



ATLANTIS-PAK

Leader In Innovative
Packaging Solutions

Casings *iCel* iCel

Process Operating Manual



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



1. APPLICATION

The **iCel** casing is designed for production, packaging, storage and sale of cooked sausages and hams, cooked-and-smoked, semi-smoked, semidry and dry sausages, wieners, hot dogs and sausage-shaped processed cheeses.

See Table 1 of this Manual for a detailed description of the types of **iCel** casing.

2. PRODUCT ADVANTAGES

2.1. Advantages of the casing

2.1.1. The **smoke-permeable iCel** casing allows roasting and smoking, which imparts to the products the pleasant traditional taste and flavor of smoke, and contributes to the formation of the coagulated protein crust and glossy surface of the product under the casing.

2.1.2. The **high mechanical strength** of the **iCel** casings makes it possible to use high-capacity automatic and semi-automatic clippers to ensure a high production speed and stuffing stability.

2.1.3. The **high elasticity** makes it possible to overfill the **iCel** casing by up to 14% (all types except for the iCel Beef Bung-Mko-E).

2.1.4. The **high oxygen barrier** compared with collagen and viscose-reinforced casings provides for the following advantages:

- reduction of oxidation processes, in particular, rancidification of fats;
- preservation of the individual flavor of spices in the finished products throughout the shelf life, regardless of whether secondary packaging is used.

2.1.5. The **high heat resistance** of the polymers used for production of the **iCel** casing significantly extends the temperature range of utilization in comparison with cellulose casings. The casing is not only stable at high smoking temperatures (up to 75-85 °C), but also resistant to a prolonged effect of such temperatures.

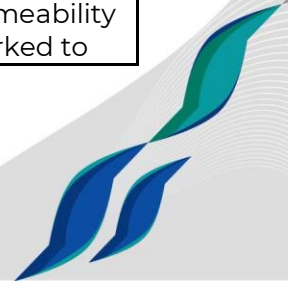
2.1.6. The **microbiological resistance** is due to the use, for production of the **iCel** casing, of polymers impervious to bacteria and mold fungi. This improves the hygienic characteristics of both the casing, and the finished products.

3. ASSORTMENT OF PRODUCTS

See Table 1 for the basic characteristics of the **iCel** casing by types.

Table 1

Casing description and type	Casing caliber, mm	Characteristics
iCel M	30 - 90	Opaque sausage casing with good permeability
iCel Mko (EU)	30 - 80	Curved sausage casing; in other respects similar to iCel M
iCel S	30 - 90	Glossy sausage casing with good permeability
iCel Beef Bung-Mko-E	65 - 80	Curved opaque casing with good permeability for cooked sausages and hams; marked to



		imitate natural bung
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*casing of bespoke calibers can be supplied

The **iCel** casing is supplied with different types of adhesion for different food groups (the following casing types are available):

- iCel S – standard adhesion
- iCel M-E – high adhesion
- iCel S-SE – super-high adhesion
- iCel Mko-EU-E – high adhesion.

- The following casing versions are recommended for semidry sausages, depending on the sausage grade and type: High Adhesion or Super-High Adhesion;

- The following casing versions are recommended for cooked sausages and hams: Standard Adhesion or High Adhesion;

- The following casing versions are recommended for semi-smoked and cooked-and-smoked sausages: High Adhesion or Super-High Adhesion;

- The following casing version is recommended for sausages stuffed with fatty batter: Super-High Adhesion.

Colors of the **iCel** line of casings: white, clear, claret, cherry, smoke, brown, red orange, salmon, mahogany, orange, light brown, dark brown, except for the iCel Bung-Mko-U supplied clear only.

The color range of the casing is subject to change.

The **iCel** line of casings is suitable for single- or double-side printing. The number of print colors varies from 1 to 6. CMYK printing is also possible.

The curved **iCel** casings can be printed on the inner, the outer or the lateral part of the ring; the customer's order should specify the location of the print.

The **iCel Beef Bung-Mko-E** casing is marked with double-side multicolor printing with permeable inks to imitate the pattern of natural bung.

