



















Böhnke+Luckau GmbH located in Wernigerode, GERMANY designs manufactures and delivers entire plants and installations to the chocolate confectionery industry worldwide.















In 2007 the workshop and office has been build up to enable the design, assembling and start up of tailor made plant solutions for our customers.



The worldwide presence in the market and the excellent reputation and acceptance by our customers, enable us to further to develop our machines and plants. German made machines build and delivered by B + L, are in operation in many countries like GUS, Ukraine, Korea, Germany, Austria, Switzerland, Turkey, Singapore, Philippines, Egypt, Iran and other countries



	Pralines, unfilled, single colour	06-09
	Pralines, solid, two colour	14-15 18-19
	Pralines, filled, nougat, chocolate	14-15
	Pralines, jelly or fondant centre	18-19 38-39
	Pralines, filled, caramel, toffee	18-19 38-39
	Pralines, stripes, one-shot	12-15
	Chocolate eggs, solid	18-19
	Hollow 3D figures	20-21
	Chocolate bars, solid	06-09
	Chocolate bars, filled, nut, crisp	06-09 30-33
	Chocolate bars, XL , XXL	22-23
	Chocolate drop, solid	24-25
	Chocolate Vermicelli, chocolate	48-50
	Depositing into blister	10-11 16-17

	Pralines, filled with crisp or nuts	18-19 33
	Pralines, filled with crisp or nuts	18-19 32
	Pralines, filled, fruit, fondant	18-19 30-33
	Pralines, filled with jelly or fondant	36-37
	Pralines, filled, cherry, berry, nuts, crisp	31
	Pralines, stripes, filled	14-17
	Pralines, 3D	14-17
	Chocolate eggs, filled	20-21
	Chocolate bars, filled	14-17
	Chocolate bars with wafer, biscuit	18-19 33
	Chocolate drops, two colour	24-25
	Chocolate Vermicelli, sugar	48-50
	Depositing on wafer, biscuit	6-9
	Croquant, hard	42-45



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Solid Bar Line



Features :

fully synchronized chain drive
depositor single
mould shaker
cooling cabinet for fast or gentle cooling
cooling time up to 90 min
cooling capacity up to 40kW
cooling cabinet complete insulated

Solid Bar Line 275 mm



The SBL275 is a small scale semi-automatic line for manual feeding and de-moulding of the moulds and for customer who wants to start manufacturing unfilled chocolate or compound products at a small scale. After manual adding the moulds, the moulds are preheated and filled. A vibrating section and a two zone cooling cabinet are installed at the end of the line, where after the operator takes manually away the moulds for manual demoulding. Böhnke & Luckau can add also an automatic demoulding section optionally, depending on demand.

Technical data

Power supply :400 Volt, 3 phase, 50 Hz
Colour :RAL 9007 stainless steel
Mould size :275 x 175 / 205
Layout :Inline
Capacity :up to 15 - 22 moulds/min
Output :up to 1500kg/h
Length :approx. 15 - 20m



Solid Bar Line automatic



Features :

- fully synchronized chain drive
- mould magazin feeder with control
- temperature adjustable mould preheating with infrared heater, two side system
- depositor single or double with, recipe control via SPS control system
- mould check before depositing
- mould shaker, adjustable
- cooling cabinet for fast or gentle cooling with temperature control via recipe
- cooling time up to 90 min
- cooling capacity up to 40kW
- cooling cabinet complete insulated
- automatic demoulding
- twin mould separation unit
- mould tilting and emptying
- double knocking station
- automatic mould check and ejection system
- combined mould change magazin
- synchronized beltdrive for product transfer and adjustable nose edge

Solid Bar Line 425-1000mm automatic



The fully automatic SBL425-1000 for automatic production of unfilled mono chocolate or compound products for medium to high capacities. The moulds are automatically added from the empty mould magazin and finally automatically demoulded and returned after automatic mould check back to the mould preheater and depositor station. A PLC control enables the operator all the time a easy operation.

Technical data

Power supply	: 400 Volt, 3 phase, 50 Hz
Colour	: RAL 9007 stainless steel
Mould size	: 425 x 175 / 205 600 x 175 / 205 800 x 175 / 205 / 275 1000 x 175 / 205 / 275
Layout	: Inline
Capacity	: up to 15 -22 moulds/min
Output	: up to 1500kg/h
Length	: approx. 25m



Depositor Solid Bar Line

The principle of the depositor is a single side servo driven piston system with one single rotary piston to guide and distribute the chocolate mass to the nozzles at the nozzle plate for multi row depositing.

