



Case Study

LOMA PROVIDES TURNERS WITH A RECIPE FOR SUCCESS

Allied Bakers, Turners - the Nottingham-based subsidiary of Associated British Foods - has just installed Loma's management information system.

"Loma's management information system helps us maximise production efficiency and reduce wastage," says Mukesh Mistry, Manufacturing Manager at Allied Bakeries, Turners. "It also provides us with proof of due diligence for Weights and Measures legislation and helps us meet ISO 9000 requirements.

"A leading supplier of a variety of breads and rolls - such as Allinson, Sunblest and Kingsmill - to major UK supermarkets, Turners regards quality inspection equipment as critical to its success. Its philosophy is one of continuous improvement through rigorously maintained quality management and its aim is to provide its customers with quality assured products. In line with this policy, Turners has also installed four Loma 6000 dough checkweighers and eight Loma 7000 Combo integrated metal detection and checkweighing systems.

"We chose Loma as they were able to work with us in tailoring equipment to match our needs," says Mukesh Mistry.

The dough checkweighers are situated at the beginning of each of two production lines after the dough rounder. On each line, once the dough has been mixed, it is conveyed to a rounder and divider. This separates the dough into individual dough balls which are distributed onto two conveyor lanes. On each lane is a checkweigher. Any dough balls which do not fall within the correct weight parameters are automatically rejected into a bin situated beneath the weighscale and recycled. Previously, manual checks were carried out every 15 minutes.

Since installing the checkweighers, Turners has benefitted from significant staffing savings as well as cost savings as a result of drastically reducing the amount of product giveaway and wastage. Previously, loaves which had been cooked and subsequently found to be underweight would have to be discarded at the end of line after they had accumulated more value through processing.

The printouts produced by the checkweigher are further proof of compliance with weights and measures legislation.



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Loma's dough checkweighers have been specially developed for the bakery industry. They are particularly easy to take apart and clean, with quick release mechanisms, gearboxes and conveyors. They are also designed to be adjusted easily - so that the line only needs to be stopped for the minimum amount of time. This is critical in a bakery where time for each stage of bread production is particularly important.

From the checkweighers the dough balls are then moulded and transferred into greased tins and then onto the prover and ovens. From the ovens the bread is automatically batched and cooled. From the cooler, the loaves are transferred to four packaging lines where they are sliced, automatically bagged, sealed and tagged. At the end of each of the eight packaging lines - four for each production line - is situated a Loma 7000 Combo integrated checkweighing and metal detection system. After the bread has been sealed and tagged, it passes over a weighscale and through a metal detector, both controlled by one panel for maximum efficiency.

If the product is under or overweight it is automatically rejected into a bin beneath the conveyor. Should a contaminant be found by the metal detector, a mechanism rejects the bread off the line into a separate bin. Installing the combos at the end of line provides complete assurance to customers that each of the 1 million products produced each week have been individually quality checked before distribution. Once leaving the metal detector, the bread is then batched into 10, placed in baskets and stacked, logged out and stored before distribution the same day.



The Loma management information system - situated in the production office - monitors all the Loma equipment in the factory. It gathers information from the equipment which is displayed as graphs and charts in an easy to use Windows format. Working closely with Allied Bakeries, Turners, Loma adapted the system specially to suit the company's individual requirements.

The system includes a screen update feature to show when each checkweigher was last calibrated, in line with weights and measures regulations.

As a result of installing Loma's management information system the operator can identify at a glance the total downtime, the amount and value of product giveaway, and equipment which is causing

line deficiency. This enables problems to be identified, analysed and sorted quickly and easily to increase line efficiency. It also enables an operator to look back over shifts and batches to spot patterns and increase efficiencies by preventative intervention.

The status reports produced are used as proof of compliance with weights and measures legislation and for ISO quality requirements.

"The benefits of installing quality inspection equipment are numerous," says Mukesh Mistry. The checkweighers enable us to prevent product giveaway and use the excess dough rather than waste it.

The metal detectors ensure that our products meet safety regulations and customer requirements and Loma's management information system enables us to monitor production and efficiency

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levels of all our equipment on all our lines. We have also been able to achieve savings through rationalising our staffing needs as the equipment replaces manual operations and is particularly easy to use."
