



SWEET TREATS AND MORE!

BAKING FORMULAS



BAKERY SHORTENING TIPS



OBSERVATIONS/TIPS ON CONVERTING TO AND HANDLING NON-PHO

- In general palm shortening flavor and mouthfeel differences can be noticed in items with large amounts of fat (20%+ fat content).
- If the customer does not have temperature controlled areas (air conditioning/heating) palm can be hard when it is very cold and soft when very hot.
- In hot temps, some palm products can eventually leak or “wick” through the case making them unuseable.
- Soy shortenings can be soft in high heat, but they can be refrigerated without becoming too hard to work with.
- Mixing too long or too fast can cause issues in the batter.

BAKERY SHORTENING TIPS

PHO PRODUCT INITIAL SUB/ SOLUTION GUIDE

Tool to aid in recommending initial non-PHO products to try when converting

1. Select current category of PHO product in left column
2. Choose type of bakery customer from top of chart
3. Choose dominant finished products involved from 2nd column
4. Find recommended solution/s where intersection occurs

SHORTENING CATEGORY FINISHED PRODUCTS	AVG % OF SHORTENING IN FORMULAS	RETAILSHOP/ NON TEMP CONTROLLED PRODUCT TO USE	RETAIL SHOP TEMP CONTROLLED PRODUCT TO USE	WHOLESALE TEMP CONTROLLED PRODUCT TO USE	MANUFACTURER TEMP CONTROLLED PRODUCT TO USE
DONUT DOUGH & BATTER BATTER	YEAST RAISED	10%	I.E. SOY	PALM/I.E. SOY	PALM/I.E. SOY
	CAKE DONUTS	9%	I.E. SOY	PALM/I.E. SOY	PALM/I.E. SOY
DONUT FRYING BATTER	YEAST RAISED		I.E. SOY	PALM/I.E. SOY	PALM/I.E. SOY
	CAKE DONUTS		I.E. SOY	PALM/I.E. SOY	PALM/I.E. SOY
ALL PURPOSE	COOKIES CUT	15%	I.E. SOY	PALM/I.E. SOY	PALM/I.E. SOY
	COOKIES BUTTER/BAG	18%	I.E. SOY	I.E. SOY	PALM/I.E. SOY
	PIE DOUGH	30%	I.E. SOY	I.E. SOY	PALM/I.E. SOY
	BISCUITS	16%	I.E. SOY	PALM/I.E. SOY	PALM/I.E. SOY
CAKE	BREAD DOUGH	3%	I.E. SOY	PALM/I.E. SOY	PALM/I.E. SOY
	LAYER CAKE	10-12%	I.E. SOY	PALM/I.E. SOY	PALM/I.E. SOY
ICING	POUND CAKE	17%	I.E. SOY	PALM/I.E. SOY	PALM/I.E. SOY
	BUTTER CREAM	15-25%	I.E. SOY	I.E. SOY	PALM/I.E. SOY
	FUDGE	15%	I.E. SOY	PALM/I.E. SOY	PALM/I.E. SOY
MARGARINE	LIGHT CREAM FILLING	30%	I.E. SOY	I.E. SOY	PALM/I.E. SOY
	SWEET DOUGH	9%	I.E. SOY	PALM/I.E. SOY	PALM/I.E. SOY
ROLL IN DANISH/ SWEET DOUGH/ PUFF PASTRY	CROISSANT	50%	I.E. SOY	I.E. SOY	PALM/I.E. SOY
	SWEET DOUGH	9%	I.E. SOY	PALM/I.E. SOY	PALM/I.E. SOY
	CROISSANTS	50%	I.E. SOY	I.E. SOY	PALM/I.E. SOY
	DANISH	50%	I.E. SOY	I.E. SOY	PALM/I.E. SOY
	PUFF PASTRY	50%	I.E. SOY	PALM/I.E. SOY	PALM/I.E. SOY

BAKERY SHORTENING TIPS

PREMIUM SHORTENING BENEFITS

LOW COLOR PALM

Low color palm addresses 4 key negatives of palm shortenings

- FLAVOR
- ODOR
- COLOR
- STABILITY

HIGH-OLEIC SOYBEAN OIL

High in monounsaturated fat and low in polyunsaturated fat

- PREMIUM STABILITY
- EXTENDED DONUT FRY LIFE

Both palm and soy products can become very soft and soupy in warm / hot temperatures. Conversely, in cold / refrigerated temps, they can become extremely hard and unworkable. Ideal storage temps for these products would be 65-75 degrees

SHORTENING OPTIONS

PALM OIL

PROS

- Works best in low fat applications (Under 26% fat)
- Most common current option
- Readily available
- Cost competitive
- Palm is Non-GMO

CONS

- Not as bright white
- Can have off flavors or odors
- Narrow storage temperature range*
- Imported
- Not viewed as a "sustainable" oil by some
- Challenged in icings and laminated doughs

SOYBEAN OIL

PROS

- Typically bright white
- Domestically sourced
- Clean flavor and odor
- Cost competitive

CONS

- Narrow storage temperature range*
- Challenged in high fat applications, i.e. icings, Danish
- "Hydrogenated" on the label**

** Both palm and soy products can become very soft and soupy in warm / hot temperatures. Conversely, in cold / refrigerated temps, they can become extremely hard and unworkable. Ideal storage temps for these products would be 65-75 degrees*

*** This product line contains only fully hydrogenated oil which contains zero trans-fat. Only partially hydrogenated oil contains trans-fat*

Any I.E. shortening not made with high-oleic soybean oil will have higher polyunsaturated fats, which are more susceptible to oxidation. Please conduct extended shelf life studies on the finished product.

