

BUNGE



WHEAT BREAD RECIPE BOOK



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At Bunge Foods, we are proud to introduce our Desire Wheat Bread Mix Concentrate— a health-driven, performance-focused solution created to empower bakeries with consistency, versatility.

Innovative solution for soft, cost-efficient, wholesome wheat breads.





WHOLE WHEAT SANDWICH BREAD

A soft, nutritious everyday loaf made entirely with whole wheat for a wholesome bite.

INGREDIENTS

QUANTITY

Whole Wheat Bread Mix Concentrate	200 g
Whole Wheat	1000 g
Water (15°C)	850 g
Angel Yeast/ Fresh Yeast	18 g/ 30 g
Lily Refined Sunflower Oil Lotus Margarine	30 g

METHOD:

- **Scaling:** Weigh all ingredients accurately as per the recipe.
- **Mixing:** Mix all the ingredients & add water and mix for 2-3 minutes at slow speed followed by 2nd speed for 3-4 mins until dough is smooth and gluten well developed.
- **Bulk Fermentation (First Proofing):** Rest dough for 10 mins to allow gluten relax and yeast activity start.
- **Dividing, Scaling & Shaping:** Divide dough into required loaf sizes (e.g., 480 g for standard loaf). Shape dough into loaves or rolls as required. Place it into greased bread mold for loafs.
- **Final Proofing:** Proof at 30-35°C with 75-80% humidity for 120 minutes (until dough doubles in size and springs back slowly when pressed).
- **Baking:** Bake at 200°C for 40 minutes (loaves). For rolls: 200-210°C for 15-20 minutes. Ensure crust is golden brown and loaf sounds hollow when tapped.
- **Cooling:** Remove from tins immediately. Cool on wire racks for at least 2-3 hours before slicing/packing



HI-FIBRE MULTIGRAIN BREAD

A hearty, fibre-rich bread packed with nutritious grains and seeds for balanced nutrition.

INGREDIENTS	QUANTITY
Whole Wheat Bread Mix Concentrate	200 g
Whole Wheat Flour	500 g
Refined Flour	200 g
Multigrain Atta	200 g
- Rolled oats	30 g
- Flaxseed powder	20 g
- Sunflower seeds	15 g
- Sesame seeds	10 g
- Wheat bran	25 g
Water (15°C)	900 g
Fresh Yeast / Angel Yeast	18 g / 30 g
Refined Sunflower Oil / Margarine	30 g
Optional: Honey or jaggery	20-25 g

Important Notes:

Fibre + seeds increase water absorption → add 30-50 g extra water depending on desired softness.
Allow proper hydration during mixing for softer crumb.
If using very coarse grains (millets, cracked wheat), pre-soak 30 mins.

METHOD:

- **Scaling:** Weigh all ingredients accurately.
Pre-soak coarse grains (if used) in warm water for 20-30 minutes and drain.
- **Mixing:**
 1. Add whole wheat flour + Multigrain Atta+ Maida concentrate + into the mixer.
 2. Add 90% of water and start mixing at slow speed for 3-4 minutes.
 3. Add yeast and fat, mix until incorporated.
 4. Shift to medium speed for 4-6 minutes until:
 - a. Dough is smooth
 - b. Gluten is developed
 - c. Dough surface becomes slightly shiny
 5. Add multigrain mixture and mix on speed 1 till it uniformly mixed with the dough
 6. Add remaining water gradually if dough feels tight.
Target Dough Temperature: 26-30°C.
- **Bulk Fermentation (First Proofing):** Rest dough 10-12 minutes to let gluten relax and yeast activate.
- **Dividing, Scaling & Shaping:**
 1. Divide dough into loaf portions (450-500 g for standard tin).
 2. Round lightly and rest for 5 minutes.
 3. Shape into loaves and place into greased tins.
 4. Optional: apply water and sprinkle oats/sesame on top.
- **Final Proofing:**
Proof at 30-35°C, 75-80% RH for 70-90 minutes (multigrain proofs faster than whole wheat).
Proof until dough:
 - ✓ Reaches $\frac{3}{4}$ height of the tin
 - ✓ Springs back very slowly when pressed
- **Baking:**
 - Loaves: 200°C for 38-40 minutes
 - Rolls: 200-210°C for 15-18 minutes
 - Bread is done when:
 - ✓ Crust is golden brown
 - ✓ Loaf sounds hollow when tapped



EXOTIC VEG PIZZA BASE

A healthy, chewy whole wheat crust perfect for flavorful and guilt-free pizzas.

