12 Bakery Formula Recipes

ARTISAN BAKING

Whole Grain & Gluten-Free

Whole Grain

Gluten Free

DEVELOPED BY CRAIG PONSFORD

PONSFORD PLACE
SAN RAFAEL, CA

CALIFORNIA RAISIN

CALIFORNIA

™
Meet the Chef

A gold medal in France did not prepare Craig Ponsford for a shift in his career. After 25 years of baking, Craig, met Joe Vanderlet of Certified Foods, Incorporated and was introduced to their stone milled whole grain products. In 2009, Craig, a white flour baker, began product development for Joe and discovered he was able to make lofty and laminated products with this whole grain milled flour. Since then, Craig has been exposed to the nutritional benefits of whole milled flour as well as experiencing firsthand the enhanced complexity and depth in flavor that are possible from baking products using whole milled flour.

Now, Craig is converted and almost always bakes with the whole milled flour so that his treats are not only super tasty but also provide all the additional nutritional attributes of the whole grain. All the formulas developed in this book are made using only whole milled flour and plump, scrumptious and nutritious California Raisins.

Baker’s Notes

Whole Grain Flours

* Hard Red Winter Wheat
  Moisture 14.0%, max,
  Ash 1.35%, Protein 13.50%

** 95% Extraction Hard Red Winter Wheat
  Protein 13.90%

*** Hard White Winter Wheat
  Moisture 9.5 -11.0% max,
  Ash 1.40%, Protein 11.5 -12.0%

**** 95% Extraction Hard White Winter Wheat:
  Protein 11.5 - 12.5%

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**Pumpernickel**

**Formula**
- **Total Dough Weight:** 7,200 Kg
- **Yield:** 12
- **Total Flour Preferred fermented:** 40%

<table>
<thead>
<tr>
<th>INGREDIENTS</th>
<th>TOTAL FORMULA</th>
<th>PREFERMENTED DOUGH</th>
<th>FINAL DOUGH</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Total Flour</strong></td>
<td>100.00%</td>
<td>50.00%</td>
<td>3.576 Kg</td>
</tr>
<tr>
<td>Hard Red Winter Wheat Flour</td>
<td>80.00%</td>
<td>40.00%</td>
<td>1.073 Kg</td>
</tr>
<tr>
<td>Pumpernickel Rye</td>
<td>20.00%</td>
<td>10.00%</td>
<td>1.431 Kg</td>
</tr>
<tr>
<td>Water</td>
<td>20.00%</td>
<td>10.00%</td>
<td>1.073 Kg</td>
</tr>
<tr>
<td>Salt</td>
<td>10.00%</td>
<td>5.00%</td>
<td>0.004 Kg</td>
</tr>
<tr>
<td>Instant Yeast</td>
<td>5.00%</td>
<td>2.50%</td>
<td>0.004 Kg</td>
</tr>
<tr>
<td>Natural Raisin Paste</td>
<td>2.50%</td>
<td>1.25%</td>
<td>0.004 Kg</td>
</tr>
<tr>
<td>Maceration Liquid</td>
<td>2.50%</td>
<td>1.25%</td>
<td>0.004 Kg</td>
</tr>
<tr>
<td>Mixed Raisins</td>
<td>7.50%</td>
<td>3.75%</td>
<td>0.006 Kg</td>
</tr>
<tr>
<td>Sour Seed</td>
<td>5.00%</td>
<td>2.50%</td>
<td>0.004 Kg</td>
</tr>
</tbody>
</table>

**Totals**
- 234.76% 8.400 Kg
- 172.50% 2.474 Kg
- 8.497 Kg

**Procedure**
- **12 hours prior to final mixing:** Take sourdough seed and mix with sponge ingredients until a cohesive dough is formed. Let rise, covered, for 12 hours at 75°F.
- Also, 12 hrs in advance, macerate raisins in enough water, just until covered. Drain well prior to mixing (ideal macerated weight is reflected in the formula).

**Final Dough**
- Mix pumpernickel, salt, yeast, raisin paste and water on low for 2 minutes.
- Break the mature sour into small pieces and mix on low for 15 minutes more (desired dough temperature is 75°F).
- Add drained raisins and mix to disperse evenly.
- Remove dough from mox and place in a covered container to bulk ferment for 45 minutes.

**Shaping and Proofing**
- After fermenting for 45 minutes, divide with thoroughly wet hands, smooth into a round shape and coat with a medium grind pumpernickel rye, sunflower seeds or coriander and press evenly into a small loaf pan.
- Proof for 1 hour, even though it is a dense bread there will be noticeable expansion.

**Baking**
- Bake at 400°F for 15 minutes, lower the oven to 350°F and bake for approximately 45 minutes.
- After the first 45 minutes, remove bread from the pans in order to firm up the side walls and finish the bake on sheet pans.
- Cool on rack. Traditional pumpernickel has a seven day shelf life, it is best after at least 12 hours.

- To add character, consider accenting with a dash of **P.K. Sherry**, balsamic vinegar or cardamom liqueur.

**Preferments**
- **Sour Dough**

**Mixing**
- **Type of Mixer:** Spiral
- **First Fermentation**
  - **Length of Time:** 4 hours
  - **at room temperature:** 38°F

**Final Dough**
- **Mixing**
  - **Type of Mixer:** Spiral
  - **Mix Style:** Short
  - **Mix Speed:** 5-10 minutes
  - **Dough Temp:** 73°F

**First Fermentation**
- **Length of Time:** 45 minutes

**Shaping**
- **Divide:** 600 g
- **Shape:** Mini loaf pan

**Proof and Bake**
- **Final Proof Time:** 45 min.
- **Oven Type:** Deck
- **Steam:** No
- **Total Bake:** 60 minutes
- **Temperature:** 400°F (15 min) 350°F (45 min)
**Morning Bun**

**Preferments**

Biga

- **Mixing**
  - Type of Mixer: Spiral

- **First Fermentation**
  - Length of Time: 12 hours
  - Temperature: 75°F

**Final Dough**

- **Mixing**
  - Type of Mixer: Planetary
  - Mix Style: Improved
  - 1st Speed: 3 minutes
  - 2nd Speed: 3 minutes
  - Dough Temp: 75°F

