

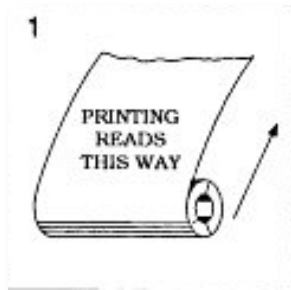
Atlapac Inno-Lok Converting Preferences and Requirements

We appreciate the opportunity to service your Inno-Lok 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 Inno-Lok converting.

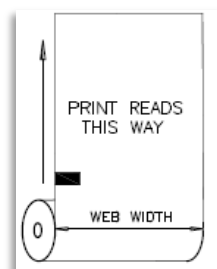
Film

- **Wind**


- We prefer to have the sealant layer wound “in”. This helps keep the sealant layer clean during the Zipper Application 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.
- The overwhelming majority of the time the film will need to be supplied to us with a #1 Unwind (with respect to the Zipper Graphics). This is because the zipper graphic needs to run this way through the machine so the actual zipper opening matches what the graphic instructs the consumer to do.



- When running printed film the 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 film, 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 diagram below:



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The diagram above depicts the eyemark on the left side of the film; technically this designation is an Unwind #1B.

- No micro-dots, logos, or markings of any kind may be in the eyemark track area.
 - 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.
 - **Surface Printed jobs:** Ink must be able to withstand 400° F.
 - Splices – maximum 2 per roll and must be well marked.
 - Rolls need to have flush cores or a handling fee per roll may apply.
 - Markings – each roll must be clearly marked with the PO#, number of imps and weight and also included on shipping paperwork
- **Guidelines for Inno-Lok® Zipper Graphics Placement**
(Front panel thumb tab opening)
 - Overall length of the zipper approximates .75" longer than zipper opening. Overall length of the zipper must be a 1/2" shorter than the total package width of finished bag. There are approximately 20 "standard" Inno-lok® zipper lengths available from Atlapac.
 - There is no requirement for additional film at the header of the bag to accommodate Front Panel Inno-lok® since it is placed within the front panel of the finished bag.
 - The perforated opening for the zipper (straight line with half-moon) needs to be positioned a minimum of 1.25" from the inside of the top seal and centered on the front panel of the artwork. This is important such that none of the zipper flange risks being sealed in to the jaw seal as the bag is formed on the FFS machine.
 - The "teardrop to teardrop" dimension on the Inno-lok® template graphics needs to match the overall zipper length dimension. The overall zipper length will always be greater than the zipper opening by approximately .75".
 - The film needs to be laid out in the opposite unwind and odd unwind number than the end-users delivered film unwind specification.
 - Eyemarks must hold registered lengths of +/- 1/8" or zipper registration issues may arise.


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- The majority of Inno-Lok film will come pre-printed with the zipper location clearly indicated on the print; however, we require a proof with copy and dimensions prior to running the job so that we can ascertain the correct position on the web to locate the zipper.
 - This is especially important on the rare occasion that zipper graphics will not be printed on the film. In situations of that nature it is an absolute must that we see a color copy of the print, complete with accurate dimensions that clearly indicate where the zipper profile should be located relative to the print.
- **Roll diameters and core sizes:**
 - Maximum Roll OD: 24"
 - Minimum Roll OD: 20". *Any shipment received containing more than one roll below the minimum diameter will be subject to refusal or charge back for additional set-up time equal to \$50 per roll.*
 - Core sizes: 3" (preferred) and 6".
- **Slip (COF)**
 - Too low of a slip level can cause problems by causing the film to block or the film to stick to the rollers 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. This can cause the film to not grip the rollers, have registration issues and may cause finished rolls to "telescope".
 - 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 including excessive scrap and at times 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

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Pack Out – Proper pack out of finished rolls is vital to your customer’s success with Inno-Lok roll-stock.

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

- Pack Flat (on roll cradles), Stood on Edge, or boxed.
- Banding and Stretch Wrap requirements.
- Labeling requirements and label information.
 - Pallet label requirements
 - Roll label requirements
 - Partial pallets and/or partial rolls are likely to occur. Please make sure that your clients are aware of this.

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