INGREDIENTS

(For 10–12 medium pizza bases)
(Approx. 220–250 g dough per base)

QUANTITY

Whole Wheat Bread Mix Concentrate	200 g
Whole Wheat Flour	1000 g
Water (18–22°C)	800 g
Angel Yeast	10 g
Refined Sunflower Oil / Olive Oil	40 g
Sugar (optional, for browning)	10 g
Oregano / Mixed Herbs (optional)	5 g
Garlic Powder (optional, enhances pizza flavour)	3–4 g

Note:
Pizza dough requires less hydration and less fermentation than bread to maintain structure.

Optional Exotic Enhancements

Add any of the following into the dough for an "exotic veg pizza base" profile:

Option A – Italian Herb Base

Add:

- 5 g oregano
- 5 g chilli flakes
- 3 g garlic powder

Option B – Cheese Flavoured Base

Add:

- 20 g cheese powder
- 5 g herbs

Option C – Veggie-Infused Dough

Add:

- 20–30 g dehydrated tomato flakes
- 10 g dried spinach powder
- 5 g basil

METHOD:

- **Scaling:** Weigh all ingredients accurately.
- **Mixing:**
 1. Add flours + bread mix concentrate +).
 2. Add 90% of water and begin mixing at slow speed for 2–3 minutes.
 3. Add yeast, sugar, herbs (optional) and oil.
 4. Mix at medium speed for 4–5 minutes until dough is:
 - Smooth
 - Stretchy
 - Not fully gluten-developed (pizza needs moderate gluten)
 5. Adjust dough with remaining water if required.

Target dough temperature: 26–30°C
- **Bulk Fermentation (Resting):** Rest dough for 10–12 minutes only. This helps gluten relax and improves shaping.
- **Dividing & Shaping:**
 1. Divide dough into 220–250 g per pizza base (6–8 inches).
 2. Round each portion gently.
 3. Rest portions for 5 minutes.
 4. Roll or hand-stretch each piece into a 6–8 inch base.
 5. Dock (poke holes) using a docker or fork to avoid puffing during baking.
- **Proofing (Light Proof Only):**
Proof lightly for **20–25 minutes** at:
Temperature: 28–30°C
Humidity: 70–75%
Pizza bases should NOT double in size.
- **Baking:**
For Par-Baked Pizza Bases:
 - 195–200°C for 6–8 minutes

Base should be:

 - ✓ Slightly dry on top
 - ✓ Light golden on bottom
 - ✓ Soft & flexible

For Fully Baked Bases:

 - 200–210°C for 10–12 minutes
- **Cooling & Packing:**
 1. Cool on racks for 30–40 minutes.
 2. Pack in plastic bags / stack with butter paper in between.
 3. Store at:
 - Ambient: 2–3 days
 - Chilled: 7 days
 - Frozen: 45–60 days



WHOLE WHEAT BURGER BUN

Whole wheat burger buns that hold shape and add wholesome flavour.

INGREDIENTS

(For 8 standard buns, ~90-100 g each)

QUANTITY

Whole Wheat Bread Mix Concentrate	100 g
Whole Wheat Flour	500 g
Water	400 g
Angel Yeast	9 g
Lotus Margarine	25 g
Sesame Seeds	as needed optional

Note:

Pizza dough requires less hydration and less fermentation than bread to maintain structure.

Tips for Whole Wheat Burger Buns:

- ✓ Add 3-4% Lotus margarine for extra softness and height
- ✓ Slightly lower hydration gives better bun structure
- ✓ Do NOT over-bake—whole wheat dries quickly
- ✓ Butter wash after baking keeps buns soft
- ✓ Use a light mist of water before proofing to prevent drying

METHOD:

- **Mixing the Dough:**
 - In the bowl, combine, whole wheat flour, Whole wheat concentrate, yeast, water.
 - Knead until 80% of dough formation becomes (8-9 minutes on spiral mixer)
 - Add Margarine and knead further for 2 mins till dough becomes smooth, elastic, and slightly tacky
- **First Fermentation (Bulk Rise):** Keep the dough covered for 15-20 minutes.
- **Scaling and Pre-shaping:**
 1. Handle the dough gently.
 2. Scale into 90-100 g portions (standard burger size).
 3. Pre-round each piece into a ball.
 4. Rest the balls for 10 minutes covered. (Resting relaxes gluten and helps shaping.)
- **Final Shaping:**
 1. Take each rested ball and gently tighten it into a smooth, round bun.
 2. Slightly flatten the top so buns bake uniformly.
 3. Place on a baking tray with at least 2 inches gap between buns.
- **Final Proof:**

Proof for 45-60 minutes depending on temperature/yeast.