Working width: of 275, 425, 600, 800, 1000mm
Moves per Minute: 15 - 22



Depositor 275- 1000mm – Solid Bar Line



The range of depositors for solid product depositing lines are especially designed to deposit chocolate or compound for pralines, chocolate bars and other chocolate products with one chocolate mass only.

One Shot Line automatic



Technical data

Power supply: 400 Volt, 3 phase, 50 Hz
 Colour: RAL 9007 stainless steel
 Mould size: 275 x 175 / 205
 Layout: Inline
 Capacity: up to 15 - 22 moulds/min

One Shot Line 275mm automatic

One-Shot by meaning of a filling ratio of 70/30 for centre filled pralines. To enter this market, we have developed our smallest One-Shot line OSL275 for mould sizes of 275mm, for customers which are looking for a small output.

The lines are either fully automatic, or can be as well semi automatic operated, depending on the need and the initial investments.



One Shot Line automatic



Technical data

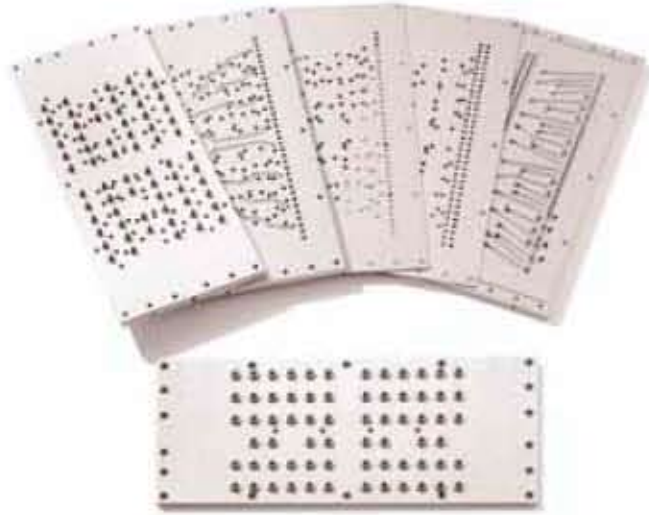
Power supply	:400 Volt, 3 phase, 50 Hz
Colour	:RAL 9007 stainless steel
Mould size	: 425 x 175 / 205 600 x 175 / 205 800 x 175 / 205 / 275 1000 x 175 / 205 / 275
Layout	:Inline / U-shape
Capacity	:up to 15 - 22 moulds/min

One Shot Line 425-1000mm automatic

The automatic One-Shot Lines OSL425 to 1000 are designed for the production of centre filled pralines, bars or other one-shot products of large outputs with a fully automatic operation. The lines are PLC controlled and are equipped with an automatic demoulding station, mould check and mould backhaul.



Depositor One-Shot Line



The range of depositors for one-shot product depositing lines are especially designed to produce centrefilled, or two coloured chocolate or compound pralines, chocolate bars and other chocolate products with more than one fatbased mass.

Depositor 275-1000mm – One-Shot Line



The principle of the depositor is a twin side servo driven piston system with two rotary pistons to guide and distribute the chocolate mass to the nozzles at the nozzle plate for multi row depositing.

Working width: of 275, 425, 600, 800, 1000mm
Moves per Minute: 15 - 22



Shell Moulding INLINE



Technical data

Power supply	:400 Volt, 3 phase, 50 Hz
Colour	:RAL 9007 stainless steel
Mould size	:275 x 175 / 205 425 x 175 / 205 600 x 175 / 205 800 x 175 / 205 / 275 1000 x 175 / 205 / 275
Layout	:Inline
Capacity	:up to 15 - 22 moulds/min

Shell Moulding Line 275-1000mm - INLINE

The SML275 is a shell moulding line for the production of small and medium size volumes of centre filled parlines, bars and other products with different viscosity variations from centre to shell. Also inclusions like nuts, or crisp and fruits are able to be added with this technology.

The lines are tailor made depending on the individual final product and are equipped with at least one depositor for the shell, one depositor for the centre and one depositor for the bottom cover. The depositor type can vary from single, one-shot to depositors for sugar based masses. After each deposit the mould passes a cooling cabinet.



