

Enercon Seal Integrity



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



Good Seal



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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