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Instructions for Use of Chocolate Moulds

One of Brunner's quality objectives is to extend the life-time of our chocolate moulds in production by giving you our recommendations for proper use.

Notice:

Newly delivered moulds have to be washed prior to the first use

Recommendations:

1. Usage of the moulds:

- Minimise the twisting of the mould to a max. deflection over length and width of the mould. As a general guideline you can use following formula: deflection (in mm) = 10 % x (length in mm + width in mm) / 2
- For demoulding the product, hammer only on the strengthening ribs
- Avoid any notch impact on the mould; do not use any sharp devices or edges for demoulding
- The Hammer material should be softer than PC, e.g. PA/POM or rubber
- Several softer hits are better than one hard hit
- Avoid pointed and abrupt impacts on the mould during transport on the line and in the vibration station
- Avoid compression load on the mould e.g. by the scraper or collecting roller
- Prevent fillings (eg. Caramel, especially alcohol) from contacting the mould surface



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- Make sure to follow our recommendations for removing spinning moulds (SE or EF type moulds) from the spinning head.
Recommendations are shown in our homepage video; Please check www.brunner.com
- The max usage temperature of the moulds is 80 – 100°C (176 – 212°F) in dry conditions. Avoid any temperature above range e.g. under the heating elements for mould pre-heating or chocolate shell-rim-heater.

2. Washing of the moulds:

- Mechanical cleaning e.g. with a cotton swab, brush or eraser scratches and damages the mould surface
- Use only low water pressure with max. 3 bar (43,5 Psi) pressure
- Use only demineralised water through osmosis process:
 - Raw water hardness: approx.: 0,18 – 0,36 mol/ m³
- Only use washing agents, rinsing aids and de-foamers suitable for PC. The pH value of washing agent should be around 9.5 to 10,5 and the pH value of the rinsing agent below 7
- Make sure that the mixing ratio is approx. 1,0 to 3,0 g/liter (4 –11 g/gallons) washing agent/water
- Contact the detergent and washing equipment supplier for further details and recommendations
- The max. mould surface temperature should not exceed 60°C (140°F) while washing and drying



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- Make sure that the mould is completely dry with no remaining moisture or detergent after drying

3. Storage of the moulds:

- Make sure that the moulds are completely dry before storing
- Make sure that the moulds are stored without any compression load, no bending and stress free
- Make sure that the moulds are stored in darkness and especially protect the moulds from ultra-violet radiation exposure
- Book moulds should be stored closed

4. Disposal of the used moulds:

- The moulds can be recycled for use in applications other than chocolate moulds
- Brunner will take back the used moulds free of charge (except the freight costs). Moulds must be clean and consist only of pure PC.

Warning notice:

Opening or closing book-moulds may create a pinch point at the fingers due to the high closing force of the magnets

Make sure that the moulds visually inspected on a periodic basis for breakage, cracks or missing parts (magnets, caps, metal pieces)

Damaged moulds have to be removed from production immediately

The Brunner team would be pleased to answer all your questions on the above recommendations.