



# CHOCOLATE IS OUR PASSION

Product range

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## Company Portrait



[ENG]

- Best quality „Made-in-Germany“ components
- Flexible solutions for small and big projects
- Technical guidance and support
- Professional customer support
- Hygienic and sturdy design
- Energy efficient solutions



## Company Portrait



[ENG]

B&L Chocolate combines the traditional machinery palette of our predecessor "Hoppe Maschinenbau" with highly innovative and effective production lines to position itself as a global market leader in confectionery engineering. B&L Chocolate stands for flexible solutions for small and big projects. Every modular composition production line is designed to meet the individual requirements of our customers. Our engineers focus on durability, user friendliness, sanitary design, cost effectiveness and energy efficiency. Only the best German components are integrated into each B&L Chocolate production line.

## Block moulding lines



[ENG]

- Timeless and durable stainless steel design
- Quick mould- and mass changeover
- Highly precise depositing weights
- Perfect cooling temperature
- Easy to clean and maintain

Capacity	300 kg/h – 2500 kg/h
Blocksize	0.5 to 5 kg
Working Width	275/ 425/ 600/ 800/ 1000 mm
Velocity	up to 10 moulds/minute
Type	Fully/ Semi-automatic



## Block moulding lines



[ENG]

Block moulding lines are used to produce large blocks of chocolate or chocolate compound up to 5 kg in weight. B&L Chocolate block moulding lines feature precise depositing weights. Cooling times of up to 150 minutes are realized to provide gentle cooling in several zones. This prevents buildup of fat blooming that can damage masses made with real cocoa butter.

## Tablet moulding lines



[ENG]

- One-Shot, Ribbon- or Spot depositing
- Modular design and high capacities
- Numerous inclusion variations
- Optimal mass distribution

Capacity	300 kg/h – 3000 kg/h
Working Width	275/ 600/ 800/ 1000/ 1200/ 1500 mm
Velocity	up to 28 moulds/minute
Type	Fully/ Semi Automatic, intermittent/ continuous running, race track/ in line
Options	Ingredients feeder/ mixer, mould heating paternoster, water-/ air-/ brine cooling



## Tablet moulding lines



[ENG]

A tablet moulding line is used for the production of a large variety of chocolate tablets, including plain, filled, and fruit- and nut inclusions. The line is equipped with a heavy ribbon depositor. The heavy ribbon depositor features a moving head that distributes the chocolate mixture in an optimal manner. Other techniques such as Spot depositing or One-Shot are also possible thereby guaranteeing maximum production flexibility.

## One-Shot lines



[ENG]

- A variety of filling masses possible
- Nut inclusions possible
- Triple-Shot available
- Blister form option
- High filling ratio

Capacity	300 kg/h – 2000 kg/h
Working Width	275/ 600/ 800/ 1000/ 1200/ 1500 mm
Velocity	15 – 18 moulds/minute
Type	Fully-/ Semi-automatic, intermittent/ continuous running, race track/ in line
Options	Blister moulds, sea fruit effect, ingredientsinfeeder, mould heating paternoster, Triple-Shot



## One-Shot lines



[ENG]

The One-Shot method is known in the confectionery industry as the process of moulding a filled chocolate piece in one working step. On a B&L Chocolate One-Shot line, pralines, tablets, bottles, balls, and many other shapes can be filled with fat cream, caramel, fondant, chocolate, nougat, gianduja or truffle masses. Nut inclusions are also possible. What makes our lines so special is the precise mould clamping unit and the servo lifting station, which allow for filling rates of up to 70%.

## Shell moulding lines



[ENG]

- Easy adjustable shell thickness
- Hygienic and clean design
- Exact product weights
- Variety of infeeders
- 3D Products

Capacity	300 kg/h – 2000 kg/h
Working Width	275/ 600/ 800/ 1000 mm
Velocity	15 – 20 moulds/minute
Type	Fully-/ Semi Automatic, intermittent/ continuous running, race track/ in line
Options	Infeeder (Nuts/ Raisins/ Granules/ Crispy/ Wafers, Almonds/ Sticks/ Marzipan/ Persipan and others), Bookmould/ Demould station



## Shell moulding lines



[ENG]

Confectionary companies use B&L Chocolate shell moulding lines to reach the highest possible filling ratio of chocolate products. The integrated shell maker allows the production of stable chocolate shells of adjustable thickness. In a series of easy steps, these shells are filled with depositable or extrudable masses or with fruits, nuts and granules. B&L Chocolate shell moulding lines can also be equipped with a book mould and book demould station to manufacture filled and hollow figures like eggs and balls. The variety of infeder options make this line one of the most flexible solutions on the market.

