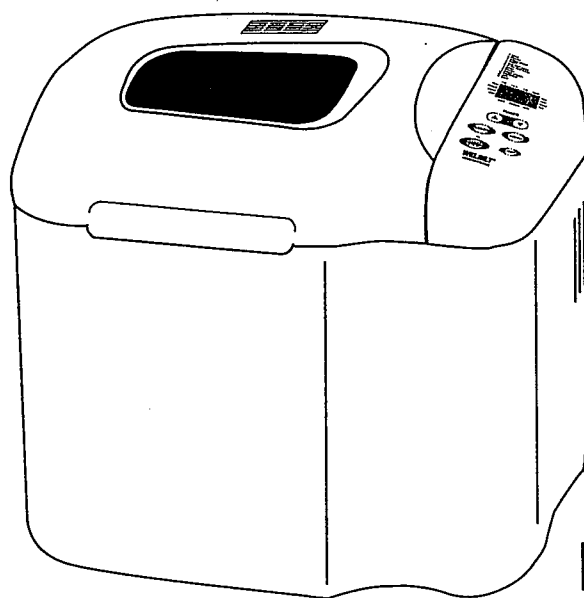
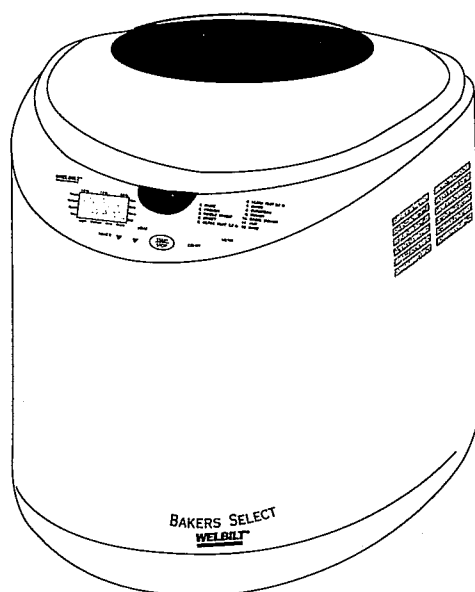


THE BREAD MACHINE



MODEL ABM2H52



MODEL ABMY2K1

INSTRUCTION MANUAL

WELBILT[®]

HOUSEHOLD USE ONLY

IMPORTANT SAFEGUARDS

WHEN USING ELECTRICAL APPLIANCES, BASIC SAFETY PRECAUTIONS SHOULD ALWAYS BE FOLLOWED, INCLUDING THE FOLLOWING:

1. Read all instructions carefully.
2. Do not touch hot surfaces. Use handles or knobs and a potholder. Do not close or clog the steam vent openings under any circumstances.
3. To protect against electrical shock, do not immerse cord, plug, or any other part of this bread machine, in water or other liquid.
4. Close supervision is necessary when any appliance is used by or near children.
5. Unplug the power supply cord when the appliance is not in use, or before cleaning. Allow to cool before putting on or taking off any parts.
6. Do not use or operate the appliance with a damaged cord or plug, or after the appliance malfunctions or has been damaged in any manner. Return appliance to the nearest authorized service facility for examination, repair or adjustment.
7. The use of accessory attachments not recommended or sold by the manufacturer may cause injuries.
8. Do not use outdoors.
9. Do not let the power supply cord hang over the edge of table or counter, or touch hot surfaces.
10. Do not place the appliance on or near hot gas or electric burners, or in a heated oven.
11. Extreme caution must be used when moving an appliance containing hot contents or liquids.
12. To disconnect, press STOP, then remove plug from wall outlet. Grip plug and pull from wall outlet. Never pull on the cord.
13. Do not use the bread machine for other than intended use.
14. Avoid contact with moving parts during operation.
15. Do not pour any ingredients directly into the bread machine - only into the baking pan. The baking pan must then be placed in the machine.
16. Do not operate this appliance in the presence of explosive and/or flammable fumes.
17. This appliance is intended for HOUSEHOLD USE ONLY and not for commercial or industrial use.
18. To avoid damaging the machine, do not place any object on top of the unit.
19. Do not clean with scouring pads. Pieces can break off the pad and touch electrical parts, creating a risk of electric shock.
20. Do not use bread machine for storage purposes nor insert any utensils, as they may create a fire or electric shock.

SAVE THESE INSTRUCTIONS

This appliance has a polarized plug (one blade is wider than the other). As a safety feature, this plug will fit in a polarized outlet only one way. If the plug does not fit fully in the outlet, reverse the plug. If it still does not fit, contact a qualified electrician. **DO NOT ATTEMPT TO DEFEAT THIS SAFETY FEATURE.**

A short power-supply cord is provided to reduce the risk of becoming entangled in or tripping over a longer cord. An extension cord may be used if precautions are taken in their use. If an extension cord is used:

1. The marked electrical rating of the extension cord should be at least as great as the electrical rating of the appliance.
2. The cord should be arranged so that it will not drape over the countertop or tabletop where it can be pulled on by children or tripped over accidentally.

About Your Bread Machine

- The bread machines in this manual make REGULAR(1 lb.), LARGE (1 1/2 lb.) and EXTRA LARGE (2 lb.) horizontal loaves of breads.
- The bread machine has 47 settings. See *Bread Machine Cycle Times*, page 16.
- Two special ULTRA FAST settings allow you to complete the breadmaking process in 58 minutes. Special recipes must be used for these cycles.
- The Fruit and Nut Beep signals when it is time to add ingredients, such as fruits, nuts, or chips. It will maintain ingredients' shape and texture rather than be chopped up by the kneading blade. If you use the TIMER to delay baking, you may add all the ingredients at once and bypass the function. However, the fruits, nuts, or chips may get somewhat chopped.
- RAPID settings for BASIC, FRENCH, and WHOLE WHEAT breads allow you to make standard recipes in a shorter period of time. Choose the RAPID setting by pressing the COLOR key.
- The crust color of your fresh homemade bread can be controlled for personal preference.
- 13-HOUR PROGRAMMABLE TIMER lets you wake up to hot baked bread in the morning.
- Large VIEWING WINDOW allows you to watch the breadmaking process.
- The KEEP WARM function prevents the bread from getting soggy by keeping finished bread warm up to an hour after the baking is completed. This function stops when the unit is turned OFF/STOP or is unplugged.
- The bread machine is designed with a cool-touch exterior. It is compact and lightweight. Model ABM2H52 has handles molded into the sides for easy handling.
- The lid of the machine is removable to make cleaning easier.
- The bread machine has POWER LOSS MEMORY, which resumes cycle where it left off when a short-term power loss occurs.
- Do not cover the bread machine with towels or other materials that may prevent steam from escaping. Some steaming from vents is normal.
- Do not place any objects on top of the bread machine.
- Unplug the unit and wait until it cools, then remove any spilled ingredients or crumbs from the baking chamber of the bread machine by wiping with a damp sponge or cloth. See *Care and Cleaning*, page 16.

IMPORTANT: Always add ingredients in the order they are specified in the recipe. For best results, **accurate measuring of ingredients is vital**. Do not put larger quantities than recommended into the baking pan as it may produce poor results and may damage the bread machine.

NOTE: The model of your bread machine is located on the control panel.

Before Your First Use

Enjoy using your Welbilt Bread Machine. Before your first use, please take a few minutes to read this Instruction Manual and keep it handy for reference. Please pay particular attention to the safety instructions we have provided for your protection.

Carefully unpack the bread machine and remove all packaging materials. To remove any dust that may have accumulated during packing, wipe the baking pan, kneading blade and outside surface of the bread machine with a clean, damp cloth. **Do not use scouring pads or any abrasives on any part of the bread machine.**

Plug the cord into a 120-volt AC outlet. The cord length of this bread machine was selected to reduce the possibility of tangling or tripping over a longer cord. If more cord length is needed, use a UL certified extension cord rated no less than 15 amperes and 120 volts. The longer cord should be arranged so that it will not drape over the countertop where it can be pulled on by children or tripped over.

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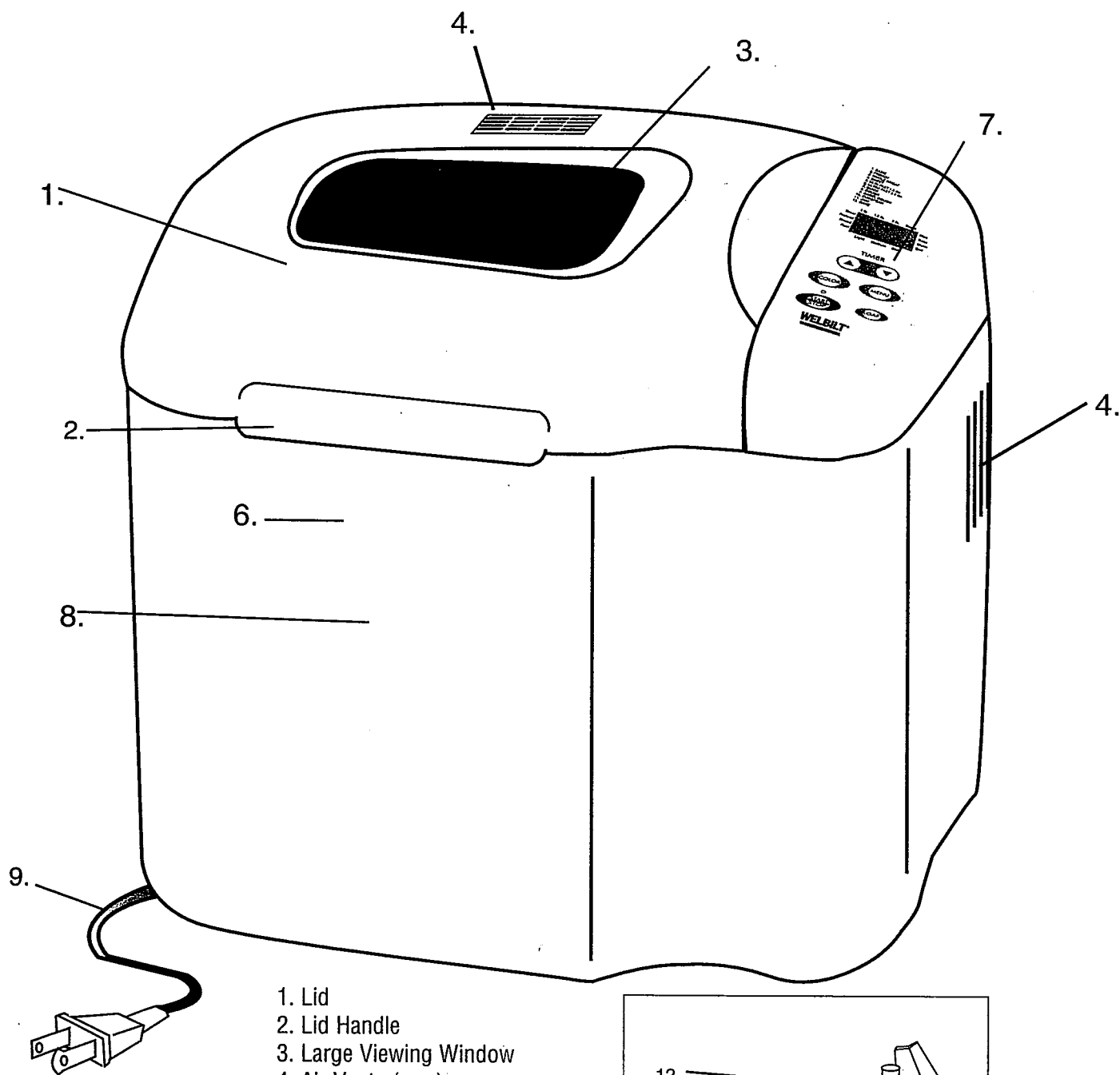
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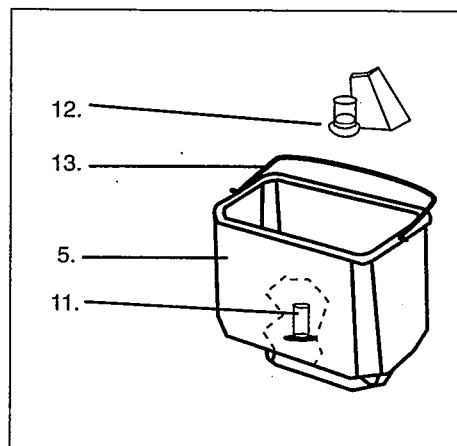
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Know Your Bread Machine

