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Packaging Solutions

Films AMISTYLE

AMISTYLE CPP/CPE

Process Operating Manual

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1. APPLICATION

This Process Operating Manual describes the packaging of food products in trays with the use of the **AMISTYLE CPE** and **AMISTYLE CPP** films.

AMISTYLE CPE and **AMISTYLE CPP** are multilayer heat-shrink vapor- and gas-tight heat-sealable films made of polyamide, polyolefin, polyethylene terephthalate, EVOH and adhesive (modified polyethylene) permitted by the Russian Ministry of Health for use in the food industry. The quality of the raw materials used for production of the film is confirmed by Russian and international quality certificates.

The **AMISTYLE CPE** and **AMISTYLE CPP** films are manufactured according to their original formula and are intended for packaging of chilled food products (meat-based food, chilled meat, chilled poultry, sausages and specialties, chilled fish and fish-based products, cheeses and cheese-based products, cookery, etc.) in trays filled with a modified atmosphere in order to prolong the shelf life.

The **AMISTYLE CPE** and **AMISTYLE CPP** films are intended for use on manual, semiautomatic and automatic tray sealers.

The shelf life of the food products packaged in the **AMISTYLE CPE/CPP** films shall be set by the manufacturers and approved following the procedure stipulated by the laws.

See TU 22.21.30-052-27147091-2012 and Product Specifications for information on the technical characteristics, assortment, colors, forms of supply, processing options, terms and shelf life of the **AMISTYLE CPE** and **AMISTYLE CPP** films.

2. CONSUMER PROPERTIES AND ADVANTAGES

The structure of the **AMISTYLE CPE/CPP** films combines a number of polymer materials, which provides for:

– high transparency and gloss of the film to create an attractive appearance of the package;

– high barrier against gases, which keeps the modified atmosphere inside the package to extend the shelf life;

– high strength, which keeps the package intact at all stages of transportation and storage;

– excellent sealability within a wide temperature range, which ensures tight sealing.

Addition of an antifogging agent to the formula of the **AMISTYLE CPE/CPP** films keeps the package highly transparent despite temperature fluctuations, prolongs the shelf life of the product due to absence of any condensate at the package bottom, and preserves the esthetic package appearance.

Heat-shrink properties of the **AMISTYLE CPE/CPP** films provide for uniform tensioning of the films over the tray (drum effect).

Absence of chlorine-containing substances makes the **AMISTYLE CPE/CPP** films even more environment-friendly, since the disposal of chlorine-free packaging is less harmful for the environment.

The **AMISTYLE CPE-25**, **AMISTYLE CPE-40** and **AMISTYLE CPE-40-M** films have a heat-sealable layer of polyethylene (PE).

The **AMISTYLE CPP-25** and **AMISTYLE CPP-40** films have a heat-sealable layer made of polyolefin plastomers suitable for sealing with polypropylene (PP) and polyethylene (PE).

3. HOW TO USE THE FILM

3.1. Preparation of the film

3.1.1. If the film was stored at a subzero temperature, keep it at room temperature before processing for at least 24 hours without opening the manufacturer's packing.

3.2. Food product packaging

Packaging of food products in the AMISTYLE CPE/CPP films shall be made in production rooms compliant with the requirements of the applicable food safety regulations and standards.

The sealable layer is located on the inner side of the film web (See Fig. 1 below).

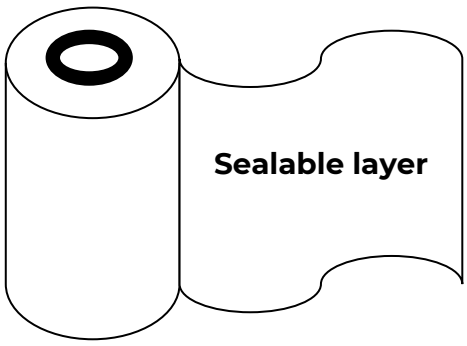

Fig. 1 – AMISTYLE film roll

Loading of the film in the automatic equipment must be made in accordance with the instructions of the equipment manufacturer and the loading procedure.

The process of packaging of food products in polymer trays with the use of the **AMISTYLE CPE/CPP** film comprises the following stages:

- placing of food in trays;
- evacuation of air from the trays and filling them with a mixture of gases;
- sealing of the trays with film and punching of the film along the tray outline.

The equipment setting (sealing temperature, sealing time, gas mixture quantity, etc.) should be selected on a case by case basis, since the equipment type and its technical condition, the characteristics of the selected trays, and the packaged product nature all have an effect of the packaging quality.

Film and trays should be compatible (have the same sealable layer) to achieve the 'lock' sealing.

When films and trays with differing sealing layers are selected, the use of certain conditions and adjustment of the sealing temperature and time make it possible to produce 'easy-to-open' packages.

To ensure compatibility of the films and trays, and to obtain the exact tear-off resistance, select the correct type of the **AMISTYLE** film based on the results of production tests.

When the inside-cut tray sealers are used, it is recommended to use the AMISTYLE CPE-40-M film.

3.3. Filling of trays with the product

The trays are filled with the product either manually or automatically. The product quantity must match the size and shape of the tray - the product level must be lower than the tray height. The filled trays are then moved to the seats of the sealing unit.

3.4. Evacuation of air from the trays and filling them with a mixture of gases

In accordance with the recommended procedure for evacuation of air from trays and filling them with a mixture of gases, the gas-to-product volume ratio should be from 1:1 to 1:2. To avoid deformation of the tray, the end pressure of the gas inside the tray should be close to the atmospheric

pressure (1000 mbar). To make the tray look convex, the gas pressure must be higher than the atmospheric pressure.

3.5. Sealing of the tray and punching of the film along the tray outline

To avoid loss of vacuum inside the package, the product must be kept away from the film and tray sealing zone. The product to be filled must be free of any sharp edges capable of piercing the package and compromising, with time, the product quality. The sealing temperature and time should be adjusted with regard to the condition of the equipment and the type of the selected trays.

During the operation, take care to maintain the film well-tensioned and completely covering the sealing area.

The seals must be even and continuous, bearing a clear imprint of the sealing bar, without any signs of burn-through.

The sealing temperature for the **AMISTYLE CPP** film varies within the range of 160 – 190 °C.

The sealing temperature for the **AMISTYLE CPE** film varies within the range of 130 – 170 °C.

If the sealing quality is unsatisfactory, check the temperature settings.

The sealing time varies within the range from 0.6 to 2 seconds, subject to proper operating condition of the equipment.

3.6. Transportation and storage of the products

The products packaged in the AMISTYLE CPE/CPP films shall be transported and stored in accordance with the standard documentation applicable to the product (GOST, TU).

4. APPENDICES

There are no appendices to the present document.

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