BAKERY SHORTENING TIPS



- Maintain recommended storage conditions and usage temperature for all types of shortenings, especially non-PHO shortenings, both palm and IE. In doing so you will always achieve the desired performance and functionality of the finished baked goods.
- Making adjustments in your process conditions such as mixing time, amount of water and/or creaming of shortening with flour or sugar may be necessary.
- Proper proofing is a vital part of specialty bakery applications such as Danish, Puff Pastry and Croissants. To achieve optimum results, pay close attention to relative humidity (RH) of the proofer and the required proofing time for that specific application. High and/or low RH and improper proofing time could result in poor performance of the finished product.

SPECIFIC GRAVITY ICINGS

Specific gravity is a way to measure the air added into icing or batter. It is the weight of a cake batter or icing in an empty cup, compared to the weight of water in the same cup. For example, if the cup weighs 16 ounces with water in it, and 14 ounces with batter or icing in it, then you divide 14 by 16 to determine a specific gravity of 0.875.

To help make this clear, the average specific gravity for the most common icings made in the United States is listed below:

- American Butter Cream 0.85 to 0.90
- American Chocolate Butter Cream 0.90
- Fudge 0.95
- Swiss-French Style Icing 0.80

The average butter cream formula in the U.S. is 2 parts sugar to 1 part shortening, and about 10% water (see below). For a silky smooth butter cream, try replacing half the sugar with icing fondant.

LBS./OZS.	PERCENT	INGREDIENTS	METHOD
10 --- 5 --- --- 0.5 --- 4	58.7% 29.4% 0.2% 1.5%	6X Sugar ALPINE® Shortening Salt Non-Fat Milk Solids (optional)	Place in mixing bowl
1 12 --- ---	10.3%	Water (variable) Flavoring (to taste)	Combine. Add one third and mix at a low speed (2nd on 4 speed) for 3-4 minutes. Gradually add remaining water and vanilla. Scrape down and continue mixing for approximately 10 minutes or until smooth. If a lighter icing is desired, use third speed.
10 lbs	100%	Total	

Notes: Use Non-Fat Dry Milk only if a quick drying icing is desired.

Please visit www.stratasfoods.com/product-support to watch videos offering tips on bakery applications.

SPECIFIC GRAVITY CAKES



If the grain of your cakes is too open and is uneven, the specific gravity should be adjusted and the mixing time needs to be shortened.

If the grain is too tight and the cake is too dense, the batter needs to be mixed longer.

Below is the average specific gravity for the most common cake types. This is a general guide and you can adjust the specific gravity as needed.

- Pound Cakes & Cream Cakes 0.90. This is the simplest type of cake. A classic pound cake is made with a pound each of shortening, sugar, eggs, and flour.
- Shortening (and Oil) Layer Cakes 0.80. Chocolate, yellow, and white classic American layer cakes.
- Angel Food Cake 0.30. This type is made with egg whites alone and no yolks.
- Genoese 0.50. This type of sponge cake is made with whole eggs rather than just egg whites.
- Chiffon Cake 0.50. A classic chiffon cake is a cross between an oil cake and a sponge cake. Eggs are separated and the whites are beaten then folded into the batter.

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SWEETEX® 140% WHITE CAKE

LBS./OZS.	PERCENT	INGREDIENTS	METHOD
2 3.5 3 2 --- 4 --- 0.80 --- 1.5	22.3% 31.2% 2.7% 0.5% 1.0%	Cake Flour Sugar Non-Fat Dry Milk Salt Baking Powder	Blend together.
2 1.75 1 13	11.1% 18.3%	Sweetex® Shortening Water	Add Sweetex® and 2/3 of the water and mix on speed 1 using a flat paddle. Add remaining water while mixing. Turn mixer to speed 2 and beat 1 min. Scrape bowl and paddle, then mix 5 min. on speed 2.
1 2.5 --- 2 --- ---	11.6% 1.3% ---	Egg White Water Flavoring (to taste)	Turn mixer to speed 1 and add slowly. After 30 sec. stop mixer and scrape bowl and paddle. Blend on speed 1 for 3 min. Scale 350g (12 1/3 oz.) into 8-in. round, well-greased cake pans. Bake at 350°F for approximately 23 min.
10 lbs	100%	Total	

