

Troubleshooting Induction Sealing:

How to Diagnose & Fix Faulty Seals

NO SEAL



Characteristics:

No induction liner container bonding

Machine Cause:

Induction Sealer is not turned on

Process/Operator Causes:

Changes to:

- Cap torque
- Line speed
- Power level
- Sealing head gap to cap

Material Causes:

No induction liner in cap
Liner/container compatibility
Supplier change

PARTIAL SEAL



Characteristics:

Seal is partial/weak

Process/Operator Causes:

Low application torque
Inadequate exposure time (line speed too high)
Caps not centred 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



Characteristics:

Good adhesion
Minimal wrinkling
No discolouration or burning
Clean and even seal

Process/Operator Causes:

Correct:

- Cap torque
- Line speed
- Power level
- Sealing head gap to cap
- Caps centred under sealing head

OVERHEATED SEAL



Characteristics:

Seal wrinkling
Odour
Pulp board discolouration
Foam deforming
Pinholing
Delamination of liner
Difficult to remove seal

Process/Operator Causes:

Too much sealing power:
• Excessive power from sealer
• Excessive exposure time (line speed too slow)



Unsure if your induction sealer is set to the correct power level? Download our **Quick Guide to Operating Windows** to learn more.



**THE GLOBAL LEADER IN
INDUCTION CAP SEALING SYSTEMS**

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