- **First Fermentation**
  - Length of Time: 1 hour

**Shaping**

- Divide: 1600 g
- Number of folds: 3 single
- Resting Time: 90 minutes
- Shape: Danish roll

**Proof and Bake**

- Final proof time: 1 hour
- Oven Type: Deck
- Total Bake: 12-15 minutes
- Temperature: 375°F

---

**Formula**

<table>
<thead>
<tr>
<th>INGREDIENTS</th>
<th>TOTAL FORMULA</th>
<th>POLISH</th>
<th>FINAL DOUGH</th>
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<tbody>
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<td>Total Flour</td>
<td>0.900 kg</td>
<td>0.900 kg</td>
<td>0.879 kg</td>
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<tr>
<td>Bread bakers</td>
<td>0.300%</td>
<td>0.100%</td>
<td>0.239%</td>
</tr>
<tr>
<td>Water</td>
<td>0.220%</td>
<td>0.100%</td>
<td>0.099%</td>
</tr>
<tr>
<td>Milk</td>
<td>0.200%</td>
<td>0.018%</td>
<td>0.018%</td>
</tr>
<tr>
<td>Eggs</td>
<td>0.150%</td>
<td>0.019%</td>
<td>0.019%</td>
</tr>
<tr>
<td>Sugar</td>
<td>0.050%</td>
<td>0.005%</td>
<td>0.005%</td>
</tr>
<tr>
<td>Applesauce</td>
<td>0.090%</td>
<td>0.018%</td>
<td>0.018%</td>
</tr>
<tr>
<td>Salt</td>
<td>0.010%</td>
<td>0.010%</td>
<td>0.010%</td>
</tr>
<tr>
<td>Yeast</td>
<td>0.010%</td>
<td>0.003%</td>
<td>0.003%</td>
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<tr>
<td>Malt</td>
<td>0.010%</td>
<td>0.001%</td>
<td>0.001%</td>
</tr>
<tr>
<td>Deactive yeast</td>
<td>0.10%</td>
<td>0.010%</td>
<td>0.010%</td>
</tr>
<tr>
<td>Butter</td>
<td>0.004%</td>
<td>0.006%</td>
<td>0.006%</td>
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**Totals**

<table>
<thead>
<tr>
<th>Total Dough Weight: 1.600 kg</th>
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<tbody>
<tr>
<td>Block/Yield: 1/20</td>
</tr>
<tr>
<td>Total Flour Prefermented: 90%</td>
</tr>
<tr>
<td>Butter: 25%/6.400 kg</td>
</tr>
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</table>

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**Procedure**

**Preferments**

- 12 hours before final mixing, mix the sponge ingredients until a cohesive dough is formed. Move to a covered container and let rise for 12 hours at 75°F.
- Also, 12 hrs in advance, macerate raisins in water, just until covered. Drain well prior to mixing (final macerated weight is reflected in the formula).

**Final Dough**

- Place flour, water, milk, eggs, sugar, applesauce, salt, yeast, malt, and deactive yeast in the bowl of a planetary mixer fitted with a dough hook. Mix 3 minutes on low.
- Break biga into small pieces and mix on 2nd speed for 3 min.
- Mix in butter and mix on medium speed until fully absorbed, 2 minutes.
- Let dough ferment at room temperature for 1 hour in a covered container.
- Divide into 1600 g pieces, flatten to expose excess gas and shape into rectangles.
- Place dough on a floured board, cover and freeze for one hour.
- Measure 400 g butter for roll-in, pour into a block that covers the width and half the length of the dough.
- Place butter block in center of dough and fold both sides of dough to meet in the center.

**Shaping**

- Fold dough into a 12" roll and 4½" long.
- Egg wash and dust with sugar.
- Spray with cinnamon/sugar mixture (600 g) and drizzle with cinnamon sugar mixture (40 g), leaving an undusted strip on the near edge.
- Sprinkle 1/2 of a 1/16" strip of cinnamon/sugar mixture over the egg washed edge to seal the seam.
- Beginning at one end, mark dough in 2½" increments.
- Cut into rolls with a chef's knife and press flat into a well-buttered muffin pan.

**Proofing**

- Place rolls in a proof box, cover and proof for 1 hour at 75°F.
- Proof in an enclosed, slightly humid, 75-78°F environment until they become rounded and soft, about 1 to 1½ hours.
- Remove from oven and immediately roll in cinnamon and sugar.
- To add character, consider accossing with a splash of orange blossom water or brandy, or add clove, cardamom and nutmeg to the cinnamon sugar mixture.

- Refrigerate for 30 minutes, roll out one final single fold on the sheeter.
- Return dough to dusted board, cover and refrigerate for a minimum of 1 hour.

- Shaping
- Final dough
- Proofing
**Walnut-Raisin English Muffin**

**Formula**

<table>
<thead>
<tr>
<th>INGREDIENTS</th>
<th>TOTAL FORMULA</th>
<th>PREFERMENTED DOUGH</th>
<th>FINAL DOUGH</th>
</tr>
</thead>
<tbody>
<tr>
<td>Total Dough Weight 6 kg</td>
<td>100%</td>
<td>25.00%</td>
<td>1.488 kg</td>
</tr>
<tr>
<td>Total Flour</td>
<td>100.00%</td>
<td>1.488 kg</td>
<td>1.116 kg</td>
</tr>
<tr>
<td>Hard White Bakers Flour</td>
<td>100.00%</td>
<td>1.488 kg</td>
<td>1.116 kg</td>
</tr>
<tr>
<td>Powdered Milk</td>
<td>0.00%</td>
<td>0.036 kg</td>
<td>0.036 kg</td>
</tr>
<tr>
<td>Water</td>
<td>35.00%</td>
<td>1.414 kg</td>
<td>1.153 kg</td>
</tr>
<tr>
<td>Salt</td>
<td>2.00%</td>
<td>0.049 kg</td>
<td>0.049 kg</td>
</tr>
<tr>
<td>Instant Yeast</td>
<td>0.75%</td>
<td>0.017 kg</td>
<td>0.017 kg</td>
</tr>
<tr>
<td>Applesauce</td>
<td>5.00%</td>
<td>0.074 kg</td>
<td>0.074 kg</td>
</tr>
<tr>
<td>Butter, Unsalted</td>
<td>1.00%</td>
<td>0.015 kg</td>
<td>0.015 kg</td>
</tr>
<tr>
<td>Walnuts</td>
<td>20.00%</td>
<td>0.298 kg</td>
<td>0.298 kg</td>
</tr>
<tr>
<td>Maceration Liquid</td>
<td>15.00%</td>
<td>0.223 kg</td>
<td>0.223 kg</td>
</tr>
<tr>
<td>Natural Raisins</td>
<td>25.00%</td>
<td>0.372 kg</td>
<td>0.372 kg</td>
</tr>
<tr>
<td><strong>Totals</strong></td>
<td>268.75%</td>
<td>4.000 kg</td>
<td>4.000 kg</td>
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</tbody>
</table>