Shell Moulding Line - SQUARE



Technical data

Power supply	:400 Volt, 3 phase, 50 Hz
Colour	:RAL 9007 stainless steel
Mould size	:275 x 175 / 205 425 x 175 / 205 600 x 175 / 205 800 x 175 / 205 / 275 1000 x 175 / 205 / 275
Layout	:square
Capacity	:up to 15 - 22 moulds/min

Shell Moulding Line 275-1000mm - SQUARE



The SML-SQUARE shell moulding lines are for the production of medium to large volumes of centre filled parlines, bars and other products with different viscosity variations from centre to shell. The lines are tailor made depending on the individual final product and are equipped with at least one depositor for the shell, one depositor for the centre and one depositor for the bottom cover. The square design of the lines enable deposit and insert ingredients while the moulds are returned.



Block Moulding Line XXL



Technical data

Power supply	:400 Volt, 3 phase, 50 Hz
Colour	:RAL 9007 stainless steel
Mould size	:600 x 175 / 205 800 x 175 / 205 / 275 1000 x 175 / 205 / 275
Layout	:inline
Capacity	:1500 - 2500 kg/hr
Block sizes	:1kg / 2,5kg / 5kg

Block Moulding Line XXL



High capacity moulding lines for depositing of chocolate or compound to medium and large blocks of up to 5000g. This block moulding lines with special fixed moulds for high capacities and special long cooling times for gentle cooling into the centre of the block. The moulds are feed without any transfer fixed in the chain through the entire line and returned back to the depositing station.





Drop Depositing Line 275-600mm



The special drop depositing lines are mainly combined with a standard chocolate belt cooling tunnel, where a large number of the drops are deposited with one stroke, at the same time onto the PU belt.

Technical data

Power supply	:400 Volt, 3 phase, 50 Hz
Colour	:RAL 9007 stainless steel
Working width	:275 - 600mm
Drop size	:d = 5 - 15 mm
Drop shape	:flat / drop
Drop weight	:1,2 - 18 g
Layout	:inline
Capacity	:up to 30 moves/min



Cooling Systems



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 loss.



Cooling Systems

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 - 130min. 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.



SOLID BAR LINE FOR LOLLIES



SOLID BAR LINE 800 mm



SHELL MOULDING LINE special edition



SHELL MOULDING LINE standard



Demoulding Systems



For fully automatic moulding lines, demoulding systems of 275 / 425 / 600 / 800 and 1000mm width are designed. The system incorporates a double twisting station, tilting unit, knocking station. An automatic mould dirty control checks and ejects the mould before returning towards the front of the line.



The demoulding station transfers the demoulded and aligned products onto a PU transport belt. After this the products can be feed directly towards a packing line.

Dosing Systems for nuts,



...crisp or dried fruits



Dosing systems for gentle volumetric depositing of dry ingredients like nuts, rice crisp e.g. are available and can be attached depending on the final product. The drum dosing system is the most simple design and for most of the products a optimal solution.



The feeding of the hopper can be either manual or automatic. A built in rotating format drum takes gentle the right amount from the top and discharges at the bottom side into the chocolate mould.

- Working width :
- 275 mm
 - 425 mm
 - 600 mm
 - 800 mm
 - 900 mm
 - 1000 mm



Dosing Systems for nuts,



Dosing systems for individual positioning and adding of nuts or dried fruits are designed for any kind of moulding lines. The special chain type design, enables a very accurate dosing and the most gentle placing of the ingredients. A brush takes away the surplus of the ingredients. Additional equipment for placing the nuts or dried fruits into the centre and a pushing device to press them into the chocolate mass is required for special final products.