ABM2H52 MAKES 1, 1 1/2, AND 2 LB. HORIZONTAL LOAVES

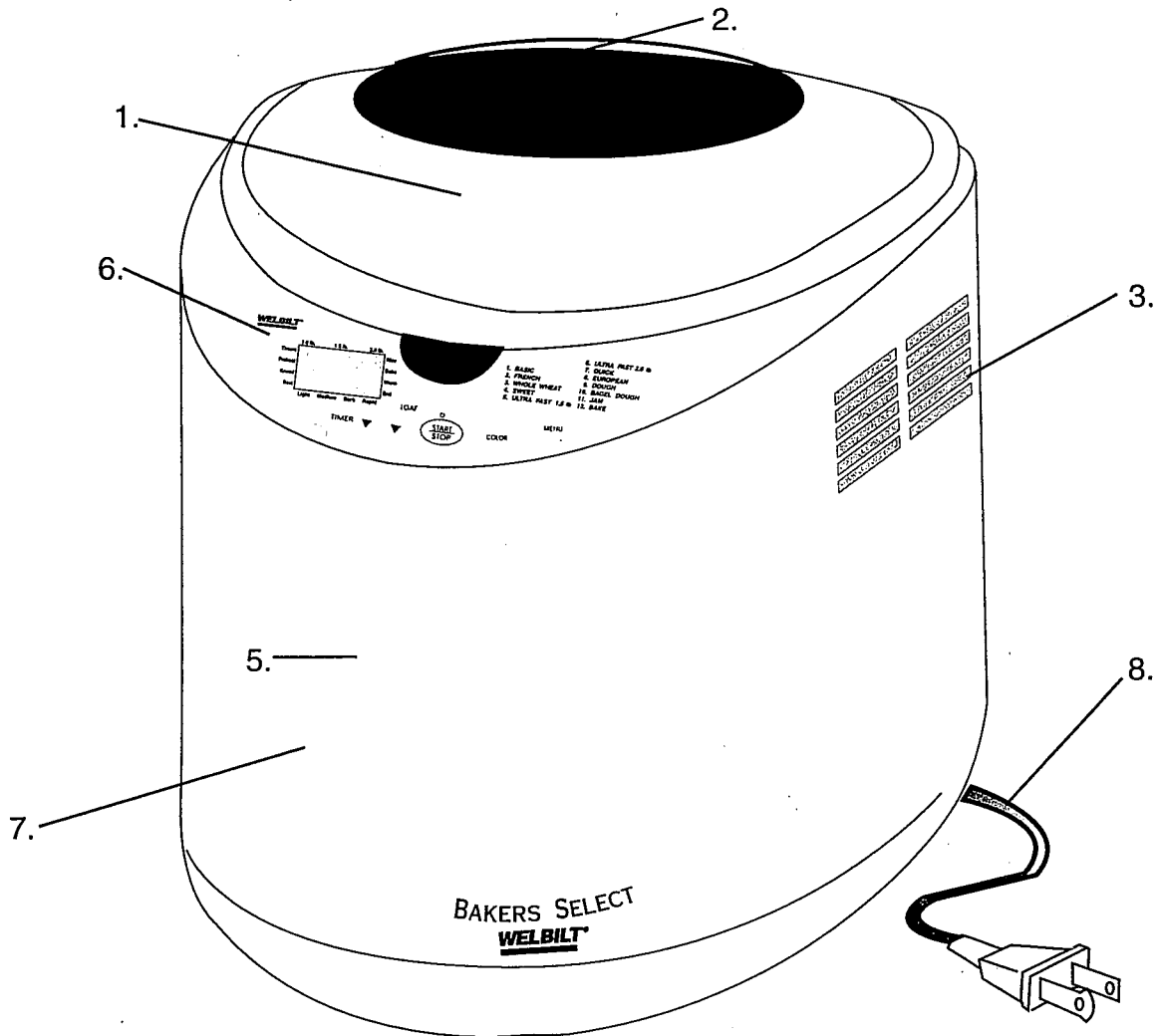


- 1. Lid
- 2. Lid Handle
- 3. Large Viewing Window
- 4. Air Vents (rear)
- 5. Bread pan
- 6. Baking Chamber (not shown)
- 7. Control Panel
- 8. Cool-Touch Body
- 9. Power Cord with Plug
- 10. Drive Shaft
- 11. Kneading Blade
- 12. Bread Pan Handle

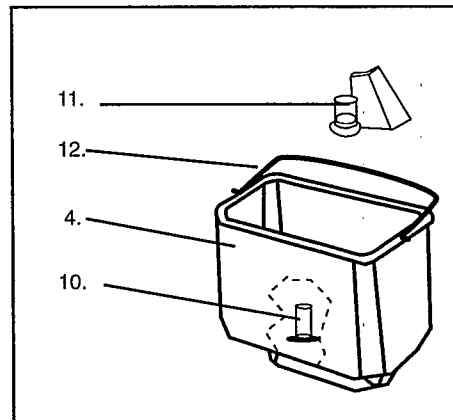


Know Your Bread Machine

ABMY2K1 MAKES 1, 1 1/2, AND 2 LB. HORIZONTAL LOAVES

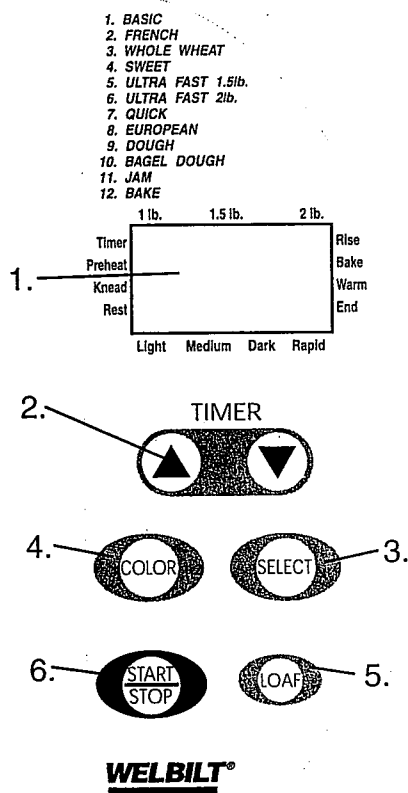


1. Reversible Lid
2. Viewing Window
3. Air Vents
4. Bread pan
5. Baking Chamber (not shown)
6. Control Panel
7. Cool-Touch Body
8. Power Cord with Plug
9. Drive Shaft
10. Kneading Blade
11. Bread Pan Handle

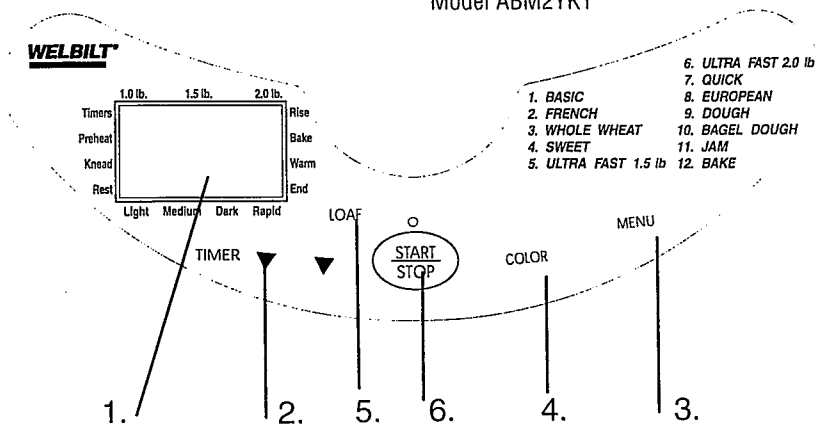


Control Panel

Model ABM2H52



Model ABM2YK1

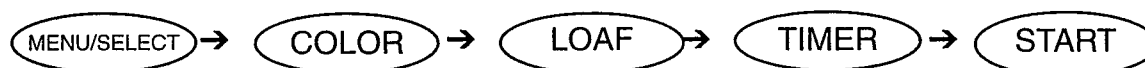


NOTE: When using the touchpad controls, be sure to press the pad until you hear a beep.

1 DISPLAY WINDOW	<ul style="list-style-type: none"> Shows the MENU/SELECT number selected. Shows the LOAF size selected. Shows the CRUST COLOR selected. Shows minute-by-minute baking time countdown. Shows DELAY BAKING TIME selected. Shows the stage of breadmaking (TIMER, PREHEAT, KNEAD, REST, RISE, BAKE, WARM, END).
2 TIMER	<ul style="list-style-type: none"> Use when setting the TIMER to delay baking. Press ▲ and ▼ arrows to set timer for delayed completion up to 13 hours later. Arrows will move time up or down in 10-minute increments. Press and hold button for faster movement. TIMER is not available on some cycles, please check the <i>Bread Machine Cycle Times</i>, page 16.
3 MENU/SELECT	<ul style="list-style-type: none"> Press to select the baking cycle of your choice. The selected cycle automatically assigns the time needed to complete the process.
4 COLOR	<ul style="list-style-type: none"> Press to select the crust color.
5 LOAF	<ul style="list-style-type: none"> Press to select the loaf size: REGULAR (1 lb.), LARGE (1 1/2 lb.), or EXTRA LARGE (2 lb.).
6 START/STOP	<ul style="list-style-type: none"> Press to start operation or begin TIMER countdown for delayed completion. Press and hold until you hear a beep to stop operation or to cancel a TIMER setting. <p>NOTE: Do not press "STOP" when checking the progress of bread.</p>

SETTING DESCRIPTIONS

Follow this flow chart to make bread as easy as 1,2,3.



1. Press MENU/SELECT key to select the desired baking cycle.
2. Press COLOR key to select the crust color preferred.
3. Press LOAF key to select the desired bread size.
4. Press TIMER key only if you want to make bread up to 13 hours in advance.
5. Press START key to begin baking.

BASIC BREADS

The settings are used for breads that primarily use white flour, although some recipes may include small amounts of whole wheat flour. The settings have the minimum number of rising cycles and the shortest overall times until baking is completed. Therefore, loaves will be slightly denser than French or Sweet breads. Select from Basic settings, according to loaf size and crust color.

FRENCH

Traditionally, French bread has a crispier crust and lighter texture than basic breads. Recipes usually do not include butter, margarine, or milk.

WHOLE WHEAT/ MULTI-GRAIN

The settings are used for recipes with significant amounts of whole wheat or rye flour, oats, or bran. It begins with a rest period during which the flours or grains absorb the liquid ingredients. Soaking causes the flour or grain to soften and helps ingredients to combine well. The settings have an extra rise cycle to allow heavy wheat and grains to expand. Generally, whole wheat and multi-grain breads are shorter and denser than basic, French, or sweet breads. Select from WHOLE WHEAT settings.

SWEET

Use this setting for recipes that use fruit juice, additional sugar, or added sweet ingredients such as coconut flakes, raisins, dried fruit, or chocolate. Baking temperature is reduced to prevent burning and the extra rise cycle gives the loaves a light, airy texture.

ULTRA FAST

This setting is designed to make bread in only 58 minutes. Only specially designed recipes are appropriate for this setting. These recipes call for very warm water and a large amount of bread machine or fast rising yeast. Heavy flours and other heavy ingredients are not suitable for this setting.

QUICK CAKE/ BREAD

This setting is used for recipes that contain baking powder or baking soda rather than yeast to make bread or cake rise. Cake recipes must be specially designed for this setting.

EUROPEAN

Use this setting to make dark European breads such as Swedish Limpa, Russian Black Bread, Pumpernickel, etc.

DOUGH

This setting only makes dough and will not bake the final bread. Remove the dough and shape it to make pizza, rolls, pretzels, doughnuts, and round or braided breads. Then bake in a conventional oven or fry in a deep fryer (i.e. doughnuts).

BAGEL DOUGH

This setting is a special dough setting for bagels only and will not bake the final bread. Remove the dough and follow the recipe for making bagels.

JAM

Use this setting for making jam from fresh fruits. Do not double recipes or allow ingredients to boil over the pan into the baking chamber. Should this happen, stop the machine immediately. Allow to cool and clean thoroughly.

BAKE

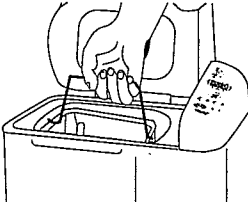
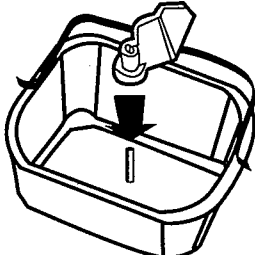

This setting is especially helpful when making gluten-free breads. After the first rise, stop the machine and cancel the cycle by pressing the STOP key until it beeps. Set the machine to the BAKE setting and press the START key.

Using Your Bread Machine

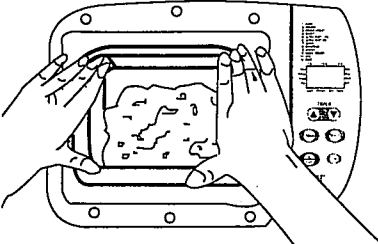
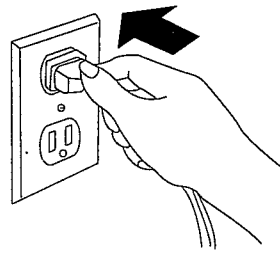
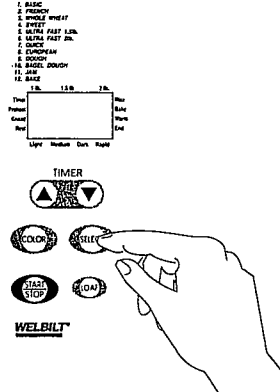
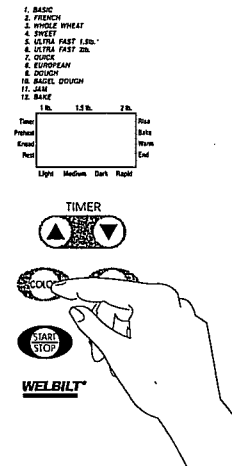
The bread settings in these units will combine ingredients, knead, and make bread from start to finish automatically. The DOUGH setting makes dough for a variety of recipes that can be shaped and baked in an oven. To delay completion, the automatic TIMER may be programmed to make bread or dough while you are at work or asleep. See *Using The Timer*, page 14.

The recipes included with this booklet have been thoroughly tested to ensure best results. Recipes have been created by home economists specifically for these bread machines and may not produce acceptable results in other similar bread machines.