SWEETEX[®] 130% YELLOW CAKE

LBS./OZS.	PERCENT	INGREDIENTS	METHOD
1 1.8 2 3.7	11.1% 22.3%	Sweetex [®] Shortening Cake Flour	Place shortening in the bottom of the bowl first. Add cake flour. Mix together on low speed for 5 minutes.
2 14.2 --- 3.5 --- 2.1 --- 1.1 1 5.4	28.9% 2.2% 1.3% 0.7% 13.4%	Granulated Sugar Non-Fat Milk Solids Baking Powder Salt Water	Add to the above, mix on low speed for 1 minute, scrape down, and continue mixing for 4 minutes on low speed.
1 5.4 --- 10.7 --- ---	13.4% 6.7% ---	Whole Eggs Water Flavoring (to taste)	Add while mixing on low speed, scrape down and mix for 4 minutes on low speed. Scale into pans and bake at 365°F for 20-25 minutes for layers.
10 lbs	100%	Total	

SWEETEX® DOUBLE DUTCH FUDGE CAKE

LBS./OZS.		PERCENT	INGREDIENTS	METHOD
2	12	10.1	Sweetex® Cake & Icing	Use a paddle. Mix for 5 minutes on low speed if using a 3 speed machine or second speed on a four-speed machine. Scrape down the bowl and paddle at least once in this stage.
4	---	14.7	Shortening	
7	---	25.7	Cake Flour	
1	8	5.5	Granulated Sugar	
---	3	.7	Cocoa	
---	0.5	.1	Salt	
---	1	.2	Cinnamon	
---	3	.7	Baking Soda	
---	12	2.8	Baking Powder	
4	---	14.7	Non-Fat Dry Milk	
			Water	Scale off eggs, water, and flavor together and add approximately half of it to the bowl. Mix again until smooth, scrape down again. Then add the balance of the liquid ingredients and continue mixing for a total of 3 minutes in this stage, scraping down again to ensure a smooth batter. 7" layers – 10 oz. 8" layers – 13 oz.
3	12	13.8	Whole Eggs	
3	---	11.0	Water	
			Vanilla to taste	
27.22 lbs		100%	Total	

NUTEX[®] 120% WHITE CAKE

LBS./OZS.	PERCENT	INGREDIENTS	METHOD
2 3.5 2 12 --- 5.5 --- 0.75 --- 2.25 1 1	22.1% 27.4% 3.2% 0.5% 1.4% 10.6%	Cake Flour Sugar Non-Fat Dry Milk Salt Baking Powder Nutex [®] Shortening	Combine dry ingredients and Nutex [®] and mix on speed 1 for 1 minute.
1 7.75	14.8%	Water	Add water and mix on speed 1 using flat paddle for 1 minute. Scrape bowl and paddle, then mix 5 min. on speed 2 on a 3 speed mixer, speed 3 on a 4 speed mixer.
1 4.25 --- 11.75 --- ---	12.6% 7.4% --	Egg White Water Flavoring (to taste)	Add eggs, water and flavoring, and mix on speed 1 for 1 minute. Scrape bowl and paddle. Mix 2 minutes on speed 2 on a 3 speed mixer, speed 3 on a 4 speed mixer. Scale into well-greased cake pans. Bake at 360°F for approximately 23 min.
10 lbs.	100%	Total	

NUTEX[®] 120% YELLOW CAKE

LBS./OZS.	PERCENT	INGREDIENTS	METHOD
2 6.75 2 15.5 --- 3.75 --- 0.75 --- 2 --- 15	24.2% 29.7% 2.3% 0.5% 1.3% 9.3%	Cake Flour Sugar Non-Fat Dry Milk Salt Baking Powder Nutex [®] Shortening	Combine dry ingredients and Nutex [®] and mix on speed 1 for 1 minute.
1 4.75	13.0%	Water	Add water and mix on speed 1 using flat paddle for 1 minute. Scrape bowl and paddle, then mix 5 min. on speed 2 on a 3 speed mixer, speed 3 on a 4 speed mixer.
1 7.25 --- 8.25 --- ---	14.5% 5.2% --	Whole Eggs Water Flavoring (to taste)	Add eggs, water and flavoring, and mix on speed 1 for 1 minute. Scrape bowl and paddle. Mix 2 minutes on speed 2 on a 3 speed mixer, speed 3 on a 4 speed mixer. Scale into well-greased cake pans. Bake at 360°F for approximately 23 min.
10.0 lbs.	100%	Total	

NUTEX[®] 120% CHOCOLATE CAKE

LBS./OZS.	PERCENT	INGREDIENTS	METHOD
2 1.5 2 8.25 --- 6.75 --- 1 --- 2 1 4	20.9% 25.0% 4.2% 0.6% 1.3% 12.5%	Cake Flour Sugar Dutch Cocoa Salt Baking Powder Nutex [®] Shortening	Combine dry ingredients and Nutex [®] and mix on speed 1 for 1 minute.
1 7.5	14.6%	Water	Add water and mix on speed 1 using flat paddle for 1 minute. Scrape bowl and paddle, then mix 5 min. on speed 2 on a 3 speed mixer, speed 3 on a 4 speed mixer.
1 4 --- 13.5 --- ---	12.5% 8.4% --	Whole Eggs Water Flavoring	Add eggs, water and flavoring, and mix on speed 1 for 1 minute. Scrape bowl and paddle. Mix 2 minutes on speed 2 on a 3 speed mixer, speed 3 on a 4 speed mixer. Scale into well-greased cake pans. Bake at 360°F for approximately 23 min.
10 lbs.	100%	Total	