Working width : 275 mm
425mm
600mm
800mm
900mm
1000mm



...crisp or dried fruits



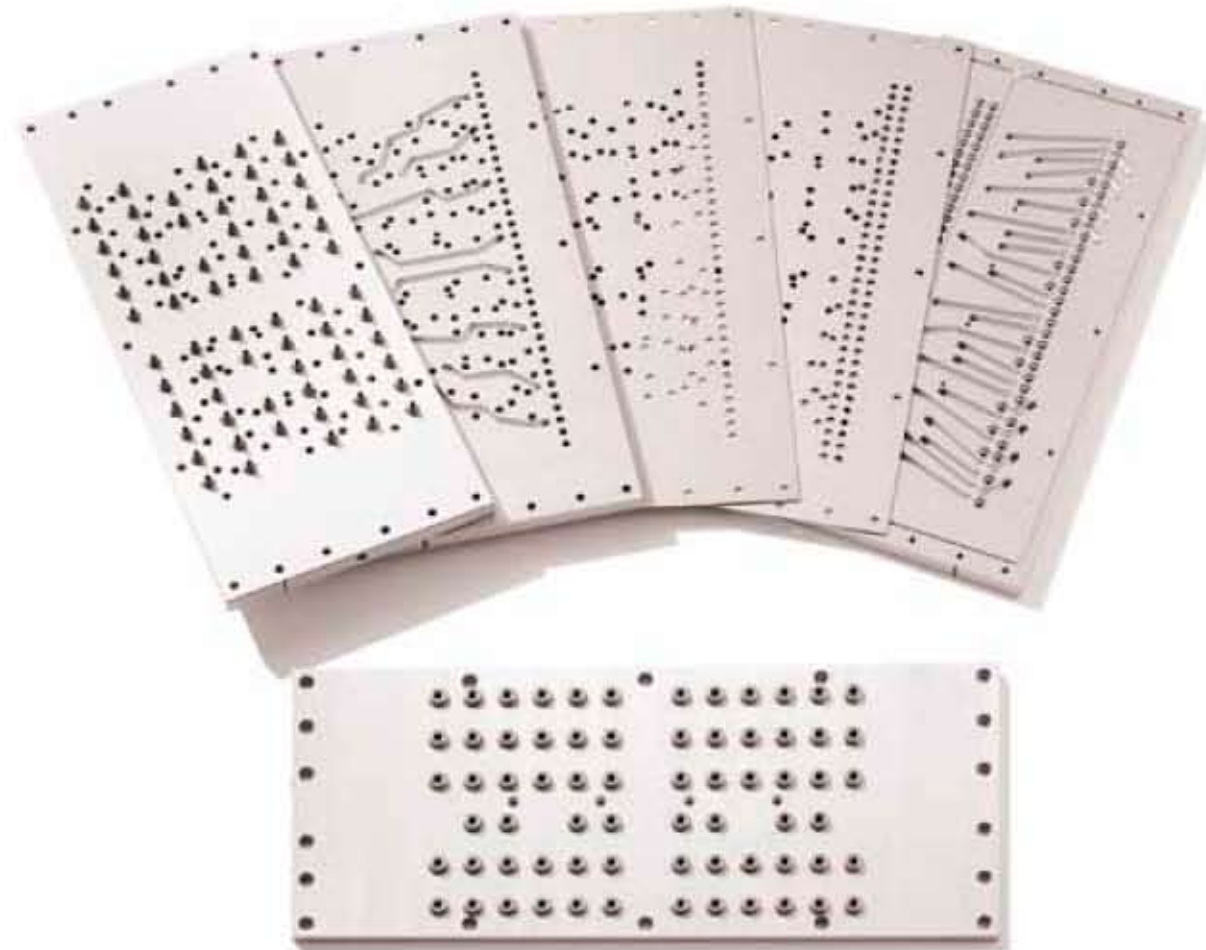
Dosing systems for filling masses or chocolate mass mixed with nuts or rice crisp prior to the depositing into the mould, complete the range of universal loose ingredient dosing systems.



The automatic wafer or biscuit feeding system can be combined with a shell moulding line or a solid bar line. Refilling of the magazine stacker is realized manually by the operator. The wafers or biscuits are then placed onto the belt



