

TECH NOTE #108 – Hamer-Fischbein

Model 390 FFS Service Reminders & Proper Bag Sizing

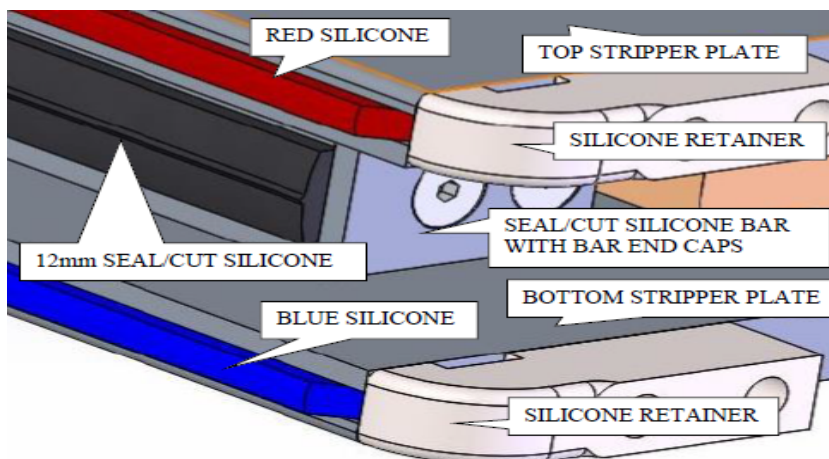
Purpose: The purpose of this technical notification is to remind Hamer-Fischbein distribution and end-users the importance of inspection/maintenance for key areas (Teflons & Silicones) of the Model 390. Also, to stress the importance of proper bag sizing for successful startups and operation.

- **TOP SEAL TEFLON –**

As all film, ice and machine wear will vary slightly, and until your proper maintenance timing is established, the Teflon and Silicone should be inspected daily. The Teflon should be inspected for burn spots and changed when this condition is observed. An inspection schedule can be established specific to the end user's needs during the first few weeks of operation. The area that burns first is typically the section of the Teflon that is not contacting the bag. Higher bagging rates will require higher temperatures and influence Teflon life. Establishing the lowest possible seal temperature and seal time can prolong Teflon life. **Approximate starting times and temperatures are 280 degrees Fahrenheit and 0.4 - 0.5 second seal time.** If holes are observed in the Teflon, plastic may have passed thru these holes and deposited on the heat band. The plastic should be removed prior to changing the Teflon, and the heat band inspected for damage. An expected Teflon life would be 100,000 bags.

- **SILICONE INSPECTION AND REPLACEMENT –**

An inspection should be completed daily for plastic build up, wear or damage to the “**12mm Seal Cut Silicone**” (Center). An inspection schedule can be established specific to the end user's needs during the first few weeks of operation. Inspection of the “**Stripper Plate Silicones (Top & Bottom)**” for plastic build up, wear or damage should be performed as well. This is done by sight and feel. If any damage or deformity is noted, the silicones should be replaced and any buildup cleared.

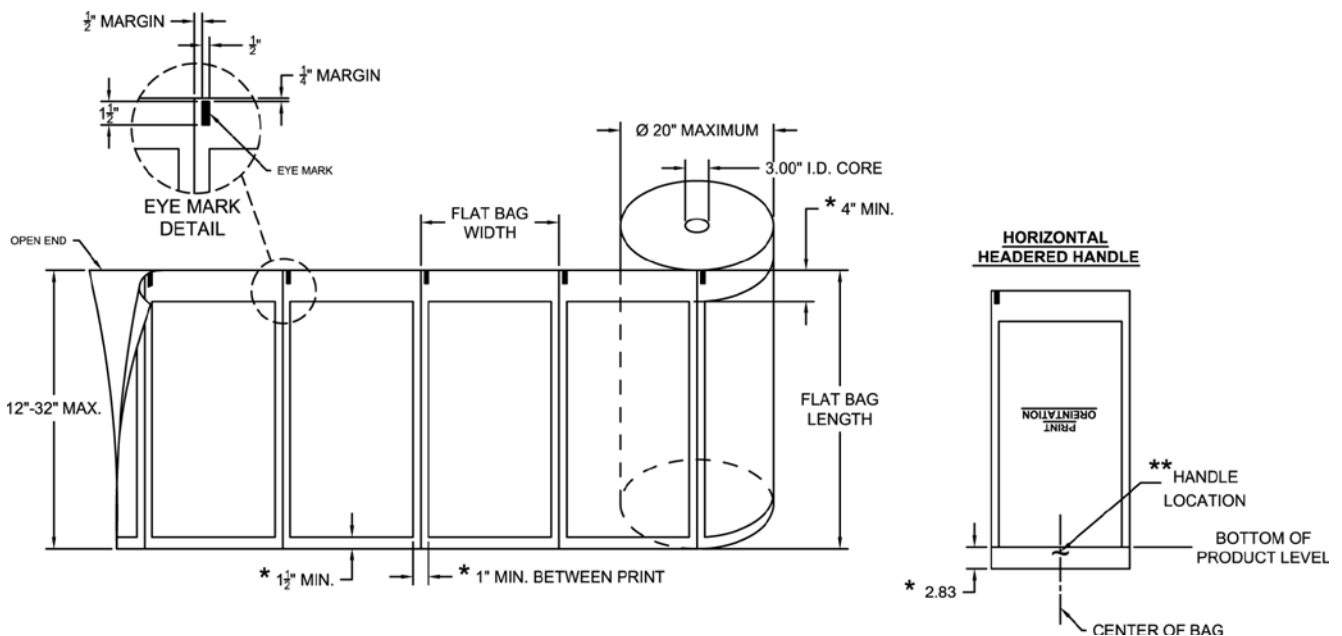


- **PROPER BAG SIZING –**

It is important to note that the Model 390 is a new technology machine and existing bags used for other models may not run proficiently. Following Hamer-Fischbein’s bag specifications is critical to successful startup and operation.

- **Film Specifications:**

- Center fold roll stock film with Film Thickness – 1.75 mil. minimum – 4.0 mil maximum.
- Internal COF must be 0.48 or less.
- Vertical roll outside diameter – 20” maximum.
- Standard bag width range: 10-3/4” minimum - 16” maximum.
- Standard bag length range: 12” minimum – 32” maximum.
- **The “NO PRINT AREAS”, eye mark dimensions and location, minimum bag sizes and mil thickness are critical.** No coatings, treatments or finishes are permitted in the “NO PRINT AREAS” on both sides of bag.
- Minimum freeboard specification must be followed (4.0” minimum).
- Eye mark will be 0.5” in from the seal – towards the roll – regardless of which way the roll is wound.
- The Eye mark should be of dark color (Black is preferred). To ensure that a proper level of contrast is present between the Eye mark and the background color, a test should be conducted. If there is any doubt regarding level of contrast, please submit film samples to Hamer-Fischbein.
- Tinted film must have a consistent tint level; variation of gradation may cause misfire issues.
- The force required to unwind film from the roll must be 8 lbs. or less.
- No print is allowed within the specified dimensions marked with the asterisk (*).



To protect your **Hamer-Fischbein** equipment investment, maximize production and minimize downtime, daily maintenance inspection and correct bag sizing are essential for proper equipment operation.

Should you have any questions concerning this technical notification, please contact Hamer-Fischbein Technical Service at (800) 927-4674 for further assistance.