ATLANTIS-PAK

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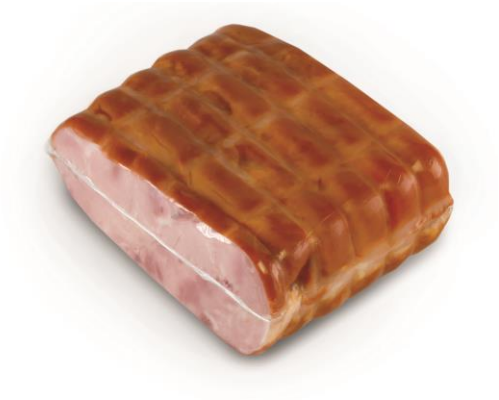
Packaging Solutions

HEAT-SHRINK BAGS

amivac

AMIVAC SE

Process Operating Manual



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1. APPLICATION

AMIVAC SE are high barrier heat shrink bags designed for vacuum or MAP packaging, storage and sale of sausages, specialties, no-bone raw meat, unripened cheeses, soft and brine cheeses, and one-meal cheese sliceware.

AMIVAC SE bags are made from a tubular multilayer film according to Specifications TU 22-22-12-007-27147091-2000 (equivalent to TU 2297-007-27147091-2000) composed of polyamide, EVOH, polyethylene, modified polyolefin and PET duly permitted for use in the food industry. Quality of the raw materials used to manufacture the bags is confirmed by Russian and international quality certificates.

AMIVAC SE bags comply with the requirements of the Technical Regulation of the Customs Union TR TS 005/2011 (Packaging Safety), as confirmed by the duly approved and registered declarations of conformity.

The production, use, storage and transportation of the bags is not harmful for the environment or human health.

1.1. Recommended shelf life of the products packaged in AMIVAC SE bags

Table 1 – Shelf life of chilled products packaged in AMIVAC SE bags

Product name	Specified shelf life	References
Smoked-and-cooked pork products	40 days at a temperature from +2 °C to +6 °C	GOST R 54043-2010
Cooked pork products	40 days at a temperature from +2 °C to +6 °C	GOST 31790-2012
Cooked sausages, premium grade, 1st grade, 2nd grade	Chubs - 30 days One-meal products - 20 days at a temperature from 0 °C to +6 °C	GOST R 52196-2017
Frankfurters, premium grade, 1st grade	20 days at a temperature from 0 °C to +6 °C	GOST R 52196-2017
Wieners, 1st grade	20 days at a temperature from 0 °C to +6 °C	GOST R 52196-2017
Hot dogs, premium grade	20 days at a temperature from 0 °C to +6 °C	GOST R 52196-2017
No-bone chilled beef cuts	25 days at a temperature from 0 °C to +4 °C	GOST 31797-2012
Beef products (one-meal sliceware, whole pieces): cooked, cooked-and-smoked, smoked-and-cooked, smoked-and-baked	40 days at a temperature from +2 °C to +6 °C	TU 9213-406-00419779-03

2. ADVANTAGES OF THE PRODUCT

2.1. **High barrier to oxygen** provides for prolonged storage of the packaged products.

2.2. **Low permeability to water vapor** excludes moisture (weight) losses of the product during storage.

2.3. **Presentation of the product** at its best to the buyer thanks to the optical properties of the bag (transparency, gloss).

2.4. **Sealability over the folds and overlaps** boosts the production rate and reduces the percentage of re-packaging.

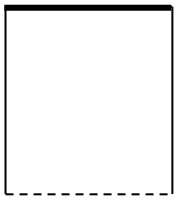
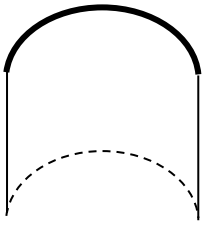
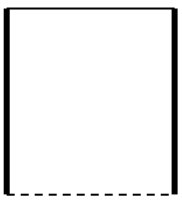
2.5. **Individual protective packaging** of the AMIVAC bag packs ensures protection from adverse external factors throughout the guaranteed storage term, and provides for an excellent sanitary and hygienic condition of the bags.

2.6. **Absence of chlorine-containing substances**. An increasing number of countries turn their attention to protection of the environment and disposal of packaging materials. Use of packaging free of chlorine containing substances is less harmful to the environment.