## Drop and button lines



[ENG]

- Uniform appearance of drops
- Multiple color drops
- Exact drop weights
- High clock speed
- Hygienic design

Capacity	300 kg/h – 1500 kg/h
Working Width	600/ 1000/ 1300 mm
Velocity	up to 22 cycles/minute
Type	Continuous running/ intermittent belt
Kind	Drops/ Buttons, one-/ two colors



## Drop and button lines



[ENG]

Due to their large surface area, chocolate and compound drops can easily be melted for further processing. Additionally these drops are easy to dose. They are produced on drop lines, which are a combination of a drop depositor and a cooling channel. B&L Chocolate drop depositors offer exact dosing weights through their servo controlled piston stroke system. The cooling channel can be equipped with bottom water cooling. Radiation cooling, convection cooling or a combination of both can also be selected by the operator.

## Semi-automatic lines



[ENG]

- Expandable to fully automatic line
- Consistent high product quality
- Low initial investment
- Simple operation
- Modular design

Capacity	300 kg/h – 800 kg/h
Working Width	275/ 425/ 600 mm
Velocity	up to 25 moulds/minute
Type	continuous running/ intermittent
Kind	One-Shot function, fruit/ nut ingredients, blister trays, sea fruit effect



## 3D Depositor for Decoration - One Shot - or Solid



[ENG]

- Water heating (Pump block and hopper)
- Removeable pneumatic mixer in hopper
- Hopper is removable for easy cleaning
- Changeable pump block for quick cleaning and product change
- Motion logic with kinematic
- decorating of geometric forms such as circles, rectangles, triangles, waves, lines
- Optional cam profile – filling of balls
- Optional band synchronization – decoration by continuous running band

Working Width 275 – 800 mm

Piston stroke 80 mm

Distance of axis X= 450 mm, Y= 180 mm, Z= 80 mm

## Retrofit depositors



[ENG]

- Easy communication between production line
- For lines of all manufacturers
- All working widths possible
- One-shot ready
- Custom made

Capacity	depending on product
Working Width	275/ 425/ 600/ 800/ 1000/ 1300/ 1500/ 1800 mm and other dimensions
Velocity	up to 30 moulds/minute
Type	One-Shot/ oscillating pump block/ spot depositing/ fruit-/ nut inclusions



## Retrofit depositors



[ENG]

In case depositors are worn on older lines or new product requirements call for new moulding equipment, we offer our retro fit depositors. These machines are specifically designed to customer requirements and space availability. The communication between the old line of equipment and a new B&L Chocolate depositor is completed by our experienced engineers. Lines of all manufacturers can be combined with our retrofit depositors.

## C-Depositors



[ENG]

- Cooling tunnels of all manufacturers possible
- Outstanding dosing accuracy
- Quick and easy cleaning
- High nut and fruit ratio
- High clock time

Capacity	depending on product
Working Width	320/ 520/ 720 mm
Velocity	up to 50 cycles/minute



## C-Depositors



[ENG]

The C-Depositor of B&L Chocolate is specifically designed for products that have a very small chocolate part. Possible ingredients are nuts, almonds, dried fruits and cereals. The depositor is placed over a B&L Chocolate cooling channel to cool the formed product in an optimal manner. Possible shapes are round, square and rectangular. The premixed mass is filled into a hopper. From there it is placed with precise weight on the continuously running belt after passing through a dosing drum. The removable drum allows for a quick change to a different shape and makes the machine easy to clean.