FOR ALL SETTINGS, FOLLOW THESE INSTRUCTIONS:

<p>1</p>	<p>Open the lid and remove the baking pan by pulling straight up on the handle. It is important to remove the baking pan from the unit when putting ingredients into the pan. This will prevent accidentally spilling ingredients into the baking chamber.</p>  <p>Model ABM2H52</p>	<p>WARNING:</p> <ul style="list-style-type: none"> • Place your bread machine where it is level, stable, and secure. • Ingredients spilled in baking chamber can cause fire when ignited by the heating element.
<p>2</p>	<p>Attach the kneading blade onto the shaft inside the baking pan by lining up the flat side of the blade with the flat side on the shaft. Push the blade firmly onto the shaft.</p> 	<ul style="list-style-type: none"> • Be sure to set the kneading blade firmly in place to prevent blade from coming off during operation, which may affect the kneading or mixing. • Be sure the shaft is clean of any residue (i.e. dough). This will ensure the kneading blade will fully seat into place and will prevent blade from sticking to shaft.
<p>3</p>	<p>Select a recipe from the recipe section of this booklet. When following the recipes:</p> <p>Measure ingredients carefully and accurately. To measure liquids, use a see-through liquid measuring cup and check the measurement at eye level. When measuring dry ingredients, use a standard dry measuring cup and level the ingredients with a straightedge knife. Slightly inaccurate measurement can make a difference in results. Use standard measuring spoons and level off with a straightedge knife.</p> <p>See <i>Measuring Your Ingredients</i>, page 20.</p> <ul style="list-style-type: none"> • Always add ingredients into the baking pan in the order listed. • Always add yeast last. Be sure the yeast does not touch the liquid ingredients.  <p>Liquids Dry Ingredients (i.e. flour) Yeast</p>	<ul style="list-style-type: none"> • Be careful not to mix the yeast with any of the wet ingredients, especially when using the delayed timer feature. Otherwise, the bread may not rise properly. <p>Breadmaking Tip: After 5 minutes of kneading, open the lid of the bread machine and check the dough consistency. The dough should form a soft, tacky ball. If too dry, add liquid. If too wet, add flour (1/2 to 1 tablespoon at a time).</p>

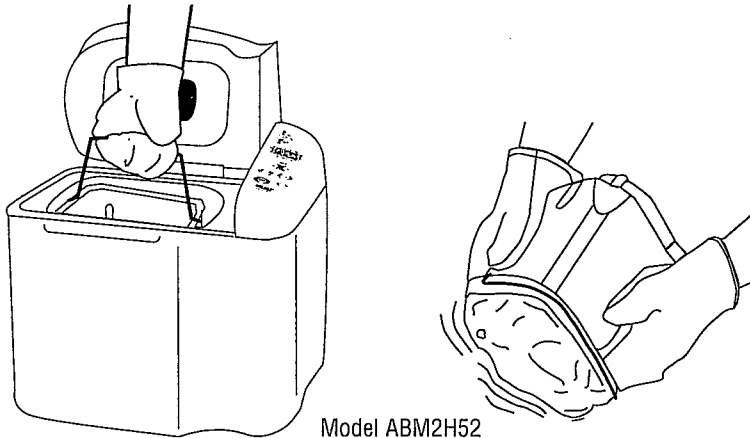
Using Your Bread Machine

<p>4</p>	<p>Place the baking pan back into the unit. Push down on the pan until you hear it click firmly into place. Fold the handle down.</p>  <p>Model ABM2H52</p>	<p>Special Note: If the baking pan is not installed properly or firmly clicked into place, the kneading blade will not operate.</p>
<p>5</p>	<p>Close the lid. Connect the plug to a 120-volt AC-only outlet. You will hear a beep and the display will show 00:00.</p> 	<p>Caution: This appliance has a polarized plug (one blade is wider than the other). As a safety feature, this plug will fit in a polarized outlet only one way. If the plug does not fit fully in the outlet, reverse the plug. If it still does not fit, contact a qualified electrician. Do not attempt to defeat this safety feature.</p>
<p>6</p>	<p>Choose the correct setting for your recipe by pressing the MENU/SELECT button. Each time MENU/SELECT is pressed, you will hear a beep and the number in the display window will advance to the next cycle.</p>  <p>Model ABM2H52</p>	<p>Special Note: The Whole Wheat and European settings begin with a rest period during which the flours or grains absorb the liquid ingredients. Soaking causes the flour or grain to soften and helps ingredients to combine well. There is no blade action during this period.</p>
<p>7</p>	<p>Press the COLOR button to choose crust color desired. There are three choices: Light, Medium, or Dark. When you press the button, you will hear a beep, and the display window will show the color selected. You can also choose Rapid cycle by pressing COLOR key.</p>  <p>Model ABM2H52</p>	

Using Your Bread Machine

8	<p>Press the LOAF button to choose the desired loaf size. When you press the button, you will hear a beep, and the display window will show the size of the loaf selected.</p>	
9	<p>Press the TIMER button to delay the completion of your bread for up to 13 hours. For details see the <i>Using The Timer</i>, page 14.</p>	<p>Special Note: For some cycles, there is no timer setting. See <i>Bread Machine Cycle Times</i>, page 16.</p>
10	<p>Press the START/STOP button to begin. The remaining time will count down in one-minute increments. When the baking time is completed, a beep will sound five times.</p>	<p>Model ABM2H52</p>
11	<p>The bread machine is designed with a Keep Warm feature that automatically begins when the bake time is completed. This will continue for up to 60 minutes after baking is complete. During this time, the bread machine will circulate hot air to keep the bread warm and there will be 5 beeps every 5 minutes. You may remove the baking pan at any time during the Keep Warm cycle. To turn off the Keep Warm feature before the 60 minutes are up, simply press the STOP button and hold it until you hear a beep. UNPLUG THE UNIT WHEN FINISHED. Never leave the unit plugged in when not in use.</p>	<p>Note: The Keep Warm feature does not function on some cycles. See <i>Bread Machine Cycle Times</i>, page 16.</p>

Using Your Bread Machine

12	<p>The bread machine has a convenient viewing window so that you may watch the progress of the bread as it is mixed, kneaded, and baked. Occasionally, some moisture may form in the window during baking. You may lift the lid to look inside during mixing and kneading stages. However, DO NOT OPEN THE LID DURING THE BAKING CYCLE, or ULTRA-FAST CYCLE (approximately the last hour) as this may cause the bread to collapse.</p>	<p>Warning: To avoid damaging the bread machine, do not put any object on top of the unit.</p>
13	<p>To remove the bread from the baking pan, use pot holders or oven mitts and pull straight up on the handle. Turn the pan upside down and shake the bread out onto a wire cooling rack. The baking pan has a non-stick finish so the bread should come out easily. Do not use metal utensils to remove bread as they may scratch the non-stick surface. If you have difficulty removing bread from the baking pan, slide a flat rubber or plastic spatula along the sides of the pan to loosen the loaf. Turn the pan over and shake the loaf out.</p> <p>Allow the bread to cool before slicing. See <i>Slicing and Storing Bread</i>, page 14. If the kneading blade remains in the bottom of the baking pan, fill the baking pan with hot water to loosen. If the kneading blade remains in the bottom of the bread, use the end of a plastic spoon or other non-metal utensil to remove. Do not use a knife or any other sharp metal object as it will scratch the non-stick coating on the kneading blade.</p>  <p>Model ABM2H52</p>	<p>Note: Always check to see where the kneading blade is when removing a baked loaf of bread. If it remains stuck in the bread, you may damage it by cutting into it while slicing.</p> <p>Important: Place warm water in pan immediately after removing bread to prevent blade from sticking to shaft.</p> <p>Warning: Do not make another loaf until the bread machine cools down.</p> <p>Note: If the temperature in the bread chamber is higher than 122° F., the DISPLAY WINDOW will show "E01". If the temperature is lower than 14° F., the DISPLAY WINDOW will show "E00".</p>

Using The Timer

Use the TIMER when you want to delay the completion of the bread for up to 13 hours. For example, you can set the TIMER at 7 p.m. so that you can wake up to fresh bread by 8 a.m. the following morning.

TO SET THE TIMER, FOLLOW THESE INSTRUCTIONS:

	NOTE: First, follow steps 1 thru 8 in <i>Using Your Bread Machine</i> , pages 10-13. Do not use the TIMER with recipes that call for perishable ingredients, such as eggs, fresh milk, sour cream, or cheese.
1	To set the TIMER, decide when you want the bread to be finished. For example, set the Timer at 7 p.m. if you want to wake up to fresh-baked Sweet bread at 8 a.m., a total of 13 hours before the bread is complete. Once the correct setting is selected for the recipe, simply set the TIMER for the total program hours, in this example, 13 hours.
2	You do not need to mathematically calculate the difference between the setting time and the total hours you want. The machine will automatically adjust to include the setting time. If you pass the desired time, simply press ▼ to go back.
3	Once you have set the time, press START. The colon (:) in the display will flash to indicate that the TIMER has been set, and the countdown will begin. The TIMER will count down in one-minute increments. When the display reaches 0:00, your bread is complete and the beeper will sound.

SLICING AND STORING BREAD

For best results, place bread on a wire rack and allow it to cool 15 to 30 minutes before slicing. Use an electric knife for even slices or use a sharp serrated knife. For square slices, place the loaf on its side and slice across.

Store unused bread tightly covered (reclosable plastic bags or plastic containers work well) at room temperature for up to three days. For longer storage (up to one month), place bread in a tightly covered container in the freezer. Since homemade bread has no preservatives, it tends to dry out and become stale faster than commercially-made bread.

Leftover slightly hardened bread may be cut into 1/2-inch or 1-inch cubes and used in recipes to make croutons, bread pudding, or stuffing.

CARE AND CLEANING

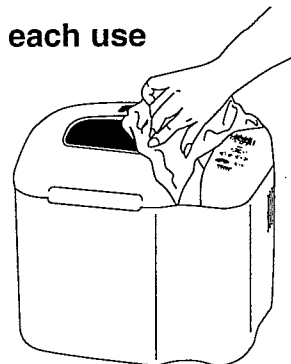
CAUTION:

To prevent electrical shock, unplug the unit before cleaning. Allow the bread machine to cool before cleaning. Do not immerse or splash either the body or lid in any liquid as this may cause damage and/or electric shock.

For best performance and maintenance, clean the bread machine after each use as follows:

Outer Body, Lid, and Baking Chamber:

Wipe the lid and outer body of the unit with a damp cloth or slightly damp sponge. Use a damp sponge or cloth to wipe out any flour, crumbs, or other materials from the baking chamber. Dry thoroughly.



Baking Pan and Kneading Blade:

Both the baking pan and kneading blade have non-stick surfaces. Do not use any harsh cleansers, abrasive materials, or utensils that may scratch the surfaces. Over time, the non-stick surface may change in appearance due to moisture and steam. This is normal and has no effect on its use or quality.



Remove the baking pan and kneading blade from the baking chamber before cleaning. Wipe the outside of the baking pan with a damp cloth. **NEVER IMMERSE THE BAKING PAN** in water or other liquid. Wash the inside of the baking pan with warm, soapy water. If the kneading blade gets stuck, fill the baking pan with hot water and soak for 30 minutes or until it loosens and can be removed easily. If the hole in the kneading blade becomes clogged, carefully clean it out with a wooden or plastic toothpick. **Use care to avoid toothpick scratching blade surface or getting stuck in blade.**

Never use any of the following to clean your bread machine:

- Paint Thinner
- Benzine
- Steel Wool Pads
- Polishing Powder
- Chemical Dustcloth

CAUTION: DO NOT place any part or parts of the bread machine in the dishwasher.

STORING THE UNIT

Be sure to dry all parts before storing including the viewing window. Close the lid, and do not store anything on top of the bread machine.

TROUBLESHOOTING

Specific questions about the bread machine functions and problems with ingredients or recipes are addressed in the *Questions and Answers* section on pages 40-42. For better performance, allow the unit to cool completely before beginning to bake a second loaf of bread. You can speed cooling by opening the lid, removing the baking pan, and allowing the baking chamber to cool.