The location of printing on the **iCel Beef Bung-Mko-E** casing is not specified.

The **iCel** products are supplied in the form of:

- reels with carton cores, straight casings are 500 m ± 2%, 1000 m ± 2%, ring-shaped casings are from 100 to 1000 m ± 2%.
- 'sticks' of shirred casing, each stick containing 38, 50 or 62 m of casing (25 or 31 m in the case of ring-shaped casings).

Orders are also accepted for the following options:

- shirring: sticks with a loop under the rear clip; bespoke stick or casing length.

4. HOW TO USE THE CASING

4.1. Storage and transportation of casing

4.1.1. The casing must be stored in its original packing in closed dry and clean rooms conforming to the sanitary/hygienic standards for the particular sector of the food industry, at a distance of no less than 80 cm from any heaters, in the



absence of strong-smelling or corrosive substances, at a temperature from 5 °C to 35 °C, and the air relative humidity not exceeding 80%.

4.1.2. It is recommended to protect the casing at storage and during transportation against exposure to direct sunlight or high temperatures.

4.1.3. It is recommended to open the manufacturer's packing just before processing of the casing. If the integrity of the manufacturer's packing is compromised during the storage, protect the casing from drying out and the resulting adhesion and ruptures during the eventual processing (proceed with re-packing of the product)

4.1.4. If the casing was stored at a subzero temperature, then prior to use hold it in its original packing at room temperature during no less than 24 hours.

4.1.5. Never drop the boxes with casings or subject them to impacts.

4.2. Preparation of the casing for processing

Preparation of the casings of the **iCel** line consists in the following:

Bring the casing (in the permitted packaging) from the store to the production room and put it on a dry surface (floor, table), then open just before the processing.

Soak in potable water at the temperature of 20-25 °C. Do not use hot water for soaking, otherwise the casing may shrink even at soaking.

Casing supplied in reels should be cut into sections of required length before soaking. When sticks of shirred **iCel** casing are used, take care to keep the sticks completely underwater. Water must freely penetrate inside the sticks, driving out the air.

Pre-soak the casing for 1-2 minutes ***just before stuffing and forming***.

After pre-soaking, drain the residual water from the tube and put the casing over the stuffing horn.

The casing has a high elasticity, which substantially facilitates the process of stuffing and provides for uniform filling of the chub along its entire length.

4.3. Preparation of the forcemeat

When cooked sausages or hams, semi-smoked or cooked-and-smoked sausages are made with the use of the **iCel** casing, the moisture content should be selected on a case-by-case basis.

When new recipes are developed according to the regulatory documentation (specifications), the quantity of the added water should be determined with regard to the moisture-retaining properties of the gelling agents used (such as carrageenans, plant proteins, animal proteins, milk proteins, etc.), and the relevant instructions on use must be followed to avoid formation of water and fat pockets.

4.4. Forming of sausages

Forming of the **iCel** casings should start with inspection of the equipment and the work table.



To prevent any damage to the casing, make sure that there are no burrs on the equipment parts, or sharp objects, indentations, or rough areas on the working surface of the table.

Avoid any friction of the end parts of the reel against various uneven surfaces in the processing of the casing.

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

An important factor is the ratio between the stuffed caliber and the nominal caliber of the casing.

The **iCel** casing should be stuffed with 10-12% overfilling rate. The **iCel Beef Bung-Mko-E** should be stuffed with 35-45% overfilling rate. Compliance with the recommended stuffed caliber ensures a good appearance of the finished products, increases the stuffing capacity, and reduces the risk of water and fat pockets.

To make the products in the **iCel Beef Bung-Mko-E** look more 'natural', we recommend dyeing of the casing or the product with natural colorants, such as Annatto or Annatto + caramel, etc.

When sausage chubs are tied manually, pay special attention to the twine material; if it contains hard inclusions, **pre-soak the twine** to avoid damaging the casing. When the **iCel Beef Bung-Mko-E** casing is used, it is recommended to imitate the natural bung by looping the twine at certain intervals.

The curved **iCel Mko** casings can be used on automatic or semi-automatic clippers. Such clippers must be equipped with a string feeder and a special receiver tray for the sausage rings. The string length between the sausage ends is adjusted on the string feeder.