## Silicon mould fondant and jelly lines



[ENG]

- Chocolate and jelly on one line
- No extra cooling room needed
- Quick changeover times
- Compact design
- Powderless line

Capacity	300 kg/h – 1500 kg/h
Working Width	275/ 425/ 600/ 800/ 1000 mm
Velocity	15 moulds/minute
Type	Fully-/ semi-automatic, race track/ in line
Options	Chocolate/ sugar sprinkler



## Silicon mould fondant and jelly lines



JELLY AND  
FONDANT

[ENG]

This line is specifically designed for the higher temperatures necessary for the production of jelly and fondant pieces. The plant design is based on the circulation of silicon moulds. The special feature of our jelly and fondant line is the ability to mould jelly and chocolate on the same line with only a short changeover time between the two productions. This provides maximum flexibility for our customers to put jelly products on the market during the hot summer months and concentrate on chocolate during the cold winter months.

## One-Shot jelly and fondant lines



[ENG]

- Different moulding temperatures of shell/ filling masses
- Chocolate and jelly on one line
- High moulding temperatures
- Quick changeover
- Modular design

Capacity	300 kg/h – 1500 kg/h
Working Width	275/ 425/ 600/ 800/ 1000 mm
Velocity	15 moulds/minute
Type	Fully-/ Semi-automatic, race track/ in line
Options	Chocolate, sugar sprinkler



## One-Shot jelly and fondant lines



JELLY AND  
FONDANT

[ENG]

One-Shot jelly and fondant lines are based on the proven principle of moulding a filling and a shell in one working step. Since jelly and fondant products require a different molding temperature than chocolate products, and occasionally different temperatures are also needed for the filling mass and the shell mass, B&L Chocolate has developed a heating system for their one shot depositor that allows two completely different temperatures. The products are moulded into silicon moulds. After products have been cooled and demoulded they are transferred to a sugar sprinkler, enrober or directly to packaging.

## KS 50 croquant cooker



[ENG]

- Timeless and robust design
- Efficient gas consumption
- Quick and easy cleaning
- Suitable LPG/CNG gas
- User-friendly

Capacity	up to 100 kg/h
Vessel Volume	50 kg
Options	optional closed hood, touchscreen display, water-repellent design (for water-based masses)



## KS 50 croquant cooker



BRITTLE

[ENG]

The croquant cooker is one of B&L Chocolate's traditional machines. It is used to produce brittle and other sugar based masses. It features a robust design and impressive durability. The copper vessel is heated with a gas burner system. The precisely lapped agitators continuously scrape off the mass from the vessel walls while a sensor gives feedback about the actual mass temperature. To take out the cooked mass, the agitators are automatically removed and the vessel is tilted by up to 90°.

## Forming lines



[ENG]

- Different nut-types possible
- A variety of product shapes
- Exact temperature control
- Easy cleaning
- High capacity

Capacity	up to 400 kg/h
Working Width	200/ 400 mm
Options	Pre-Crusher, Crusher, Deburr Drum, Crane for easy Drum change, Water-Temper units



## Forming lines



BRITTLE

[ENG]

Croquant and brittle masses of all kinds like hazelnut, peanut, sesame, or almond brittle can be formed in a variety of unique shapes with a B&L Chocolate forming line. Stars, pretzels, and egg shells are just a few examples of what is possible with the forming line. The mass will be fed from the cooker into the hopper with the help of a temperature controlled transport belt. From there the mass runs through the pre-calibration drums and then to the forming drums. All stations are temperature controlled. Afterwards, the products are cooled in a B&L Chocolate cooling channel, then separated, deburred, filled and enrobed.

## Nougama roaster



[ENG]

- Improves the taste and increases shelf life of product
- Automatic heating and cooling
- Efficient gas consumption
- Easy ingredients handling
- Robust design

Capacity	up to 150 kg/h
Batch Size	50 – 60 kg
Options	Cooling Drum, Complete Stainless Steel Design, Elevator



## Nougama roaster



BRITTLE

[ENG]

The nougama roaster was designed specifically for the production of croquant brittle crumbs which are soft but preserve a crunchy core. The initial raw materials can be sugar and either broken hazelnuts, almonds or peanuts. Some customers also use coconut flakes. During the process the sugar is not melted but merely heated, so the nut core preserves its unique flavor. The final nougama product can be used for chocolate fillings or for decorating cakes and ice cream. A treatment in the B&L Chocolate nougama roaster does not only improve the flavor of the product, it also increases shelf-life.