Yield: 40
Total Flour: 30%

**Preferments**

**Mixing**
Type of Mixer: Spiral
Length of Time: 12 hours
Temperature: 75°F

**First Fermentation**
Number of Folds: 2
Timing for Folds: 40 minutes

**Final Dough**
Mixing
Type of Mixer: Spiral
Mix Style: Improved
1st Speed: 5 minutes
2nd Speed: 5 minutes
Dough Temp: 75°F

**First Fermentation**
Length of Time: 12 hours
Number of Folds: 2
Timing for Folds: 40 minutes

**Shaping**
Divide: 100 g
Shape: Round

**Proof and Bake**
Final proof time: 1 hour
Oven Type: Griddle
Total Bake: 10-12 minutes
Temperature: Low

**Procedure**

- 12 hours before final mixing, mix the sponge ingredients until a cohesive dough is formed. Move to a covered container and let rise for 12 hours at 75°F.
- Also 12 hrs in advance, macerate raisins in water*, just until covered. Drain well prior to mixing (ideal macerated weight is reflected in the formula).

**Final Dough**

- Break biga into small pieces and mix with flour, powdered milk, salt, yeast, water and applesauce in a spiral mixer for 3 min.
- Flake in butter and mix for 3 minutes on 2nd speed
- Add drained raisins and walnut pieces. Mix on speed 1 to disperse evenly (desired dough temp 75°F).

**Shaping and Proofing**

- Let dough ferment for two hours in a covered container, folding twice with thoroughly wet hands (the dough is very loose), at 20-minute intervals.
- Using a generous dusting of flour, turn dough out onto bench and divide into 100 g pieces, premold into rounds.
- Arrange on a well-floured wooden board leaving plenty of room for spread.
- Proof for 1 hour.

**Cooking**

- Heat a griddle on low and grill to a toasted brown on each side. May be finished in a 350°F oven if needed.

*To add character, consider accenting with a dash of nocello, amaretto or vin santo.
Barley-Currant Pretzel

** Preferments **
Biga

Mixing
Type of Mixer: Spiral

First Fermentation
Length of Time: 12 hours
Temperature: 75°F

** Final Dough **
Mixing
Type of Mixer: Spiral
Mix Style: Improved
1st Speed: 3 minutes
2nd Speed: 3 minutes
Dough Temp: 75°F

First Fermentation
Length of Time: 2 hours
Number of Folds: 1
Timing for Folds: 1 hour

Shaping
Divide: 150 g
Preshape: 5 in log
Resting Time: 20 minutes
Shape: Pretzel

Proof and Bake
Final proof time:
Variable—bring to room temperature
Oven Type: Deck
Total Bake: 8-12 minutes
Temperature: 380°F

---

** Formula **
Total Dough Weight: 6.000 kg
Yield: 40
Total Flour Preference: 30%

<table>
<thead>
<tr>
<th>INGREDIENTS</th>
<th>TOTAL FORMULA</th>
<th>PREFERMENTED DOUGH</th>
<th>FINAL DOUGH</th>
</tr>
</thead>
<tbody>
<tr>
<td>Total Flour</td>
<td>100.00%</td>
<td>100.00%</td>
<td>100.00%</td>
</tr>
<tr>
<td>Hard Red Winter Wheat Flour</td>
<td>70.00%</td>
<td>1.840 kg</td>
<td>1.840 kg</td>
</tr>
<tr>
<td>Barley Flour</td>
<td>30.00%</td>
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<td>0.791 kg</td>
</tr>
<tr>
<td>Water</td>
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<td>1.978 kg</td>
<td>1.978 kg</td>
</tr>
<tr>
<td>Salt</td>
<td>2.00%</td>
<td>0.053 kg</td>
<td>0.053 kg</td>
</tr>
<tr>
<td>Instant Yeast</td>
<td>0.50%</td>
<td>0.015 kg</td>
<td>0.015 kg</td>
</tr>
<tr>
<td>Butter, Unsalted</td>
<td>3.00%</td>
<td>0.072 kg</td>
<td>0.072 kg</td>
</tr>
<tr>
<td>Raisin Juice Concentrate</td>
<td>4.00%</td>
<td>0.105 kg</td>
<td>0.105 kg</td>
</tr>
<tr>
<td>Powdered Milk</td>
<td>3.00%</td>
<td>0.079 kg</td>
<td>0.079 kg</td>
</tr>
<tr>
<td>Maceration Liquid</td>
<td>15.00%</td>
<td>0.399 kg</td>
<td>0.399 kg</td>
</tr>
<tr>
<td>Zante Currants</td>
<td>25.00%</td>
<td>0.645 kg</td>
<td>0.645 kg</td>
</tr>
<tr>
<td>Totals</td>
<td>227.50%</td>
<td>6.000 kg</td>
<td>169.00%</td>
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<table>
<thead>
<tr>
<th>INGREDIENTS</th>
<th>TOTAL FORMULA</th>
<th>PREFERMENTED DOUGH</th>
<th>FINAL DOUGH</th>
</tr>
</thead>
<tbody>
<tr>
<td>Zante Currants (Macerated)</td>
<td>1.055 kg</td>
<td>1.055 kg</td>
<td></td>
</tr>
<tr>
<td>Prefermented Dough</td>
<td>1.307 kg</td>
<td>1.307 kg</td>
<td></td>
</tr>
<tr>
<td>Totals</td>
<td>6.000 kg</td>
<td>6.000 kg</td>
<td></td>
</tr>
</tbody>
</table>

---

** Procedure **
- 12 hours before final mixing, mix the sponge ingredients until a cohesive dough is formed. Move to a covered container and let rise for 12 hours at 75°F.
- Also, 12 hrs in advance, macerate currants in water, just until covered. Drain well prior to mixing (ideal macerated weight is reflected in the formula).