Buns should rise nearly double and appear light and airy when touched.

▼ Over-proofing can cause buns to collapse post-bake.
- **Finishing Before Baking:**

Optional but recommended:

Brush with milk or egg wash (if allowed).

Sprinkle with sesame seeds.
- **Baking:**

Bake at 200°C for 14-16 minutes (deck/rotary).

Tops should be golden brown.
- **Cooling + Softening:**

Immediately brush with butter after baking.

Cool for at least 20-30 minutes before slicing.



WHOLE WHEAT PITA BREAD

Soft, pocket-perfect whole wheat pita ideal for stuffing with fresh fillings.

INGREDIENTS

For 20-22 medium pitas

QUANTITY

Whole Wheat Bread Mix Concentrate	200 g
Whole Wheat Flour	1000 g
Water (26-28°C)	750 g
Fresh Yeast / Angel Yeast	10 g / 10 g
Oil (Sunflower/Olive)	20 g

Optional Variations:

Garlic Herb Pita

Add: 5 g garlic powder

5 g mixed herbs

10 g extra oil

Oil-Free Healthy Pita

Remove oil, increase water by 10-15 g.

High-Fiber Pita

Add 20-25 g wheat bran, increase water by 20-30 g.

METHOD:

- **Scaling:** Weigh all ingredients accurately.
Use slightly warm water (26-28°C) to support quick puffing.
- **Mixing:**
 1. Add whole wheat flour + bread mix concentrate.
 2. Add 90% of water and start mixing at slow speed for 2-3 minutes.
 3. Add yeast and oil.
 4. Mix on medium speed for 3-5 minutes until dough is Soft, Smooth Slightly sticky
Only moderately gluten-developed (not as strong as bread)
Target dough temperature: 26-27°C
- **Bulk Fermentation (First Rest):** Rest dough for 15-20 minutes.
Just enough to relax gluten—not a full proof. This helps easy rolling and better puffing.
- **Dividing and Shaping:**
 1. Divide dough into 70-90 g balls (small) or 110-120 g (large pitas).
 2. Round each piece smoothly.
 3. Rest the balls for 10 minutes (very important!)
 4. Roll each ball to 4-5 mm thickness—even thickness is key for puffing.
 5. Keep rolled discs covered to avoid drying.
- **Final Rest (Short Proof):**
Rest rolled pitas for 8-10 minutes only.
Do not allow them to rise too much.
Overproofing → poor puffing.
- **Baking (High Heat for Puffing):**
You can use deck oven, tandoor, or heavy tawa.

Deck Oven Method (Best for bakeries)

Temperature: 260-300°C (top & bottom)

Bake: 60-90 seconds

Pitas should puff completely forming a pocket.

Tawa Method

Preheat tawa on medium-high heat.

Place rolled dough on hot tawa.

Flip after 20-25 seconds.

Press gently with cloth → pita puffs like a balloon.

- **Cooling:**
Cool on racks for 20-25 minutes.
Keep covered with cloth to prevent drying.



WHOLE WHEAT ENGLISH MUFFINS

Light, airy muffins made with whole wheat, ideal for toasting and breakfast sandwiches

INGREDIENTS

For 20-22 medium pitas

QUANTITY

Whole Wheat Bread Mix Concentrate	200 g
Whole Wheat Flour	1000 g
Water (25-28°C) (English muffins require softer dough)	800 g
Fresh Yeast / Angel Yeast	18 g / 10 g
Sugar (Helps Browning)	10 g
Lily Sunflower / Soft Lotus Margarine	30 g
Milk Powder (optional, better flavor + softness)	10 g
Semolina (For Dusting)	As needed

Optional Variations:

Honey Wheat English Muffins

Add 20-25 g honey; reduce water by 10-15 g.

Multigrain English Muffins

Add 30 g rolled oats + 10 g flaxseed; increase water by 20-30 g.

Sourdough Style

Add 30 g vinegar or 1% sourdough powder for tang.