Bread Machine Cycle Times

MENU	COLOR	LOAF	Total Time	Rest	Knead1	Rest	Knead2	Rise1	Punch	Rise2	Shape	Rise3	Baking	Keep Warm	Fruits & Nuts	Setting
Basic	Light	1 LB.	3:13		5m	5m	20m	39m	10s	25m50s	15s	49m45s	48m	1 Hr.	2:56	1
		1.5 LB.	3:18		5m	5m	20m	39m	10s	25m50s	15s	49m45s	53m	1 Hr.	2:59	2
		2 LB.	3:25		5m	5m	20m	39m	10s	25m50s	15s	49m45s	60m	1 Hr.	3:08	3
	Medium	1 LB.	3:13		5m	5m	20m	39m	10s	25m50s	15s	49m45s	48m	1 Hr.	2:56	4
		1.5 LB.	3:18		5m	5m	20m	39m	10s	25m50s	15s	49m45s	53m	1 Hr.	2:59	5
		2 LB.	3:25		5m	5m	20m	39m	10s	25m50s	15s	49m45s	60m	1 Hr.	3:08	6
	Dark	1 LB.	3:13		5m	5m	20m	39m	10s	25m50s	15s	49m45s	48m	1 Hr.	2:56	7
		1.5 LB.	3:18		5m	5m	20m	39m	10s	25m50s	15s	49m45s	53m	1 Hr.	2:59	8
		2 LB.	3:25		5m	5m	20m	39m	10s	25m50s	15s	49m45s	60m	1 Hr.	3:08	9
	Rapid	1 LB.	2:12		5m	5m	20m	15m	10s	8m50s	10s	29m50s	48m	1 Hr.	1:55	10
		1.5 LB.	2:17		5m	5m	20m	15m	10s	8m50s	10s	29m50s	53m	1 Hr.	1:59	11
		2 LB.	2:24		5m	5m	20m	15m	10s	8m50s	10s	29m50s	60m	1 Hr.	2:07	12
French	Light	1 LB.	3:30		5m	5m	20m	39m	10s	30m50s	10s	59m50s	50m	1 Hr.	N/A	13
		1.5 LB.	3:32		5m	5m	20m	39m	10s	30m50s	10s	59m50s	52m	1 Hr.	N/A	14
		2 LB.	3:35		5m	5m	20m	39m	10s	30m50s	10s	59m50s	55m	1 Hr.	N/A	15
	Medium	1 LB.	3:30		5m	5m	20m	39m	10s	30m50s	10s	59m50s	50m	1 Hr.	N/A	16
		1.5 LB.	3:32		5m	5m	20m	39m	10s	30m50s	10s	59m50s	52m	1 Hr.	N/A	17
		2 LB.	3:35		5m	5m	20m	39m	10s	30m50s	10s	59m50s	55m	1 Hr.	N/A	18
	Dark	1 LB.	3:30		5m	5m	20m	39m	10s	30m50s	10s	59m50s	50m	1 Hr.	N/A	19
		1.5 LB.	3:32		5m	5m	20m	39m	10s	30m50s	10s	59m50s	52m	1 Hr.	N/A	20
		2 LB.	3:35		5m	5m	20m	39m	10s	30m50s	10s	59m50s	55m	1 Hr.	N/A	21
	Rapid	1 LB.	2:30		5m	5m	20m	15m	10s	15m50s	10s	38m50s	50m	1 Hr.	N/A	22
		1.5 LB.	2:32		5m	5m	20m	15m	10s	15m50s	10s	38m50s	52m	1 Hr.	N/A	23
		2 LB.	2:35		5m	5m	20m	15m	10s	15m50s	10s	38m50s	55m	1 Hr.	N/A	24
Whole Wheat	Light	1 LB.	3:43	30m	5m	5m	15m	49m	10s	25m50s	10s	44m50s	48m	1 Hr.	3:21	25
		1.5 LB.	3:45	30m	5m	5m	15m	49m	10s	25m50s	10s	44m50s	50m	1 Hr.	3:23	26
		2 LB.	3:48	30m	5m	5m	15m	49m	10s	25m50s	10s	44m50s	53m	1 Hr.	3:26	27
	Medium	1 LB.	3:43	30m	5m	5m	15m	49m	10s	25m50s	10s	44m50s	48m	1 Hr.	3:21	28
		1.5 LB.	3:45	30m	5m	5m	15m	49m	10s	25m50s	10s	44m50s	50m	1 Hr.	3:23	29
		2 LB.	3:48	30m	5m	5m	15m	49m	10s	25m50s	10s	44m50s	53m	1 Hr.	3:26	30
	Dark	1 LB.	3:43	30m	5m	5m	15m	49m	10s	25m50s	10s	44m50s	48m	1 Hr.	3:21	31
		1.5 LB.	3:45	30m	5m	5m	15m	49m	10s	25m50s	10s	44m50s	50m	1 Hr.	3:23	32
		2 LB.	3:48	30m	5m	5m	15m	49m	10s	25m50s	10s	44m50s	53m	1 Hr.	3:26	33
	Rapid	1 LB.	2:28	30m	5m	5m	15m	24m	10s	10m50s	10s	34m50s	48m	1 Hr.	2:06	34
		1.5 LB.	2:30	30m	5m	5m	15m	24m	10s	10m50s	10s	34m50s	50m	1 Hr.	2:08	35
		2 LB.	2:33	30m	5m	5m	15m	24m	10s	10m50s	10s	34m50s	53m	1 Hr.	2:11	36
Sweet Bread		1 LB.	3:17		5m	5m	20m	39m	10s	25m50s	5s	51m55s	50m	1 Hr.	2:59	37
	Medium	1.5 LB.	3:22		5m	5m	20m	39m	10s	25m50s	5s	51m55s	55m	1 Hr.	3:05	38
		2 LB.	3:27		5m	5m	20m	39m	10s	25m50s	5s	51m55s	60m	1 Hr.	3:10	39
Ultra Fast 1.5 lbs			0:58		13m							10 min.	35m	1 Hr.	0:57	40
Ultra Fast 2 lbs			0:58		10m							8 min.	40m	1 Hr.	0:57	41
Quick			1:43		3m	5m	5m						90m	1 Hr.	N/A	42
European			3:55	30m	5m	10m	20m	39m	10s	25m50s	10s	44m50s	60m	1 Hr.	3:33	43
Dough			1:30		5m	5m	20m	60m							1:12	44
Bagel Dough			2:00		20m		10m					90 min.		N/A	1:50	45
Jam			1:05		15m								50m	N/A	N/A	46
Bake			1:00										60m	1 Hr.	N/A	47

m = Minute; s = Second; 3:13 = 3 hours and 13 minutes

NOTE 1: Setting 1, Setting 4, and Setting 7 have the same cycle time, but result in different crust colors.

NOTE 2: The *Fruit and Nut* column shows time on display when ingredients are to be added.

Know Your Ingredients

It is often said that cooking is an art relying on the creativity of the chef, while baking bread is much more of a science. This means that the process of combining flour, water and yeast results in a chemical reaction that produces bread. You have to remember that when the ingredients combine with each other they produce a specific result. Read the following information carefully to gain a better understanding of the importance each ingredient plays in the breadmaking process.

1. ALL-PURPOSE FLOUR

All-purpose flour is a blend of refined hard and soft wheat flours especially suitable for making breads and cakes. The most popular brands of flour have been tested for quick bread in The Bread Machine by Welbilt® with excellent results.

2. BREAD FLOUR

Bread flour is a high gluten/protein flour that has been treated with conditioners to give dough a greater tolerance during kneading. Bread flour typically has a higher gluten concentration than all-purpose flour. Using bread flour with the bread machine will produce loaves with better volume and structure.

3. WHOLE WHEAT FLOUR

Whole wheat flour is milled from the entire wheat kernel, which contains the bran and germ. Whole wheat flour is heavier and richer in nutrients than all-purpose flour. Breads made with this flour are usually smaller and heavier than white loaves. Many recipes mix whole wheat flour with bread flour or gluten to produce a high, light-textured bread.

4. RYE FLOUR

Rye flour is a high fiber flour similar to whole wheat flour, also called graham flour. Rye flour must always be mixed with a high proportion of bread flour, as it does not contain enough gluten to develop the structure for a high, even-grained loaf.

5. GLUTEN

Gluten is wheat flour that has been treated to remove nearly all the starch, which leaves a very high gluten content. (Gluten is the protein in the wheat that makes the dough elastic). Gluten is available at most health food stores. It is sometimes used in small portions with dense, low-gluten flours (such as whole wheat) to increase volume and lighten texture.

6. CAKE FLOUR

Cake flour is made from softer or lower protein wheats and is specially designed for use in cake recipes.

7. SELF-RISING FLOUR

Self-rising flour contains leavening ingredients that will interfere with bread and cake making. It is not recommended for use with your bread machine.

IMPORTANT NOTE ON FLOURS

Flours, while visibly similar, can be very different by virtue of how they were grown, milled, stored, etc. You may have to experiment with different brands of flour to help you make the perfect loaf. See the *Baking Tips Guide* on pages 42 and 43 to assist with these experiments.

Storage of flour is also very important. Keep flour in a secure, airtight container. Rye and whole wheat flours should be stored in a refrigerator, freezer, or a cool area to prevent them from becoming rancid.

Know Your Ingredients

8. BRAN

Bran (unprocessed) and wheat germ are the coarse outer portions of the wheat or rye grains separated from flour by sifting or bolting. They are often added in small quantities to bread for nutritional enrichment, heartiness and flavor. They are also used to enhance bread texture.

9. CORNMEAL and OATMEAL

Cornmeal and oatmeal come from coarsely ground white or yellow corn and from rolled or steel-cut oats. They are used primarily to enhance the flavor and texture.

10. CRACKED WHEAT

Cracked wheat has a very coarse texture. It comes from wheat kernels cut into angular fragments. It gives whole grain breads a nutty flavor and crunchy texture.

11. SEVEN GRAIN CEREAL BLEND

Seven grain cereal blend is a blend of cracked wheat, oats, bran, rye, corn meal, flax seeds and hulled millet.

12. YEAST

Yeast, through a fermentation process, produces gas (carbon dioxide) necessary to make the bread rise. Yeast feeds on sugar and flour carbohydrates to produce this gas. Traditional active dry granular yeast is used in all recipes that call for yeast. Three different types of yeast are available: fresh (cake), dry, and quick acting. Bread machine yeast is quick acting. For best results, use traditional dry yeast. However, quick rising yeast can also be used in smaller amounts. **Note: The recipes in this booklet were developed using traditional dry yeast.**

Always store yeast in a refrigerator to keep it fresh as heat will kill it. Ensure your yeast is fresh by checking its expiration date. Once a package or jar of yeast is opened, it is important that the remaining contents be immediately resealed and refrigerated for future use. Often, bread or dough that fails to rise is due to stale yeast. The following test can be used to determine if your yeast is stale and inactive:

1. Place 1/2 cup of lukewarm (110°F. - 115°F) water into a liquid measuring cup.
2. Stir 1 teaspoon of sugar into the water and then sprinkle 2 teaspoons of yeast over the surface.
3. Place cup in a warm area and allow to sit for 10 minutes undisturbed.
4. The mixture should foam and rise to the 1-cup mark. If this does not occur, discard this yeast and purchase fresh yeast.

Conversion Chart for Fast-Rising Yeast

1	teaspoon	active dry yeast	=	3/4	teaspoon	quick-rising yeast		
1	1/2	teaspoons	active dry yeast	=	1	teaspoon	quick-rising yeast	
2	1/4	teaspoons	active dry yeast	=	1	1/2	teaspoons	quick-rising yeast
1	tablespoon	active dry yeast	=	2	teaspoons	quick-rising yeast		

13. SUGAR

Sugar is important for the color and flavor of breads. It also serves as food for the yeast as it supports the fermentation process. Recipes in this book that call for sugar require granulated sugar. Do not substitute powdered sugar unless indicated. Artificial sweeteners cannot be used as a substitute for sugar as the yeast will not react properly with them.

Know Your Ingredients

14. SALT

Salt is necessary to balance the flavor of breads and cakes, as well as for the crust color that develops during baking. Salt also limits the growth of yeast. Do not increase amount of salt shown in the recipes. For dietary reasons, salt may be eliminated. However, the bread may overproof and rise higher than normal.

15. LIQUIDS

Liquids, such as milk (1%, 2%, whole, and skim), water, or a combination of powdered milk and water, can be used when making bread. Milk will improve flavor, provide a velvety texture and soften the crust, while water alone will produce a crispier crust. Some recipes call for juice (orange, apple, etc.) to be added as a flavor enhancer.

16. EGGS

Eggs add richness and a velvety texture to bread dough and cakes. Use large-size eggs with these recipes.

17. FATS: SHORTENING, BUTTER, AND OIL

Shortening, butter, and oil shorten or tenderize the texture of yeast breads. French bread gets its unique crust and texture from the lack of fat added. However, breads that call for fat stay fresh longer. If butter is used directly from the refrigerator, it should be cut into small pieces for easier blending during the kneading cycle.

18. BAKING POWDER

Baking powder is a leavening agent used in quick breads and cakes. This type of leavening agent does not require rising time before baking as the chemical reaction works when liquid ingredients are added.

19. BAKING SODA

Baking soda is another leavening agent not to be confused or substituted for baking powder. It also does not require rising time before baking as the chemical reaction works during baking process.

Measuring Your Ingredients

The most important step when using your bread machine is measuring your ingredients. It is very important to measure each liquid and dry ingredient accurately. Mis-measuring, even slightly, can cause poor baking results. The ingredients must also be added into the baking pan in the order given in each recipe.

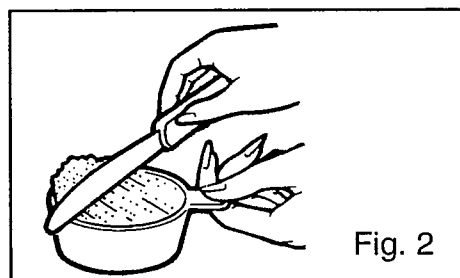
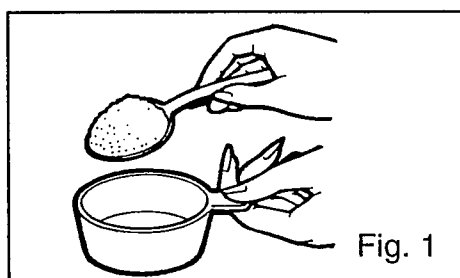
Liquid Measurements

Use transparent plastic or glass liquid measuring cups to measure all liquid ingredients. Place the cup on a horizontal flat surface and view markings at eye level. The liquid level line must be aligned to the mark of measurement. A "guesstimate" is not good enough as it could throw off the critical balance of the recipe.



Dry Measurements

Dry ingredients must be measured using standard size dry measuring cups. These cups are available in various sizes. Gently spoon dry ingredients into the measuring cup and level off with a knife (see Figs. 1 and 2 below). Do not scoop or tap a measuring cup as this will pack the ingredients. This extra amount could affect the balance of the recipe. Do not sift the flour.



When measuring small amounts of dry or liquid ingredients (i.e. yeast, sugar, salt, dry milk, honey, or molasses) a standard measuring spoon must be used. Measurements must be level, not heaping.

The bread machine produces delicious baked goods with ease. This marvelous machine asks only that you carefully follow the recipe instructions. In most cooking, "a pinch of this and a dash of that" is fine, but not for automatic bread machines. Using a bread machine correctly requires you accurately measure each ingredient.

Recipe Tips

Creating Your Own Yeast Breads

With the Welbilt® Bread Machine, even the most inexperienced baker can achieve the satisfying experience of baking a loaf of bread. All of the mystery and hard work is gone. Inside this talented machine with a computer brain, the dough is mixed, kneaded, proofed, and baked without you being present. The bread machine can also prepare dough for you to shape and bake in a conventional oven. The recipes included with this book are "tailored" for this Welbilt® Bread Machine. Each recipe features ingredients that best compliment a particular loaf of bread, and each was tested in our machines. It is extremely important not to exceed the amounts of flour specified in each of the recipes or this could result in unsatisfactory baking performance. When creating your own yeast bread recipes or baking an old favorite, use the recipes in this cookbook as a guide for converting portions from your recipe to your bread machine.