Final Dough
- Mix flours, salt, yeast, powdered milk, water and raisin juice concentrate in a spiral mixer on low for 3 minutes.
- Add biga and mix for 3 minutes, on second speed.
- Add butter and mix for 1 minute, on second speed.
- Add currants and mix to disperse evenly on low speed.

Shaping and Proofing
- Let dough ferment for two hours in a covered container with a fold after the first hour.
- Turn dough after the second hour and divide into 150 g pieces. Flatten dough pieces into rectangles and preround tight 5 in. cylinders.
- Let rest for 20 minutes, roll into tapered strands roughly 12 in long. Grabbing each end, pick up and twist 360°, set the ends down over the ring of dough, pressing them into the opposite side, to make a pretzel.
- Lay gently on a lightly floured board. Freeze or chill until an hour before use, then pull and bring to room temperature.

Lye Bath
- Make a 4% lye solution and bring to a boil (use caution as lye is a corrosive chemical). Briefly submerge each pretzel in the bath, drain well and transfer to a sheet pan, sprinkle with sugar crystals or sesame seeds.

Baking
- Bake at 380°F on low convection for 8-12 minutes, cool on rack.

* To add character consider accenting with a dash of whiskey, meadine or barley wine.
**Cinnamon-Raisin Challah**

**Formula**

<table>
<thead>
<tr>
<th>INGREDIENTS</th>
<th>TOTAL FORMULA</th>
<th>PREFERMENTED DOUGH</th>
<th>FINAL DOUGH</th>
</tr>
</thead>
<tbody>
<tr>
<td>Total Flour</td>
<td>100.00%</td>
<td>3.33%</td>
<td></td>
</tr>
<tr>
<td>Hard White Winter Wheat Flour</td>
<td>100.00%</td>
<td>3.33%</td>
<td>25.00%</td>
</tr>
<tr>
<td>Applesauce</td>
<td>10.00%</td>
<td>0.33%</td>
<td></td>
</tr>
<tr>
<td>Water</td>
<td>36.00%</td>
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<td></td>
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<tr>
<td>Salt</td>
<td>2.00%</td>
<td>0.06%</td>
<td></td>
</tr>
<tr>
<td>Instant Yeast</td>
<td>0.50%</td>
<td>0.01%</td>
<td></td>
</tr>
<tr>
<td>Whole Eggs</td>
<td>20.00%</td>
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<td></td>
</tr>
<tr>
<td>Canola Oil</td>
<td>7.00%</td>
<td>0.23%</td>
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</tr>
<tr>
<td>Cinnamon</td>
<td>1.00%</td>
<td>0.03%</td>
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</tr>
<tr>
<td>Maceration Liquid</td>
<td>16.00%</td>
<td>0.52%</td>
<td></td>
</tr>
<tr>
<td>Natural Raisins</td>
<td>20.00%</td>
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<td></td>
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<tr>
<td>Totals</td>
<td>240.75%</td>
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</tr>
<tr>
<td>Natural Raisins</td>
<td>2.127%</td>
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<td></td>
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<tr>
<td>Clipped</td>
<td>1.415%</td>
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<td></td>
</tr>
<tr>
<td>Totals</td>
<td>8.000%</td>
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**Preferments**

<table>
<thead>
<tr>
<th>Biga</th>
</tr>
</thead>
</table>

**Mixing**

<table>
<thead>
<tr>
<th>Type of Mixer: Spiral</th>
</tr>
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</table>

**First Fermentation**

<table>
<thead>
<tr>
<th>Length of Time: 12 hours</th>
<th>Temperature: 75°F</th>
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**Final Dough**

<table>
<thead>
<tr>
<th>Mixing</th>
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<tbody>
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<td>Type of Mixer: Spiral</td>
</tr>
<tr>
<td>Mix Style: Improved</td>
</tr>
<tr>
<td>1st Speed: 3 minutes</td>
</tr>
<tr>
<td>2nd Speed: 3 minutes</td>
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<tr>
<td>Dough Temp: 75°F</td>
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**Fermentation**

<table>
<thead>
<tr>
<th>Length of Time: 2 hours</th>
<th>Temperature: 350°F</th>
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**Shaping**

<table>
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<tr>
<th>Divide: 200 g</th>
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</thead>
<tbody>
<tr>
<td>Preshape: 5” log with cinnamon</td>
</tr>
<tr>
<td>Resting Time: 20 minutes</td>
</tr>
<tr>
<td>Shape: Braid, 400 g in a 7”x3” loaf pan</td>
</tr>
</tbody>
</table>

**Proof and Bake**

<table>
<thead>
<tr>
<th>Final proof time: 1 hour</th>
</tr>
</thead>
<tbody>
<tr>
<td>Oven Type: Deck</td>
</tr>
<tr>
<td>Total Bake: 25 minutes</td>
</tr>
<tr>
<td>Temperature: 350°F</td>
</tr>
</tbody>
</table>

**Procedure**

1. **12 hours before final mixing**, mix the sponge ingredients until a cohesive dough is formed. Move to a covered container and let rise for 12 hours at 75°F.
2. Also, 12 hrs in advance, macerate raisins in water for until covered. Drain well prior to mixing (ideal macerated weight is reflected in the formula).