METHOD:

- **Scaling:** Weigh all ingredients accurately. Keep semolina separately for dusting.
- **Mixing:**
 1. Add flour + bread mix concentrate + Yeast + milk powder + sugar
 2. Add 90% of water and mix on slow speed for 3 minutes.
 3. Add oil & 4. Mix on medium speed for 4-6 minutes until dough is:
 - Soft, Slightly sticky (normal for English muffins)
 - Moderately developed gluten (not as strong as bread)

Target dough temperature: 26-27°C
- **Bulk Fermentation (First Rest):** Rest dough for 15 minutes only. This helps gluten relax and makes rolling easier.
- **Rolling and Cutting:**
 1. Dust table with semolina + flour mix.
 2. Roll dough to 1.8-2.0 cm thickness.
 3. Cut with a round cutter (7-9 cm diameter).
 4. Place cut muffins on trays dusted with semolina.
 5. Lightly dust tops with semolina.

Tip: Do Not reshape the scrap dough more than once; overworked dough becomes tough.
- **Final Proofing:**

Proof at:

 - 30-32°C temperature
 - 75-80% humidity
 - Time: 35-45 minutes

Muffins should become puffy but not double in size.
- **Cooking (In Oven):**

Bake muffins in oven at 180°C for 3-4 minutes after griddle cooking..
- **Cooling:**

Cool on wire racks for 1 hour before slicing or packing.



WHOLE WHEAT SESAME ROLL

Soft, fluffy whole wheat dinner rolls ideal for everyday meals

INGREDIENTS

(Same base formula, scaled for rolls)

QUANTITY

Whole Wheat Bread Mix Concentrate	200 g
Whole Wheat Flour	1000 g
Water (15°C) (slightly reduced for roll shaping)	750 g
Angel Yeast	18 g
Lotus Margarine	30 g
Sesame Seeds	As Required

METHOD:

- **Scaling:** Weigh all ingredients accurately.
- **Mixing:**
 1. Add Whole Wheat Bread Mix, whole wheat flour, into the mixer.
 2. Add water gradually and mix at slow speed for 2-3 minutes.
 3. Switch to medium speed for 3-4 minutes until: dough is smooth, gluten is moderately developed.
 4. Add Margarine at last and mix until absorbed.

Dough will be slightly firm compared to loaf dough (to help shaping rolls).
- **Bulk Fermentation:** Rest dough for 10-15 minutes to relax gluten.
- **Dividing and Pre-Shaping:**
 1. Divide dough into 35-45 g pieces (standard dinner roll size).
 2. Pre-shape into round balls.
 3. Rest for 10 minutes covered.
- **Final Shaping:**
 1. Round each dough piece tightly into a smooth ball.
 2. Lightly brush the top with water or milk.
 3. Dip each roll into a bowl of white sesame seeds so the top is fully coated.
 4. Place onto a greased tray, leaving 2 inches spacing for expansion.
- **Final Proofing:**

Proof at 30-35°C / 75-80% RH for 45-60 minutes.

Rolls should become light, puffy, and almost double.

Avoid over-proofing—otherwise rolls will collapse after baking.
- **Baking:**

Bake at 200-210°C for 12-15 minutes. Sesame should turn light golden.
- **Cooling:**

Cool on wire rack for 30-40 minutes.

Brush with butter for extra softness (optional).



WHOLE WHEAT SAUSAGE ROLL

Soft, mildly enriched dough wrapped around sausages.

INGREDIENTS

Scaled from your original whole-wheat bread recipe

QUANTITY

Whole Wheat Bread Mix Concentrate	200 g
Whole Wheat Flour	1000 g
Water (reduced for shaping)	800 g
Angel Yeast	18 g
Lotus Margarine	40 g
Sesame Seeds	Optional

TIPS FOR BEST WHOLE WHEAT SAUSAGE ROLLS

- ✓ Slightly lower hydration gives better shaping around sausage
- ✓ Rest dough before rolling to avoid tearing
- ✓ Do not over-proof (otherwise dough will separate from sausage)
- ✓ Brush with milk or butter for soft crust
- ✓ Use pre-cooked sausages only

METHOD:

- **Scaling:** Weigh all ingredients accurately.
- **Mixing:**
 1. Add whole wheat flour + bread mix + yeast into the mixing bowl.
 2. Add water and mix at slow speed 2-3 mins.
 3. Switch to medium speed for 3-4 mins until dough becomes smooth, moderately elastic (does not need full gluten windowpane).
 4. Add margarine last and mix other 2-3 mins until fully absorbed and nice gluten formation