3. ASSORTMENT OF PRODUCTS

Assortment of AMIVAC SE bags

Table 2* – Assortment of AMIVAC SE bags

	Seals			
	Straight	**Semicircular**	**Lateral seals**	
			Straight	**V-shaped**
Bag width	from 180 to 600mm	from 180 to 550mm	from 80 to 500mm	from 110 to 500mm
Bag length	from 100** to 1200mm	from 100** to 1200mm	from 160 to 600mm	from 180 to 600mm
Type				
Pasting on strips	Option	Option	Option	Option

*in 10mm increments

**from 300mm up when strip-pasted

Available widths of the bags suppled in reels: 180-900mm

Bag colors: clear

Printing: AMIVAC SE bags can be used for single- or double-side printing. The number of printing colors varies from 1+0 to 10+10. CMYK printing is optional.

AMIVAC SE bags are supplied in the following forms:

- reels with tear-off perforation;
- reels without perforation;
- pasted on two strips (for automatic equipment);
- cut into separate bags inside transport packs each containing 100 bags.

4. HOW TO USE THE AMIVAC SE BAGS

4.1. Storage and transportation

4.1.1. AMIVAC bags must be stored at least 800mm away from any heaters, in the absence of strong-smelling or corrosive substances, at a temperature not higher than +35 °C and relative humidity not exceeding 80%.

4.1.2. AMIVAC bags must be transported at a temperature not exceeding +35 °C, and protected against direct sunlight.

4.1.3. Never drop the boxes containing the bags or subject them to impacts.

4.1.4. If the bags were stored at a subzero temperature, keep them at room temperature for at least 24 hours before opening the manufacturer's packing.

4.1.5. Leftover bags should be re-packaged under vacuum.

4.2. Selection of the appropriate bag size

4.2.1. Selection of the appropriate size for bags with a bottom seal or lateral seals

To determine the required width of the bag, measure the perimeter of the product to be packaged in its widest part. Calculate the bag width by the formula:

Width = perimeter of the product (in its widest part) x 0.55 (mm)

To determine the required length of the bag, measure the perimeter of the product to be packaged in its longest part. Calculate the bag length by the formula:

Length = perimeter of the product (in its longest part) / 2 +80 (mm)

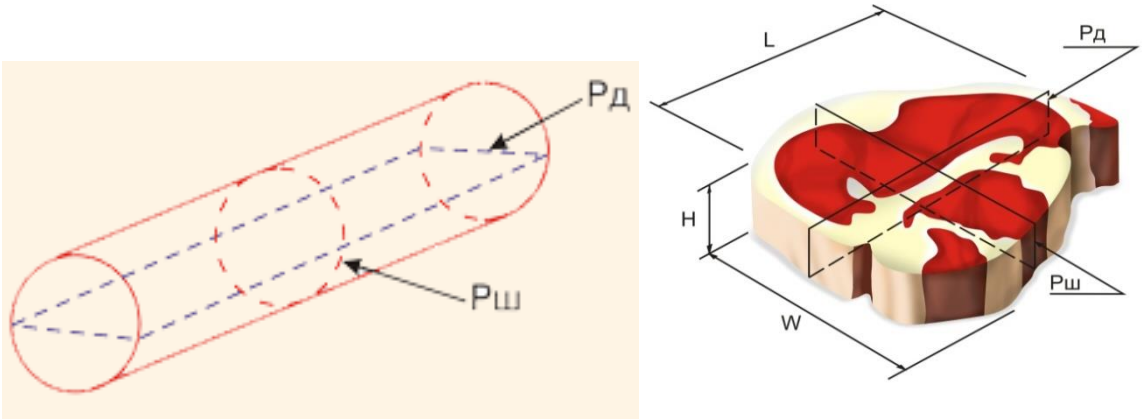


Fig. 1 – Determination of the product size

where **Рш** is the product perimeter in its widest part;
Рд is the product perimeter in its longest part;
W – width of the product in its widest part;
L – length of the product in its longest part;
H – height of the product.

