

# Enercon Seal Integrity

Good Seal



## No Seal

### Characteristics

No liner container bonding

### Basic Causes

Is the sealer on?

Is there a liner in the cap?

### Process/Operator Causes

What's changed?

- Cap Torque
- Line Speed
- Power Level
- Sealing Head Gap

### Material Change Causes

Liner/Container Compatibility  
Supplier change



## Partial or Weak Seal

### Characteristics

Seal is partial/weak

### Process/Operator Causes

Low Application torque

Output too low/line speed too high

Caps not centered under sealing head

Caps cocked or cross threaded

Sealing head not level with conveyer

### Material Causes

Saddle or ridge in land area

Liner/Container compatibility issue

Caps bottom out on shoulder of container



## Overheated Seal

### Characteristics

Seal Wrinkling

Odor

Pulp board discoloration

Foam Deforming

### Cause

Too much sealing power

- Sealing output too high
- Line speed too low



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# How to find your induction sealing operating window

The window is the range between the minimum & maximum power levels that achieve a good seal. After determining your operating window, select a power level within this range to run production based on the desired seal strength and peelability your product requires.

## 1 Find the Minimum Power Level that Produces a Good Seal

Try sealing your first container at 50% power. Follow the instructions below based on your results until you determine the minimum power level that achieves a good seal. Be sure your conveyor speed is set to your actual production rate.



## 2 Find the Maximum Power Level that Produces a Good Seal

Seal your first container at a power level that produces a good seal. Follow the instructions below based on your results until you determine the maximum power level that achieves a good seal.



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