ATLANTIS-PAK

Leader In Innovative
Packaging Solutions

HEAT-SHRINK BAGS amivac

AMIVAC MBL

Process Operating Manual



© PCF ATLANTIS-PAK LLC

www.atlantis-pak.top
info@atlantis-pak.top

1. APPLICATION

The **AMIVAC MVL** heat shrink bags are medium barrier bags designed for vacuum packaging, storage and sale of sausages, specialties, unripened, soft and brine-ripened cheeses; and one-meal sliceware.

These bags are **not** intended for packaging of the following products:

- bone-in products;
- products in decorative coating with coarse inclusions;
- dry-salted products with salt crystals remaining on the surface;
- products with rough or sharp edges;

The **AMIVAC MVL** bags are made from multilayer tubular film consisting of polyamide, polyethylene and a modified polyolefin allowed for use under the appropriate certificates of conformity.

The **AMIVAC MVL** bags comply with the requirements of the Technical Regulation of the Customs Union TP TC 005/2011 (Safety of Packaging), as confirmed by the duly issued declaration of conformity.

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

1.1. Shelf life of meat products packaged in AMIVAC MVL bags

Table 1 – Shelf life of meat products packaged in **AMIVAC MVL** bags

Product name	Specified storage term	Reference document
Smoked-and-cooked pork products	40 days at the temperature from	GOST 18255-85
Cooked pork products	40 days at the temperature from	GOST 18236-85
Cooked sausages, top grade, 1st grade, 2nd grade	30 days for chubs. 20 days for sliced portions, at the temperature from	GOST R 52196-2003, section 7.5.
Frankfurters, top grade, 1st grade	20 days at the temperature from 0 °C to +6 °C	GOST R 52196-2003, section 7.7.
Wieners, 1st grade	20 days at the temperature from 0 °C to +6 °C	GOST R 52196-2003, section 7.8.
Špekáčky, top grade	20 days at the temperature from 0 °C to +6 °C	GOST R 52196-2003, section 7.8.
Boneless chilled beef cuts	25 days at the temperature from 0 °C to +4 °C	GOST R 52601-2006
Beef products (one-meal sliceware, whole pieces): cooked, cooked-and-smoked, smoked-and-cooked. smoked-and-baked	40 days at the temperature from +2 °C to +6 °C	TU 9213-406-00419779-03

1.2. Shelf life of cheeses packaged in AMIVAC MVL bags

Table 2 Shelf life of cheeses packaged in **AMIVAC MVL** bags

Product name	Specified storage term	Reference document
Suluguni A cheese	50 days at the temperature from +2 °C to +6 °C	Amendment No.2 of 10.10.2010 to TU 9225-147-04610209-2003
Sloisty A cheese	50 days at the temperature from +2 °C to +6 °C	Amendment No.2 of 10.10.2010 to TU 9225-149-04610209-2003
Adygeisky cheese	50 days at the temperature from +2 °C to +6 °C	Amendment No.1 to COLLECTION OF TYPE PROCESS INSTRUCTIONS on production of soft cheeses
Lubitelsky cheese Moale cheese Ostankinsky cheese Klinkovy cheese	25 days at the temperature from +2 °C to +6 °C	Amendment No.3 of 01.07.03 to OST 10-088-95 Soft Rennet Cheeses
Adygeisky Smoked cheese	70 days at the temperature from +2 °C to +6 °C	Amendment No.3 of 10.10.2010 to TU 9225-066-04610209-2002
Osetinsky Fresh cheese Stolovy Fresh cheese Stolovy Ripened cheese Imeretinsky cheese Karachaevsky cheese Brinzen cheese	50 days at the temperature from +2 °C to +6 °C	Amendment No.3 of 01.07.03 to OST 10-090-95 Brine-Ripened Rennet Cheeses
Semi-hard cheeses: Gollandsky Bar and Round, Kostromskoy, Yaroslavsky, Stepnoy, Estonsky, Uglichsky, Rossiysky, Rossiysky Young, Cheddar, Poshekhonsky, Gollandsky IT, Kostromskoy IT, Poshekhonsky IT (cheese shape– bar or wedge with a weight from 500g to 2500g)	Bars, wedges or slices with a weight from 25g to 500g inclusive, MAP packaged – 70 days	Amendment No.2 to TU 9225-129-04610209-2003
	Bars or wedges with a weight from 500g to 2500g inclusive, vacuum packaged - 90 days	
Packed cheeses	Bars, wedges, slices or gratings with a weight from 25g to 2500g inclusive, vacuum or MAP packaged - 25 days	
Packed blue cheeses	Bars, wedges or slices, vacuum packaged - 10 days	

2. CONSUMER PROPERTIES AND ADVANTAGES

2.1. Extended shelf life of the packaged products due to the high barrier to oxygen.

2.2. Zero moisture (weight) losses due to the low water vapor transmission rate.

2.3. Showcasing of the product in all its attractiveness to the buyer due to the excellent optical properties of the bag (transparency, gloss).

2.4. Sealability through folds and overlaps, which boosts productivity and reduces the re-packaging rate.

2.5. Guaranteed protection against unfavorable external effects throughout the specified shelf life, and high sanitary / hygienic characteristics of the bags due to the use of the separate protective packaging of the AMIVAC bags.

2.6. Disposal of the packaging is more environment-friendly due to the absence of chlorine-containing substances in the composition.

2.7. The AMIVAC bags are made using only the materials and raw stuffs approved for direct contact with food under the applicable laws of Russia, Ukraine, the Customs Union (Russia, Belorussia, Kazakhstan), the European Union, and the USA. This means that in case of export deliveries subject to local certification, it will not be a problem to obtain the permitting health safety documents for the AMIVAC bags.

