



LACTALIS - INGLESIDE

STANDARD LINE SETTINGS - LINE 1 / 2 ILAPAK OPERATOR																																									
	PACKAGE FINE TUNING GUIDELINES BASED ON OBSERVATIONS - 'Temperature Setting adjustments of +/- 3 degrees are acceptable. Mechanical setting adjustments of +/- 2 % or mm are acceptable. - Eliminate other potential reasons for needing to run outside parameters (ex bad film, dirty jaws, other settings) and return to base condition with CIL. (Clean, Inspect, & Lubricate) - If broader adjustments are still required notify supervisor. - Validate change with 50 consecutive samples testing. RECORD ALL ACTIONS. - Closely monitor visual aspects (over heat/ under heat) and physical aspects (weak impression at end seal, leaking folds/ "T" junction, weak / leaking end seals) of the film at each roll change.																																								
	DISPLAY SCREEN SETTINGS																									MANUAL SETTINGS															
	Thermo 1 - Op \ Machine side	Thermo 2 - Op \ Machine side	Thermo 3 - Op \ Machine side	Thermo 4 - Op \ Machine side	Upper jaw	Lower Jaw	Product position	Film tension setpoint	Film tension actual	Dwell time	Roller belt ratio	Exit belt ratio	Roller Box Height	Product Max Height Sensor setpoint	Product Max Height Sensor actual	Tamper Thickness	Tilting Bed ratio	Product Height	Jaw Requested Position	Jaw Position	Film Position	Label Position	Gas Flow L/min	Line rate / Output	Crumb Blast Air - Dist. after Sensor	Crumb Blast Air - Dist. To Blow	Bag Length	Pre-Tamp height	Folding Box Width	Folding Box Condition	Tamper Pad Condition	Misplaced Sensor Position	Cutting Blade Condition	Jaw Alignment pins secure	Code date position	Crumb Blowers	Package Cooling Knives	Finseal Roller 1 PSI	Finseal Roller 2 PSI	Finseal Roller 3 PSI	Gas Heater
Line 1																																									
400g	85 / 85	70 / 70	65 / 65	60 / 60	115 / 115	115 / 115	20 / 20	2.8 / 2.8	1.5 / 1.5	1 / 1	1.02 / 1.02	1.03 / 1.03	35 / 35	30 / 30	0 / 0	55 / 55	1.05 / 1.05	21 / 21	10 / 10	10 / 10	181 / 181	N/A	0 / 0	95 / 95	N/A	N/A	312 / 312	60 / 60	340 / 340	Good	Good	312 / 312	Good	Yes	42 / 42	On	On	0.9 / 0.9	3 / 3	2 / 2	On
600g	85 / 85	80 / 80	75 / 75	70 / 70	107 / 115	107 / 115	2 / 22	1.6 / 2.2	0.73 / 1.2	1 / 1	1.02 / 1.02	1.02 / 1.03	37 / 40	35 / 35	0 / 0	56 / 63	1.2 / 1.2	0.21 / 22	10 / 11	10 / 10	170 / 195	N/A	68 / 68	75 / 90	N/A	N/A	360 / 360	50 / 56	360 / 360	Good	Good	360 / 360	Good	Yes	289 / 308	On	On	0.9 / 2.5	3 / 3	1 / 2	On
820g	85 / 85	75 / 80	75 / 80	65 / 75	100 / 125	100 / 125	-12 / 35	1.8 / 3.2	0.98 / 1.9	0.95 / 1	1.02 / 1.04	1 / 1.07	42 / 46	38 / 44	0 / 0	32 / 66	1.2 / 1.2	0.32 / 0.32	16 / 16	16 / 16	37 / 67	N/A	79 / 99	70 / 80	N/A	N/A	381 / 381	52 / 64	360 / 380	Good	Good	381 / 381	Good	Yes	278 / 300	On	On	0.8 / 2.2	1.4 / 3	1 / 2	On
1150g	65 / 80	65 / 75	65 / 70	60 / 70	100 / 125	100 / 125	-42 / 30	1.2 / 3.2	-0.05 / 2.2	0.94 / 1	1 / 1.06	1.02 / 1.08	60 / 62	41 / 54	0 / 0	30 / 39	1.15 / 1.15	30 / 42	15 / 21	15 / 21	25 / 85	N/A	79 / 90	50 / 70	N/A	N/A	375 / 389	38 / 56	360 / 380	Good	Good	375 / 375	Good	Yes	280 / 297	On	On	0.9 / 2.6	2 / 3	1 / 2	On