**Final Dough**

- Flatten dough pieces into rectangles, dust heavily with cinnamon and premold tight 5” cylinders.
- Let rest for 20 minutes, roll into even strands roughly 24” long. Using two strands, weave into a braid.
- At the ends, tuck the longest piece over the others and give the braid a quick roll to make the thickness more uniform.
- Move to a well-sprayed loaf pan, lightly egg wash and proof for one hour.
- Just before baking, brush again with egg wash and sprinkle with sugar crystals and cinnamon.

**Baking**

- Bake at 350°F on low convection for 25 minutes.
- De-pan and cool on rack.

*To add character, consider accenting with a dash of Grand Marnier, Marsala or vin santo.
Schiacciata (ski-a-cha-ta) means crushed or flattened, and Zibibbo refers to a specific grape variety, popular in Italy for making into raisins or wine.

**Sciacciatta con Zibibbo with Blood Orange Raisins**

**Ingredients**

<table>
<thead>
<tr>
<th>Ingredients</th>
<th>Total Formula</th>
<th>Biga</th>
</tr>
</thead>
<tbody>
<tr>
<td>Total Flour</td>
<td>2,206 kg</td>
<td>1,434 kg</td>
</tr>
<tr>
<td>Hard White Winter Wheat Flour</td>
<td>1,296 kg</td>
<td>810 kg</td>
</tr>
<tr>
<td>Rye Flour, Fine</td>
<td>0.110 kg</td>
<td>0.070 kg</td>
</tr>
<tr>
<td>Water</td>
<td>1,544 kg</td>
<td>1,010 kg</td>
</tr>
<tr>
<td>Butter</td>
<td>0.044 kg</td>
<td>0.028 kg</td>
</tr>
<tr>
<td>Eggs</td>
<td>0.044 kg</td>
<td>0.028 kg</td>
</tr>
<tr>
<td>Blood Orange Olive Oil</td>
<td>0.221 kg</td>
<td>0.148 kg</td>
</tr>
<tr>
<td>Applesauce</td>
<td>0.221 kg</td>
<td>0.148 kg</td>
</tr>
<tr>
<td>Instant Yeast</td>
<td>0.171 kg</td>
<td>0.114 kg</td>
</tr>
<tr>
<td>Anise Seeds</td>
<td>0.010 kg</td>
<td>0.007 kg</td>
</tr>
<tr>
<td>Salt</td>
<td>0.044 kg</td>
<td>0.028 kg</td>
</tr>
<tr>
<td>Maceration: Blood Orange Olive Oil</td>
<td>0.331 kg</td>
<td>0.221 kg</td>
</tr>
<tr>
<td>Mixed Raisins</td>
<td>1,324 kg</td>
<td>876 kg</td>
</tr>
<tr>
<td><strong>Totals</strong></td>
<td>6,000 kg</td>
<td>3,900 kg</td>
</tr>
</tbody>
</table>

**Final Dough**

- 24 hours in advance, macerate raisins in blood orange agrumato.
- Toast and grind anise seeds.
- 12 hours before final mixing, mix the sponge ingredients until a cohesive dough is formed. Move to a covered container and let rise, for 12 hours at 75°F.

**Process**

1. Shaping and Proofing
   - Let dough ferment for two hours in a covered container with 2 folds at 40-minute intervals.
   - Turn out dough after the second hour and divide into 300 g or 3½ kg (½ sheet) pieces, and gather loosely into a ball.
   - Set in generously oiled 8½ round cake pans, flipping once to coat well (for the ½ sheet, oil the top well)
   - Dimple heavily with fingers.
   - Proof for 45 minutes, top with 50 g each of raisins and applesauce and dimple again (for 1/2 sheet, 500 g of each).
   - Proof for 15 minutes more.

2. Baking
   - Bake at 350°F on convection for 25 minutes.
   - De-pan and cool on rack.
   - Any citrus infused olive oil will do. Or, using water and 1½ teaspoons of muscato wine, zest or Grand Marnier.
GLUTEN-FREE
Pocket Tart

FORMULA

Total Dough Weight: 4.000 Kg  Yield: 50

<table>
<thead>
<tr>
<th>INGREDIENTS</th>
<th>TOTAL FORMULA</th>
</tr>
</thead>
<tbody>
<tr>
<td>Total Flour</td>
<td>100.00% 2.000 Kg</td>
</tr>
<tr>
<td>Sweet Rice Flour, Fine</td>
<td>50.00% 1.000 Kg</td>
</tr>
<tr>
<td>Almond Meal</td>
<td>50.00% 0.791 Kg</td>
</tr>
<tr>
<td>Sorghum</td>
<td>20.00% 0.791 Kg</td>
</tr>
<tr>
<td>Butter, Unsalted</td>
<td>85.00% 0.052 Kg</td>
</tr>
<tr>
<td>Coconut Sugar</td>
<td>5.00% 0.015 Kg</td>
</tr>
<tr>
<td>Ice Water</td>
<td>25.00% 0.075 Kg</td>
</tr>
<tr>
<td>Salt</td>
<td>2.00% 0.015 Kg</td>
</tr>
<tr>
<td>Lemon Juice</td>
<td>1.00% 0.007 Kg</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>FILLING</th>
<th>TOTAL FORMULA</th>
</tr>
</thead>
<tbody>
<tr>
<td>Total Flour</td>
<td>100.00% 1.000 Kg</td>
</tr>
<tr>
<td>Apples</td>
<td>28.00% 0.280 Kg</td>
</tr>
<tr>
<td>Oranges</td>
<td>28.00% 0.280 Kg</td>
</tr>
<tr>
<td>Golden Raisins</td>
<td>28.00% 0.280 Kg</td>
</tr>
<tr>
<td>Golden Raisin Paste</td>
<td>12.00% 0.120 Kg</td>
</tr>
<tr>
<td>Fresh Ginger</td>
<td>2.00% 0.020 Kg</td>
</tr>
<tr>
<td>Cardamom</td>
<td>0.20% 0.002 Kg</td>
</tr>
<tr>
<td>Vanilla</td>
<td>1.00% 0.010 Kg</td>
</tr>
<tr>
<td>Salt</td>
<td>0.20% 0.002 Kg</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>ICING</th>
<th>TOTAL FORMULA</th>
</tr>
</thead>
<tbody>
<tr>
<td>Total Flour</td>
<td>100.00% 0.080 Kg</td>
</tr>
<tr>
<td>Coconut Sugar</td>
<td>85.00% 0.068 Kg</td>
</tr>
<tr>
<td>Raisin Juice</td>
<td>10.00% 0.008 Kg</td>
</tr>
<tr>
<td>Concentrate</td>
<td>5.00% 0.004 Kg</td>
</tr>
<tr>
<td>Water</td>
<td>5.00% 0.004 Kg</td>
</tr>
</tbody>
</table>

PROCEDURE

Filling
- Peel, core and chop apples into 1” chunks.
- Cut oranges into 1” chunks and remove seeds.
- Combine apples, oranges, raisins and raisin paste and run through a food processor with a medium-fine blade attachment (or a food processor, one fruit at a time, pulsing to desired consistency).
- Mix in cardamom, salt and vanilla.

