

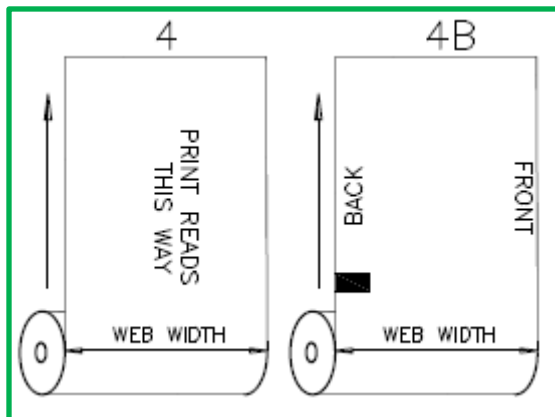
Atlapac Pouch Converting Preferences and Requirements

We appreciate the opportunity to service your pouch converting needs. We would like to detail some of the general film attributes and product specifications that we would like to see to help insure successful pouch converting.

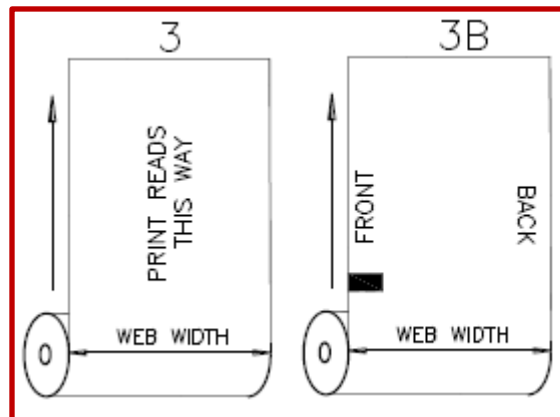
Film

- **Wind**

- We prefer to have the sealant layer wound “in”. This helps keep the sealant layer clean during the entire bag making process and makes film identification much easier. If winding the sealant layer in is not possible we have the ability to run film where it is wound out.
- When running printed film each machine has a Photo Eye that reads each impression with regard to repeat length. Many times we can “trip” off of a printed element on the bag, but the majority of the time we need an “eyemark” to trip off of. It is important that the eyemark is on the correct side of the web with respect to how the film is wound. Please see the diagrams below:




We would prefer film be wound as a #4 (with respect to the front panel). Locate the eyemark as shown in 4B.



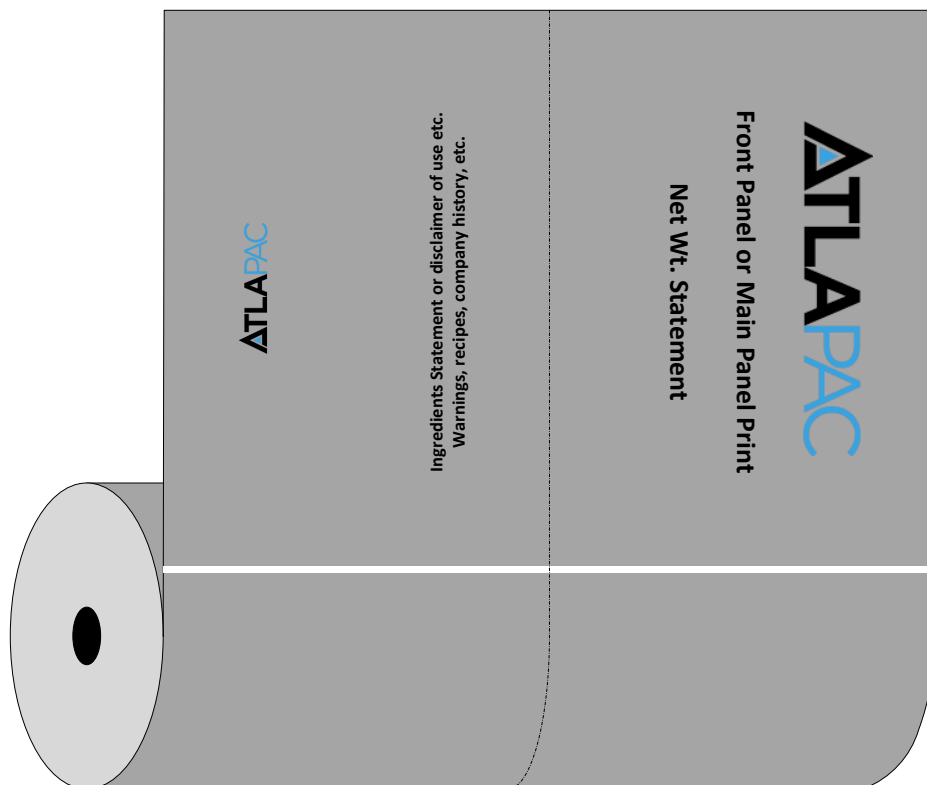
A #3 (with respect to the front panel) will work as well; however it will require the eyemark to be placed on the front panel as shown in 3B.