3. HOW TO USE THE BAGS

3.1. Storage and transportation of the bags

3.1.1. The bags must be stored in closed dry and clean rooms, where the temperature is not higher than 35 °C, and the relative humidity is not more than 80 %.

3.1.2. During the storage and transportation the cases containing the bags should not be exposed to high temperatures (more than 35 °C) or direct sunlight.

3.1.3. Never drop the boxes containing the casings or subject them to impacts.

3.1.4. If the bags were stored at a temperature below 0 °C, keep them at room temperature for at least 24 hours before opening the manufacturer's packing.

3.1.5. The leftover bags should be re-packaged under vacuum into a new pack.

3.2. Selection of the required bag size

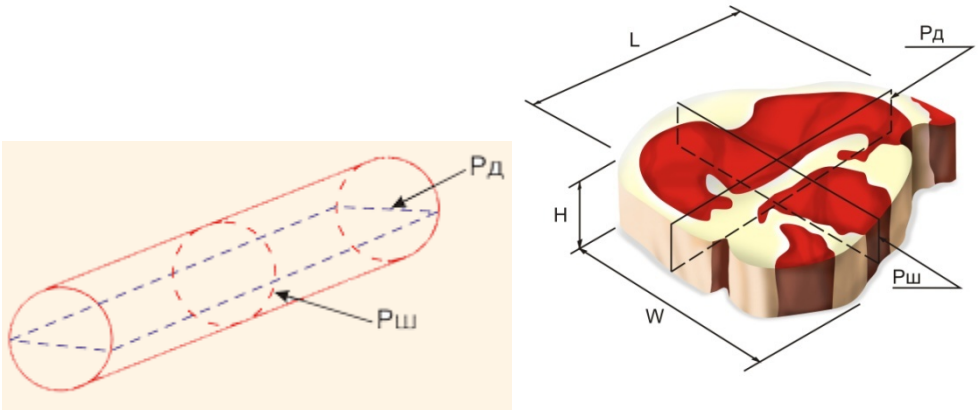
To determine the required width (S) of the bag, measure the perimeter of the product to be packaged at its widest part. Calculate the bag width by the formula:

Width = Perimeter of the product (at its widest part) x 0.55(mm)

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

Length = Perimeter of the product (at its longest part) / 2 +80 (100)mm

If the bag will be closed by clipping, add **100**mm to the calculated bag length value.



a. b.

Fig. 1 – Determination of the product size

where $P_ш$ is the perimeter of the product at its widest part;
$P_д$ is the perimeter of the product at its longest part.

3.3. Preparation of the bags for use

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

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

3.4. Packaging

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

Packaging of the product will be performed by means of special equipment (vacuum packaging machines, clippers). Observe the operating modes recommended by the manufacturer of the packaging equipment to ensure a stable packaging process.

If there is no operating manual for the equipment, comply with the following instructions:

3.4.1. Packaging on chamber-type machines:

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

- Put the bag containing the product in the vacuuming zone. The product inside the bag should be as close to the heat-sealing bar as possible (see Fig. 2), to improve the appearance and ensure the tight envelopment of the product.

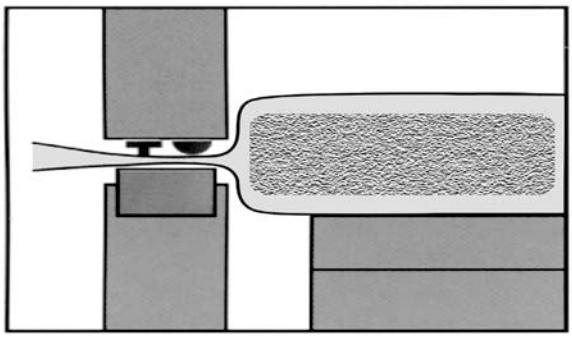


Fig. 2 – Heat-sealing zone

- Select the vacuum depth. The vacuum depth is adjusted depending on the 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, the vacuum depth must be reduced (the higher is the moisture content, the less is the vacuum depth value).

- 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 adjustment is necessary, it will take a period of 5-10 minutes, and 1-3 bags).

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

- Evacuate the bag and heat-seal by closing the lid of the vacuum packaging equipment.

- After heat-sealing, the joint must be continuous and must show the imprint of the sealing bar of the packaging machine.

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

> **Note**: Package soft and brine-ripened cheeses in accordance with the Process Instruction on the use of Amivac bags for production of soft and brine-ripened cheeses, approved by the Federal Consumer Rights and Human Well-Being Supervision Agency on 20 June 2005.

3.5. Heat shrinkage

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

Heat shrinkage will be performed by immersion of the bag with the product in hot water or by sprinkling with hot water (or steam treatment) at the temperature from 90 °C to 95 °C during 2-3 seconds.

It is recommended to observe the scheduled maintenance plan for washing and sanitizing of the equipment.

3.6. Storage and transportation of products packaged in AMIVAC MVL bags

It is recommended to transfer the packaged products to a cold store with a temperature not higher than 6°C, not later than 20 minutes after packaging.

> **Note**: Ripen and store soft and brine-ripened cheeses in accordance with the Process Instruction on the use of Amivac bags for production of soft and brine-ripened cheeses, approved by the Federal Consumer Rights and Human Well-Being Supervision Agency on 20 June 2005.

4. APPENDICES

There are no appendices to the present document.

ATLANTIS-PAK

PCF ATLANTIS-PAK LLC
Address: 72 Onuchkina str., village of Lenin,
Aksay district, Rostov region,
346703 Russian Federation
Phones: +7 863 255-85-85 / +7 863 261-85-80
Fax: +7 863 261-85-79
www.atlantis-pak.top
info@atlantis-pak.top

Download on the App Store

GET IT ON Google Play