4.2.2. Selection of the required size for bags with a V-shaped seal

To determine the required width of the bag, measure the perimeter of the product to be packaged in its widest part. Calculate the bag width by the formula:

Width = perimeter of the product (in its widest part) x 0.55 (mm)

To determine the required length of the bag, measure the perimeter of the product to be packaged in its longest part. Calculate the bag length by the formula:

Length = product length + product height + 80mm

To determine the required width of the bag's narrow part, measure the perimeter of the packaged product in its narrow part. Calculate the narrow part width by the formula:

Width of the bag's narrow part = perimeter of the product's narrow part * 0.4

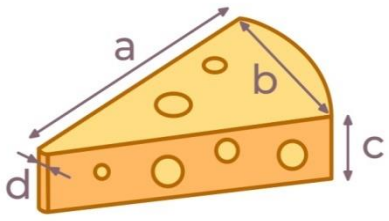


Fig. 2 – Determination of the product size

where **a** – product length in its longest part;
b – product width in its widest part;
c – product height;
d – product width in its narrowest part;

4.3. Preparation of the bags for processing

It is recommended to open the packs containing the bags just before use. If any bags taken out of the transportation packing are left over, re-package them under vacuum into a separate package.

No contact of the bags with water is allowable before completion of the product packaging.

4.4. Packaging

Packaging of food products must be performed in a production / packaging section compliant with the requirements of the sanitary regulations and rules applicable to the food industry.

Packaging of the product shall be performed by means of special equipment (vacuum packaging machines). Comply with the operating modes recommended by the manufacturer of the packaging equipment to ensure stability of the packaging process.

If no operating manual is available for the equipment, it is recommended to use the following operating modes:

4.4.1. Packaging on chamber-type machines:

- Check the sealing zone. Keep the sealing zone clean. No foreign admixtures are allowable, and the protective coating of the heating element must be free of burnt-through areas.

- Bring the bag containing the product in the vacuum zone. The product inside the bag should be as close to the heat-sealing bar as possible (Fig. 3), to improve the appearance and ensure the tight envelopment of the product.

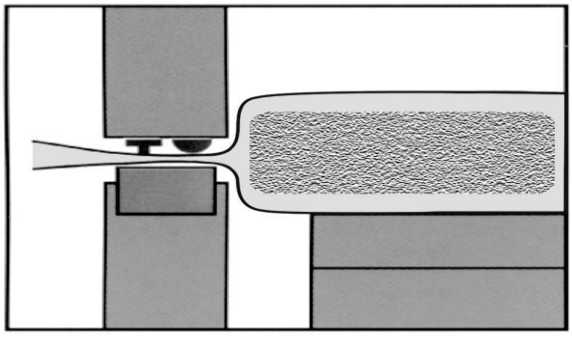


Fig. 3 – Bag sealing zone

- Select the vacuum depth. The vacuum depth is adjusted depending on product to be packaged. Vacuum depth should be 95 - 98% (residual pressure about 4.9 kPa). When packaging the products with a high moisture content, reduce the vacuum depth.

- Select the mean sealing time. Increase or decrease the sealing time to achieve the best sealing mode, as the bags are consumed (required adjustment depends on the condition of the equipment).

- If the bags are sealed with separate control of the strings, select such a time for the cutoff string contact as to provide for free separation of the separated part of the bag.

Evacuate the air and seal by closing the lid of the vacuum packaging equipment.

- Heat sealing must produce a continuous seal with the imprint of the sealing bar of the packaging machine on the bag.

If the vacuum is lost, the product must be returned for re-packaging. Bags may not be re-used.

4.5. Heat shrinking

Heat shrinking of the bag containing the product is achieved in a heat shrinking tank. The equipment must provide for adjustment and control of the conditions and parameters of the technological process of heat shrinking.

Heat shrinking will be performed by immersion of the bag with the product in hot water or by sprinkling with hot water (exposure to steam) at a temperature from 80 °C to 95 °C during 2 to 3 seconds).

It is recommended to carry out the scheduled maintenance washing and treatment of the equipment.

5. MANUFACTURER'S GUARANTEES

5.1. The Manufacturer guarantees conformity of the bags with the Specification requirements 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.

5.2. The shelf life of the bags is 1 year from the date of manufacture to processing, subject to compliance with these Specifications.

6. APPENDICES

There are no appendices to the present document.

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