## Enrobing lines



[ENG]

- Perfect control of enrobing thickness
- For compound or real chocolate
- Hygienic and robust design
- Removable tank

Working Width 600/ 800/ 1000/ 1200/ 1500 mm

Options Pressing wire mesh, easy removable tank, chocolate stringer (decorator)



## Enrobing lines



BRITTLE

[ENG]

B&L Chocolate enrobing machines are used to enrobe products that were made on a B&L Chocolate forming line. Real chocolate and compound chocolate can be used. Other products that can be covered include pastries, chocolate centers and bar centers. These products can be enrobed fully, partially, or only from the bottom. A sanitary design provides easy cleaning of the machine. The enrobing machine is equipped with a touch screen panel featuring adjustable settings. A chocolate circulation system provides a constant temperature and an even coating thickness.

## Cooling tunnels



[ENG]

- Bottom-, radiation- and convection-cooling
- Temperature zones adjustable
- Water-cooled bottom plates
- Perfect insulation
- Easy cleaning

Working Width      600/ 800/ 1000/ 1200/ 1500/ 1800 mm  
                                 custom sizes available

Lenght                      up to 50 m

Options                     Bottom cooling, adjustable edges



## Cooling channels



COOLING CHANNEL

[ENG]

A B&L Chocolate cooling channel is used in the industry mainly to cool drops, enrobed products, chocolate strings, croquant brittle and vermicelli. It can be equipped with several cooling zones. The method and amount of cooling is adjustable by the operator. Cooling methods include radiation cooling, convection cooling or a combination of both. Cooling the bottom of the product is realized by either cold air or by cold water flown plates. The hoods are made of stainless steel or food safe plastics. They are easily opened and supported by gas springs. At B&L Chocolate a sanitary design is a focal point for every machine and our cooling channel is no exception.

## The length cutter



[ENG]

The length cutter has several cutting discs and is designed to cut the product length ways. The distance between the cutters dictates the thickness of the product.

Rotation speed can be regulated as can the number of cutting discs.