NUTEX[®] RED VELVET CAKE

LBS./OZS.	PERCENT	INGREDIENTS	METHOD
2 1.3 2 8.0 --- 6.7 --- 1.0 --- 2.0 1 4.0	20.8% 25.0% 4.2% 0.6% 1.3% 12.5%	Cake Flour Sugar Dutch Cocoa Salt Baking Powder Nutex [®] Shortening	Combine dry ingredients with Nutex [®] and mix on low for 1 minute.
1 7.4	14.6%	Water	Add water and mix on speed 1 using flat paddle for 1 minute. Scrape bowl and paddle, then mix 5 minutes on speed 2 on a 3-speed mixer, speed 3 on a 4-speed mixer.
1 4.0 --- 13.6 --- ---	12.5% 8.5% To Taste	Whole Eggs Water Flavoring (to taste)	Add eggs, water and flavoring, and mix on speed 1 for 1 minute. Scrape bowl and paddle. Mix 2 minutes on speed 2 on a 3-speed mixer, speed 3 on a 4-speed mixer. Scale into well-greased cake pans. Bake at 360°F for approximately 23 minutes.
10 lbs.	100%	Total	

NUTEX[®] YELLOW POUND CAKE

LBS./OZS.	PERCENT	INGREDIENTS	METHOD
2 5.6 1 11.2	23.5% 17.0%	Cake Flour Nutex [®] Shortening	Using paddle, cream flour and Nutex [®] together for 3 minutes on second speed. Scrape down at least once during mixing.
2 13.6 --- 1.6 1 1.6 --- 3.2	28.5% 1.0% 11.0% 2.0%	Granulated Sugar Salt Water Non-Fat Dry Milk	Add sugar, salt, water, and Non-Fat dry milk. Mix for 6 minutes on second speed. Scrape down at least once during mixing.
1 11.2 --- ---	17.0% To Taste	Whole Eggs Flavoring	Scale eggs and flavoring together. Add approximately ½ of it into the bowl. Using first speed, mix until smooth. Scrape down and mix until smooth again. Add balance of liquid ingredients and continue mixing for a total of 5 minutes in this stage, scraping down again to insure a smooth batter. Scale 1 pound of batter into a greased loaf pan and bake at 350°F for about 60-75 minutes.
10 lbs.	100%	Total	

Hymo® DEVIL'S FOOD CAKE

LBS./OZS.		PERCENT	INGREDIENTS	METHOD
10	6	26.0%	Granulated Sugar	Place dry ingredients and Hymo® in a mixing bowl and blend on first speed for 1 minutes. Add water and mix 1 minute on first speed. Scrape. Mix 3 minutes on second speed.
7	4	18.2%	Cake Flour	
2	10	4.0%	Dutch Cocoa	
1	10	1.5%	Non-Fat Dry Milk	
---	5	0.8%	Baking Powder	
---	3	0.5%	Salt	
---	3	0.5%	Baking Soda	
3	3	8.0%	Hymo® Cake & Icing Shortening	
6	6	16.0%	Water	
6	10	14.0%	Whole Eggs	
3	6	8.5%	Water	Gradually add water and soybean oil. Mix 1 minute on first speed. Scrape. Mix 3 minutes on first speed. Scale into desired pans and bake at 360° F.
1	13	2.0%	Sterling® Soybean Oil	
44 lbs.		100%	Total	

HYMO[®] WHITE CAKE

LBS./OZS.	PERCENT	INGREDIENTS	METHOD
11 3 10 --- --- 8 --- 3 3 13 5 14	28.2% 25.2% 1.3% 0.5% 9.6% 14.9%	Granulated Sugar Cake Flour Baking Powder Salt Hymo [®] Cake & Icing Shortening Water	Combine dry ingredients with Hymo [®] and mix 1 minute on first speed. Add water, mix 1 minute on first speed; scrape. Mix 5 minutes on second speed.
5 1 3 0 --- ---	12.8% 7.5% ---	Egg Whites Water Flavoring (to taste)	Add water and eggs. Mix 1 minute on first speed; scrape. Mix 3 minutes on second speed. Scale into desired pans and bake at 360°F.
39.6 lbs.	100%	Total	

HYMO[®] HARVEST CAKE

LBS./OZS.	PERCENT	INGREDIENTS	METHOD
5 9	22.3%	Granulated Sugar	Put all ingredients into bowl and mix 5 minutes on low speed. Scrape down bowl and paddle during mixing as needed.
2	8.1%	Hymo [®] Shortening	
4 5	17.2%	Cake Flour	
--- 8	2.0%	Non-Fat Milk Solids	
--- 2	0.5%	Salt	
--- 6	1.5%	Baking Powder	
--- 1	0.3%	Cinnamon	
--- 0.5	0.15	Allspice	
6 7	25.8%	Canned Pumpkin	
3 4	13.1%	Whole Eggs	Add slowly to above and mix 5 minutes on low speed.
1 8	6.1%	Molasses	Mix 2 minutes on low speed
--- 12	3.0	Water	Scale into desired pans and Bake at 350°F until done
25 lbs.	100%	Total	