Special Glazes for Yeast Breads

Give your just-baked bread a professional finish. Select one of the following special glazes to enhance your bread:

Egg Glaze

Beat 1 large egg and 1 tablespoon of water together, brush generously over dough.

Note: Apply only to breads made using the dough setting just before baking.

Melted Butter Crust

Brush melted butter over just-baked bread for a softer, tender crust.

Milk Glaze

For a softer, shiny crust, brush just-baked bread with milk or cream.

Sweet Icing Glaze

Mix 1 cup sifted icing sugar with 1 to 2 tablespoons of milk to make a smooth glaze. Drizzle over Raisin Bread or Sweet Breads when almost cool.

Poppy/Sesame/Caraway Seed

Generously sprinkle your choice of these seeds over just-glazed bread.

Recipes

BASIC WHITE BREAD

	1 lb. loaf	1 1/2 lb. loaf	2 lb. loaf
Water	1/4 cup	1/4 cup	1/3 cup
Milk	1/2 cup	3/4 cup	1 cup
Oil	1 tablespoons	4 teaspoons	2 tablespoons
Salt	1 teaspoon	1 1/2 teaspoons	2 teaspoons
Sugar	1 tablespoon	2 tablespoons	3 tablespoons
Bread flour	2 1/4 cups	3 cups	4 cups
RED STAR® Active Dry Yeast	1 1/2 teaspoons	2 1/4 teaspoons	1 tablespoon
or			
RED STAR® QUICK RISE™ Yeast			
or	1 teaspoon	1 1/2 teaspoons	2 teaspoons
Bread Machine Yeast	1 teaspoon	1 1/2 teaspoons	2 teaspoons

Use **Basic** cycle

ULTRA-FAST WHITE BREAD

	1 1/2 lb. loaf	2 lb. loaf
Water	1/3 cup	1/3 cup
		+ 2 tablespoons
Milk	3/4 cup	1 cup
Oil	4 teaspoons	2 tablespoons
Salt	1 teaspoon	1 1/2 teaspoons
Sugar	2 tablespoons	3 tablespoons
Bread flour	3 cups	4 cups
RED STAR® QUICK RISE™ Yeast	4 1/2 teaspoons	2 tablespoons
or		
Bread Machine Yeast	4 1/2 teaspoons	2 tablespoons

Use **Ultra-fast** cycle

YOGURT BREAD

	1 lb. loaf	1 1/2 lb. loaf	2 lb. loaf
Water	1/2 cup + 1 tablespoon	3/4 cup	1 cup
Yogurt	3 tablespoons	1/4 cup	1/3 cup
Salt	3/4 teaspoon	1 teaspoon	1 1/2 teaspoons
Sugar	1 tablespoon	2 tablespoons	3 tablespoons
Sesame seeds	2 tablespoons	3 tablespoons	1/4 cup
Bread flour	2 1/4 cups	3 cups	4 cups
RED STAR® Active Dry Yeast	1 1/2 teaspoons	2 1/4 teaspoons	1 tablespoon
or			
RED STAR® QUICK RISE™ Yeast			
or	1 teaspoon	1 1/2 teaspoons	2 teaspoons
Bread Machine Yeast	1 teaspoon	1 1/2 teaspoons	2 teaspoons

Use **Basic** cycle

Recipes

ULTRA FAST YOGURT BREAD

Water	1 1/2 lb. loaf 3/4 cup + 2 tablespoons	2 lb. loaf 1 1/4 cups
Yogurt	1/4 cup	1/3 cup
Salt	1 teaspoon	1 1/2 teaspoons
Sugar	2 tablespoons	3 tablespoons
Sesame seeds	3 tablespoons	1/4 cup
Bread flour	3 cups	4 cups
RED STAR® QUICK RISE™ Yeast	4 1/2 teaspoons	2 tablespoons
or		
Bread Machine Yeast	4 1/2 teaspoons	2 tablespoons

Use **Ultra-fast** cycle

CARROT BREAD

	1 lb. loaf	1.5 lb. loaf	2 lb. loaf
Water	3/4 cup	1 cup	1 1/4 cup
Carrot, shredded	3 tablespoons	1/4 cup	1/3 cup
Oil	1 tablespoon	4 teaspoons	2 tablespoons
Salt	1 teaspoon	1 1/2 teaspoons	2 teaspoons
Sugar	2 tablespoons	3 tablespoons	1/4 cup
Dry milk	1 tablespoon	2 tablespoons	3 tablespoons
Bread flour	2 1/4 cups	3 cups	4 cups
RED STAR® Active Dry Yeast	1 1/2 teaspoons	2 1/4 teaspoons	1 tablespoon
or			
RED STAR® QUICK RISE™ Yeast			
or	1 teaspoon	1 1/2 teaspoons	2 teaspoons
Bread Machine Yeast	1 teaspoon	1 1/2 teaspoons	2 teaspoons

Use **Basic** cycle

ULTRA-FAST CARROT BREAD

	1.5 lb. loaf	2 lb. loaf
Water	1 cup + 2 tablespoons	1 1/2 cups + 1 tablespoon
Carrot, shredded	1/4 cup	1/3 cup
Oil	4 teaspoons	2 tablespoons
Salt	1 teaspoons	1 1/2 teaspoons
Sugar	3 tablespoons	1/4 cup
Dry milk	2 tablespoons	3 tablespoons
Bread flour	3 cups	4 cups
RED STAR® QUICK RISE™ Yeast	4 1/2 teaspoons	2 tablespoons
or		
Bread Machine Yeast	4 1/2 teaspoons	2 tablespoons

Use **Ultra-fast** cycle

Recipes

LEMON PEPPER BREAD

	1 lb. loaf	1.5 lb. loaf	2 lb. loaf
Water	3/4 cup	1 cup	1 1/4 cup
Oil	1 tablespoon	2 tablespoons	3 tablespoons
Salt	1 teaspoon	1 1/2 teaspoons	2 teaspoons
Sugar	1 tablespoons	2 tablespoons	3 tablespoons
Dry milk	1 tablespoon	2 tablespoons	3 tablespoons
Black pepper	1 teaspoon	1 1/2 teaspoon	2 teaspoons
Lemon zest (grated lemon rind)	2 tablespoons	3 tablespoons	1/4 cup
Bread flour	2 1/4 cups	3 cups	4 cups
RED STAR® Active Dry Yeast	1 1/2 teaspoons	2 1/4 teaspoons	1 tablespoon
or			
RED STAR® QUICK RISE™ Yeast			
or			
Bread Machine Yeast	1 teaspoon	1 1/2 teaspoons	2 teaspoons
	1 teaspoon	1 1/2 teaspoons	2 teaspoons

Use Basic cycle

ULTRA-FAST LEMON PEPPER BREAD

	1.5 lb. loaf	2 lb. loaf
Water	1 cup	1 1/2 cups
	+ 2 tablespoons	+ 2 tablespoon
Oil	2 tablespoons	3 tablespoons
Salt	1 teaspoon	1 1/2 teaspoons
Sugar	2 tablespoons	3 tablespoons
Dry milk	2 tablespoons	3 tablespoons
Black pepper	1 1/2 teaspoon	2 teaspoons
Lemon zest (grated lemon rind)	3 tablespoons	1/4 cup
Bread flour	3 cups	4 cups
RED STAR® QUICK RISE™ Yeast	4 1/2 teaspoons	2 tablespoons
or		
Bread Machine Yeast	4 1/2 teaspoons	2 tablespoons

Use Ultra-fast cycle

EGG BREAD

Do not use on the delay timer.

	1 lb. loaf	1.5 lb. loaf	2 lb. loaf
Water	3 tablespoons	3 tablespoons	1/4 cup
Milk	1/3 cup	1/3 cup	1/2 cup
Eggs, large*	1	2	2
Butter	1 tablespoon	2 tablespoons	3 tablespoons
Salt	1 teaspoon	1 1/2 teaspoons	2 teaspoons
Sugar	1 tablespoon	2 tablespoons	3 tablespoons
Bread flour	2 1/4 cups	3 cups	4 cups
RED STAR® Active Dry Yeast	1 1/2 teaspoons	2 1/4 teaspoons	1 tablespoon
or			
RED STAR® QUICK RISE™ Yeast			
or			
Bread Machine Yeast	1 teaspoon	1 1/2 teaspoons	2 teaspoons
	1 teaspoon	1 1/2 teaspoons	2 teaspoons

* Large eggs should measure 1/4 cup each. If smaller, add water to equal 1/4 cup liquid for each egg.

Use Basic cycle

Recipes

ULTRA-FAST EGG BREAD

Do not use on the delay timer.

	1.5 lb. loaf	2 lb. loaf
Water	1/4 cup	1/3 cup + 2 tablespoons
Milk	1/2 cup	2/3 cup
Eggs, large*	2	2
Butter	2 tablespoons	3 tablespoons
Salt	1 teaspoon	1 1/2 teaspoons
Sugar	2 tablespoons	3 tablespoons
Bread flour	3 cups	4 cups
RED STAR® QUICK RISE™ Yeast or	4 1/2 teaspoons	2 tablespoons
Bread Machine Yeast	4 1/2 teaspoons	2 tablespoons

* Large eggs should measure 1/4 cup each. If smaller, add water to equal 1/4 cup liquid for each egg.

Use Ultra-fast cycle

RYE BREAD

	1 lb. loaf	1.5 lb. loaf	2 lb. loaf
Water	2/3 cup	1 cup	1 1/4 cup
Oil	1 tablespoon	4 teaspoons	2 tablespoons
Salt	1/2 teaspoon	1 teaspoon	1 1/2 teaspoons
Sugar	1 tablespoon	2 tablespoons	3 tablespoons
Dry milk	1 tablespoon	2 tablespoons	3 tablespoons
Allspice	1/2 teaspoon	1 teaspoon	1 1/2 teaspoons
Caraway seeds	1 teaspoon	1 1/2 teaspoons	2 teaspoons
Rye flour	2/3 cup	1 cup	1 1/3 cups
Bread flour	1 1/2 cups	2 1/4 cups	3 cups
RED STAR® Active Dry Yeast or	1 1/2 teaspoons	2 1/4 teaspoons	1 tablespoon
RED STAR® QUICK RISE™ Yeast or	1 teaspoon	1 1/2 teaspoons	2 teaspoons
Bread Machine Yeast	1 teaspoon	1 1/2 teaspoons	2 teaspoons

Use Basic cycle

ULTRA-FAST RYE BREAD

	1.5 lb. loaf	2 lb. loaf
Water	1 cup + 2 tablespoons	1 1/2 cups
Oil	4 teaspoons	2 tablespoons
Salt	1/2 teaspoon	1 teaspoon
Sugar	2 tablespoons	3 tablespoons
Dry milk	2 tablespoons	3 tablespoons
Allspice	1 teaspoon	1 1/2 teaspoons
Caraway seeds	1 1/2 teaspoons	2 teaspoons
Rye flour	1 cup	1 1/3 cups
Bread flour	2 1/4 cups	3 cups
RED STAR® QUICK RISE™ Yeast or	4 1/2 teaspoons	2 tablespoons
Bread Machine Yeast	4 1/2 teaspoons	2 tablespoons

Use Ultra-fast cycle

Recipes

FRENCH BREAD

	1 lb. loaf	1.5 lb. loaf	2 lb. loaf
Water	1 cup	1 1/4 cups	1 2/3 cups
Oil	1/2 teaspoon	1 teaspoon	1 teaspoon
Salt	1/2 teaspoon	1 teaspoon	1 teaspoon
Sugar	1/2 teaspoon	1 teaspoon	1 teaspoon
Bread flour	2 1/3 cups	3 cups	4 cups
RED STAR® Active Dry Yeast	1 1/2 teaspoons	2 1/4 teaspoons	1 tablespoon
or			
RED STAR® QUICK RISE™ Yeast			
or	1 teaspoon	1 1/2 teaspoons	2 teaspoons
Bread Machine Yeast	1 teaspoon	1 1/2 teaspoons	2 teaspoons

Use French cycle

ULTRA-FAST FRENCH BREAD

	1.5 lb. loaf	2 lb. loaf
Water	1 1/3 cups	1 3/4 cups
Oil	1 teaspoon	1 teaspoon
Salt	1/2 teaspoon	1/2 teaspoon
Sugar	1 teaspoon	1 teaspoon
Bread flour	3 cups	4 cups
RED STAR® QUICK RISE™ Yeast	4 1/2 teaspoons	2 tablespoons
or		
Bread Machine Yeast	4 1/2 teaspoons	2 tablespoons

Use Ultra-Fast cycle

LIGHT WHOLE WHEAT

	1 lb. loaf	1.5 lb. loaf	2 lb. loaf
Water	3/4 cup	1 cup	1 1/3 cups
Oil	1 tablespoon	2 tablespoons	3 tablespoons
Salt	1 teaspoon	1 1/2 teaspoons	2 teaspoons
Sugar	2 tablespoons	3 tablespoons	1/4 cup
Dry milk	1 tablespoon	2 tablespoons	3 tablespoons
Whole wheat flour	1 cup	1 1/2 cups	2 cups
	+ 2 tablespoons		
Bread flour	1 cup	1 1/2 cups	2 cups
	+ 2 tablespoons		
RED STAR® Active Dry Yeast	1 1/2 teaspoons	2 1/4 teaspoons	1 tablespoon
or			
RED STAR® QUICK RISE™ Yeast			
or	1 teaspoon	1 1/2 teaspoons	2 teaspoons
Bread Machine Yeast	1 teaspoon	1 1/2 teaspoons	2 teaspoons

