FORMING TUBE ASSEMBLIES AND INNO–LOK™ FILM

INTRODUCTION

When running Inno–Lok™ film on a vertical form, fill, seal machine, difficulties may arise in pulling the zipper through the forming tube assembly (FTA).

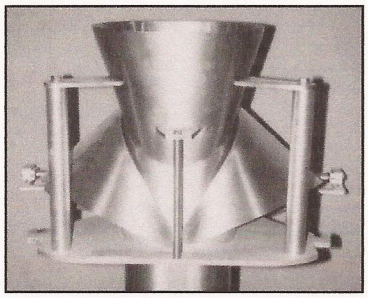

Figure 1 – Forming Tube Assembly (FTA)

This is usually due to the amount (or lack) of clearance in the assembly, which can vary greatly depending upon the manufacturer of the assembly. In many cases, the FTA can be adjusted enough to pull the zipper through. In extreme cases, a new assembly may need to be purchased.

FTA CONSTRUCTION

FTAs are comprised of two main components, the forming tube, and the forming collar. Figure 2 shows a disassembled FTA.

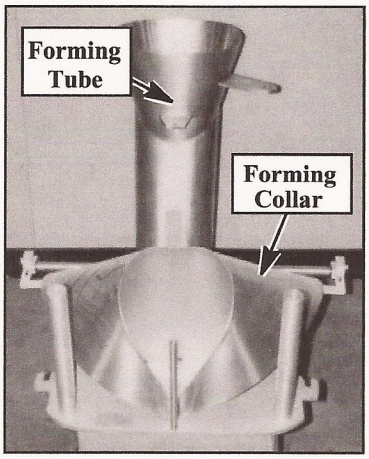

Figure 2 – Disassembled FTA

FTA CLEARANCE

When difficulties arise in pulling Inno–Lok™ film through a FTA, it is usually because there is not enough clearance between the back of the tube and the collar (Figure 3).

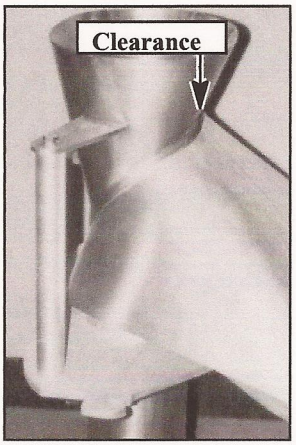

Figure 3 – FTA Tube/Collar Clearance

ADJUSTMENTS

FTAs can sometimes be adjusted to increase the clearance between the tube and the collar. To adjust:

1. Support the bottom plate (see Figure 4) of the FTA and allow the tube to hang free of any interference.
2. Loosen the three bolts that hold the tube and collar together.
3. Move the tube toward the front of the collar, leaving just enough room between the collar and the *front* of the tube to pull the film through.
4. Tighten the bolts.

NOTE: You may need to repeat these steps several times, since the tube tends to move as the bolts are tightened. It sometimes helps to place wedges (cardboard, screwdriver blades, etc.) between the tube and bottom plate to hold the tube stationary as the bolts are tightened.

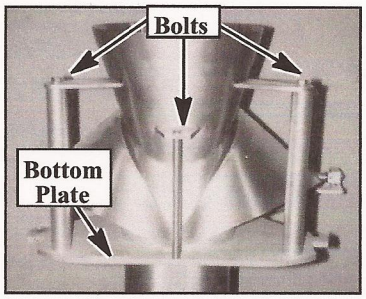

Figure 4 – Forming Tube Assembly (FTA)

If enough clearance cannot be gained by this adjustment (approximately .120"/3mm is recommended), a new FTA with a slightly undersized tube is needed.