WHIRL® CARROT CAKE

LBS./OZS.	PERCENT	INGREDIENTS	METHOD
4 11.3	18.8%	Eggs	Whisk on high until light and fluffy.
4 --- 5 14.5	16.0% 23.7%	Whirl® Sugar	In a separate bowl, whisk together and add to eggs. Mix well.
3 11.2 --- 2.4 --- 1.6 --- 1.0	14.9% 0.6% 0.4% 0.3%	All-Purpose Flour Baking Soda Baking Powder Cinnamon	In a separate bowl blend together. Remove about 15% and set aside. Add the remainder slowly to the egg mixture. Mix until just combined
4 11.0 1 10.0	18.8% 6.5%	Carrots (grated) Pecans (chopped)	Blend carrots and pecans together and coat with the remaining flour blend. Fold into batter. Pour into prepared pans. Bake 325°F until done.
25 lbs.	100%	Total	

WHIRL® CREAM CHEESE BROWNIE BASE

LBS./OZS.	PERCENT	INGREDIENTS	METHOD
2 1.3 1 0.5	20.8% 10.5%	Whirl® Unsweetened Chocolate	Blend Whirl® and chocolate together while heating until chocolate is melted. Allow to cool.
3 8 2 0.8 --- 3.8	35.0% 20.5% 2.4%	Sugar Eggs Vanilla	Cream together sugar, eggs and vanilla until blended (approximately 2 min on low). Scrape sides of bowl and paddle. Mix another 1 minutes on low speed.
1 1.3	10.8%	All-Purpose Flour	Mix in flour until blended (approximately 2 minutes on low speed). Scrape sides of bowl and paddle. Mix another 1 minute on medium speed. Pour into pan and set aside. Spread Cream Cheese Brownie Topping (50% of brownie base weight) evenly over brownie mixture and swirl through with a spatula Bake at 350°F 35-40 minutes, or until done.
10 lbs.	100%	Total	

Cream Cheese Brownie Topping for Cream Cheese Brownie Base on next page

CREAM CHEESE BROWNIE TOPPING

LBS./OZS.	PERCENT	INGREDIENTS	METHOD
2 1	41.3%	Cream Cheese	Cream together Cream Cheese, Sugar, Eggs and Salt. Mix 2 minutes on low. Mix 1 minute on medium.
--- 14	17.6%	Sugar	
--- 8	9.7%	Eggs	
--- 0.3	0.4%	Salt	Fold in chocolate chips.
1 9	31.0%	Chocolate Chips	
5 lbs.	100%	Total	Apply 50% of Brownie Base weight evenly over the brownie mixture and swirl through with a spatula.

NOTE: 1 batch of Cream Cheese Brownie Topping covers 1 batch of Cream Cheese Brownie Base

SWEETEX® RICH CHOCOLATE FUDGE ICING

LBS./OZS.	PERCENT	INGREDIENTS	METHOD
10 10 --- 1	52.7% 0.3%	6X Powdered Sugar Non-Fat Dry Milk Salt	Blend together.
2 15	14.6%	Sweetex® Shortening	Manually slice Sweetex® into small pieces. Add to mixing bowl and place bowl and paddle on mixer.
1 10.5 --- 1	8.2% 0.3%	Water Vanilla Extract	Slowly pour in water and flavoring and mix on speed 1 for 30 sec. Scrape bowl and paddle and mix for 3 min. Scrape bowl and paddle again and mix for 6 min.
3 5	16.5%	Chocolate Liqueur (melted)	Add and mix 1 min. on speed 1. Scrape down and mix 1 additional minute on speed 1.
1 8	7.4%	Evaporated Milk	Add slowly while mixing on speed 1 and mix until smooth.
19 lbs.	100 %	Total	

SWEETEX[®] BUTTER CREAM ICING

LBS./OZS.	PERCENT	INGREDIENTS	METHOD
6 9 --- 7 --- 0.33	65.3% 4.4% 0.2%	6X Powdered Sugar Non-Fat Dry Milk Salt	Blend together.
1 15	19.3%	Sweetex [®] Shortening	Manually slice Sweetex [®] into small pieces. Add to mixing bowl and place bowl and paddle on mixer.
1 1.5 --- ---	10.8% ---	Water Flavoring (to taste)	Slowly pour in water and flavor and mix on speed 1 for 30 sec. Scrape bowl and paddle and mix for 3 min. Scrape bowl and paddle again and mix for 6 min.
10 lbs.	100%	Total	

