

Pinch Bottom Bags – *Standard Hot Melt*

Checking Proper Closer Heat Settings

PURPOSE:

Since temperature is the single most important variable influencing achieving a strong closure, this information will provide a method to check that sufficient heat is being applied to the pre-applied hot melt to close the bag.

HOW APPLY & TO USE:

1. Peel back paper strip to remove one label at a time.
2. Place the label in the center of the hot melt of the open and unfilled pinch bottom bag.
3. Send marked / empty bag with label through closer.
4. Allow the bag to cool for 2 to 5 minutes and carefully open the cooled bag top to expose the temperature label.
5. Observe the temperature label for which dots turned from a white to a dark gray/black color.

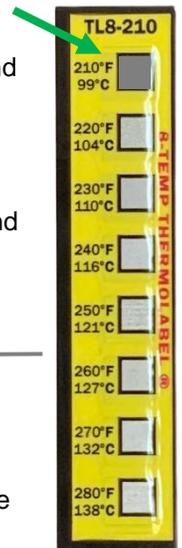


When adjusting the closer temperature, always follow the equipment instructions including any safety instructions. If the equipment requires temperature adjustment, it is important to retest to verify the proper temperature. In the event that the proper temperature is achieved, and the bag does not achieve a strong closure with over 75% fiber tear, there could be other machine adjustments necessary. Please consult your equipment owner's manual for further instruction on adjusting the closer settings.

READING THE LABEL:

After sending a bag with a label through the closer, open carefully and observe the boxes.

1. If 'no' boxes have turned a dark grey, the closer is set too 'low'. Increase the closer by 25° F and retest.
2. If the boxes that correlate to 210° F and/or 220°F are dark grey, the temperature is set adequately to close the bag. No action needed – see sample to the right.
3. If the 230°F box or above is dark grey, the closer is set too high. Reduce the closer by 25° F and retest.



INFORMATION:

Set 'TOO LOW': If the hot melt is 'too cold' or 'too low', the hot melt is not liquid enough to flow and penetrate into the paper fibers. Hot melt will look typically look 'shiny' and will not show signs of being closed. Increasing the temperature make the hot melt more fluid and able to bond to paper.

Set 'TOO HIGH': If the hot melt is 'too hot' or 'too high', the hot melt will flow too easily and will squeeze out and potentially drip on the closer equipment. This can lead to hot melt building up quickly on the plenum, fold guides, and pressure belts. In addition, the hot melt may stay too hot after exiting the closer and can pop open leading to sifting of product or weak closures.

Set 'Optimally': When the hot melt is set 'optimally' as indicated by the temperature strip, the hot melt reaches the optimal temperature to form a strong hot melt closure without having issues of being 'too high' or 'too low'.

IMPORTANT:

- The machine temperature setting does not indicate the temperature achieved by the hot melt. This is the only method to verify the actual hot melt temperature achieved. This method has been used reliably for over 25 years.
- This test should not replace a tear down inspection of the hot melt closure for fiber tear bonds.

RE-ORDER INFORMATION:

Non reversible temperature labels can be purchased at www.paperthermometer.com or calling 1-877-PTLABEL and ordering Item:TL8-210.