



Achieve a Perfect Seal

Best Practices for Induction Sealing Success



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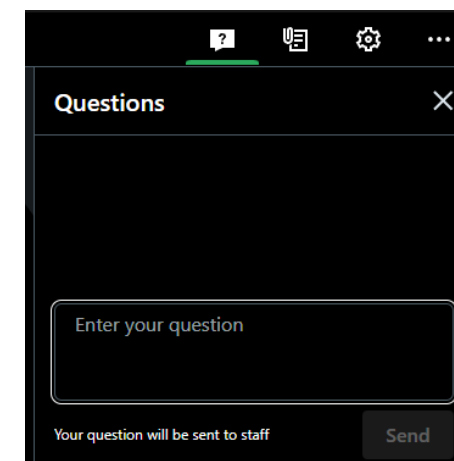
RECORDING



***Yes, the webinar is
being recorded.***



QUESTIONS



***Use this tool
to ask questions.***

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Overview

- Why Brands Use Induction Sealing
- How Induction Sealing Works
- Selecting an Induction Sealer
- Sealing Head Design
- Proper Set Up & Power Levels
- Troubleshooting Tips
- Q&A



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About Enercon

The Global Leader in Induction Cap Sealing



GLOBAL SERVICE
AND SUPPORT



200 MILLION CONTAINERS
SEALED EVERY DAY



"The expertise and product that Enercon offers is second to none and by purchasing this equipment we were certain of the quality of product and support to expect."

Samuel Tozer
Site Engineer at Orchard Valley Foods



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Our Presenters



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Why Induction Seal?



Automotive



Beverage



Cannabis



Chemical &
Argochemical



Cosmetic



Dairy



Food



Household



Pharmaceutical



Sports Nutrition



Prevent
Leaks



Provide Tamper
Evidence



Preserve
Freshness



Lightweight
Containers



Deter Pilferage



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Induction Sealing Basics

ONE
PIECE
LINER



Closure

Backing

Foil

Heat Seal

Container



Good Seal



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Pressure, Heat and Time



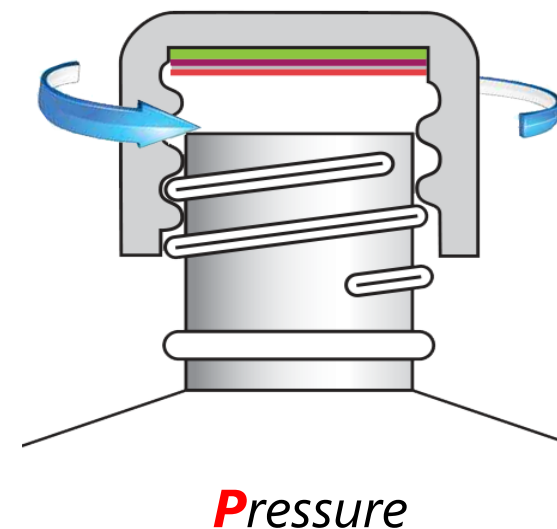
Cap Application Torque



Pressure, Heat and Time

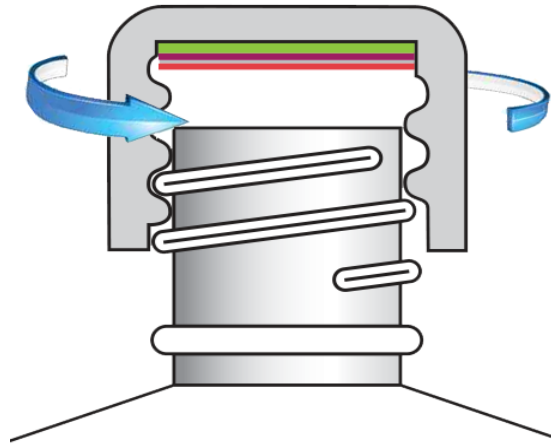
Cap Application Torque General Guidelines

Cap Size (mm)	15	18	20	22	24	28	33	38	43	48	53
Torque (inch/lbs)	6 to 9	7 to 10	8 to 12	9 to 14	10 to 16	12 to 18	15 to 25	17 to 26	18 to 27	19 to 30	21 to 36



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#1 Reason for Cap Seal Failures: Improper Application Torque



Pressure, **Heat** and Time



**Electromagnetic field reacts
with foil to generate heat**



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Pressure, Heat and **Time**



Conveyor Speed



Don't know your conveyor speed?
Scan the QR code to use our Line Speed Calculator.