SWEETEX[®] DECORATOR ICING

LBS./OZS.	PERCENT	INGREDIENTS	METHOD
6 10.25 --- 5.75 --- 0.33	66.4% 3.6% 0.2%	6X Powdered Sugar Non-Fat Dry Milk Salt	Blend together.
2 0.25	20.1%	Sweetex [®] Shortening	Manually slice Sweetex [®] into small pieces. Add to mixing bowl and place bowl and paddle on mixer.
--- 15 --- 0.5	9.4% 0.3%	Water Flavoring	Slowly pour in water and flavoring and mix on speed 1 for 30 sec. Scrape bowl and paddle and mix for 3 min. Scrape bowl and paddle again and mix for 6 min.
10 lbs.	100%	Total	

ALPINE[®] CREAM ICING (50% FAT)

LBS./OZS.	PERCENT	INGREDIENTS	METHOD
10 --- 5 --- --- 0.5 --- 4	58.7% 29.4% 0.2% 1.5%	6X Sugar Alpine [®] Shortening Salt Non-Fat Milk Solids (optional)	Place in mixing bowl.
1 12 --- ---	10.3% ---	Water (variable) Flavoring (to taste)	Combine. Add one third and mix at low speed (2nd on 4 speed) for 3-4 minutes. Gradually add remaining water and vanilla. Scrape down and continue mixing for approximately 10 minutes or until smooth. If a lighter icing is desired, use third speed.
17 lbs.	100%	Total	

Notes:
 Use Non-Fat Dry Milk only if a quick drying icing is desired.

ALPINE[®] CREAM ICING (30% FAT)

LBS./OZS.	PERCENT	INGREDIENTS	METHOD
10 3.5 3 1 --- 0.5 --- 4	68.1% 20.4% 0.2% 1.7%	6X Sugar Alpine [®] Shortening Salt Non-Fat Milk Solids (optional)	Place in mixing bowl.
1 4.5 --- 2.75	8.5% 1.1%	Water (variable) Vanilla	Combine. Add one third and mix at low speed (2nd on 4 speed) for 3-4 minutes. Gradually add remaining water and vanilla. Scrape down and continue mixing for approximately 10 minutes or until smooth. If a lighter icing is desired, use third speed.
15 lbs.	100%	Total	

Notes:
 Use Non-Fat Dry Milk only if a quick drying icing is desired.

ALPINE[®] CREAM (EGG WHITE)

LBS./OZS.	PERCENT	INGREDIENTS	METHOD
12 --- 8 --- --- ¾	51.7% 34.5% 0.2%	6X Sugar Alpine [®] Icing Shortening Salt	Place in mixing bowl and cream light, using 2nd speed. Will take about 4 minutes
3 --- --- 2 ¾	12.9% .7%	Egg Whites Vanilla	Combine. Gradually add and continue to mix for 10 minutes. If a light fluffy icing is required, mix at 3rd speed until the desired lightness is obtained. Cover mixing bowl with a damp cloth to slow drying out and setting up.
10 lbs	100%	Total	

ALPINE[®] CHOCOLATE CREAM ICING

LBS./OZS.	PERCENT	INGREDIENTS	METHOD
12 ---	54.2%	6X Sugar	Place in mixing bowl and cream light at medium speed.
3 ---	13.5%	Alpine [®] Icing Shortening	
1 ---	4.5%	Corn Syrup	
2 ---	9.0%	Water	
--- 2	.6%	Salt	
1 8	6.8%	Nonfat Milk Solids	
2 ---	9.0%	Chocolate Liquor (melted)	Add to above and mix thoroughly.
--- 8	2.4%	Water	
22.2 lbs	100%	Total	Add slowly and cream to desired lightness

ALPINE® FONDANT CREAM ICING

LBS./OZS.	PERCENT	INGREDIENTS	METHOD
10 ---	225.25	6 x Sugar	Place in mixing bowl and cream light on low speed.
10 ---	25.25	Alpine® Icing Shortening	
--- 1.5	.2	Salt	
2 8	6.3	Flavor to suit	
---	---	Nonfat Milk Solids	
15 ---	38	Fondant	Add. Mix smooth at low speed.
2 ---	5.0	Egg Whites	Add. Scrape down and mix
39.95 lbs	100%	Total	

BUCKEYE[®] CREAM CHEESE FROSTING

LBS./OZS.	PERCENT	INGREDIENTS	METHOD
2 8 2 7	25% 24.4%	Buckeye [®] Margarine Cream Cheese	Whip Margarine and Cream Cheese until fluffy.
5 --- --- 1	50% 0.6%	Powdered Sugar Vanilla	Add Powdered Sugar slowly. Add Vanilla, whip until fluffy
10 lbs.	100%	Total	

PRIMEX[®] OATMEAL COOKIES

LBS./OZS.	PERCENT	INGREDIENTS	METHOD
3 12	10.20	Primex [®] All-Purpose Shortening	Mix together.
7 8 --- 2.5	20.36 .04	Granulated Sugar Salt	Add and cream together.
1 8	4.1	Honey (or invert)	Add while creaming
4 --- --- 4 --- 2 --- 2 --- 10	10.9 .75 .35 .35 1.7	Water Soda Ammonia Vanilla Raisins	Dissolve together and add.
5 ---	13.7	Rolled Oats (work until well separated)	Add, mix to incorporate
12 8 1 4 --- .25 --- .25 --- .25	34 .34 .05 .05 .05	Flour Non-fat Dry Milk Ground Cinnamon Ground Mace Ground Ginger	Sift together and add.
36.8 lbs	100%	Total	

