



- **Coffee Web** – Coffee including single serve and ground coffee packages. Not suitable for coffee beans.
- **Cosmetic Web Family** – Dry and liquid goods for food and personal care. A variety of sealants and chemical resistant barriers are available.
- **Stickpak Family** – Varied sealants and face stocks allow for wet and dry goods designed to form and flow in multi-lane stickpak equipment.
- **ChemControl Family** – 'NEW' structures designed to provide superior chemical resistance and barrier properties. These laminations offer alternatives to barex packaging and new "hard-to-hold" opportunities for the narrow web converter.
- An example would be Cosmetic Web 350 HB which is listed as 350°F/5 sec./40PSI which implies this material will seal best when the sealant layer achieves a temperature of 350° F and that temperature is maintained for a half second with the seal jaws applying 40 pounds of pressure to the seal area.
- The seal initiation temperature is the melting point of the sealant layer. This minimum temperature must be reached at the seal film in order to get a good seal. A thicker pouch material will require a higher heat, pressure and longer dwell to ensure the correct temperature makes it all the way down to the sealant film.
- The amount of pressure applied between the seal jaws is also a critical adjustment to ensure the material is held in place without wrinkling until the heat is driven into the seal area.

## Pouching

- Each pouch material and specific end-use application has a bearing on the settings necessary for creating a pouch.
- Heat, pressure and dwell are the three ingredients necessary to create a good seal for a pouch.
- The amount of time the seal jaws are closed is defined as dwell. The amount of time is adjustable on most FFS machines and is a tool to ensure the correct temperature is obtained on the sealant film.
- Starting points for each criteria can be found in our Fasson® Rapid-Roll® FlexPak™ matrix
- It is important when sealing issues arise that all three characteristics are adjusted during trouble shooting to uncover root cause.

Visit [www.label.averydennison.com](http://www.label.averydennison.com) for our warranty statement and terms and conditions.

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