals (Traditional)

Ideal for consistent, gentle product handling, but highly sensitive to tension imbalance and system contamination.

Active Drive Spirals (Positive Engagement)

Deliver predictable belt motion and reduced tension peaks, making them suitable for high-throughput or sanitation-critical operations.

Edge-Driven Spirals (Efficient Footprint)

Allow flexible layouts and space-saving designs while requiring precise alignment and consistent load distribution.

These categories align with the challenges and pain points identified in Spiral Cage Digital Experience Content, such as belt tension, product waste, sanitation issues, and maintenance complexity.

Key System Checks Performed

During each Premium Services engagement, we complete a detailed mechanical and operational assessment, including:

Cage Geometry & Belt Dimensions

Ensuring the spiral structure and belting are correctly matched to prevent tension spikes, fatigue, premature wear, or misalignment.

Drive and Overdrive Details

Verifying drive system settings, sprocket condition, friction interface behavior, and load distribution to ensure smooth, safe operation.

Infeed & Discharge Lengths

Assessing transition areas for alignment, smooth product transfer, and optimal tension distribution.

These checks help reduce product damage and downtime, themes highlighted in materials such as the Bakery Playbook.

On-Site Inspection Services

Our Premium Services offering includes a thorough on-site inspection performed by trained specialists. The evaluation typically covers:

System Setup Verification

Checking installation quality, spiral alignment, and mechanical condition of key components.

Belt Condition Assessment

Identifying wear patterns, fatigue indicators, sanitation risks, and opportunities for improved belt selection.

Mechanical Component Review

Inspecting bearings, motors, gear units, rails, wearstrips, and tensioning elements to prevent failure before it occurs.

Tension & Load Measurements

Using specialized tools to measure belt tension, overdrive performance, and load consistency for optimized system performance.

These activities directly address common industry challenges such as cleaning difficulty, product jams, wear debris, and alignment issues documented in internal spiral-system content

REFERENCES IN BAKERY

REFERENCES IN BAKERY

NEW HORIZON BAKERY (6400 SERIES)

Challenge

New Horizon Bakery produced approximately 200,000 English muffins per day and experienced frequent issues with their metal spiral belt. Splicing and repairs were required two to three times per month, with each repair taking up to three hours. In addition, food grade oil had to be applied to the rails weekly, adding significant maintenance time. These issues led to product waste, lost revenue, and constant concern over unexpected failures, resulting in estimated monthly costs of around \$35,000, including maintenance, waste, oiling, and overtime.

Solution

Regal Rexnord replaced the existing metal belt with a **Rexnord 6400 Series Plastic Spiral Belt with BSE material**. Proper belt selection, expert installation, and on site maintenance and cleaning training were provided. The new belt eliminated the need for oiling and reduced repair time to a simple five minute intervention by a single technician. Repairs could be performed without removing product from the spiral, eliminating contamination risk.

Results

- Maintenance time and repair complexity were dramatically reduced
- Product waste during repairs was eliminated
- Metal contamination risk was removed
- Line availability and operator confidence improved significantly
- Overall operating costs were substantially lowered

As stated by the Maintenance Manager:

“The new plastic belt is super simple to maintain and repair... product can remain on the spiral, which means faster start up and less waste.”



REFERENCES IN BAKERY

BAKERY SPIRAL OPTIMIZATION (CAMBRIDGE DURALITE® BELT)

Challenge

A baking manufacturing facility operating four spiral cage systems experienced significant operational challenges due to poor belt performance. The existing systems relied on a $\frac{3}{4}$ " rod only belt that struggled to handle the high production demand. Operating under 100 lbs. of tension, the belt failed to meet throughput requirements, leading to frequent splicing and unplanned downtime.

Across the four spiral systems, a total of 96 splices per year were required, with each downtime event resulting in an average revenue loss of **\$9,000 per hour**. When combined, these stoppages led to an estimated annual revenue loss of **\$864,000**, driven by production interruptions and ongoing belt repair needs.

Solution

To address these challenges, the facility partnered with Regal Rexnord for an optimized spiral belt solution. Regal Rexnord application and industry experts recommended retrofitting the existing spiral systems with a **Cambridge DuraLite® Belt**. The DuraLite belt features a **400 lbs. tension**

rating, significantly higher than the original belt, and is specifically designed to support higher speeds and increased throughput. In addition, the belt delivers a substantially longer service life—**four times longer** than the previous $\frac{3}{4}$ " rod belt—reducing the need for frequent splicing and lowering maintenance demands. This solution not only resolved the tension limitations but also improved overall system reliability and efficiency.

Results

- Splice frequency reduced from **96 splices per year** to **just 24 splices per year** across four spiral cages
- Maintenance interruptions significantly decreased
- Production uptime improved and operational disruptions minimized
- Approximately **\$648,000 in annual revenue recovered** (from \$864,000 to \$216,000 in estimated losses)*
- Overall spiral system performance, throughput, and reliability substantially increased

*Savings are approximate and based on internal estimates; actual results may vary.



REFERENCES IN BAKERY

BAGEL FACILITY SPIRAL COOLING OPTIMIZATION (CAMBRIDGE™ ACTIVE DRIVE™ METAL BELT)

Challenge

At a high volume bagel manufacturing facility, the spiral cage cooling system faced serious operational challenges due to excessively high belt tension. This high tension caused increased strain and wear on the belt and equipment. Frequent belt pulsation led to product misalignment, requiring operators to manually reorient bagels during production.

These labor intensive interventions consumed significant time and resources, while the inefficient cooling process resulted in substantial product loss. Together, these issues negatively impacted the facility's productivity, operational efficiency, and overall profitability.

Solution

To resolve these challenges, the facility partnered with Regal Rexnord to implement a customized solution. Based on recommendations from Regal Rexnord's industry and application experts, the existing spiral system was retrofitted with a **Cambridge™ Active Drive™ Metal Belt**.

This solution was specifically designed to reduce belt tension while maintaining smooth, consistent operation. The retrofit successfully reduced belt tension by 50%, significantly decreasing mechanical stress on the system. In addition, the Active Drive belt eliminated the need for manual bagel reorientation, allowing the cooling line to operate more efficiently with reduced labor intervention.

Results

- **50% reduction in belt tension**, resulting in smoother, more reliable operation
- Elimination of manual product reorientation
- Labor savings of over **\$240,000 annually***
- Reduced wear and tear on equipment
- Improved cooling consistency and increased production capacity
- Higher overall efficiency and profitability of the spiral cooling operation

*Labor savings calculated at \$30 per hour for two employees over two shifts, with 250 production days per year.





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