Dough
- Cut butter into 1” cubes and chill well. Briefly mix flours, sugar, and salt in an spiral mixer.
- Add butter and mix on low for 2 minutes until butter has broken into pea-sized pieces.
- Add chilled water, lemon juice and applesauce. Mix until shaggy. Press together and flatten into a rectangle.
- Chill for one hour, roll out and fold, repeating several times until dough becomes cohesive and can be rolled to 1/4”.
- Chill again and cut into rectangles 2 ½” x 3 ½”
- Egg wash and top with 20 g of filling, lay a second dough on top, use a fork to seal edges and dock to vent while baking.

Baking
- Egg wash and bake at 350°F for 20 minutes.
- Let cool completely before decorating.

Icing
- Pour coconut sugar, raisin juice concentrate and water into a planetary mixer fitted with a whisk and whip until smooth and light.
- Pipe or drizzle on cooled tarts and decorate with sprinkles or candied orange zest.
GLUTEN-FREE
ALMOND CORN RASIN SCONES

FORMULA

<table>
<thead>
<tr>
<th>INGREDIENTS</th>
<th>TOTAL FORMULA</th>
</tr>
</thead>
<tbody>
<tr>
<td>Total Dough Weight: 5.000 kg</td>
<td>Yield: 20</td>
</tr>
<tr>
<td>Total Flour</td>
<td>100%</td>
</tr>
<tr>
<td>Cornmeal</td>
<td>0.965 kg</td>
</tr>
<tr>
<td>Almond Meal</td>
<td>0.248 kg</td>
</tr>
<tr>
<td>Sorghum</td>
<td>0.242 kg</td>
</tr>
<tr>
<td>tapioca starch</td>
<td>0.368 kg</td>
</tr>
<tr>
<td>Sugar</td>
<td>0.124 kg</td>
</tr>
<tr>
<td>Baking Powder</td>
<td>0.068 kg</td>
</tr>
<tr>
<td>Salt</td>
<td>0.012 kg</td>
</tr>
<tr>
<td>Butter, Unsalted</td>
<td>0.369 kg</td>
</tr>
<tr>
<td>Eggs</td>
<td>0.179 kg</td>
</tr>
<tr>
<td>Cream</td>
<td>0.300 kg</td>
</tr>
<tr>
<td>Honey</td>
<td>0.073 kg</td>
</tr>
<tr>
<td>Applesauce</td>
<td>0.058 kg</td>
</tr>
<tr>
<td>Natural Raisins</td>
<td>0.028 kg</td>
</tr>
<tr>
<td>Maceration Liquid</td>
<td>0.025 kg</td>
</tr>
<tr>
<td>Lemon Zest</td>
<td>0.018 kg</td>
</tr>
<tr>
<td>Totals, x 100</td>
<td>248.00%</td>
</tr>
<tr>
<td></td>
<td>3.000 kg</td>
</tr>
</tbody>
</table>

PROCEDURE

- One day in advance, macerate raisins in water* just until covered. Drain well prior to mixing (ideal macerated weight is reflected in the formula).

Dough
- Cut butter into 1/2" cubes and chill well.
- Briefly mix flour, sugar, baking powder and salt in a planetary mixer fitted with a paddle.
- Away butter and mix on low for 2 minutes until butter has broken into slightly smaller pieces.
- Add eggs, cream, honey and applesauce. Mix until shaggy.
  • Mix in drained raisins and zest until just incorporated.
- Divide into 1500 g pieces, and press into 9" rounds lined with parchment, invert onto sheet pans with parchment.
- Chill, cut into wedges, egg wash, sprinkle with sliced almonds and sugar crystals.
- Arrange wedges from two rounds on a sheet pan, leaving room for expansion.

Baking
- Bake at 325°F on low convection for 20 minutes.
- Cool completely.

* To add character, consider accenenting with a dash of orange blossom water, amaretto or limoncello.
Gluten-Free Raisin Newton

Formula

Total Dough Weight: 2.000 kg  Yield: 50

**INGREDIENTS**

<table>
<thead>
<tr>
<th>TOTAL FORMULA</th>
<th>RAISIN FILLING</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Total Flour</strong></td>
<td>1.042 kg</td>
</tr>
<tr>
<td><strong>Oat Flour</strong></td>
<td>0.002 kg</td>
</tr>
<tr>
<td><strong>Powdered Sugar</strong></td>
<td>0.208 kg</td>
</tr>
<tr>
<td><strong>Butter</strong></td>
<td>0.625 kg</td>
</tr>
<tr>
<td><strong>Vanilla Extract</strong></td>
<td>0.001 kg</td>
</tr>
<tr>
<td><strong>Egg Yolks</strong></td>
<td>0.039 kg</td>
</tr>
<tr>
<td><strong>Salt</strong></td>
<td>0.021 kg</td>
</tr>
<tr>
<td><strong>Totals</strong></td>
<td>2.000 kg</td>
</tr>
</tbody>
</table>

Procedure

**Dough**
- Briefly mix soft butter and sugar, in a planetary mixer fitted with a paddle.
- Add egg yolks and vanilla, mix until combined.
- Mix in flour and salt on low until combined. Scoop dough onto a well floured surface and flatten into a rectangle.
- Chill for one hour, roll out to ½". Chill for 20 minutes.
- Take out and cut into 5" wide strips, measure out 100 g of raisin paste per ¾" of length.
- Scoop filling into a piping bag and pipe a ½" wide line down the center of each strip.
- Fold dough in carefully on both sides avoiding air pockets and roll into a uniform log.
- Place seam-side down on parchment-lined sheet pans, flatten the top to create a rectangle.

