



**ATLANTIS-PAK**

Leader In Innovative  
Packaging Solutions

**HEAT-SHRINK BAGS**



# AMIVAC MBC

Process Operating Manual



## 1. APPLICATION

The **AMIVAC MBC** barrier heat-shrink bags are designed for vacuum packaging, storage, sale, and cooking in ovens of meat products. The production, use, storage, and transportation of the bags do not harm the environment or the human health.

### 1. PROPERTIES AND ADVANTAGES OF THE PRODUCTS

**2.1. High oxygen and water vapor characteristics** provide for long-term storage of the products, whereby the product's weight and its sensory characteristics are preserved until consumption.

**2.2. High heat resistance** makes it possible to cook the products at temperatures of up to 190°C inclusive.

**2.3. High strength of the bags** excludes the risk of damage of the product's packaging during transportation, storage, and cooking.

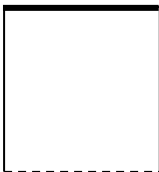
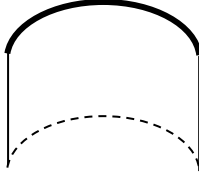
**2.4. Individual protective packaging** of the AMIVAC bag packs ensures protection against adverse outside impacts throughout the guaranteed shelf life, and provides for the high sanitary and hygienic level of the bags.

**2.5. High transparency** provides for showcasing of the packaged product in shops.

### 3. ASSORTMENT OF THE PRODUCTS

The assortment of the **AMIVAC MBC** bags is shown in Table 1

Table 1

	Seals	
	Straight	Semi-circular
Bag width	200- 450 mm	200 – 450 mm
Bag length	100*-1200 mm	100*-1200 mm
Appearance		
Pasting on tape	Optional	Optional

Bespoke bag sizes can be supplied to the customers' specifications.

\*From 300 mm when paste on a tape

**Bag colors:** clear

**Printing:** The **AMIVAC MBC** bags are not printed

**Forms of supply:**

- rolls without perforation;
- pasted on two tapes (for automatic equipment);
- cut into separate bags inside 100-pc transportation packs.

## **4. HOW TO USE THE ANIVAC MVS BAGS**

### **4.1. Storage and transportation**

**4.1.1.** The bags must be stored in closed dry and clean rooms at a temperature not exceeding 35°C, with a relative humidity of not more than 80%.

**4.1.2.** In the course of storage and transportation, do not expose the boxes containing the bags to high temperatures (more than 35°C) or direct sunlight.

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

**4.1.4.** If the bags were transported at a temperature below 0°C, hold them at room temperature for at least 24 hours prior to opening of the manufacturer's packing and use.

**4.1.5.** Any leftover bags should be repackaged under vacuum into a new pack.

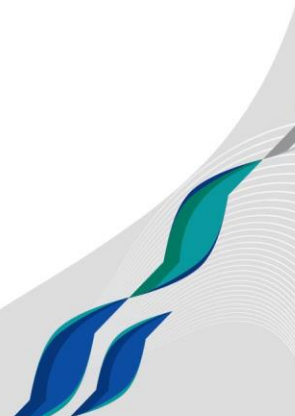
### **4.2. Selection of the required bag size**

To determine the required width (S) of the bag, measure the perimeter of the product to be packaged in its widest part, multiplied by 0.55 and add 30%. Calculate the bag width by the formula:

*Width = Perimeter of the product (in its widest part)\*0,55 + 30%.*

To determine the required length (L) 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  
+100mm.*



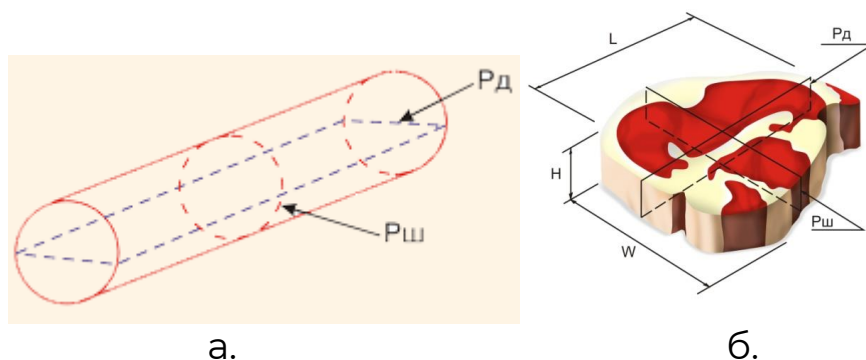


Fig.1

where  $P_{ш}$  – perimeter of the product in its widest part;  
 $P_{д}$  – perimeter of the product in its longest part.

