SiS

Seal-it-Systems

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16th September 2008

Ref: Technical visit (11/09/08)

Please fine below a summary of last weeks visit

Machine profile:

M/C No,1 – *********
2 lane linear
Beaded sealing heads with self levelling
4x foil location pins
Speed @ 24 cpm

Excellent seal with good 'central' bead impression (no reported issues)

M/C No,2 – **********
4 lane linear
Beaded sealing heads with self levelling (bead NOT central on rim)
Heat seal temp – set temp @ 360°C actual measured temp @ 233 to 246°C
4x foil location pins
Speed @ 30 cpm

Reported to have a high level of leakers. Leakers seen during visit (small sections with NO contact – e.g. no melt down)

M/C No,3 – ********
6 lane linear
Beaded sealing heads with self levelling (high level of flex on both slat & heat seal bracket)
4x foil location pins (pins made from M6 cap screw with washers as spacers)
Speed @ 28 cpm

Good 'central' bead impression bead (reported to have a leakers. Leakers seen during visit (small to medium sections with NO contact – e.g. no melt down)

Critical dimensions:

Machine	Head Ø	Cup ring (slat) Ø
	70.80	64.40
	71.35	64.75
	71.00	65.40

Conclusion:

The ******** machine is running well on the 'new' polypropylene (PP) pots. This machine runs slightly slower than m/c No. 2 & 3 although the set-up is in theory the same (e.g. sealing bead, location pins, fill, etc) –No further action is required

Leakers have been identified on both the ******* and ******* machines. The nature of the leakers appear to be the same and the 'corrective action' is therefore similar (see below)

Action:

******* - a) Check track position in relationship to eject pads
b) Check/set heat seal position to ensure that heat seal face is concentric to the cup and not contacting the location pins (SIS recommends making a setting block)
c) Ensure heat seal block is 'square' to track
d) Ensure that the DOME on the self level is sufficient
e) Produce NEW seal faces as per SIS drawing (sent by email 12/09/08 & attached)
f) Work to maintain set temp of 360°C for PP pots (current procedure for PP pots is to increase temp to 380°C

******* - a) Check track position in relationship to eject pads
b) Check/set heat seal position to ensure that heat seal face is concentric to the cup and not contacting the location pins (SIS recommends making a setting block)
c) Produce NEW seal faces as per SIS drawing (sent by email 12/09/08 & attached)
d) Replace ALL location pins with new pins and reduce diameter – e.g. – 0.50mm (this is to increase the overall clearance between the sealing face and pins)

The above actions are all based on ensuring that the heat seal face is concentric to the cup when sealing and that the heat seal head does not contact the location pins as this will lead to poor seals

Seal-it-Systems are able to supply and manufacture sealing heads, etc for both the Lintrack & Colunio (sample or dwg required) as well as offering further on-site assistance if required – SIS rates are £37.50 per hour + travel

Best regards,

Paul Whelan