



**ATLANTIS-PAK**

Leader In Innovative  
Packaging Solutions

# Casings

# Additional service R2U

Process Operating Manual



## **1. APPLICATION**

This Process Operating Manual describes the processing of:

- R2U (ready to use) multilayer barrier casings for the production of cooked sausages and hams, spreads and liver sausages;
- R2U (ready to use) permeable casings for the production of semi-smoked, cooked-and-smoked and cooked sausages made with the use of technologies that involve the stage of smoking.

The distinctive feature of the R2U casings is the possibility of their processing without pre-soaking. Elasticity required for overfilling of the casings to the recommended final calibers is achieved by means of either of the two methods:

- special treatment with a humidifying solution in the course of 'loose' shirring;
- treatment with a humidifying solution with the use of the special Nickelman 1000 equipment.

## **2. PROPERTIES AND ADVANTAGES**

### **2.1. Specifications of the R2U casings**

All types of the AMIFLEX, AMITEX, AMILINE and EXTRAFLEX multilayer casings, and of the FIBROSMOK and ICEL permeable casings supplied in the R2U option conform to the following specifications:

- TU 22.21.29-010-27147091-2000 Amiflex Sausage Casing;
- TU 22.21.29-015-27147091-2004 Amitex Sausage Casing;
- TU 2291-017-27147091-2006 Extraflex Sausage Casing;
- TU 22.21.29-018-27147091-2006 Fibrosmok Sausage Casing;
- TU 22.21.29-048-27147091-2012 Amiline Sausage Casing;
- TU 2291-049-27147091-2012 iCel Sausage Casing.

### **2.2. Advantages of the R2U casings**

The R2U casings possess all properties of multilayer and permeable casings that make them suitable for automatic processing, provide for an excellent selling appearance, and ensure a prolonged shelf life of food products, such as:

- mechanical strength;
- high elasticity;
- heat shrink ratio;
- low permeability to oxygen;

- resistance to microbiological damage.

Moreover, the R2U casings grant to the manufacturer a number of extra benefits:

#### 2.2.1. Economy of

- time - no time is wasted for pre-soaking of the casing;
- space - no need to clutter the shop floor with pre-soaking vats.

2.2.2. Improvement of the production site hygiene and possible extension of the products' shelf life through dispensing with the pre-soaking stage in the production process, which also reduces the germ count of the casing.

2.2.3. Simplification of the production technology - no need to control the water temperature in the pre-soaking vats, or the soaking duration, or penetration of water inside the tube.

### 3. ASSORTMENT

The R2U option is available for the following types and calibers of multilayer and permeable casings (see Table 1):

Table 1

<b>Casing description and type</b>	<b>Casing caliber, mm</b>
AMIFLEX T	29- 120
AMIFLEX M	35 - 120
AMIFLEX E	40 - 120
AMIFLEX Tko	32 - 80
AMIFLEX Tc	35 - 120
AMIFLEX Optima	29 - 120
AMIFLEX Perfect	40 - 120
AMITEX Elite-C	35 - 120
AMITEX Komplekt	40 - 90
AMITEX Rondo 1	45 - 120
AMITEX Elite-K	24 - 120
AMITEX Elite-Kc	24 - 120
EXTRAFLEX	32 - 120
EXTRAFLEX Ko	32 - 51
FIBROSMOK	29 - 80
FIBROSMOK Ko	29 - 51
ICEL Premium	35 – 90
ICEL	35 - 90

The 'loose' shirring parameters of the R2U casings correspond to the specified 'loose' shirring parameters of the casings without the R2U capability.

The length of the casing in a shirred 'stick' may vary from 20 to 62 m.

## **4. CASING USE TECHNOLOGY**

### **4.1. Storage and transportation of casing**

4.1.1 The R2U casings must be stored in the manufacturer's packing in dry, clean, and cool rooms (at a temperature from 5 °C to 35 °C and relative humidity not exceeding 80%) compliant with the sanitary and hygienic standards applicable to the meat processing industry.

4.1.2. During storage and transportation protect the casing against exposure to high temperatures or direct sunlight.

4.1.3. When the casing was stored at a temperature below zero, hold it at room temperature in the manufacturer's packing for at least 24 hours before processing.

4.1.4. After opening of the packing containing the R2U shirred casing, keep the packing closed to protect the casing against drying out.

4.1.5. Protect the casing against damage throughout the processing cycle.

### **4.2. Preparation of the casing for processing**

The R2U casing does not require pre-soaking and can be processed immediately after opening of the manufacturer's packing. The packing with any leftover casing must be kept tightly closed to preserve the casing's characteristics.

### **4.3. Forcemeat composition**

The forcemeat for production of sausages, hams or spreads shall be prepared in accordance with the regulatory documentation for the particular products (GOST, TU) and in conformity with the process operating manuals for the casing type in question.

#### 4.4. Forming of sausages

Multilayer and permeable R2U casings are intended for automatic and semi-automatic stuffing and clipping equipment.

In order to ensure a good appearance of the finished products, increase the holding capacity of the casing, and reduce the risk of fat and water pockets, the R2U multilayer casings should be stuffed in accordance with the process operating manual for the particular type of casing (see Table 2).

Table 2

Casing description and type	Overfilling, %
AMIFLEX T	8-10
AMIFLEX M	10-12
AMIFLEX E	10
AMIFLEX Tko	10-12
AMIFLEX Tc	12-16
AMIFLEX Optima	10
AMIFLEX Perfect	4-6
AMITEX Elite-C	8-10
AMITEX Komplekt	10
AMITEX Rondo 1	10-12
AMITEX Elite-K	4-6
AMITEX Elite-Kc	8-10
EXTRAFLEX	12-15
EXTRAFLEX Ko	12-15
FIBROSMOK	12-14
FIBROSMOK Ko	12-14
ICEL Premium	10-12
ICEL	10-12

For production of spreads by the hot method, when the emulsion is liquid and its temperature exceeds 40 °C, the overfilling ratio relative to the nominal caliber should be increased by 3 - 5 % relative to the recommended value.

Never puncture the chubs (perforate the casing). The casing will burst, if punctured.

The clip must securely hold the ends of the chub, without damaging the casing. Observe the recommendations of the manufacturer of the clipping equipment and the process operating manuals for the particular type of casing.

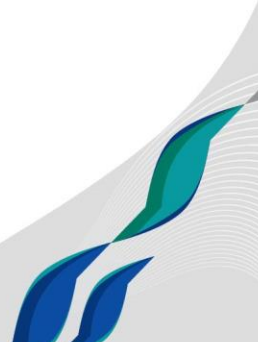
## **4.5. Thermal processing**

Thermal processing of meat products in multilayer and permeable R2U casings must be performed according to the regulatory documentation for such products, and the process operating manuals for the particular types of casing.

## **5. MANUFACTURER'S GUARANTEES**

5.1. The Manufacturer guarantees conformity of the casing with the Specification subject to compliance with the required conditions of transportation and storage at the user's warehouse, and preservation of the integrity of the original packing.

5.3. The guaranteed shelf life is 6 months from the date of manufacture for the multilayer R2U casings of the types AMIFLEX, AMITEX, AMILINE and EXTRAFLEX kept in their original packing; and 3 months from the date of manufacture for the R2U permeable casings.





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