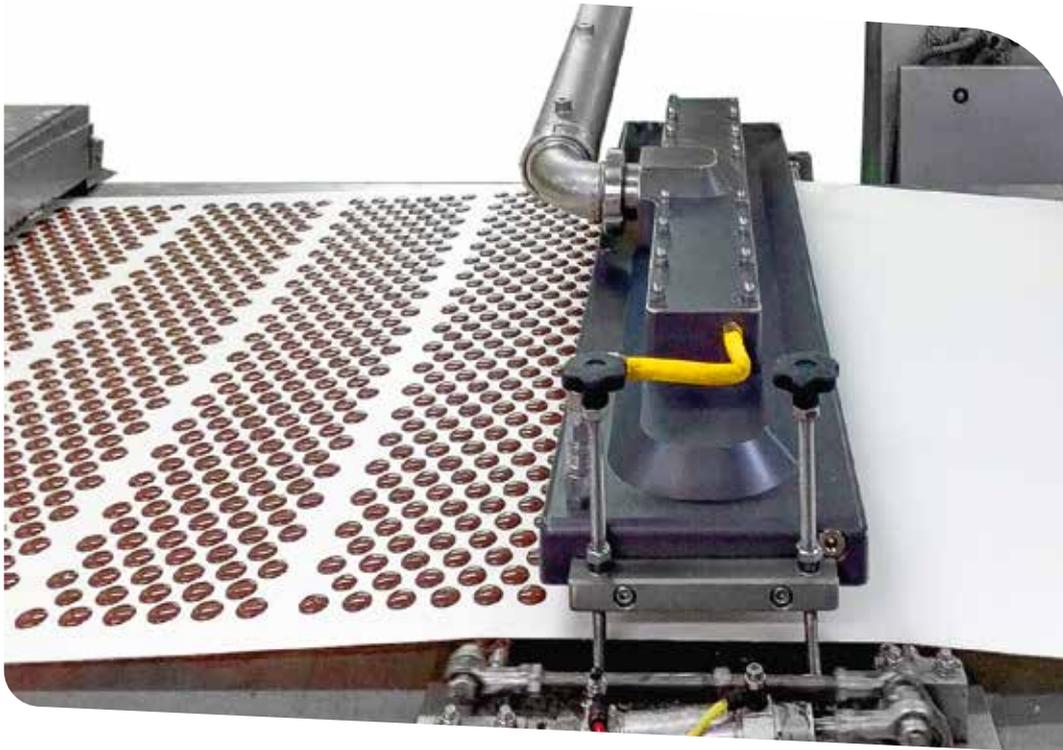


## High capacity vermicelli line



VERMICELLI  
LINE

## Simple drop depositor



[ENG]

The simple drop depositor has been developed for customers that already have a cooling tunnel and wish to increase their product range.

It can however be offered with cooling tunnel if required.

The flexibility shows itself with the simple installation and easy connection to a present plant. The depositor is positioned over a band and the dosing is synchronised to the band speed with a pump that can be regulated by the frequency. The depositor is equipped with a coloured touch display, where all parameters can be set and recipes be stored.

Depending on the drop size and cooling channel size, productions of up to 600kg/h can be produced.

Cooling tunnel sizes are: 300mm, 600mm and 800mm or through customers wishes.



## The guillotine



THE  
GUILLOTINE

[ENG]

The guillotine has two or more ultrasonic cutting blades attached to a connecting rod that moves up and down as required. The guillotine hacks the product strips that have been previously cut by the length cutter to the required width. The quicker it hacks, the shorter the product becomes.

The cutting blades are manufactured from stainless-steel. By each cycle a small notch is hacked. So that the product strips do not stick, the blades are vibrated using ultrasound. The depth of the cutting thickness is regulated mechanically. The number of the cuts is regulated by the speed of the transport band and the length of the required product.

## CD-50 with inclusion mixer



## CD-50 with inclusion mixer



CD-50

## Rotation drop depositor



[ENG]

Ideal for the production of different size drops, this depositor produces a consistent sized product at a higher capacity. The depositor shell has the capability of change the outer cylinder to enable production of drops of a different size.

- Retrofit for plastic belt cooling tunnel lines
- Different drop Chip sizes possible
- Servo motor driven
- High capacity in small chip counts
- Low maintenance time



## The chocolate lentil in-feeder



[ENG]

The chocolate lentil in-feeder is designed for small to medium capacity. With 60 to 150Kg/hour (depending upon lentil size), it is a versatile machine capable of producing all size of lentils, 0.9 to 20mm after coating. It is placed over a cooling tunnel, and can be used in conjunction with other machinery such as Drop depositor, enrober, C-Depositor or Vermicelli extruder, to produce a multi-functional plant.

The in-feeder requires an ice bank, that cools the rollers upto  $-25^{\circ}\text{C}$  to  $-29^{\circ}\text{C}$ . The chocolate is poured from above by a specially designed heated pipe, between the rollers where it is shock cooled and a Lentil carpet is produced. This carpet then goes through the cooling tunnel before being transfer to a braking drum.

The braking drum then separates the lentils from the carpet and transports them to holding cases. The excess chocolate is collected in trays beneath the in-feeder and can be re-melted in the compound tank.

## Cooling systems



[ENG]

The cooling cabinet available from width of 100 / 275 / 425 / 600 / 800 and 1000mm width. Depending on the mould size and the cooling time 20 or 30 levels are filled with moulds to achieve a cooling time of approx 90 – 130 min. Maximum height is approx. 2900mm and can be tailor made fit in in new and existing factories. The temperature control is automatic, depending on the recipe adjustable from the build in PLC control.



## Cooling systems



COOLING  
SYSTEMS

[ENG]

The paternoster principle of our cooling cabinets is the most space saving design available in the market. The standard cooling cabinet is splitted into two sections. For real chocolate the first cooling zone will be adjusted to a gentle cooling, followed by second zone. For compound the first zone will be converted to a shock cooling followed by a second zone. The design of the cooling cabinet is sanitary and insulated to avoid energy lass.

