

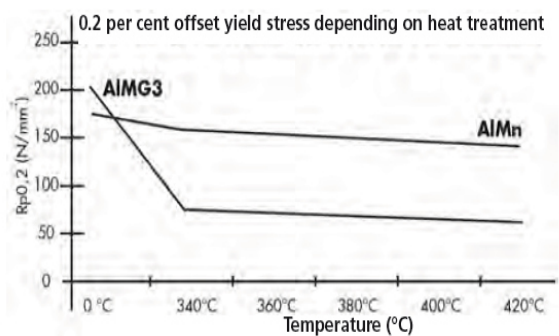
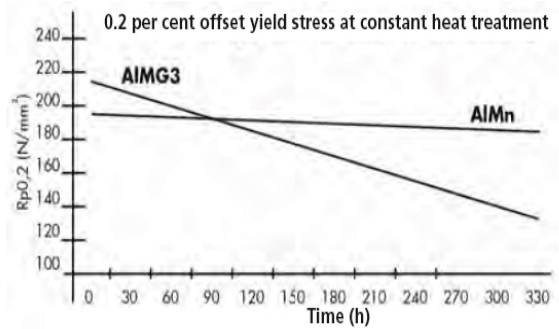
## A.1 All you need to know about our baking trays and tin sets

### Aluminum-manganese - the more stable solution

The true stability of a baking tray only comes to light during actual baking. Having to withstand long-term use in the oven and temperatures of around 230°C, AlMn proves to be the more dimensionally stable alternative to the AlMg 3 alloy, which was previously used. As shown in the graph, AlMg 3 has a slightly higher stability when not exposed to heat, however, this stability decreases with every baking and after a short time is significantly lower than the stability of AlMn. This is the key advantage of aluminium-manganese (AlMn).

### Aluminium-manganese is more heat resistant

When perforated trays undergo a non-stick coating process, the coating is fired at about 420°C. The graph based on a study by the Institute of Ferrous Metallurgy at the RWTH Aachen, shows clearly, that AlMg 3 - after only one single heating at 340°C - loses almost half of its original stability and 'anneals', while the AlMn curve practically remains constant and the material almost nearly retains its original stability.

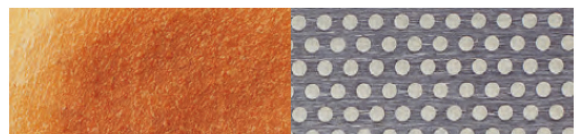


### EN 485-4

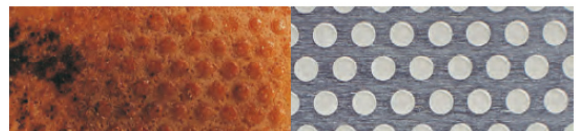
When sheet metal is fabricated, barely perceptible variances, e.g. in material thickness, can result in significant differences in quality. It is of the utmost importance for us to be able to ensure and guarantee quality of the highest consistency. Therefore, all our aluminium sheets comply with the requirements of the EN 485-4 EN norm. All our production steps are documented accordingly and our suppliers must adhere to these standards.

### The crucial millimetre

We questioned why the holes in perforated trays have to have a diameter of 3 mm. Then we made them smaller and invented a new product - the micro-hole tray. And the benefits? Complete customer-orientation. Traditional perforated trays have a severe disadvantage. Bread rolls grow 'mushrooms' through the holes of perforated trays. What many describe as 'sticking' or 'glueing' has, however, a purely mechanical cause. The dough pushes through the holes and forms a dough 'mushroom' on the bottom of the tray. During the baking process, this hardens and the roll remains firmly attached to the tray. So, it is not without pride, that we can say that we have solved this problem with the micro-hole tray.



With our 2.0 mm micro-hole trays, this mushrooming no longer occurs and the bottoms of the trays remain completely smooth.



Trays with round 3.0 mm perforation holes are prone to rolls sticking to them due to this mushrooming.



Flattened or round channels

### Channels

In addition to our standard 'round' and 'flattened' channels, we supply a wide variety of different forms. A list of all the channel configurations is available at our sales office. On request, customer-specific channels are available.