Either of these unwinds will insure that the eyemark will be readable to the Photo Eye.


- No micro-dots, logos, or markings of any kind may be in the eyemark track area.

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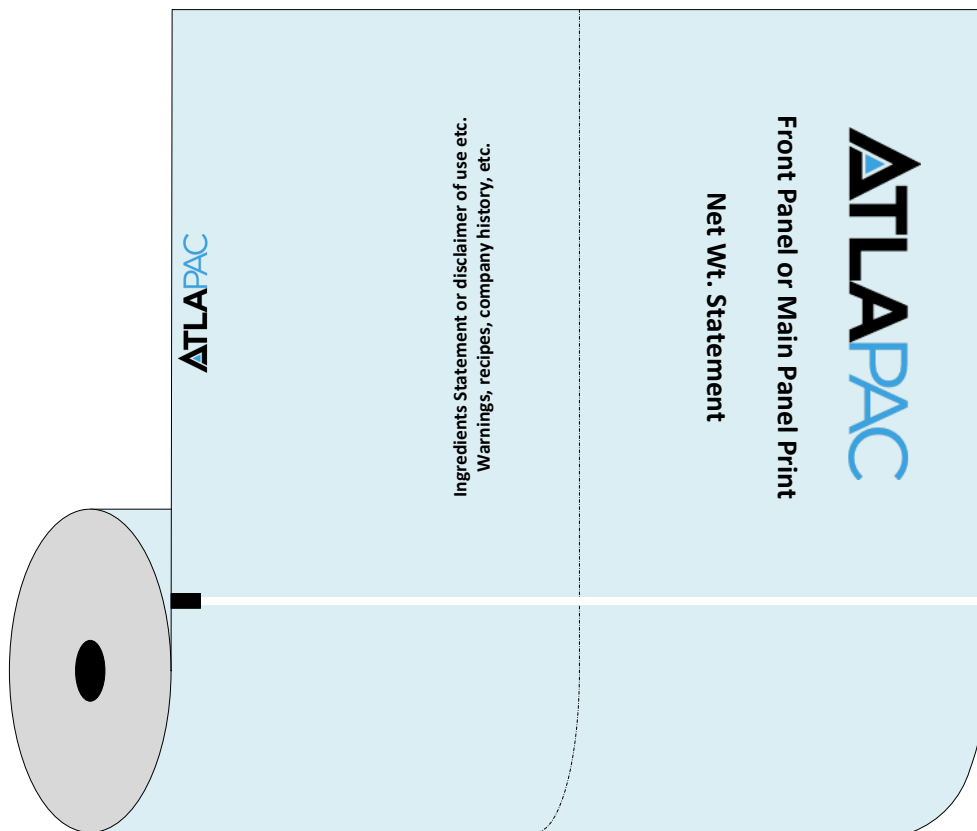
- Consult with Atlapac before you send in printed film. Written approval is required.
- Minimum eyemark size is 1/8" x 1/2". Eyemark color should contrast from the background color of the film web.
- **Tripping off an eyemark or the plate break**
 - We can trip off the plate break between impressions provided that:
 - There is sufficient contrast between the print and the plate break color.
 - There is a clear lane where the eyemark will be able to pick up the break without having other print or elements that interfere with the eye's ability to see that contrast. (see below).



