

Standard Operating Procedure

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|---|----------|--|---------------|--|
| Department: | | Subject: | | |
| Practice No: SOP WWW XXX/YY-ZZ | | Replaces: | | |
| New ____ Revised ____ Procedure | Rev. No. | Effective Date: | Issuing Date: | |
| Originator/Compiled by _____ Date _____ | | Issuing Dept. Approval _____ Date _____ | | |
| Referenced Procedural Documents: | | | | |

Technical Approval

Date

Quality Assurance Approval

Date

1.0

The ILAPAK wrapper is used to pack materials automatically, using high temperature sealing on thermoplastic wrapping film.

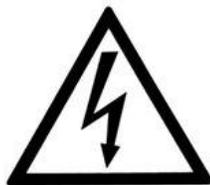
A rubber coated drive roller, a series of idler rollers and dancer bars pull the wrapping film from the reels through the film conveyor while maintaining constant tension on the film.

Labels are automatically dispensed and applied to the wrapping film, if specified for the product being run. The first set of "cold" rollers in the fin seal assembly pull the film through the forming box where the product is wrapped.

Stacks of adult or baby wipes are conveyed by the infeed table to the film conveyor for wrapping. After the stacks are wrapped and heat sealed, they are discharged via the mechanically driven outfeed conveyor.

2.0

SAFETY DEVICES



Voltage Present



Hot Surface



Pinch Point



Moving Parts

The ILAPAK wrapper is equipped with safety devices designed to prevent injuries to the Operator and accidental damage to the machine.

- All safety devices should always be maintained in proper working condition and be inspected

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periodically.

- The safety devices should not be removed or disabled for any reason.
- In case it is necessary to carry out maintenance requiring the opening or removal of safety guards, operate with particular care and take specific safety measures.
- Be aware of the danger signaling plates on the machine and know what they mean.

3.0 ILPAK Machine Components

Machine Components



The ILPAK wrapper consists of the following:

3.1 Film infeed section

The **label application section**, where pre-printed labels are applied, if applicable, to the wrapping film, consists of two labelers; one primary and one secondary. The secondary labeler is used only when the labels are depleted in the primary labeler and only long enough to reload the primary with labels.

3.2 Die cut assembly

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The **die cut assembly** consists of:

- A rubber coated magnetic brake roller that controls the film tension through the die cut roller.
- A die cut roller that partially cuts an oval slug through the film, when it comes in contact with the anvil roll, for removal of wipes from the pack. The die is held in place by magnets.

3.3 Label application section

The **label application section**, where pre-printed labels are applied, if applicable, to the wrapping film, consists of two labelers; one primary and one secondary. The secondary labeler is used only when the labels are depleted in the primary labeler and only long enough to reload the primary with labels.

3.4 Product infeed section

The labelers are set up for the secondary labeler to take-over when the labels in the primary labeler are depleted. When the new reel is installed on the primary labeler, the process is switched back to the primary labeler per the following:

To switch back to the primary labeler, the Alarm must be reset, and then the labeler can be put back on line.

3.5 Product wrapping and fin sealing section

The film travels along the film conveyor where labels are applied, if applicable.

As the label reel is unwound, a sensor detects any web breaks as the labels progress to the application assembly.

The labels pass a brush that maintains tension through the application of labels.

3.6 End seal jaws assembly

The film folds under the stack as it is being pulled into the fin sealing assembly by the first pair of "cold" rollers.

3.7 Discharge / reject conveyor

Description

The film passes between each pair of heated sealing rollers that form the seal along the length of the package. The second pair of "cold" rollers continue to pull the package through and into the end sealing assembly.