1150g 3 Ply	75 / 75	70 / 70	65 / 65	60 / 60	100 / 100	100 / 100	-22 / -5	1.5 / 2	0.9 / 1.3	0.95 / 0.95	1.04 / 1.04	1.06 / 1.06	60 / 60	53 / 53	0 / 0	35 / 37	1.15 / 1.15	42 / 42	21 / 21	21 / 21	65 / 75	N/A	0 / 0	70 / 70	N/A	N/A	375 / 375	38 / 54	360 / 360	Good	Good	375 / 375	Good	Yes	280 / 290	On	On	0.9 / 1.8	2.9 / 3	1.1 / 1.1	On
2000g	30 / 30	57 / 57	60 / 60	30 / 30	80 / 80	80 / 80	15 / 15	1.2 / 1.2	1.4 / 1.4	0.95 / 0.95	1.04 / 1.04	1.04 / 1.04	104 / 104	92 / 92	0 / 0	10 / 10	1.05 / 1.05	82 / 82	41 / 41	41 / 41	270 / 270	N/A	0 / 0	15 / 15	N/A	N/A	413 / 413	30 / 30	360 / 360	Good	Good	413 / 413	Good	Yes	299 / 299	On	On	1.8 / 1.8	3 / 3	2 / 2	On
2300g	60	55	55	60	105	105	0	2.5	1.5	0.97	1.08	108%	106	97	0	10	1.05	75 / 87	43	43	200	N/A	125	35	N/A	N/A	455	30	380	Good	Good	455	Good	Yes	265	On	On	2.2	3	2.8	On
2300g clear 2 ply	50 / 50	55 / 55	55 / 55	60 / 60	100 / 100	100 / 100	5 / 5	2 / 2	1.6 / 1.6	0.95 / 0.95	1.04 / 1.04	1.06 / 1.06	106 / 106	87 / 87	0 / 0	0 / 0	1.05 / 1.05	87 / 87	43 / 43	43 / 43	30 / 30	N/A	0 / 0	28 / 28	N/A	N/A	455 / 455	48 / 48	360 / 360	Good	Good	455 / 455	Good	Yes	360 / 360	On	On	0.9 / 0.9	2.9 / 2.9	1.1 / 1.1	On
Line 2																																									
270g CB	85 / 97	80 / 95	70 / 95	55 / 90	103 / 127	103 / 127	-28 / -2	2.5 / 3.5	1.17 / 1.8	0.95 / 0.97	0.98 / 1.02	1.03 / 1.15	35 / 40	29 / 35	0 / 0	37 / 65	1.15 / 1.2	30 / 32	11 / 15	11 / 15	25 / 95	N/A	74 / 91	120 / 128	N/A	N/A	212 / 217	45 / 56	340 / 380	Good	Good	212 / 217	Good	Yes	140 / 160	On	On	1.2 / 2	2 / 2.1	2 / 2	On
270g PB 3 ply	85 / 85	80 / 80	70 / 70	60 / 60	108 / 108	108 / 108	6 / 6	1.7 / 1.7	0.96 / 0.96	95 / 95	98 / 98	100 / 100	40 / 40	33 / 33	0 / 0	40 / 40	115 / 115	30 / 30	15 / 15	15 / 15	48 / 48	N/A	0 / 0	108 / 108	N/A	N/A	48 / 48	48 / 48	340 / 340	Good	Good	217 / 217	Good	Yes	148 / 148	On	On	1 / 1	1.8 / 1.8	1.2 / 1.2	On
270g PQ	60 / 60	75 / 75	80 / 80	85 / 85	130 / 130	130 / 130	-6 / -6	2.5 / 2.5	1.6 / 1.6	1 / 1	1 / 1	1.1 / 1.1	33 / 33	29 / 29	0 / 0	65 / 65	1.25 / 1.25	22 / 22	11 / 11	11 / 11	92 / 92	N/A	82 / 82	128 / 128	N/A	N/A	212 / 212	48 / 48	380 / 380	Good	Good	212 / 212	Good	Yes	155 / 155	On	On	2 / 2	2 / 2	2 / 2	On
400g	85 / 90	85 / 85	65 / 75	55 / 75	110 / 127	110 / 127	6 / 9	1.5 / 1.8	1.1 / 1.3	1 / 3.12	0.98 / 1	1.02 / 1.16	34 / 36	26 / 32	0 / 0	55 / 65	1.15 / 1.15	20 / 20	10 / 10	10 / 10	198 / 203	N/A	0 / 0	95 / 98	N/A	N/A	312 / 312	38 / 50	360 / 360	Good	Good	312 / 312	Good	Yes	58 / 70	On	On	1 / 1.9	1.8 / 2	1.2 / 2	On
600g	85 / 85	90 / 90	90 / 90	85 / 85	120 / 120	120 / 120	-14 / -14	2.5 / 2.5	1.6 / 1.6	1 / 1	1.01 / 1.01	1.1 / 1.1	38 / 38	33 / 33	0 / 0	60 / 60	1.11 / 1.11	20 / 20	10 / 10	10 / 10	180 / 180	N/A	0 / 0	85 / 85	N/A	N/A	360 / 360	52 / 52	380 / 380	Good	Good	360 / 360	Good	Yes	319 / 319	On	On	2 / 2	2 / 2	2 / 2	On

820g	0/0	0/0	0/0	0/0	0/0	0/0	0/0	0/0	0/0	0/0	0/0	0/0	0/0	0/0	0/0	0/0	0/0	0/0	0/0	0/0	0/0	N/A	0/0	0/0	N/A	N/A	0/0	0/0	0/0	Good	Good	0/0	Good	Yes	0/0	On	On	0/0	0/0	0/0	On
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