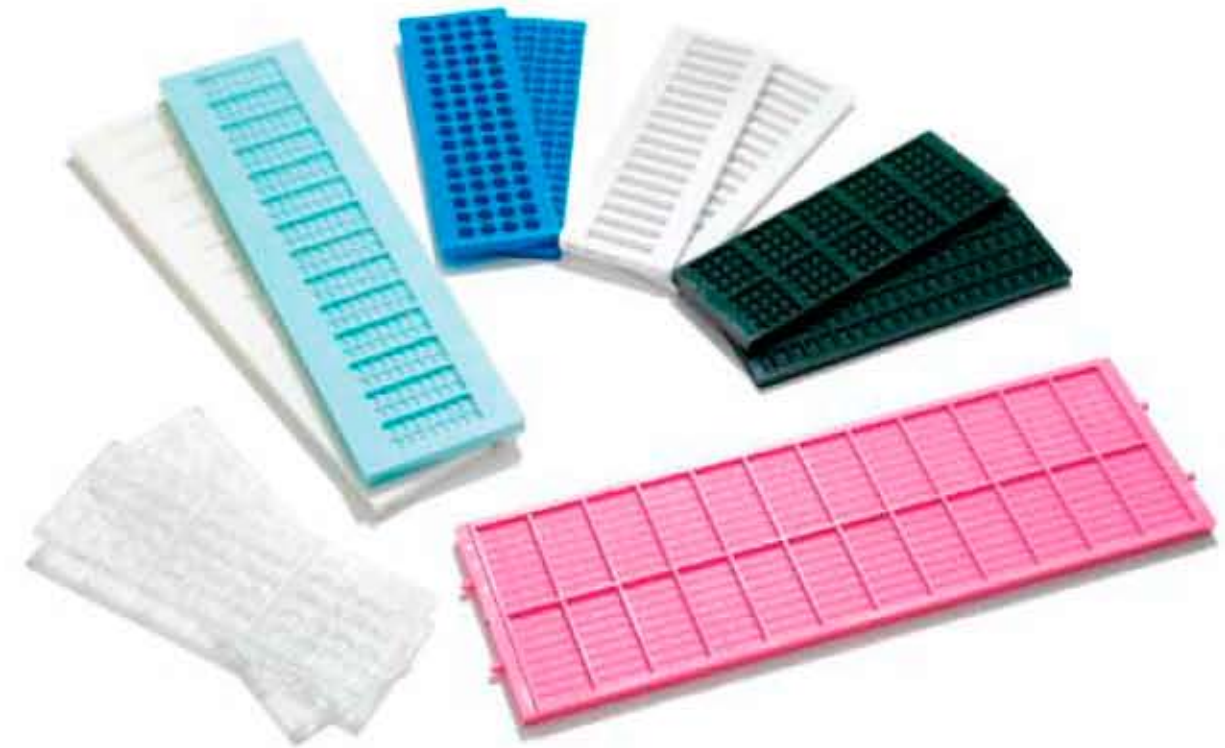
Depositing Plates



Special tailor made depositing plates for single , one-shot and triple shot applications are required to deposit chocolates, compounds, cremes, filling masses which are fat based as well as sugar based mass like fondant creme, jelly and caramel.

Working width : 275 mm
425 mm
600 mm
800 mm
900 mm
1000 mm

Depositing Moulds



For each delivered line we recommend the most suitable mould supplier for our lines. Our Lines do not especially require very specific mould sets, as our working principle is based on the loose mould system which allows us to be independend from any mould supplier. Most important is, that the moulds are reliable and the dimensions and surfaces are suitable for industrial machines. Please feel free to contact us if you need any support.



Vertical Depositing Lines 275 – 1000mm



for jellies, fondant and caramel



Technical data

For sugar based masses like fondant, jellies and caramel, Böhnke + Luckau have developed a range of vertical depositing machines based on the vertical piston system. Based on the same loose mould system the lines can run universal eighter on fat based or sugar based masses.

Power supply	:400 Volt, 3 phase, 50 Hz
Colour	:RAL 9007 stainless steel
Mould size	:275 x 175 425 x 175 / 205 600 x 175 / 205 800 x 175 / 205 / 275
Mould	:silicone
Layout	:inline
Capacity	:up to 15 - 22 moulds/min

Vertical Depositor 275 – 800mm

For depositing jelly or fondant directly into the mould, special silicon moulds are designed and delivered together with the line. Different product shapes are available.

Mould width : 275 mm
425mm
600mm
800mm



The principle of the depositor is a vertical servo piston system with two rotary piston to guide and distribute the jelly or sugar mass to the nozzles at the nozzle plate for multi row depositing. The sugar mass fills by gravity the upper piston chambers and are forced through the depositing head to the individual nozzles for multi row depositing. The whole system is heated to ensure stable product temperatures prior the depositing nozzles.

Working width: of 275, 425, 600, 800 mm
Moves per Minute: 15 - 22



Enrobing Line



Enrobing Line



The B+L enrobing lines are in operation, for enrobing of different centres, either from B+L moulding lines or formed croquant centres or centres based on wafer or biscuit. Enrobing machines cover most of the requirements. Build in radiation heaters control the temperature in the enrobing area. A double chocolate curtain float the centres from the top



Technical Data:

Working width : 275 / 400 / 600 / 800 / 1000 mm
 Cooling tunnel length : 12 to 50m
 Coating mass : chocolate / compound

Croquant – cooking



Technical Data:

Batch size :20-50 kg
 Capacity :approx. 20 - 150kg/hr
 Heating :LPG or city gas
 Dimensions :1300 x 1600 x 2500 mm

The KR50 a universal cooker for processing of especially croquant as well as for other applications like praline mass nut brittle, toffee caramel, melting of sugar and processing of food colours. For the processing of croquant, the sugar is heated up and melts first before the adding of calibrated nuts, almonds, sesame or other ingredients. The special agitator with two fast rotating and one slow motion speed, ensure a homogenous mixing during the heating time. The ready batch can be either collected afterwards in collection pans or feed directly to the Böhnke + Luckau croquant forming line PA 200, PA 300, PA 400 or PA 600 via a intermediate belt conveyor continuously.