PRIMEX[®] PIE DOUGH

LBS./OZS.	PERCENT	INGREDIENTS	METHOD
3 0.96 --- 0.96 --- 1.5	51.4% 1.0% 1.5%	Pastry Flour Salt Whey	Blend flour, salt and whey together.
1 13.4	30.9%	Primex [®] Shortening	Cut in Primex [®] just until loose flour adheres into a ball.
--- 14.4	15.2%	Water (ice cold)	Add water and blend just until the water is incorporated into the dough. Cover and let stand for at least 10 minutes. Sheet dough and bake as desired.
6 lbs.	100 %	Total	

PRIMEX[®] BUTTERMILK BISCUITS

LBS./OZS.	PERCENT	INGREDIENTS	METHOD
4 1.75 --- 0.75 --- 2.5	41% 0.5% 1.5%	All-Purpose Flour Salt Double-Acting Baking Powder	Blend dry ingredients together.
1 9.75	16%	Primex [®] Shortening	Cut in Primex [®] until it forms small lumps.
4 1.75	41%	Buttermilk	Add buttermilk and mix until thoroughly moistened. Continue mixing until dough just starts to become elastic. DO NOT OVERMIX. Turn onto floured dough board and roll to 3/4" thick. Cut with desired size, sharp biscuit cutter, using a straight downward motion without twisting. Place cut biscuits in a greased aluminum sheet pan so that the biscuits are just touching. Bake at 450°F for 10-15 minutes until golden brown.
10 lbs.	100%	Total	

BBS® BUTTER TEA COOKIES

LBS./OZS.	PERCENT	INGREDIENTS	METHOD
2 2.5 --- 1 2 2.5 1 8	17.9% 0.5% 17.9% 12.9%	Granulated Sugar Salt BBS® Shortening Butter	Cream for 2 minutes on low speed.
--- 8 --- 8 --- 3.5	4.5% 4.5% 1.7%	Egg Whites Evaporated Milk Vanilla	Add and cream for 2 minutes.
3 9.5 1 3.5	30.1% 10.0%	Pastry Flour Bread Flour	Add and cream for 2 minutes. Dress out on lightly greased flour-dusted pans, using desired size star tube. This cookie may be made up in many varieties and shapes, using glazed cherries, nuts, etc. for decoration. Bake at 360° - 370°F.
12 lbs.	100%	Total	

BBS® PEANUT BUTTER COOKIES

LBS./OZS.	PERCENT	INGREDIENTS	METHOD
2 8	20.7%	Peanut Butter	Combine and cream until blended and fluffy.
1 11	13.8%	BBS® Shortening	
--- 15	7.8%	Whole Eggs	
--- 2	1.1%	Baking Soda	
--- 0.6	0.3%	Salt	
--- 11	5.8%	Liquid Milk	Add to above and mix until blended.
1 11	13.8%	Granulated Sugar	Add to above and mix smooth.
1 12	14.4%	Brown Sugar	
2 9.5	21.9%	Pastry Flour	Gradually add and mix on low speed until blended (approximately 3 minutes). Form as desired and bake at 370°F.
--- 0.7	0.4%	Baking Powder	
12 lbs.	100%	Total	

BBS[®] CHOCOLATE CHIP COOKIES

LBS./OZS.	PERCENT	INGREDIENTS	METHOD
2 10 --- 6 --- 0.66 --- 0.16	20.4% 2.9% 0.5% 0.3% 0.1%	All Purpose Flour Oatmeal Baking Soda Salt Cinnamon	Grind oats in a blender until fine. Combine oats with other dry ingredients.
2 0.66 1 1 1 3.3 --- 0.66 --- 0.16 --- 12.5	15.7% 8.2% 9.3% 0.3% 0.1% 6.0%	BBS [®] Shortening Brown Sugar Granulated Sugar Vanilla Lemon Juice Eggs	Cream together shortening, sugars, vanilla and lemon juice. Add eggs and mix until smooth. Stir in the dry ingredients and blend well.
3 9.25 1 2	27.5% 8.7%	Semi-Sweet Chocolate Chips Walnuts	Add and mix until blended. Chill overnight for best results. Spoon round ¼ cup portions onto cookie sheet. Bake at 350°F for 13-15 minutes or until cookies are light brown and soft in the middle.
13 lbs.	100%	Total	

BUCKEYE[®] CHOCOLATE CHIP COOKIES

LBS./OZS.	PERCENT	INGREDIENTS	METHOD
3 --- 3 --- 2 --- 2 ---	12.37 12.37 8.25 8.25	Granulated Sugar Brown Sugar Buckeye [®] Margarine BBS [®] All-Purpose Shortening	Cream together smooth.
1 ---	4.1	Whole Eggs	Add and mix smooth
--- 1 --- 2.5 1 --- 6 --- 6 ---	.25 .65 4.1 24.8 24.8	Soda Salt Pecan Pieces Pastry Flour Chocolate Chips Vanilla to taste	Add and mix smooth
30.35 lbs	100%	Total	