**Baking**
- Bake for 15-20 minutes at 350°F.
- Cool and cut into squares or diamonds.
Gluten-Free Cracker

Formula

Total Dough Weight: 0.600 Kg  Yield: 50

Ingredients  | Total Formula
-------------|-----------------
Total Flour  | 100.00% 0.391 Kg
Oat Flour    | 40.00% 0.159 Kg
Almond Meal  | 60.00% 0.199 Kg
Baking Powder| 3.00% 0.009 Kg
Natural Raisin Paste | 40.00% 0.153 Kg
Water        | 40.00% 0.159 Kg
Salt         | 1.50% 0.005 Kg
Rosemary     | 1.00% 0.003 Kg
Totals       | 0.600 Kg

Procedure

Dough
- Chop fresh rosemary finely.
- Briefly mix flours, baking powder, rosemary and salt in a bowl.
- Add natural raisin paste and mix until mixture is crumbly.
- Add water and mix until shaggy, press together and flatten into a rectangle.
- Chill for one hour, roll out and fold until dough becomes cohesive and roll to 1/4" thick.
- Dock as desired and chill for 20 minutes.
- Take out and cut into 1" wide strips, place on parchment-lined sheet pans.

Baking
- Bake for 15 minutes at 325°F. Crackers will be a deep golden brown.
**Gluten-Free Coconut Raisin Cookie**

**Formula**

<table>
<thead>
<tr>
<th>INGREDIENTS</th>
<th>TOTAL FORMULA</th>
</tr>
</thead>
<tbody>
<tr>
<td>Total Dough Weight: 5.500 kg</td>
<td>Yield: 100</td>
</tr>
</tbody>
</table>

**Total Flour**: 100.00% 0.787 kg

**Coconut Flour**: 30.00% 0.236 kg

**Brown Rice Flour**: 40.00% 0.315 kg

**Potato Starch**: 30.00% 0.236 kg

**Cardamom**: 1.00% 0.008 kg

**Cinnamon**: 2.50% 0.020 kg

**Baking Soda**: 5.00% 0.039 kg

**Kosher Salt**: 1.00% 0.008 kg

**Butter, Unsalted**: 60.00% 0.472 kg

**Coconut Sugar**: 50.00% 0.395 kg

**Eggs**: 25.00% 0.191 kg

**Applesauce**: 2.00% 0.016 kg

**Vanilla Flax Seeds**: 12.50% 0.096 kg

**Chia Seeds**: 12.50% 0.098 kg

**Chia Flax Hydration**: 25.00% 0.193 kg

**Unsweetened Coconut Flakes**: 20.00% 0.157 kg

**Raisins**: 20.00% 0.157 kg

**Raisin Maceration Liquid**: 30.00% 0.236 kg

**Totals**: 444.50% 3.500 kg

**Procedure**

- One day in advance, macerate raisins in water*, just until covered. Drain well prior to mixing (ideal macerated weight is reflected in the formula).
- Toast coconut to a light golden brown in a low oven, cool and set aside.

**Dough**

- Pour chia and flax seeds into a bowl and add water, set aside for 15 minutes.
- Mix softened butter and sugar in a planetary mixer fitted with a paddle, on medium for 5 minutes until pale and fluffy.
- Add seed mixture, break into small pieces and mix thoroughly.
- Add eggs, applesauce and vanilla. Mix until dispersed, stop mixer and scrape sides.
- Add flours and other dry ingredients and mix on lowest speed until nearly incorporated, add drained raisins and mix until consistent.
- Scoop into 25 g pieces, arrange on sheet trays with parchment, leaving some room for spreading.

**Baking**

- Bake at 350°F on low convection for 20 minutes.
- Cool on rack.

* To add character, consider accenting with a dash of rum, coconut milk or limoncello.
**Gluten-Free Brownie with Raisins**

<table>
<thead>
<tr>
<th>INGREDIENTS</th>
<th>TOTAL FORMULA</th>
<th>TOTAL PER KG</th>
</tr>
</thead>
<tbody>
<tr>
<td>Total Dough Weight: 5,000 kg</td>
<td>Yield: 100</td>
<td></td>
</tr>
<tr>
<td>Total Flour</td>
<td>100.00%</td>
<td>0.815 kg</td>
</tr>
<tr>
<td>Cocoa Powder</td>
<td>55.00%</td>
<td>0.393 kg</td>
</tr>
<tr>
<td>Brown Rice Flour</td>
<td>40.00%</td>
<td>0.285 kg</td>
</tr>
<tr>
<td>Potato Starch</td>
<td>30.00%</td>
<td>0.216 kg</td>
</tr>
<tr>
<td>Tapioca Starch</td>
<td>30.00%</td>
<td>0.216 kg</td>
</tr>
<tr>
<td>Salt</td>
<td>2.50%</td>
<td>0.018 kg</td>
</tr>
<tr>
<td>Baking Powder</td>
<td>1.50%</td>
<td>0.009 kg</td>
</tr>
<tr>
<td>Brown Sugar</td>
<td>0.919 kg</td>
<td></td>
</tr>
<tr>
<td>Raisin Juice Concentrate</td>
<td>0.919 kg</td>
<td></td>
</tr>
<tr>
<td>Butter, Unsalted</td>
<td>1.703 kg</td>
<td></td>
</tr>
<tr>
<td>Eggs</td>
<td>75.00%</td>
<td>0.610 kg</td>
</tr>
<tr>
<td>Vanilla</td>
<td>6.00%</td>
<td>0.049 kg</td>
</tr>
<tr>
<td>Orange Zest</td>
<td>6.00%</td>
<td>0.046 kg</td>
</tr>
<tr>
<td>Golden Raisins</td>
<td>50.00%</td>
<td>0.406 kg</td>
</tr>
<tr>
<td>Orange Juice</td>
<td>40.00%</td>
<td>0.325 kg</td>
</tr>
<tr>
<td>Bittersweet Chocolate</td>
<td>0.00%</td>
<td>0.000 kg</td>
</tr>
<tr>
<td>Heavy Cream</td>
<td>20.00%</td>
<td>0.160 kg</td>
</tr>
</tbody>
</table>

**Procedure**

- One day in advance, macerate raisins in Orange juice with zest* (do not drain excess).

