



ATLANTIS-PAK

Leader In Innovative
Packaging Solutions

Films **AMISTYLE**

AMISTYLE BP/CP

FOR FLOW PACK WRAPPERS

Process Operating Manual



1. APPLICATION

This Process Operating Manual describes the procedure for packaging of food products with the use of the **AMISTYLE CP** and **AMISTYLE BP** films.

AMISTYLE CP/BP are multilayer 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 CP/BP** films are manufactured according to Specifications TU 22.21.30-052-27147091-2012 and are intended for packaging of various food products (meat-based food, chilled and frozen meat, chilled and frozen poultry, sausages and specialties, chilled and frozen fish, cheeses and cheese-based products) in order to prolong the shelf life.

The **AMISTYLE CP/BP** films are designed for use on high-capacity horizontal or vertical packaging machines, and are suitable for both individual and group packaging.

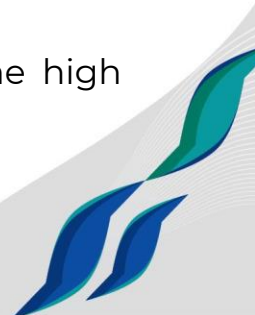
The shelf life of the food products packaged in the **AMISTYLE CP/BP** films shall be set by the manufacturers and approved following the procedure stipulated by the laws.

See Specifications TU 22.21.30-052-27147091-2012 and the Product Specifications for the technical data, assortment, forms of supply, additional processing options, storage conditions and shelf life of the **AMISTYLE CP/BP** film.

2. PROPERTIES AND ADVANTAGES

The combination of different polymer materials in the structure of the **AMISTYLE CP/BP** films provide for:

- excellent sealability within a wide range of temperatures, and tightness of the packaging to protect the product against the external factors;
- high strength to preserve the integrity of the packaged products at the stages of transportation and storage;
- attractive appearance of the packaged products due to the high transparency and gloss;



- high barrier to oxygen and water vapor, which ensures a prolonged shelf life.

Thus, the combination of different polymer materials in the film structure provides for good preservation of the products and their extended shelf life, and makes it possible to package food products of various sizes and shapes on high-capacity automatic equipment.

The absence of chlorine-containing substances, adhesive layers or interlayer printing makes the **AMISTYLE** films more environment-friendly, because the disposal of such films is less harmful for the environment.

3. PROCESSING TECHNOLOGY

3.1. Preparation of the film

3.1.1. If the film was stored at a temperature below zero, 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 CP/BP** films shall be made in production rooms meeting the requirements of the applicable food safety regulations and standards.

The Flow Pack process consists in automatic forming of a tight bag from the **AMISTYLE CP/BP** film around the product by heat-sealing of the film after filling of the bag with a modified atmosphere.

To ensure stability of the packaging process, observe the manufacturer-recommended operating modes for the packaging equipment.

The Flow Pack process includes the following stages:

- using the film to form a bag with a size sufficient to hold the product;
- heat-sealing of the package;
- cutting (separation of the packages from one another).

3.3. Forming and sealing of packages

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



The **AMISTYLE CP/BP** films have a heat-sealable polyethylene (PE) layer on the inner side of the film web (See Fig. 1. in this Process Operating Manual).

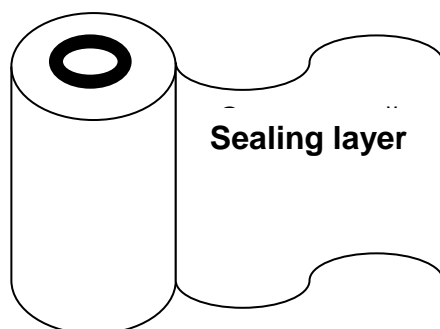


Fig. 1 – AMISTYLE film roll

The products are placed, manually or automatically, on the conveyor belt carrying the products to the **AMISTYLE** film in the forming zone of the forming machine. Make sure that the product size matches the film width. Take care to exclude any product getting into the film heat-sealing zone, otherwise the package may become unsealed.

Take care to maintain the film well-tensioned during the operation.

The equipment settings (sealing temperature, packages per minute rate, etc.) shall be selected on a case-by-case basis.

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

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

The sealing temperature for the **AMISTYLE** film varies, depending on the product size and shape, the equipment capacity, and the film thickness, within the range of 130 to 190 °C (on the sealing rollers and sealing bars).

The sealing bar contact time is 1-2 seconds.

Keep the sealing zone clean, avoiding any foreign inclusions or burnt-through areas on the protective coating of the heating element.

When a modified atmosphere is used, preset the gas quantity at the sealing station.

Use tightness testers to check the packages for eventual leaks.

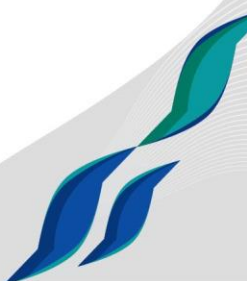
The packaged product is then dispatched for weighing, labeling and storage.

3.4. Transportation and storage of products

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

4. APPENDICES

This document contains no appendices.





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