Use Whole Wheat cycle

Recipes

WHEAT BRAN BREAD

	1 lb. loaf	1.5 lb. loaf	2 lb. loaf
Milk	3/4 cup + 1 tablespoon	1 1/4 cups	1 1/2 cups + 2 tablespoons
Oil	1 tablespoon	2 tablespoons	3 tablespoons
Salt	1/2 teaspoon	1 teaspoon	1 1/2 teaspoons
Brown Sugar	2 tablespoons	3 tablespoons	1/4 cup
Wheat bran cereal	1/3 cup	1/2 cup	2/3 cup
Whole wheat flour	1 cup + 2 tablespoons	1 1/2 cups	2 cups
Bread flour	1 cup + 2 tablespoons	1 1/2 cups	2 cups
Gluten	2 teaspoons	1 tablespoon	4 teaspoons
RED STAR® Active Dry Yeast	1 1/2 teaspoons	2 1/4 teaspoons	1 tablespoon
or			
RED STAR® QUICK RISE™ Yeast	1 teaspoon	1 1/2 teaspoons	2 teaspoons
or			
Bread Machine Yeast	1 teaspoon	1 1/2 teaspoons	2 teaspoons

Use Whole Wheat cycle

WHOLE WHEAT APPLESAUCE RAISIN

	1 lb. loaf	1.5 lb. loaf	2 lb. loaf
Water	2/3 cup	3/4 cup	1 cup
Applesauce	1/3 cup	1/2 cup	2/3 cup
Oil	1 tablespoon	2 tablespoons	3 tablespoons
Salt	1/2 teaspoon	1 teaspoon	1 1/2 teaspoons
Brown Sugar	2 tablespoons	3 tablespoons	1/4 cup
Dry milk	1 tablespoon	2 tablespoons	3 tablespoons
Cinnamon	1/2 teaspoon	1 teaspoon	1 1/2 teaspoons
Whole wheat flour	1 cup + 2 tablespoons	1 1/2 cups	2 cups
Bread flour	1 cup + 2 tablespoons	1 1/2 cups	2 cups
RED STAR® Active Dry Yeast	1 1/2 teaspoons	2 1/4 teaspoons	1 tablespoon
or			
RED STAR® QUICK RISE™ Yeast	1 teaspoon	1 1/2 teaspoons	2 teaspoons
or			
Bread Machine Yeast	1 teaspoon	1 1/2 teaspoons	2 teaspoons
Raisins	1/3 cup	1/2 cup	2/3 cup

Use Whole Wheat cycle

SWEET BREAD

Do not use on the delay timer.

	1 lb. loaf	1.5 lb. loaf	2 lb. loaf
Water	2/3 cup	3/4 cup + 2 tablespoons	1 cup + 2 tablespoons
Egg yolk	1	1	2
Butter	1 tablespoon	2 tablespoons	3 tablespoons
Salt	1 teaspoon	1 1/2 teaspoons	2 teaspoons
Sugar	1/4 cup	1/3 cup	1/2 cup
Dry Milk	1 tablespoon	2 tablespoons	3 tablespoons
Bread flour	2 1/4 cups	3 cups	4 cups
RED STAR® Active Dry Yeast	1 1/2 teaspoons	2 1/4 teaspoons	1 tablespoon
or			
RED STAR® QUICK RISE™ Yeast	1 teaspoon	1 1/2 teaspoons	2 teaspoons
or			
Bread Machine Yeast	1 teaspoon	1 1/2 teaspoons	2 teaspoons

Use Sweet cycle

Recipes

SPICED PUMPKIN BREAD

Do not use on the delay timer.

	1 lb. loaf	1.5 lb. loaf	2 lb. loaf
Water	1/4 cup	1/4 cup	1/4 cup
Pumpkin pie mix	2/3 cup	1 cup	1 1/3 cups
Vegetable oil	2 tablespoons	3 tablespoons	1/4 cup
Egg(s)	1	1	2
Bread flour	2 1/4 cups	3 cups	4 cups
RED STAR® Active Dry Yeast	1 1/2 teaspoons	2 1/4 teaspoons	1 tablespoon
or			
RED STAR® QUICK RISE™ Yeast	1 teaspoon	1 1/2 teaspoons	2 teaspoons
or			
Bread Machine Yeast	1 teaspoon	1 1/2 teaspoons	2 teaspoons
Pecan halves	1/3 cup	1/2 cup	3/4 cup

Use **Sweet** cycle

ULTRA-FAST SPICED PUMPKIN BREAD

Do not use on the delay timer.

	1.5 lb. loaf	2 lb. loaf
Water	5 tablespoons	1/3 cup
Pumpkin pie mix	1 cup	1 1/3 cups
Vegetable oil	3 tablespoons	1/4 cup
Egg(s)	1	2
Bread flour	3 cups	4 cups
RED STAR® QUICK RISE™ Yeast	4 1/2 teaspoons	2 tablespoons
or		
Bread Machine Yeast	4 1/2 teaspoons	2 tablespoons
Pecan halves	1/2 cup	3/4 cup

Use **Ultra-Fast** cycle

RAISIN BREAD

	1 lb. loaf	1.5 lb. loaf	2 lb. loaf
Water	3/4 cup	1 cup	1 1/4 cups
Oil	1 tablespoon	4 teaspoons	2 tablespoons
Salt	1 teaspoon	1 1/2 teaspoons	2 teaspoons
Sugar	1 tablespoon	2 tablespoons	3 tablespoons
Dry milk	1 tablespoon	2 tablespoons	3 tablespoons
Cinnamon	1/2 teaspoon	1 teaspoon	1 1/2 teaspoons
Bread flour	2 1/4 cups	3 cups	4 cups
RED STAR® Active Dry Yeast	1 1/2 teaspoons	2 1/4 teaspoons	1 tablespoon
or			
RED STAR® QUICK RISE™ Yeast	1 teaspoon	1 1/2 teaspoons	2 teaspoons
or			
Bread Machine Yeast	1 teaspoon	1 1/2 teaspoons	2 teaspoons
Raisins	1/3 cup	1/2 cup	2/3 cup

Use **Sweet** cycle

ULTRA-FAST RAISIN BREAD

	1.5 lb. loaf	2 lb. loaf
Water	1 cup	1 1/2 cups
	+2 tablespoons	
Oil	4 teaspoons	2 tablespoons
Salt	1 teaspoon	1 1/2 teaspoons
Sugar	2 tablespoons	3 tablespoons
Dry milk	2 tablespoons	3 tablespoons
Cinnamon	1 teaspoon	1 1/2 teaspoons
Bread flour	3 cups	4 cups
RED STAR® QUICK RISE™ Yeast		
or	4 1/2 teaspoons	2 tablespoons
Bread Machine Yeast	4 1/2 teaspoons	2 tablespoons
Raisins	1/2 cup	2/3 cup

Use **Ultra-Fast** cycle

Recipes

ORANGE MARMALADE BREAD

	1 lb. loaf	1.5 lb. loaf	2 lb. loaf
Water	3/4 cup	1 cup	1 cup
Marmalade	1/3 cup	1/2 cup	2/3 cup
Oil	1 tablespoon	2 tablespoons	3 tablespoons
Salt	1 teaspoon	1 1/2 teaspoons	2 teaspoons
Dry Milk	1 tablespoon	2 tablespoons	3 tablespoons
Bread flour	2 1/4 cups	3 cups	4 cups
RED STAR® Active Dry Yeast	1 1/2 teaspoons	2 1/4 teaspoons	1 tablespoon
or			
RED STAR® QUICK RISE® Yeast			
or	1 teaspoon	1 1/2 teaspoons	2 teaspoons
Bread Machine Yeast	1 teaspoon	1 1/2 teaspoons	2 teaspoons

Use **Sweet** cycle

IRISH SODA BREAD

During the mixing time, use a rubber spatula to assure the dry ingredients are completely moistened.

Water	2 cups
Buttermilk powder	1/2 cup
Salt	1 1/2 teaspoons
Baking soda	1 teaspoon
Sugar	1/2 cup
All-purpose flour	4 cups

When cycle is complete, remove the pan from the machine but allow the bread to remain in the pan for 10 minutes. Then remove the bread to cool on a rack.

Use **Quick** cycle

CITRUS BREAD

Do not use on the delay timer.

During the mixing time, use a rubber spatula to assure the dry ingredients are completely moistened.

Ingredients	Cycle 7
Orange juice	1 1/2 cups
Lemon juice	3 tablespoons
Eggs	4 large
Vegetable oil	2/3 cup
All-purpose flour	4 cups
Baking powder	2 tablespoons
Baking soda	2 teaspoons
Sugar	1 1/2 cups
Salt	1 teaspoon
Orange zest (grated orange peel)	1 tablespoon
Lemon zest (grated lemon peel)	1 tablespoon

When cycle is complete, remove the pan from the machine but allow the bread to remain in the pan for 10 minutes. Then remove the bread to cool on a rack.

Use **Quick** cycle

Recipes

BANANA BREAD WITH BISCUIT MIX

Do not use on the delay timer.

During the mixing time, use a rubber spatula to assure the dry ingredients are completely moistened.

Ripe bananas, mashed	2 cups
Vegetable oil	1/2 cup
Eggs	4
Sugar	1 1/2 cups
Biscuit mix	4 cups
Chopped nuts	2/3 cup

When cycle is complete, remove the pan from the machine but allow the bread to remain in the pan for 10 minutes. Then remove the bread to cool on a rack.

Use **Quick** cycle

GINGER BREAD

Do not use on the delay timer.

During the mixing time, use a rubber spatula to assure the dry ingredients are completely moistened.

Vegetable oil	1 cup
Dark molasses	1 cup
Eggs	4
Dark brown sugar, firmly packed	1 1/2 cups
Salt	1 teaspoon
Baking soda	1 teaspoon
Baking powder	1 1/2 teaspoons
Ginger	2 1/2 teaspoons
Cinnamon	2 teaspoons
Whole wheat flour	4 cups
Boiling water	1 cup

When cycle is complete, remove the pan from the machine but allow the bread to remain in the pan for 10 minutes. Then remove the bread to cool on a rack.

Use **Quick** cycle

DARK PUMPERNICKEL RYE BREAD

	1 lb. loaf	1.5 lb. loaf	2 lb. loaf
Brewed coffee	2/3 cup	3/4 cup + 2 tablespoons	1 cups + 3 tablespoons
Vegetable Oil	1 tablespoon	2 tablespoons	3 tablespoons
Dark molasses	1 tablespoon	2 tablespoons	3 tablespoons
Salt	1/2 teaspoon	1 teaspoon	1 1/2 teaspoons
Sugar	1 teaspoon	1 1/2 teaspoons	2 teaspoons
Cocoa	1 tablespoon	5 teaspoons	2 tablespoons
Onion powder	1/2 teaspoon	3/4 teaspoon	1 teaspoon
Rye flour	2/3 cup	1 cup	1 1/3 cups
Bread flour	1 1/2 cups + 1 tablespoon	2 cups	2 2/3 cups
RED STAR® Active Dry Yeast or RED STAR® QUICK RISE™ Yeast or Bread Machine Yeast	1 1/2 teaspoons 1 teaspoon 1 teaspoon	2 1/4 teaspoons 1 1/2 teaspoons 1 1/2 teaspoons	1 tablespoon 2 teaspoons 2 teaspoons

Use **European** cycle

Recipes

RUSSIAN BLACK BREAD

	1 lb. loaf	1.5 lb. loaf	2 lb. loaf
Water	3 tablespoons	1/4 cup	1/3 cup
Milk	1/2 cup	3/4 cup	1 cup
Dark molasses	1 tablespoon	2 tablespoons	3 tablespoons
Unsweetened chocolate	1/3 ounce	1/2 ounce	3/4 ounce
Salt	1/2 teaspoon	1 teaspoon	1 1/2 teaspoons
Caraway seeds	1 teaspoon	2 teaspoons	1 tablespoon
Onion powder	1/2 teaspoon	1 teaspoon	1 1/2 teaspoons
Whole bran cereal	3 tablespoons	1/4 cup	1/3 cup
Rye flour	1/2 cup	3/4 cup	1 cup
Bread flour	1 1/2 cups	2 1/4 cups	3 cups
RED STAR® Active Dry Yeast	1 1/2 teaspoons	2 1/4 teaspoons	1 tablespoon
or			
RED STAR® QUICK RISE™ Yeast			
or	1 teaspoon	1 1/2 teaspoons	2 teaspoons
Bread Machine Yeast	1 teaspoon	1 1/2 teaspoons	2 teaspoons

Use **European** cycle

PIZZA

Water	1 cup
Oil	2 tablespoons
Salt	1 1/2 teaspoons
All-purpose flour	2 1/2 cups
RED STAR® Active Dry Yeast	2 1/4 teaspoons

Remove dough from machine. Punch down; divide dough in half. Press each half into a greased 12-inch round pizza pan sprinkled with cornmeal. Prebake for 10 to 12 minutes at 400°F until edges of crust begin to turn a light golden brown. Add desired toppings and bake at 400°F for 15 minutes.

Topping suggestions: 1 1/2 cups pizza sauce, 4 cups cheese, pepperoni, sliced onion, mushrooms, olives, sausage, green pepper.

Use **Dough** cycle

CROISSANTS

Water	1/2 cup
Evaporated milk	1/3 cup
Butter, room temperature	3 tablespoons
Egg, room temperature	1
Salt	1 1/2 teaspoons
Sugar	3 tablespoons
Bread flour	3 cups
RED STAR® Active Dry Yeast	2 1/4 teaspoons

At end of the kneading cycle, press STOP. Remove dough and place in a lightly oiled bowl. Turn to grease top. Cover and refrigerate for 2 hours. Place dough on floured surface and knead about 6 times to release air bubbles. Divide into 4 parts. Roll each part into a 14-inch circle. With a sharp knife, cut into 8 pie-shaped wedges. Starting with wide edge, roll each wedge toward the point. Place on ungreased cookie sheets, point side down, and curve into crescent shape. Cover; let rise until indentation remains after touching. Combine 1 slightly beaten egg and 1 tablespoon water; brush croissants with egg mixture. Bake in preheated 350°F oven 15 to 18 minutes or until golden brown. Remove from cookie sheets and cool.

Makes 32 croissants.