BBS[®] SUGAR COOKIES

LBS./OZS.	PERCENT	INGREDIENTS	METHOD
3 5 2 1	25.7% 15.9%	Granulated Sugar BBS [®] Shortening	Combine and mix at medium speed for 1 minute.
1 5 1 1 --- 2	10.2% 8.3% 0.9%	Whole Eggs Corn Syrup Vanilla	Add to sugar and shortening mixture. Mix for 2 minutes at medium speed until well blended and fluffy.
4 15 --- 1 --- 5 --- 1	38.0% 0.4% 0.3% 0.3%	All-Purpose Flour Baking Powder Baking Soda Salt	Gradually add to cream mixture at low speed for 3 minutes until well blended. Refrigerate dough for at least one hour. Roll dough to ¼ inch thickness. Cut with floured cookie cutter and transfer to ungreased baking sheet. Bake at 375°F for 9-11 minutes. Cool for two minutes on baking sheet.
13 lbs.	100%	Total	

GOLDEN SWEETEX Z[®] BASIC SWEET YEAST DOUGH

LBS./OZS.	PERCENT	INGREDIENTS	METHOD
--- 13 2 ---	4.12% 10.16%	Active Dry Yeast Water	Dissolve yeast in warm water and set aside.
1 10 --- 2 8 1 ---	8.25% .65% 2.54% 5.08%	Granulated Sugar Salt Nonfat Dry Milk Golden Sweetex Z [®] Roll-In Shortening	Blend dry ingredients with Golden Sweetex Z [®] for 2 minutes on 2nd speed or until smooth.
1 8	7.62%	Whole Eggs	Add to the above mixture in two stages and mix for 1 minute after each addition on second speed.
2 2	10.79%	Water Vanilla to taste Spice to taste	Add slowly and mix 2 minutes on first speed. Combine with the above ingredients. Add yeast/water mixture and mix to a smooth dough (approx. 5 minutes on second speed).
2 10.16 8 40.63	10.16% 40.63%	Cake Flour Bread Flour	Allow the dough to poof for 2 hours. Punch a fold of the dough down and allow it to rest for 30 minutes.
10 lbs	100%	Total	The dough can be used for a variety of sweet goods.

BUCKEYE® BASIC DANISH

LBS./OZS.		PERCENT	INGREDIENTS	METHOD
---	8	7.2%	Whole Eggs	In a 10qt bowl, using a flat paddle, cream together eggs, sugar, shortening, salt and Non-Fat dry milk for 1 minute on 1st speed.
---	12	10.0%	Sugar	
---	5	4.8%	Buckeye® Margarine	
---	2	2.0%	Salt	
---	4	3.8%	Non-Fat Dry Milk	
1	8	21.0%	Water (warm, 105° F)	Add yeast to water and and let sit until foam forms on top (about 5 minutes). Stir into above mixture for 30 seconds on 1st speed.
---	4	3.4%	Compressed Yeast	
3	5	47.8%	Bread Flour	Slowly add flour and mix for 1 minute. Scrape down bowl and change to a dough hook. Mix on 2nd speed until a nice dough develops. Typically takes 5-6 minutes. Do not over-develop. Sheet dough to approximately ¾ inch and spot-in the following: For Rich Danish – 600 grams Buckeye Margarine. For Leaner Danish – 300 grams Buckeye Margarine. Give one three-fold and retard about 20 minutes at 40°F. Give 3 additional three-folds for rich Danish or 2 additional three-folds for lean Danish (retard about 20 minutes between folds). Retard for a minimum of 30 minutes or overnight if desired.
7 lbs.	100%	Total		

To Make Cinnamon Rolls:

1. Sheet out finished dough until it is about ¼ inch thick
2. Apply Cinnamon Smear (15-20% of laminated dough weight) (see next page)
3. Roll into a log and cut into sections about 1.5 inches wide.
4. Proof for 40 – 45 minutes @ 95°F.
5. Bake 12- 14 minutes @ 380°F.

BUCKEYE[®] CINNAMON SMEAR

LBS./OZS.	PERCENT	INGREDIENTS	METHOD
--- 2 --- 2	8.5% 8.5%	Granulated Sugar Cinnamon	Blend sugar and cinnamon on first speed with paddle attachment
--- 10 --- 2 --- 8	38% 7.5% 30%	Brown Sugar Non-Fat Dry Milk Buckeye [®] Margarine	Add brown sugar, Non-Fat dry milk and margarine to above mixture and mix on first speed for one minute. Scrape bowl and mix an additional minute on first speed.
--- 2	7.5%	Liquid Egg Whites	Add egg whites and mix one minute on first speed. Scrape and mix additional one minute on first speed. Store under refrigeration until use. Apply 15-20% of laminated dough weight.
1.6 lbs.	100%	Total	

NOTE: 1 batch of Cinnamon Smear covers 1 Batch of Basic Danish Dough



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