**Dough**

- Mix butter, raisin juice concentrate and sugar in an planetary mixer fitted with a paddle, on medium for 5 min until pale and fluffy.
- Add eggs two at a time, whipping until smooth between each addition, add vanilla and mix until dispersed.
- Gif together flours, cocoa powder and other dry ingredients.
- Add to mixing bowl on lowest speed until newly incorporated.
- Add juice and raisins and mix until consistent.
- Scoop 50 g each into scalloped paper molds, or 2 kg per 1/4 sheet, greased, with parchment.

**Baking**

- Bake at 350° F on low convection for 20 minutes.
- Cool on rack.

**Ganache**

- Chop chocolate into small pieces.
- Bring cream to a simmer, pull off heat and pour over chocolate, let sit for 5 minutes and whisk gently until shiny and smooth.
- Pour into a piping bag with a plain tip and top each cooled brownie with a pillow of ganache.
- Drizzle golden raisins if desired.

* For variations, consider accenting with a dash of balsamic vinegar, crème de cassis or vin santo.
California Raisins, Whole Grains and Gluten-Free

If you want to be on-trend in the baking category, it is important to consider the needs and desires of your customers. With concerns over obesity and type 2 diabetes, being at near-epidemic proportions, consumers are demanding healthier products in all categories of food, including baked goods.

All Natural - California Raisins have been around for over 100 years, but they are completely on-trend in the baking category for those consumers who want a wholly natural product. One look at our ingredient statement and you see the word -raisins—and that’s it. Naturally dried in the sun, California raisins are indeed solar-powered goodness, and aside from a thorough washing, and removal of stems, they are included in baked goods as they come from the fields. Want to go green? Use California Raisins in your baked goods.

Whole Grains - Also on-trend is the use of whole grains in breads, not in combinations with other flours, but 100% whole grains. This trend has been slowly building over the past several years, but it too seems to be gaining momentum and now accounts for close to 10% of all baked products in the commercial and artisan categories. With the new MyPlate Food Guidelines coming from the USDA, the importance of whole grains has been made even more important for a balanced diet. Craig Ponsford, one of America’s best artisan bakers, has incorporated whole grains in more than half of the recipes contained in this book, and we’re sure you will find the formulas easy to use and producing truly delicious results for you and your customers.

Gluten-Free - Craig has also taken up the challenge of preparing several formulas which are gluten-free, for those Americans who are discovering that they have celiac disease, making them allergic to wheat products. Craig has developed some excellent recipes that are absolutely delightful so that all consumers can enjoy breads and pastries, even with a gluten intolerance.

California Raisins are, not only versatile and delicious but they are all-natural, fat and cholesterol-free, and high in antioxidants and potassium. They contain inulin, and polyphenols to deliver on the promise of being good for you.

Our 3,000 plus growers in the sun-drenched San Joaquin Valley of Central California are proud to share with you, the most widely known and universally consumed dried fruit in the world—California Raisins. Please use these formulas to offer healthful and tasty products for your customers. And please check our website, LoveYourRaisins.com for more information on our products and packers, nutritional data, and other equally tasty recipes.

Thanks again to Craig Ponsford for his assistance in preparing these delicious and healthy recipes.
From their consistent color and flavor, to extending product shelf life, there are many advantages to using California Raisins in your products.

**Characteristics**

- Flavor Stability
- Flavor Enhancement
- Flavor Compatibility
- Texture/Fat Replacement
- Texture/Skin Integrity
- Texture/Binding
- Water Activity
- Chemical Properties
- Consistency
- Quality Control

**Value**

The sweet and fruity flavor develops during 2-3 weeks of sun-drying. It is stable for up to 15 months when stored in recommended conditions.

California Raisins contain 2.2% tartaric acid, a flavor enhancer. They also contain precursors of the Maillard reaction, which occurs during the browning of sugars.

California Raisins blend well with sweet flavors - vanilla, cinnamon and citrus. They also blend well with savory flavors - both mild and spicy.

California Raisins are plump, fresh-tasting and have a soft “chew” that mimics fat and richness. Raisins act as a fat-replacer in baked goods without the addition of significant amounts of water.

Their skin is not damaged by processing aids or by other processes. California Raisins retain their shape and integrity during manufacturing processes.

California Raisin sugars create a firm texture that can help bind dry ingredients.

At the same moisture content, California Raisins generally have a lower water activity than other dried vine fruits due to their intact skin and fructose and glucose content.

Naturally occurring organic acids including tartaric, proionic and glutamic acids provide valuable benefits to manufacturers.

Careful harvesting and state-of-the-art processing ensure a consistent product, crop year to crop year.

Quality backed by strict inspection procedures makes California Raisins best in the world.

**Benefits**

- A natural flavor that consumers recognize and value in food products
- Does not change during storage
- Not affected by manufacturing processes
- Function as flavor enhancers
- Flavor potentiators in roasted, baked and microwaveable products
- Excellent flavor background for savory dishes and ethnic foods
- Compatible with all sweet foods
- Offer pleasant chewiness in a wide range of products
- Not gritty, typically free from large sugar crystals
- Function well in fat-free baked goods, cookies and cakes
- Are not easily damaged during mixing
- Fruit plumps and keeps its integrity during microwaving and baking
- Will not collapse, builds volume
- A base ingredient in bars, snacks, cookies and other products
- Low water activity (Aw) allows use in low moisture snacks, confections and cereals
- Easily conditioned for bakery products
- Easy to formulate
- Enhance flavors
- Inhibit mold growth
- Natural preservative
- Consistent color and flavor
- Consistent chewiness
- Meaty and firm
- Aflatoxin negative
- Low microorganism count

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