## STR 500 vermicelli extruder



[ENG]

- Cooling channels of all manufacturers possible
- Up to three extrusion heads parallel
- Round or square vermicelli
- Durable, robust and reliable
- Sugar or chocolate mass

Capacity	90 kg/h – 200 kg/h
Extruder	Single-/ double-/ triple extruder
Sieve	0,9 – 3,0 mm
Possible Mass	Chocolate vermicelli/ sugar vermicelli



## STR 500 vermicelli extruder



[ENG]

Vermicelli is a popular product for decorating pastries and ice cream or for use as a bread topping. Vermicelli can be produced with a B&L Chocolate vermicelli extruder. The dough like mixture, made from sugar, fat, or real chocolate, is extruded through a sieve to 5 – 10 cm long strands. After the extrusion they are cooled and dried, broken and panned. B&L Chocolate can provide single machines or complete turnkey solutions for vermicelli production. Additionally, customers can develop individual recipes with our process technicians.

VERMICELLI

## Vermicelli lines



[ENG]

- Constant product dimensions
- Self-cooled extruder heads
- Gentle cooling and drying
- Easy and quick cleaning
- High capacity

Capacity	up to 600 kg
Working Width	600/ 1 200/ 1 800 mm (cooling channel)
Options	String depositor, drop depositor (one or two color), cooled sieves



## Vermicelli lines



[ENG]

B&L Chocolate offers a complete solution for the fully automatic production of sugar and chocolate vermicelli. A vermicelli extruder with one, two, or three extrusion heads combined with a B&L Chocolate cooling channel. After extrusion and cooling, the production process moves to breaking and panning in copper drums. To keep the line flexible it can be designed so that a drop depositor or a chocolate string depositor can be added on.

VERMICELLI

## Panning drums



[ENG]

- Complete stainless steel implementation
- Stainless steel or copper drums
- Adjustable rotational speed
- Spraying systems
- 50 Kg Batches

Capacity	up to 50 kg batches
Options	copper-/ stainless steel drum, complete stainless steel design



## Panning drums



[ENG]

B&L Chocolate panning drums are used to break, polish and apply a shining agent or colour to vermicelli sprinkles. They can also be used to put a layer of chocolate onto nuts or dried fruits. Often B&L Chocolate panning drums are used to apply sugar solutions and shining agents to chocolate lenses. The panning process does not only improve the appearance of the products, but also their shelf-life.

VERMICELLI

## Infeeders



[ENG]

- Crispy and nutbit infeder
- Biscuit infeder
- Cherry infeder
- Wafer infeder
- Stick infeder
- Nut infeder

Working Width 275/ 425/ 600/ 800/ 1000/ 1300/  
1500/ 1800 mm

Type continuous/ intermittent running,  
easy exchange/ firmly installed



## Infeeders



[ENG]

To support confectionary engineers in their efforts to distinguish themselves from the competition, B&L Chocolate continuously develops new technologies and ideas. B&L Chocolate's goal is to develop innovative manufacturing techniques and equipment that will allow purchasers to create products with ever-increasing consumer appeal. Among B&L Chocolate's finest innovations is a line of infeeders. Nuts, biscuits, crisps, granules, dried fruits, chocolate lenses, wafers and many more goods can be treated with our line of infeeders. The machines are typically installed on the transport channel of a B&L Chocolate moulding line, but can also be added to lines from other manufacturers.

INFEEDEER

## Services



[ENG]

- Aftersales services
- Project planning
- Depositing tools
- Maintenance
- Spare parts
- Logistics
- Repairs
- Piping



## Services



[ENG]

B&L Chocolate is a modern, family-owned company headquartered in Wernigerode, Germany. In 2013 we completed a new 1000 m<sup>2</sup> production factory and expanded our office space by 450 m<sup>2</sup>. These latest additions enable us to boost our engineering and service capabilities to meet the rising demand for our high-quality products and services.



**B&L Chocolate**   
BÖHNKE LUCKAU TECHNOLOGY

POWERED BY  
**ORANGeworks** 

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