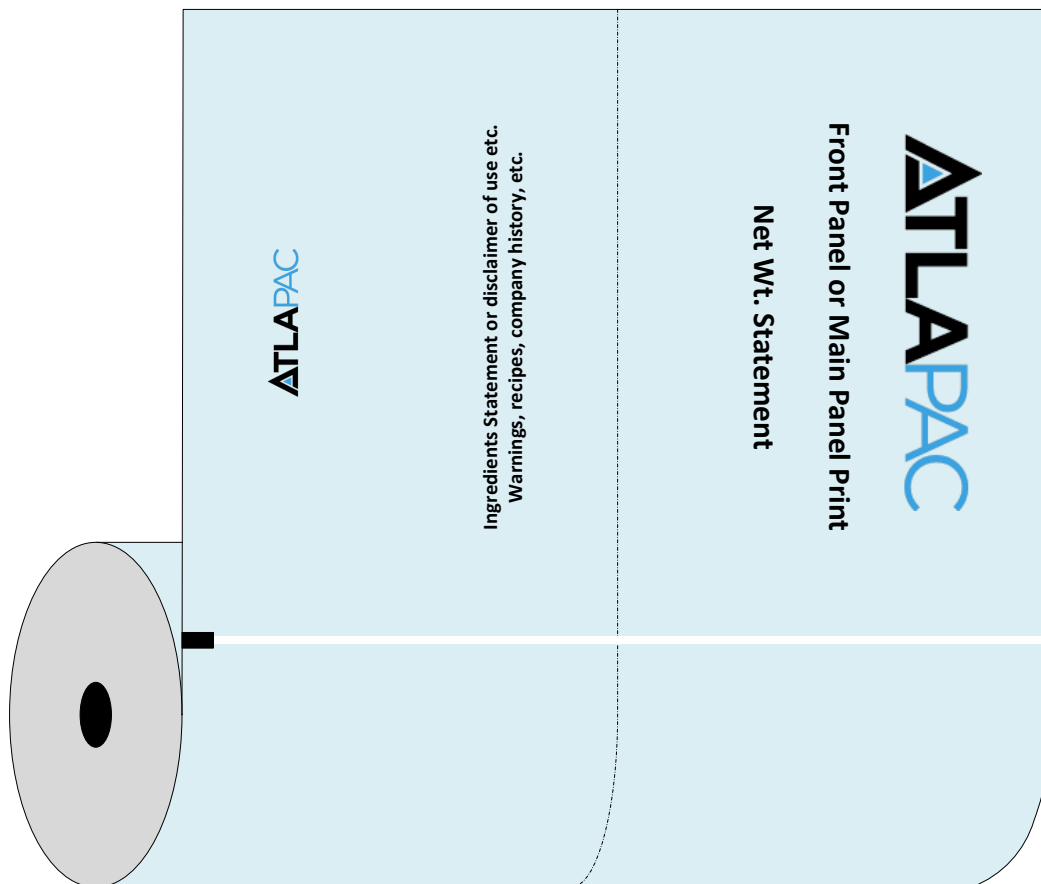
In the figure above, the contrast between the white plate break and the print is such that the eye can distinguish that contrast and trigger at the correct intervals. Additionally, there are ample spots along the width of the film (on the left side of the dashed line) where there is no interfering print that will confuse the eye from impression to impression.

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- The plate is stepped so that the breaks in between impressions are even. Uneven breaks will cause problems with the eye and the film will not run correctly.
- If there is not sufficient contrast between the plate break and the print (such as white film with printed text and no obvious element in the print that could trigger the eye without any other printed element occupying the same path). See the examples below.



In the example above, the eyemark is placed in line with other print that could cause the eye to not trip at the proper interval. Additionally, the contrast between the light blue background and the white plate break will not offer a sufficient contrast to allow the eye to trigger.



In the example above, the rear panel logo has been moved down so that there is a clear lane from eyemark to eyemark. This will allow the eye to trigger at the proper interval.