Use **Dough** cycle

Recipes

BRIOCHE

Water	1/2 cup
Egg yolks	6
Butter, cold, chipped into pieces	6 tablespoons
Salt	1 1/2 teaspoons
Sugar	6 tablespoons
Dry milk	3 tablespoons
Vanilla extract	3 drops
Bread flour	3 cups
RED STAR® Active Dry Yeast	2 1/4 teaspoons

Glaze: Whisk together 2 egg yolks and 1 tablespoon water.

Remove dough from pan and punch down to remove any air bubbles. Divide dough into 3 equal sections. Divide each section into 6 pieces. Make each piece into a brioche by dividing into a large and small ball. Roll to make round and place large ball in a greased brioche or muffin cup. Dip smaller ball into Glaze and then place on top of larger ball. Allow to rise until indentation remains after gently touching the side of the roll. Brush the rolls with Glaze. Bake in 350°F oven 10 to 15 minutes until golden brown.

Makes 18 rolls

Use **Dough** cycle

DINNER ROLLS

Water	3/4 cup
Egg	1 large
Butter, cool, cut in pieces	6 tablespoons
Salt	1 teaspoon
Sugar	3 tablespoons
Dry milk	3 tablespoons
Bread flour	3 cups
RED STAR® Active Dry Yeast	2 1/4 teaspoons

Remove dough and punch down to remove air bubbles. Divide dough into 4 sections. Divide each section into 6 equal pieces. Shape into desired form for dinner rolls. Cover; let rise until indentation remains after gently touching side of roll. Bake 350°F approximately 15 minutes, until golden brown.

Makes 24 rolls.

Use **Dough** cycle

BAGELS

Water	1 cup
Salt	1 teaspoon
Sugar	2 tablespoons
Bread flour	3 cups
RED STAR® Active Dry Yeast	2 1/4 teaspoons

When cycle is complete, remove the dough onto lightly floured surface. Punch down to remove air bubbles. Divide dough into 4 parts and each part into 3 pieces. Shape each piece into a smooth ball. With finger, punch hole in center. Pull dough gently to make a 1 to 2-inch hole. Let rise 20 minutes. Meanwhile, heat 2 quarts water and 2 tablespoons sugar to boiling. Place a few risen bagels at a time in boiling water. Simmer 3 minutes, turning once. Remove with a slotted spoon. Place on greased cookie sheets. Brush tops with 1 slightly beaten egg white; sprinkle with poppy or sesame seeds. Bake in preheated 375°F oven 20 to 25 minutes or until golden brown. Remove from cookie sheet; cool.

Makes 12 bagels.

Use **Bagel Dough** cycle

Recipes

EGG BAGELS

Water	3/4 cup
Egg	1
Salt	1 teaspoon
Sugar	2 tablespoons
Bread flour	3 cups
RED STAR® Active Dry Yeast	2 1/4 teaspoons

When cycle is complete, remove the dough onto lightly floured surface. Punch down to remove air bubbles. Divide dough into 4 parts and each part into 3 pieces. Shape each piece into a smooth ball. With finger, punch hole in center. Pull dough gently to make a 1 to 2-inch hole. Let rise 20 minutes. Meanwhile, heat 2 quarts water and 2 tablespoons sugar to boiling. Place a few risen bagels at a time in boiling water. Simmer 3 minutes, turning once. Remove with a slotted spoon. Place on greased cookie sheets. Brush tops with 1 slightly beaten egg white; sprinkle with poppy or sesame seeds. Bake in preheated 375°F oven 20 to 25 minutes or until golden brown. Remove from cookie sheet; cool.

Makes 12 bagels.

Use **Bagel Dough** cycle

WHOLE WHEAT BANANA BAGELS

Water	3/4 cup
Mashed banana	1/2 cup
Vegetable oil	2 tablespoons
Egg	1
Honey	1 tablespoon
Salt	1 1/2 teaspoons
Whole wheat flour	2 1/2 cups
Bread flour	1 cup
RED STAR® Active Dry Yeast	2 1/4 teaspoons

When cycle is complete, remove the dough onto lightly floured surface. Punch down to remove air bubbles. Divide dough into 4 parts and each part into 3 pieces. Shape each piece into a smooth ball. With finger, punch hole in center. Pull dough gently to make a 1 to 2-inch hole. Let rise 20 minutes. Meanwhile, heat 2 quarts water and 2 tablespoons sugar to boiling. Place a few risen bagels at a time in boiling water. Simmer 3 minutes, turning once. Remove with a slotted spoon. Place on greased cookie sheets. Brush tops with 1 slightly beaten egg white; sprinkle with poppy or sesame seeds. Bake in preheated 375°F oven 20 to 25 minutes or until golden brown. Remove from cookie sheet; cool.

Makes 12 bagels.

Use **Bagel Dough** cycle

Recipes

STRAWBERRY PRESERVES

Strawberries	1-20 ounce frozen, thawed and crushed or 2 cups fresh
Sugar	2 3/4 cups
Powdered pectin	1 package (1.75 oz.)
Lemon juice	2 tablespoons

After cooking is completed, remove pan from machine. Mixture is very hot. Discard any foam. Pour into containers; refrigerate or freeze.

Use **Jam** cycle

LOW SUGAR STRAWBERRY JAM

Strawberries	1-20 ounce frozen, thawed and crushed or 2 cups fresh
Sugar	2 3/4 cups
Powdered pectin for low sugar	1 package (1.75 oz.)

After cooking is completed, remove pan from machine. Mixture is very hot. Discard any foam. Pour into containers; refrigerate or freeze.

Use **Jam** cycle

Gluten-Free Bread Recipes

Gluten-free Breads

Yeast-leavened breads for people who cannot tolerate wheat, oats, barley, or rye in their diet.

DIRECTIONS FOR ALL GLUTEN-FREE BREADS

Ingredient Preparation:

- All ingredients should be at room temperature.
- Place eggs in a bowl and beat lightly. Blend in the remaining liquid ingredients. Pour into bread pan.
- Measure dry ingredients, including yeast, into a bowl and whisk together until thoroughly blended. Pour dry ingredients onto liquid ingredients in pan.

Bread Machine Program:

- Place pan in machine. Select the DOUGH cycle and press START. The dough should look like stiff pancake batter and not look like wheat bread dough.
- When the DOUGH cycle is complete, select BAKE and press START. At the end of the BAKE CYCLE, test for doneness with a toothpick. If the bread is not done, reselect the BAKE cycle and press START. Check approximately every 10 minutes until the toothpick comes out clean.

After Baking:

- Remove pan from the machine and allow the bread to remain in pan for approximately 10 minutes. Remove bread from pan and cool completely before cutting.
- If the loaf sinks in the middle when cool, remember to write a note on the recipe to reduce the liquid approximately 1 or 2 tablespoons.
- If the loaf has a rough uneven top crust, remember to write a note on the recipe to increase the liquid approximately 1 or 2 tablespoons.
- To store gluten-free bread, slice and then place the slices together. Wrap loaf in aluminum foil and place in a plastic bag. Store in freezer until almost ready to serve or eat. Slices will snap apart easily and thaw rapidly.

Gluten-free Recipes

GLUTEN-FREE POTATO BREAD

Liquid ingredients

Eggs, large or extra large	3 (must measure 3/4 cup)
Oil	3 tablespoons
Water	1 1/2 cups
Ricotta cheese	3/4 cup
Cider vinegar	1 teaspoon

Dry Ingredients

White rice flour	2 1/4 cups
Tapioca flour	1/3 cup
Potato starch flour	1/3 cup
Instant potato flakes	1/2 cup
Dry milk	1/2 cup
Xanthan gum	2 teaspoons
Salt	1 1/2 teaspoons
Sugar	3 tablespoons
Baking soda	3/4 teaspoons
RED STAR®	
Active Dry Yeast	2 1/4 teaspoons

GLUTEN-FREE CINNAMON RAISIN BREAD

Liquid ingredients

Eggs, large or extra large	3 (must measure 3/4 cup)
Oil	3 tablespoons
Water	1 1/3 cup
Cider vinegar	1 teaspoon

Dry Ingredients

White rice flour	1 3/4 cups
Brown rice flour	1 cup + 2 tablespoons
Xanthan gum	2 teaspoons
Dry milk	1/2 cup
Salt	1 1/2 teaspoons
Sugar	3 tablespoons
Cinnamon	1 1/2 teaspoons
Raisins	2/3 cup
RED STAR®	
Active Dry Yeast	2 1/4 teaspoons

GLUTEN-FREE MOCK LIGHT RYE

Liquid ingredients

Eggs, large or extra large	3 (must measure 3/4 cup)
Oil	1/4 cup
Molasses	2 tablespoons
Vinegar	1 teaspoon
Water	1 1/3 cups

Dry Ingredients

White rice flour	2 1/4 cups
Brown rice flour	3/4 cup + 2 tablespoons
Salt	1 1/2 teaspoons
Light brown sugar	1/4 cup
Xanthan gum	1 tablespoon
Caraway seeds	4 teaspoons
Dry milk	1/2 cup
RED STAR®	
Active Dry Yeast	2 1/4 teaspoons

Gluten-free Recipes

GLUTEN-FREE BROWN & WHITE RICE BREAD

Liquid ingredients

Eggs, large or extra large	3 (must measure 3/4 cup)
Oil	1/4 cup
Vinegar	1 teaspoon
Water	1 1/2 cups

Dry Ingredients

White rice flour	2 1/4 cup
Brown rice flour	1 cup + 2 tablespoons
Salt	1 1/2 teaspoons
Sugar	3 tablespoons
Xanthan gum	2 1/2 teaspoons
Dry milk	1/2 cup
RED STAR®	
Active Dry Yeast	2 1/4 teaspoons

GLUTEN-FREE ROMANO BEAN BREAD

Liquid ingredients

Eggs, large or extra large	3 (must measure 3/4 cup)
Oil	3 tablespoons
Vinegar	1 teaspoon
Honey	1/4 cup
Water	1 1/3 cups

Dry Ingredients

Romano bean flour	1 cup
Cornstarch	1 cup
Tapioca flour	1 cup
Xanthan gum	1 tablespoon
Salt	1 teaspoon
Brown sugar	1/4 cup
RED STAR®	
Active Dry Yeast	2 1/4 teaspoons

Variation: Add 1 teaspoon fresh grated orange rind.

GLUTEN-FREE CHEDDAR LOAF

Liquid ingredients

Eggs, large or extra large	3 (must measure 3/4 cup)
Oil	3 tablespoons
Vinegar	1 teaspoon
Water	1 1/2 cups

Dry Ingredients

White rice flour	2 cups
Brown rice flour	1 cup
Salt	1 1/2 teaspoons
Sugar	3 tablespoons
Xanthan gum	3 1/2 teaspoons
Dry milk	1/4 cup
Grated cheddar cheese	1 1/2 cups
RED STAR®	
Active Dry Yeast	2 1/4 teaspoons

Variations: A teaspoon of one or more of the following may be added: instant minced onion, poppy seeds, celery seeds, or dill weed.

Gluten-free Recipes

GLUTEN-FREE CARDAMOM FRUIT BREAD

Liquid Ingredients

Eggs, large or extra large	3 (must measure 3/4 cup)
Oil	1/4 cup
Vinegar	1 teaspoon
Water	1 3/4 cups

Dry Ingredients

White rice	2 cups
Potato starch flour	3/4 cups
Tapioca flour	1/3 cups
Xanthan gum	1 tablespoon
Sugar	3 tablespoons
Cardamom	1 tablespoon
Dry milk	1/2 cup
Salt	1 teaspoon
Dried fruit bits	6 oz. (about 1 1/2 cups)
RED STAR®	
Active Dry Yeast	2 1/4 teaspoons

Troubleshooting

CHECKING DOUGH CONSISTENCY

Although the bread machine will mix, knead, and bake bread, it is absolutely necessary that you learn to recognize the condition of your dough. The ratio of flour to liquid is the most critical factor in any bread recipe, yet most easily remedied. It is alright to open the machine to check the dough's consistency. Do this after about five minutes into the KNEAD cycle. The dough should be in a soft, tacky ball. If it is too dry, add liquid 1/2 to 1 tablespoon at a time. If it is too wet, add 1 tablespoon of flour at a time.

Cratered Bread

If the top of the loaf caves in, this is a sign of too much moisture. You may need to make recipe adjustments, such as reducing liquid or adding flour, 1/2 to 1 tablespoon at a time. Cratered bread may also occur, to varying degrees, with cheese bread because each cheese has a distinct moisture content.

Mushroom Bread

Mushroom bread may be caused by too much yeast or too much water. Also, you may be using too much dough for the pan size. Check your recipe to make sure the total amount of flour does not exceed 4 1/3 cups.

Gnarly Loaves

The dough probably needs more moisture. See *Checking Dough Consistency*, above.

High-Altitude Baking

In high-altitude areas, dough tends to rise faster as there is less air pressure. Therefore, less yeast is necessary. In dry climates, flour is drier and requires slightly more liquid. In humid climates, flour is wetter and will absorb less liquid. Therefore, slightly more flour is required.

Jam

If you find that the jam is not thick enough, repeat the JAM cycle.

The Science of Breadmaking

Most recipes contain sugar in some form for sweetness. In breadmaking, sugar helps start or "feed" the yeast and promotes browning. Salt, on the other hand, inhibits the yeast, but also adds flavor. With this knowledge in mind, you can control the balance of the chemical reaction between flour, yeast, water, sugar, and salt to make a perfect loaf of bread. The recipes included with this booklet have been tested to work in this bread machine. When using recipes from other sources, you may have to make adjustments for perfect results. Follow suggestions from this guide.