### 4.3. Preparation of the bags for processing

The packs containing the bags should be opened immediately before use. If there is no transportation packing remaining, any leftover bags should be repackaged into a new pack under vacuum.

Do not let water contact the bags before the packaging process is completed.

### 4.4. Packaging

Packaging of the products is made by means of special equipment (vacuum packaging machines). Observe the manufacturer-recommended operating mode of the packaging equipment to provide for a stable packaging process.

If there is no operating manual for the equipment, proceed with the following recommended operating mode:

#### 4.4.1. For chamber 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 product into the bag. The product may be already pickled or spiced, or the brine or spices may be added directly into the bag before sealing.
- Place the bag containing the product into the vacuum zone. The product inside the bag should not be too close to the sealing bar (Fig.2) to allow for the eventual expansion during the cooking.



Fig.2

- Avoid any bag folds on the bar to prevent subsequent loss of vacuum (Fig. 3).

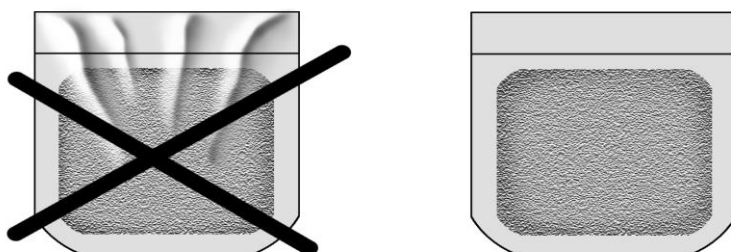


Fig.3

-Select the vacuum depth. The vacuum depth is adjusted depending on product to be packaged. The vacuum depth is 95%-98% (residual pressure about 4.9 kPa).

-Select the mean sealing time. Increase or decrease the sealing time to achieve the best seal formation mode, as the bags are consumed (the mean sealing time for the **AMIVAC MBC** is about the double of that required for the standard vacuum bags 50µm thick).

-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 cutoff part of the bag.

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

-The heat sealing should yield a continuous seal with an imprint of the sealing bar of the packaging equipment.

If the package sealing is lost, the product must be returned for repackaging. Failed bags may not be reused.

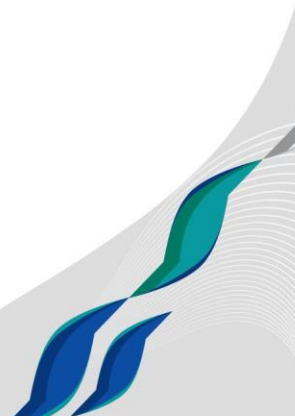
#### **4.5. Recommended cooking of products**

Put the closed (sealed) bag containing the product into an oven for 15-30 minutes to pre-heat it at a temperature of 180-190<sup>0</sup>C, then make a cut from above (better several cuts - to provide for a golden crust) (see an example of the pattern of such cuts in Appendix 1), and cook for about 1 hour until ready for consumption.

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

**5.1.** The Manufacturer guarantees conformity of the **AMIVAC MBC** bags with the requirements of the Specifications subject to compliance with the conditions for transportation and storage at the user's warehouses, and integrity of the original packing.

**5.2.** The guaranteed shelf life of the bags is 1 year from manufacture.



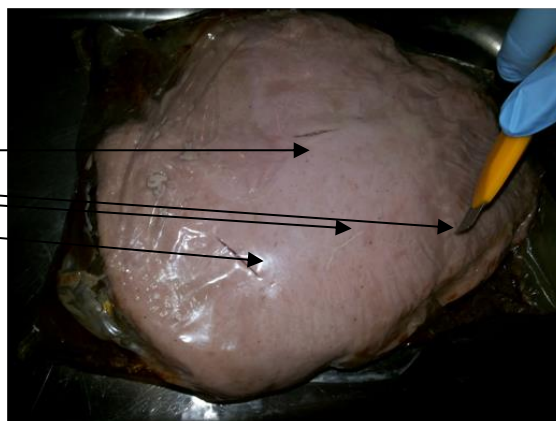
## 6. APPENDICE

### Appendix 1

The pattern of cuts on the bag to be made before the second cooking stage



HOLES



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