- **Roll diameters and core sizes:**
 - Maximum Roll OD: 23"
 - Minimum Roll OD: 20" (not including end of run butt rolls).
 - Core sizes: 3" (preferred) and 6".
- **Slip (COF) – Slip is the #1 technical film attribute related to finished pouch tolerances and our ability correctly meet the stated pouch specifications.**
 - Too low of a slip level can cause problems by not allowing the film to freely flow through a pouch machine. Film can bind up at certain points on a machine, which can lead to the film stretching or problems holding registration.
 - Too high of a slip level can cause problems by allowing the film to move too much, which can lead to problems with front to back registration and other alignment issues.



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- Atlapac has found that COF levels between 0.2 and 0.35 work well with our equipment. Slip levels outside of this range may cause some converting issues that could range from excessive scrap to an inability to convert the film.

Slip Level/COF Chart

Low Slip	COF greater than 0.4
Medium Slip	COF between 0.25 – 0.39
High Slip	COF less than 0.25
Preferred Slip Level	COF between 0.2 – 0.35

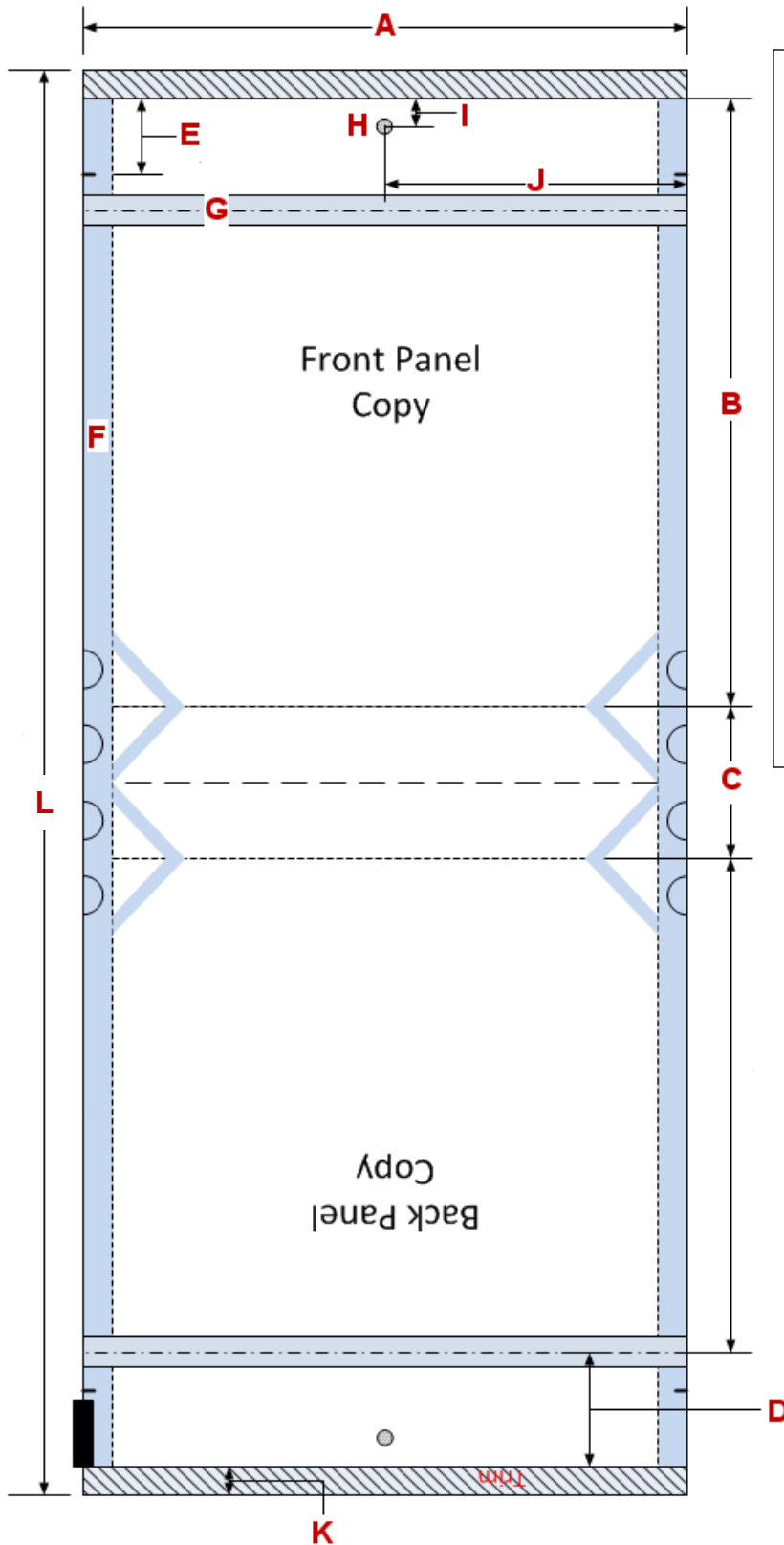
- **Trim**

- Atlapac prefers a minimum of 0.375" (0.75" total) extra film on each side of the web to trim the edges flush (if desired).
- If the film is laminated the edge trim needs to be balanced (i.e. the same amount of Print web and Sealant web).
- Too much trim can be an impediment as well. Too much trim can be difficult to pull off and wind. (1.5" is the maximum per side that we would want for trim)

Pack Out – Proper pack out of pouches is vital to your customer's success with pre-made pouches.

Atlapac is capable of fulfilling nearly any type of pack out desired – Just let us know what you need with regard to:

- Pack Flat or Pack on Edge.
- Bags per case – If you desire a certain count per case, please let us know and we will do our best to see if one of our stock box sizes will accommodate the pouch size and count. If not, we can likely order a special size that will. (Custom box sizes will require an additional cost)
- Pallet height – Please communicate any pallet weight or pallet height restrictions that you may be aware of downstream.
- Labeling requirements and label information.
 - Pallet label requirements
 - Case label requirements
 - Partial pallets and/or partial cases are likely to occur. Please make sure that your clients are aware of this.