Simple Test To Determine Yeast Activity

Dissolve 1 teaspoon of granulated sugar in 1/2 cup warm water (115-115°F). Sprinkle 1 packet of yeast (about 1 T) slowly over the surface. Stir the yeast, then set a timer for 10 minutes. In 3 to 4 minutes, it will have absorbed enough liquid to activate and will start rising to the surface. If at the end of 10 minutes, the yeast has multiplied to the 1 cup mark and has a rounded crown, it is very active. The yeast mixture may be used in your dough. Remember to deduct the 1/2 cup of liquid from the total used in the recipe.

Questions and Answers

QUESTIONS ABOUT GENERAL PERFORMANCE AND OPERATION

Q1 How do I make doughnuts using my bread machine?	A1 Use the dough setting to make the dough for the doughnuts. Then shape and fry the doughnuts in a conventional deep fryer.
Q2 What should I do if the kneading blade comes out with the bread?	A2 Remove it with care with a crochet hook or a sandwich pick before slicing the bread. Since the blade can be separated from the pan, it is not a malfunction if it comes out in your bread.
Q3 Why does my bread sometimes have some flour on the side crust?	A3 Your dough may be too dry. Next time, check your recipe and measuring. You may need to add more liquid, 1/2 to 1 tablespoon at a time. You can simply trim off that portion of the outer crust.
Q4 Why isn't the dough mixing? I can hear the motor running.	A4 The kneading blade or baking pan may not be inserted properly. Make sure the pan is facing the right way and that it has clicked into place.
Q5 How long does it take to make bread?	A5 See <i>Bread Machine Cycle Times</i> , page 16.
Q6 Why can't I use the timer when baking with fresh milk?	A6 The milk will spoil if left sitting in the machine too long. Perishable ingredients, such as eggs and milk, should never be used with the timer feature.
Q7 If the power goes out in the middle of a cycle, will my bread machine finish baking bread or making dough?	A7 If the power failure is no more than approximately 30 minutes, bread machine resumes cycle where it left off and will finish baking bread or making dough.
Q8 Why do I have to add the ingredients in a certain order?	A8 This allows the bread machine to mix the ingredients in the most efficient manner possible. When using the timer, it also keeps the yeast from combining with the liquid before the dough is mixed.
Q9 When setting the timer for morning, why does the machine make sounds late at night?	A9 The machine must start operation several hours before the bread will be ready. These sounds are made by the motor when kneading the dough. It is a normal operation, not a malfunction.
Q10 What size loaf does the bread machine make?	A10 Your Bread maker makes REGULAR (1 lb.), LARGE (1 1/2 lb.), and EXTRA LARGE (2 lb.) loaves of bread.
Q11 The kneading blade is stuck in the bread pan after baking. How do I get it out?	A11 If the kneading blade gets stuck, pour hot water into the bread pan. Rotate the kneading blade to clean under it. Remove blade and clean inside. See <i>Care and Cleaning</i> , page 15.

Questions and Answers

QUESTIONS ABOUT GENERAL PERFORMANCE AND OPERATION

Q12 How many watts is my bread machine?	A12 Please refer to the rating label on the machine.
Q13 Can I wash the baking pan in the dishwasher?	A13 No. The baking pan and kneading blade must be washed by hand. Do not immerse the pan in water.
Q14 What will happen if I leave the finished bread in the baking pan?	A14 The keep warm cycle will keep it warm and prevent it from becoming soggy for 1 hr. If the bread is left in the pan after 1 hr. it may start to become soggy.
Q15 Why did the dough only partially mix?	A15 Check to make sure the kneading blade and baking pan are inserted properly. Also, check the dough consistency. After 5 minutes of kneading, check dough. If too dry, add liquid. If too moist, add flour. Only add 1/2 to 1 tablespoon at a time.
Q16 Why didn't the bread rise?	A16 The yeast could be old or expired, or possibly no yeast was added at all. Check to see if your yeast is fresh. Also, check the dough consistency. After 5 minutes of kneading, check dough. If too dry, add liquids. If too moist, add flour. Only add 1/2 to 1 tablespoon at a time.
Q17 Why can't the delayed finish be set for more than 13 hours?	A17 The maximum length of delay is 13 hours, including the particular cycle time. See <i>Using The Timer</i> , page 14.
Q18 Why can't I operate the machine when the DISPLAY WINDOW shows "E00" or "E01"?	A18 If the temperature in the bread chamber is higher than 122° F, the DISPLAY WINDOW will show "E01". If the temperature is lower than 14° F, the DISPLAY WINDOW will show "E00". Let the machine cool down before you make bread.
Q19 How will I know when to add fruits and nuts to the bread?	A19 The Fruit & Nut beep signals when to add raisins, nuts, etc. If it is more convenient for you to add them at the start, you will still have acceptable results. However, the added ingredients may be broken apart during kneading. See <i>Bread Machine Cycle Times</i> , page 16.
Q20 My baked bread is too moist? What can I do?	A20 Humidity may affect the dough. After 5 minutes of kneading, check the dough consistency. If it appears too moist, add more flour 1/2 to 1 tablespoon at a time. For best results, remove the baked bread from the pan soon after the baking is completed.

Questions And Answers

QUESTIONS ABOUT INGREDIENTS / RECIPES

Q21 Why do I get air bubbles at the top of the bread?	A21 This can be caused by using too much yeast.
Q22 When using raisins, the bread machine crushes them. How can I avoid this?	A22 Add raisins, nuts etc., at the Fruit and Nut Beep. For best results, use dry raisins. Also check your dough consistency 5 minutes into kneading. If the dough is too dry, it will not incorporate the raisins easily.
Q23 Why does my bread rise and then collapse or crater?	A23 The bread may be rising too fast. To reduce the rate of rising, reduce the amount of water and/or increase the amount of salt and/or decrease the amount of yeast. See <i>Baking Tips Guide</i> , on page 43.
Q24 Can I use my favorite bread recipes (traditional yeast bread) in my bread machine?	A24 Yes, but you will need to experiment to get the right proportion of ingredients. Become familiar with the unit and make several loaves of bread before you begin experimenting. Never exceed a total amount of 4 1/3 cups dry ingredients. Use the recipes in this book to help determine the ratio of flour to liquid and amounts of yeast, sugar, salt, and fat to use.
Q25 Why do the loaves vary in height and weight? The whole wheat and multi-grain breads are always shorter. Am I doing something wrong?	A25 No, it is normal for Whole Wheat and Multi-Grain breads to be shorter and denser than Basic or French breads. Whole Wheat and Rye flours are heavier than white bread flour, therefore they don't rise as much during the bread making process. They also typically have added ingredients, such as oats, bran, nuts, and raisins, which contribute to the shorter height and denser texture.

BAKING TIPS INTRODUCTION

When developing Welbilt® Bread Machine recipes, hundreds of loaves of bread were baked using the most popular brands of flours and yeasts available. If you use flour processed by a local mill it may have different characteristics and produce different results than popular national brands. If you followed the recipe in the cookbook exactly and feel the results should be better, use the BAKING TIPS on the following pages to help you produce a better loaf of bread. There are usually several ways to improve baking results. We recommend you make adjustments one at a time. Also, keep track of your adjustments to know what changes were made to create your perfect loaf.

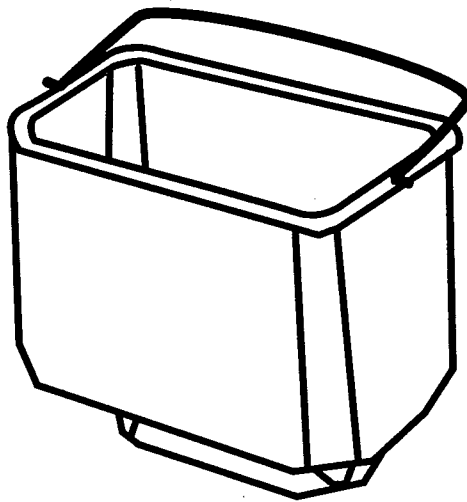
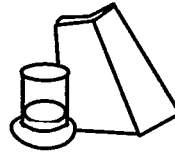
Baking Tips For Yeast Breads

RESULTS POSSIBLE SOLUTIONS		MEASUREMENT										INGREDIENT									
		Water or	Increase +	Decrease -	Increase +	Decrease -	Increase +	Decrease -	Increase +	Decrease -	Increase +	Decrease -	Water or	Increase +	Decrease -	Increase +	Decrease -	Increase +	Decrease -	Increase +	Decrease -
Milk	Salt	Sugar or Honey	Flour	Yeast	Water or Milk	Flour	Yeast	Water or Milk	Flour	Yeast	Water or Milk	Flour	Yeast	Water or Milk	Flour	Yeast	Water or Milk	Flour	Yeast	Water or Milk	Flour
Yeast	Salt	Sugar or Honey	Flour	Yeast	Water or Milk	Flour	Yeast	Water or Milk	Flour	Yeast	Water or Milk	Flour	Yeast	Water or Milk	Flour	Yeast	Water or Milk	Flour	Yeast	Water or Milk	Flour
Yeast	Salt	Sugar or Honey	Flour	Yeast	Water or Milk	Flour	Yeast	Water or Milk	Flour	Yeast	Water or Milk	Flour	Yeast	Water or Milk	Flour	Yeast	Water or Milk	Flour	Yeast	Water or Milk	Flour
Yeast	Salt	Sugar or Honey	Flour	Yeast	Water or Milk	Flour	Yeast	Water or Milk	Flour	Yeast	Water or Milk	Flour	Yeast	Water or Milk	Flour	Yeast	Water or Milk	Flour	Yeast	Water or Milk	Flour
Yeast	Salt	Sugar or Honey	Flour	Yeast	Water or Milk	Flour	Yeast	Water or Milk	Flour	Yeast	Water or Milk	Flour	Yeast	Water or Milk	Flour	Yeast	Water or Milk	Flour	Yeast	Water or Milk	Flour

Replacement Parts

If you would like to order replacement or spare parts for your bread machine, please call our Consumer Relations Center at 1-800-872-1656. We accept Visa, Mastercard, or Discover. Please refer to the model number located on the control panel of the bread machine.

Kneading Blade



Horizontal Bread Pan
ABM2H52
ABMY2K1

LIMITED WARRANTY

What is Covered and For How Long?

This warranty covers all defects in workmanship or materials in the mechanical and electrical parts, arising under normal usage and care, in this Welbilt® product for a period of 12 months from the date of purchase provided you are able to present a valid proof-of-purchase. A valid proof-of-purchase is a receipt specifying item, date purchased, and cost of item. A gift receipt with date of purchase and item is also an acceptable proof-of-purchase. Product is intended for household use only. Any commercial use voids the warranty.

**YOU MUST KEEP YOUR ORIGINAL PROOF-OF-PURCHASE
TO OBTAIN WARRANTY SERVICE.**

Who is Covered?

The original retail purchaser or gift recipient who can provide proof-of-purchase.

What Will Be Done?

During the applicable warranty period within normal household use, we will repair or replace, at our discretion, any mechanical or electrical part which proves defective, or replace unit with a comparable model.

How Can You Get Service?

Call 1-800-872-1656

**DO NOT RETURN THIS WELBIT® PRODUCT TO
APPLIANCE CO. OF AMERICA, LLC**

All service must be performed by an ACA authorized Service Center. A valid proof-of-purchase must be submitted to obtain warranty service. Maintain a copy of proof-of-purchase for your records. In the event service is required:

- a. ACA is not responsible for loss or damage during incoming shipment.
- b. Carefully package product for prepaid shipment and insure it with the carrier. Be sure to enclose any accessories related to your problem.
- c. Retain tracking information for your protection in case of loss or damage in shipment.

**THIS LIMITED WARRANTY COVERS UNITS PURCHASED AND
USED WITHIN THE UNITED STATES AND DOES NOT COVER:**

- * Damages from improper installation.
- * Damages in shipping.
- * Defects other than manufacturing defects.
- * Damages from misuse, abuse, accident, alteration, lack of proper care and maintenance, or incorrect current or voltage.
- * Damage from service by other than an authorized dealer or service center.
- * Any transportation and shipping charges.

MANUFACTURER MAKES NO WARRANTY, EXPRESS OR IMPLIED, INCLUDING WITHOUT LIMITATION, ANY WARRANTIES OF FITNESS OR MERCHANTABILITY, EXCEPT AS EXPRESSLY SET FORTH ABOVE WITH RESPECT TO SUCH PRODUCTS OR PARTS THEREFOR. NOR SHALL MANUFACTURER HAVE INCURRED ANY OTHER OBLIGATIONS OR LIABILITIES ON ITS PART OR BE LIABLE FOR ANY ANTICIPATED OR LOST PROFITS, INCIDENTAL DAMAGES, CONSEQUENTIAL DAMAGES, TIME CHARGES OR ANY OTHER LOSSES INCURRED IN CONNECTION WITH THE PURCHASE, INSTALLATION, REPLACEMENT, OR REPAIR OF SUCH PRODUCTS OR ANY PARTS THEREFOR WHETHER ORIGINAL EQUIPMENT OR INSTALLED AS A REPLACEMENT COVERED BY THIS WARRANTY OR OTHERWISE; AND MANUFACTURER DOES NOT AUTHORIZE ANY PERSON TO ASSUME FOR MANUFACTURER ANY OTHER LIABILITY IN CONNECTION WITH THE PRODUCTS OR PARTS THEREFOR.

Manufacturer assumes no liability for delay in performing its obligations hereunder if failure results, directly or indirectly, from any cause beyond its control, including but not limited to acts of God, acts of government, floods, fires, shortages of materials, strikes and other labor difficulties, or delays, or failures of transportation facilities.

This image shows a single sheet of white paper with horizontal blue or grey ruling lines. The lines are evenly spaced and run across the width of the page. There are no margins, text, or other markings on the paper.

IMPORTANT NOTICE

PLEASE DO NOT RETURN TO STORE
If you have any problem with the unit contact
ACA Consumer Relations for service
PHONE: 1-800-872-1656

Please read operating instructions before
using this product

Please keep original box and packing
materials in the event that service is required

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