Dough should be soft but not sticky.
- **Bulk Fermentation:** Rest dough for 10-15 minutes. This short fermentation gives better handling for shaping
- **Dividing and Pre-Shaping:**
 1. Divide dough into 50-60 g pieces for mini rolls OR 80-90 g for large rolls.
 2. Pre-round each piece into a small ball.
 3. Rest 10 minutes covered (relaxes gluten for smooth rolling).
- **Shaping - Wrapping the Sausages:**
 1. Roll each dough ball into an flat rectangular shape oval strip (about 15 cm long).
 2. Place a sausage at one end.
 3. Roll the dough around the sausage.
 4. Pinch seam tightly so it doesn't open during baking.
 5. Place seam-side down on tray.
- **Final Proofing:** Proof at 30-35°C / 75-80% humidity for 35-45 minutes. Dough should look puffy and increased by 80%.
- **Finishing Before Baking:** Optional but recommended:
 - Brush with milk for shine.
 - Sprinkle with sesame seeds.
 - Add a diagonal score (optional) for bakery-style look.
- **Baking:** Bake at 190-200°C for 13-16 minutes. Rolls should be golden brown, and dough around sausage should be fully baked.
- **Cooling:** Cool for 10-15 minutes before packing. Brush with melted butter for extra softness (optional)



WHOLE WHEAT CINNAMON RAISIN SWIRL BREAD

A warm, aromatic whole wheat loaf filled with a sweet cinnamon ribbon

INGREDIENTS

Scaled from your original whole-wheat bread recipe

QUANTITY

Whole Wheat Bread Mix Concentrate	200 g
Whole Wheat Flour	1000 g
Water (reduced for shaping)	800 g
Angel Yeast	18 g
Lotus Margarine	40 g
Sesame Seeds	Optional

OPTIONAL ENHANCEMENTS

Honey Cinnamon Raisin Bread

Add 20–25 g honey; reduce water by 10–15 g.

Cream Cheese Cinnamon Swirl

Add a cream-cheese stripe inside the swirl (bakery specialty).

Extra Soft Version

Replace 80 g water with 80 g milk.

METHOD:

- **Scaling:** Weigh everything accurately. Wash raisins, drain well, pat dry, and toss with 1 tablespoon flour so they don't sink
- **Mixing:**
 1. Add whole wheat flour + bread mix concentrate + milk powder + sugar.
 2. Add 90% of the water and mix on slow speed for 2 minutes.
 3. Add yeast and oil/Margarine.
 4. Mix on medium speed for 6–8 minutes until: Dough is soft, Smooth, Slightly sticky (normal for raisin breads)
 5. Add raisins at the last 1 minute of mixing (slow speed) → prevents crushing. Target dough temperature: 26–30°C
- **Bulk Fermentation:** Rest dough for 15–20 minutes. It should relax but not rise fully
- **Dividing and Resting:**
 1. Divide into 450–500 g loaf pieces.
 2. Pre-shape into tight rounds.
 3. Rest for 10 minutes (important for clean rolling)
- **Rolling & Swirl Formation:**
 1. Roll each dough piece into a rectangle approximately 25–28 cm long.
 2. Spread a thin layer of soft butter across the surface.
 3. Sprinkle evenly the cinnamon-sugar mixture (leave 1 cm gap at edges).
 4. Roll tightly from the shorter side to form a log.
 5. Pinch seam well to avoid swirl bursting. Place seam side down into greased loaf tins.
- **Final Proofing:** Proof at: 30–35°C/75–80% humidity | Time: 60–90 minutes. Proof until loaf reaches ¾ of the tin height and springs back slowly when touched.
- **Baking:** Bake at 190–200°C for 35–40 minutes.
 - ✓ Golden brown crust
 - ✓ Swirl smells fragrant & sweet
 - (Optional) Brush with butter after baking for a softer crust.
- **Cooling:** Cool for minimum 2–3 hours before slicing to avoid swirl tearing.



WHOLE WHEAT ONION FOCACCIA

A wholesome Italian flatbread made with whole wheat and topped with herbs.

INGREDIENTS

Scaled from your original whole-wheat bread recipe

QUANTITY

Whole Wheat Bread Mix Concentrate	200 g
Whole Wheat Flour	1000 g
Water (reduced for shaping)	800 g
Angel Yeast	18 g
Lotus Margarine	40 g
Sesame Seeds	Optional

OPTIONAL VARIATIONS

Garlic Herb Focaccia -

Add 10 g garlic powder + 5 g mixed herbs into dough.

Cheese Focaccia -

Add grated cheese after proofing & before baking.