Croquant – Embossing and Forming



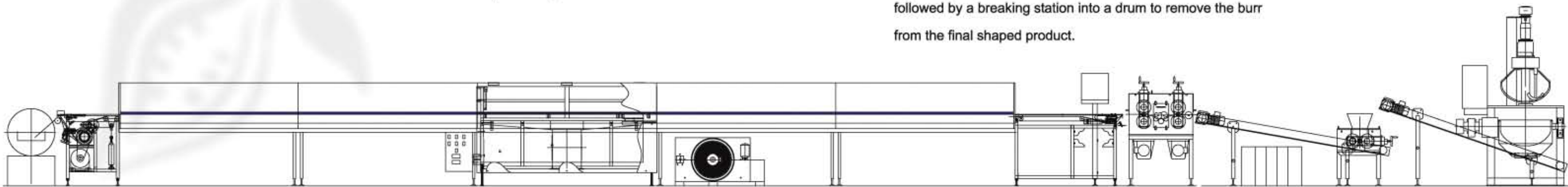
Technical Data:

Working width	:200mm / 300mm / 400mm / 600mm
Capacity	:approx. 100 - 500kg/hr
Dimensions	:14000 x 800 x 2500 mm
Electrical consumption	:37,0 KW



For the embossing and forming of croquant bars, shells, like egg shape, ball shape or stars, Böhnke+Luckau manufactures a range of calibration and embossing and forming machines type PA 200, PA 300, PA 400 and PA 600.

The hot sugar mass coming from the cooker KR50 via a tempered feeding belt continuously into the infeed hopper of the precalibration station. The formed slab is subsequently further calibrated and finally embossed. A continuous slab leaves the last embossing pair through a cooling and tempering tunnel followed by a breaking station into a drum to remove the burr from the final shaped product.



Croquant Roaster - NOUGAMA



The NOUGAMA roaster is especially designed for the processing of croquant brittle crumbs made from calibrated hazelnuts, peanuts, almonds e.g in combination with sugar. During the processing the sugar is not melted but heated so that the nuts are covered by the sugar to maintain the flavour. This croquant brittle product finally can be ground to a praline filling mass, or can be used for cake or ice cream decoration. Coconut flakes can be preserved by roasting in the NOUGAMA for longer shelf life and flavour enhancement.

Technical Data:

Batch size	:approx. 50-80 kg
Capacity	:approx. 100-150 kg/hr
Dimensions	:1400 x 800 x 2500 mm
Electrical consumption	:37,0 KW

The NOUGAMA roaster is a batchwise operation unit and can be delivered as a stand alone unit or combined with an automatic operated lifting system and a discharge belt for semi automatic processing. The upper roasting drum is gas heated for excellent flavour enhancement during the roasting process. A second lower drum collects after roasting the batch immediately and cools the granulate.



Vermicelli Extruder



The STR vermicelli or strand extruder is very compact machine for forming of different kind of vermicelli shapes. Depending if fat based or sugar based different capacities can be achieved. This extruder can be delivered either as a stand alone unit or for higher capacities with twin or triple extrusion heads, be combined with a cooling tunnel. A quick exchange of the extrusion sieve allows an easy change form shape to shape.

Technical Data:

Working width	:600 / 1300 / 1800mm
Capacity	:approx. 100- 1000kg/hr
Dimensions	:8000mm length
Electrical consumption	:10 - 30 KW

Vermicelli Extruder



Capacities:

Chocolate vermicelli

D= 0,9 mm - approx. 130kg/hr

D= 1,1 mm - approx. 300kg/hr

D= 2,0 mm - approx. 420kg/hr

Sugar vermicelli

D= 0,9 mm - approx. 100kg/hr

D= 1,1 mm - approx. 210kg/hr

D= 2,0 mm - approx. 320kg/hr

Choco LAB

Böhnke + Luckau GmbH have established a 50 qm laboratory, where customers have the possibility to see the machines in operation.

A entire chocolate one-shot moulding line, a croquant cooking and forming line as well as a vermicelli extrusion line are available for trials with product.



Please do not hesitate to contact us!