Critical Pouch Dimension call outs

- A. Pouch Width (repeat length)
- B. Pouch Length
- C. Gusset size
- D. Header size (from middle of zipper profile to the top edge of pouch)
- E. Distance from the tear slit to the top edge of the pouch.
- F. Side seal width (0.25" or 0.375")
- G. Zipper size (10mm flange is standard – anything other than this type needs to be communicated).
- H. Hang hole type and size.
- I. Distance from center of hang hole to the top edge of the pouch
- J. Distance from center of hang hole to the side edge of the pouch
- K. Trim
- L. Finished Web Width

Special considerations for Slider zipper

The information regarding the requirements to run regular pouches mostly holds true for Slider; however, there are a few special considerations that should be addresses when preparing to run a Slider pouch.

- **Trim:** Unlike a standard pouch, slider pouches must not have any trim included in the web.
- **Zipper type:**
 - We offer two general styles of zipper for Slider applications:
 - **Tamper Evident** – this is a one piece flange that is sealed to one of the pouch panels and the other panel is left unsealed. This will allow the pouch to be filled “behind” the zipper. Once the pouch has been filled, it will need to be sealed at the top to eliminate the open side. The consumer will access the contents of the pouch by breaking the flange membrane after opening the zipper.



- **Note:** it is very important to specify any preference as to which panel of the pouch that the zipper flange should be sealed. This decision has a direct impact on what finished wind we will want to have sent to us:
 - For the zipper flange to be sealed to the front panel, we would want the film sent to us with a #3 unwind (with respect to the front panel graphics). If this configuration is desired, we must make certain that there is an element that will allow the photo eye to trip (eye mark etc.).
 - For the zipper flange to be sealed to the back panel, we would want the film sent to us with a #4 unwind (with respect to the front panel graphics).

- Two piece flange – this flange type does not have a tamper evident flange and must have both sides of the flange sealed to their respective pouch panels. This type of Slider pouch will be filled through the zipper and no finished seal at the filler is needed.



- **Slider Clip:**

- We offer an ergonomic slider clip (.276” x .567” x .308”) in red or white.