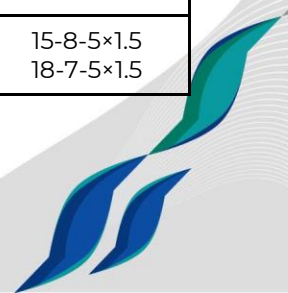
If no string feeder is supplied with the equipment, this should not be an obstacle to the use of the curved casings. The string can be fed manually. When manual clippers are used, the string is fed into the clipper working zone from the side of the stick of shirred casing and clipped together with the casing. When the casing is put over the horn, it must be positioned in such a way as to prevent the resulting rings twisting into the working parts of the clipper, and to guide them into the receiver tray.

The clip used must securely hold the ends of the chub, without damaging the casing (see Table 2).

Recommended clip types

Table 2

Caliber	POLY-CLIP			TECHNOPACK		COMPO	ALPINA
	Clip interval 15 interval 18	R-ID	Clip series S	Clip series E	Clip series G	Clip series B	Clip interval 15 interval 18
30-65	15-7-4×1.25 15-7-5×1.5 15-7-5×1.75 18-7-5×1.5 18-7-5×1.75	M08-175 M07-150 M07-200 L07-175 L08-200	524 528 625 628	210 410	175 370	B1 BP1	15-7-5×1.5 15-7-5×1.75 18-7-5×1.5 18-7-5×1.75
66-90	15-8-5×1.5 18-7-5×1.5	L07-150 L08-175	632	212 220	175 200	B2 BP2	15-8-5×1.5 18-7-5×1.5



	18-7-5×1.75	L08-200 L09-200		222 410	370		18-7-5×1.75
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4.5. Thermal processing

Thermal processing of all types of semi-smoked and cooked-and-smoked sausages in the **iCel** casings produced with the use of technologies that involve smoking (smoke roasting) is performed in universal heat chambers.

The manufacturers should choose their individual thermal processing modes, because the equipment capacity is all-important in this process.

We recommend the classical thermal processing, which includes the stages of settling (4 -12 hrs), reddening (heating of the product), drying (color formation), smoking, and cooking.

Heating should start at a temperature of 50 - 55 °C. As the drying cycle progresses, the temperature is gradually raised to 60 - 65 °C. At this stage coagulation of the emulsion proteins occurs, and the 'protein crust' is formed.

The next stage is smoking at a temperature of about 70 - 75 °C. At this stage the crust is consolidated and colored with the smoke components.

Then the product is cooked at the air humidity of 100% and temperature of 75 - 80 °C until ready for consumption.

After completion of the cooking process, it is recommended to carry out a short drying during 5-10 minutes at the temperature of 65 °C.

The process of drying and smoking significantly influences the quality of the finished product. By adjusting the temperature, the smoking moisture content, and the duration of these stages, the thermal processing weight losses, the crust thickness, the color and the taste of the product can be controlled.

The best thermal processing conditions are achieved when programmable units are used for drying, smoking, cooking and cooling.

4.6. Cooling

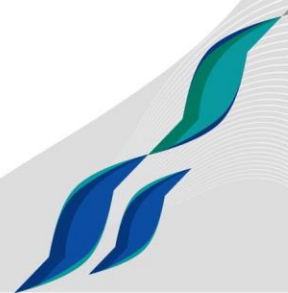
Upon completion of the thermal processing, the products in the **iCel** casing must be immediately cooled. Cooling can be carried out under running water or shower, or by means of time-delayed sprayers, or in universal cooling chambers until the chub core temperature is down to 25 - 35 °C.

Cold air cooling is not allowed. Avoid any exposure of the finished products to air draughts until completely cooled, otherwise the surface may become wrinkled.

5. MANUFACTURER'S GUARANTEES

The Manufacturer guarantees conformity of the casing with the specifications subject to compliance with the required conditions of transportation and storage at the user's warehouse.

The guaranteed term of storage of the casing is 2 years from the date of manufacture, subject to integrity of the manufacturer's packing.





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