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Considerations When Selecting a Cap Sealer

- Product to be sealed
- Purpose of sealing
- Liner Style
- Line Speed
- Cap style and bottle configuration



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Cap Considerations

- Cap Diameter
- Cap Style
- Cap Material



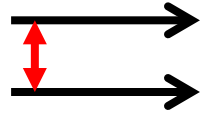
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Cap Styles – Depth of Foil Comparison

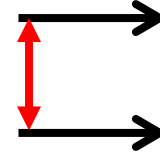
Depth of Foil



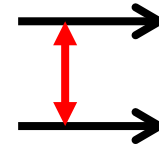
Continuous
Thread



Child Resistant Cap



Flip-top



Spouted



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Sealing Head Options

Enercon offers a variety of sealing heads to ensure energy efficiency & provide the largest operating window possible.

If you have more than one sealing head, make sure you are using the correct one for the container/cap you are sealing.



FLAT SEALING HEAD



WIDE TUNNEL SEALING HEAD



DEEP TUNNEL SEALING HEAD

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All-in-One Sealing Head

For lines that frequently change container sizes an All-in-One Sealing head is used. Be sure to adjust the sealing head to the proper position for the size cap you are sealing.



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Cap Sealer Set up



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Setup- Alignment with Conveyor

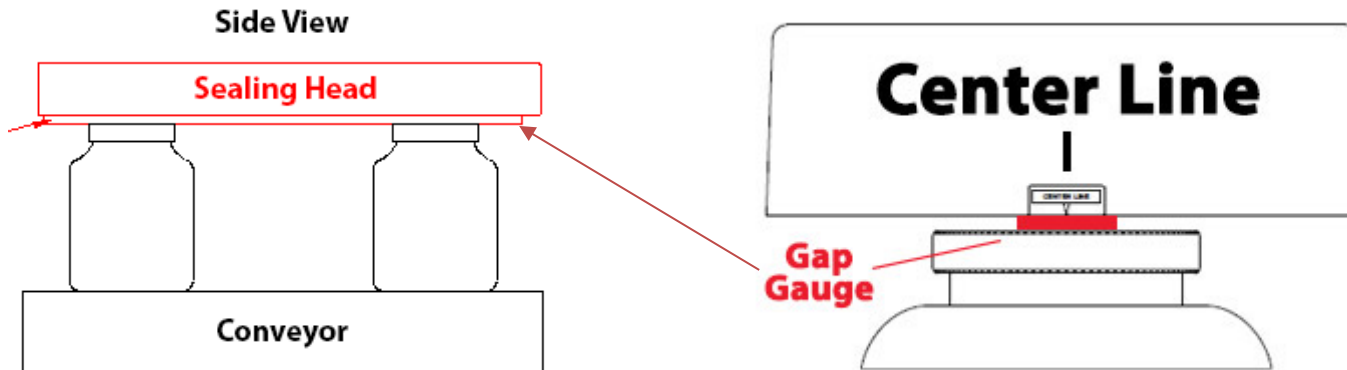
- Cap Sealer should be parallel with conveyor
- Controlled and centered container path
- Adjust guide rails as needed



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Setup- Flat Sealing Head Air Gap

- Distance between cap & sealing head
- Set air gap – must be parallel to conveyor
- Use Enercon Gap Gauge



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Maintain a Consistent Gap Between the Foil and the Sealing Head

The power of the electromagnetic field reduces very rapidly as the distance from the sealing head increases.