Whole Wheat Onion Focaccia -

Top with caramelized onions + black sesame.

METHOD:

- **Scaling:** Weigh all ingredients accurately. Prepare toppings (slice tomatoes, olives, garlic).
- **Mixing:**
 1. Add whole wheat flour + bread mix concentrate + sugar + salt.
 2. Add 90% of water.
 3. Mix at slow speed for 3 minutes.
 4. Add yeast and 40 g olive oil.
 5. Mix at medium speed for 4–6 minutes until dough becomes:
 - Very soft / Sticky (normal for focaccia)
 - Smooth with moderate gluten
 - Add remaining water only if dough feels tight.
 - Target dough temperature: 26–28°C
 - High hydration is key for open crumb focaccia.
- **Bulk Fermentation (Longer Rest):** Rest dough for 45–60 minutes. Midway (after 20–25 minutes), give 1 set of stretch & fold to build strength.
- **Panning:**
 1. Grease your sheet pan generously with olive oil (10–15 g).
 2. Transfer dough gently onto the tray.
 3. Oil your hands and stretch the dough softly to fit the tray (do not deflate completely).
 4. Drizzle more olive oil on top.
- **Intermediate Rest:** Rest the dough in tray for 15–20 minutes until relaxed
- **Dimpling & Topping:**
 1. Oil your fingers.
 2. Press deep dimples across surface using fingertips.
 3. Add toppings such as: rosemary, olives, cherry tomatoes, garlic slices
 4. Drizzle 10–15 g extra olive oil.
 5. Sprinkle sea salt flakes or regular salt.
- **Final Proofing:** Proof at: 30–35°C | 75–80% humidity | Time: 30–40 minutes
The dough should look airy and slightly bubbly.
- **Baking:**
 - Bake at 210–220°C for 20–25 mins until:
 - ✓ Golden brown
 - ✓ Crispy edges
 - ✓ Soft, airy crumb
 - Rotate tray mid-bake for even color.
- **Post-Bake:**
 - Brush with a final light coat of olive oil for shine & softness.
 - Cool for 20–30 mins before cutting.



WHOLE WHEAT TIFFIN CAKE

A festive, fruity Italian bread made wholesome with whole wheat

INGREDIENTS

Yield: 2 medium Tiffin cake (500-600 g dough)

QUANTITY

1. Dry Ingredients:

Whole Wheat Bread Mix Concentrate	60 g
Whole Wheat Flour	300 g

2. Wet & Enrichment Ingredients:

Honey	15 g
Butter (Soft)	20 g
Milk Powder (Option, help softness)	10 g
Eggs	1 whole egg + 1 Yolk
Milk/Water (adjust to soft enriched dough)	120-130 ml

3. Flavouring:

Vanilla Essence	½ tsp
Orange Zest	1 tsp
Lemon Zest	½ tsp

4. Fruit Mix

Raisins	18 g
Chopped candied orange/lemon peel	40 g

Soak mix in 20 ml warm water + 5 ml rum/essence (optional) for 30 mins. Drain before use.

METHOD:

- **Prepare the Dough**
 1. In a bowl mix: add Whole wheat flour, Yeast, Milk Powder
 2. Add, honey, egg, egg yolk, milk/water and start mixing.
 3. Knead until dough forms (5-7 mins).
- **Add Butter**
 - Add softened butter gradually and continue kneading 8-10 mins.
 - Dough should become smooth, stretchy and slightly sticky.
 - Whole wheat dough won't be as elastic as maida, but gluten helps.
- **Add Flavourings + Fruit**
 1. Add vanilla + citrus zest.
 2. Gently fold the soaked and drained fruits into the dough.

Do not over-knead after fruits.
- **First Proofing:**
 1. Cover and proof for 60-75 mins or till dough doubles.
 2. Shaping
 3. Lightly pat the dough to remove excess gas (air bubbles)
 4. Shape into a tight round ball.
 5. Place into a panettone mold (500 g size)

If no mold, use a deep tall tin lined with parchment extending above the rim.
- **Final Proof:**

Proof for 50-70 mins until dough rises near the top of the mold.
- **Topping (optional but traditional):**

Cut a small "+" on top and place a small cube of butter in the center.
- **Baking:**

Bake at 170°C for 35-40 mins.

If the top browns too fast, cover with foil.

Internal temperature should reach 92-94°C.
- **Cooling (Important for structure)**

Cool at least 2 hours before slicing.