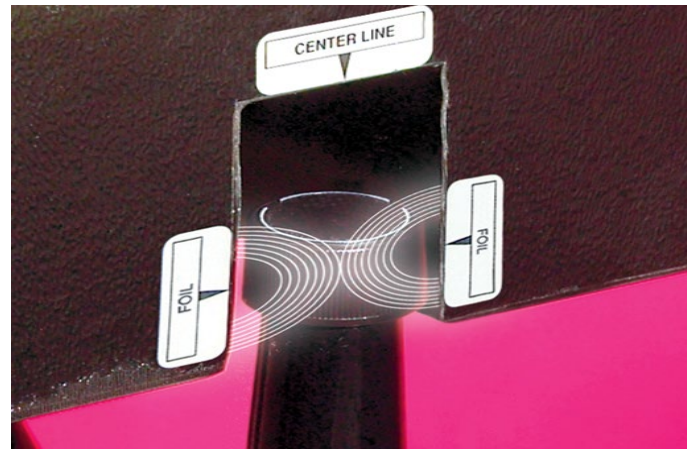
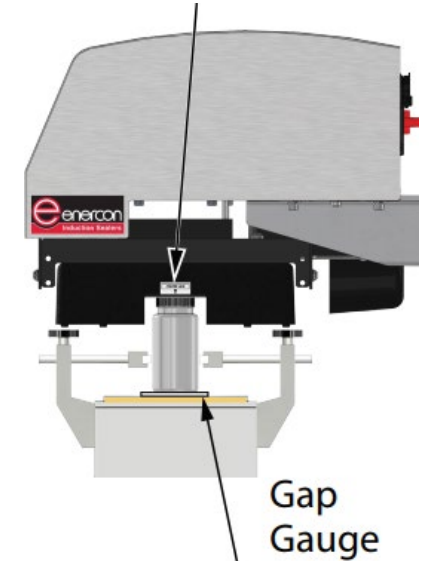
Small changes in the gap can have a large impact on the sealing power.



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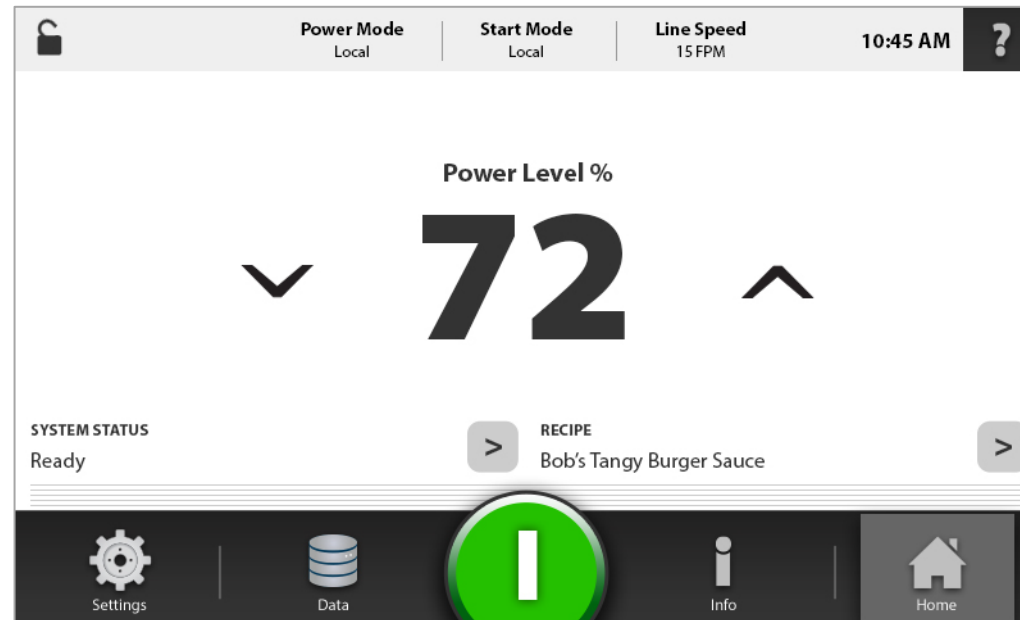
Setup- Tunnel Sealing Head Air Gap

- Sealing head must be parallel to the conveyor
- Controlled and centered container path
- Distance between cap & sealing head
 - For standard tunnel sealing head
 - Set air gap using Gap Gauge
 - For Deep Tunnel
 - Align foil height with labels



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What Power Level Should I Use?



**The proven practice
used by leading packagers**



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Establishing Your Cap Sealing Operating Window

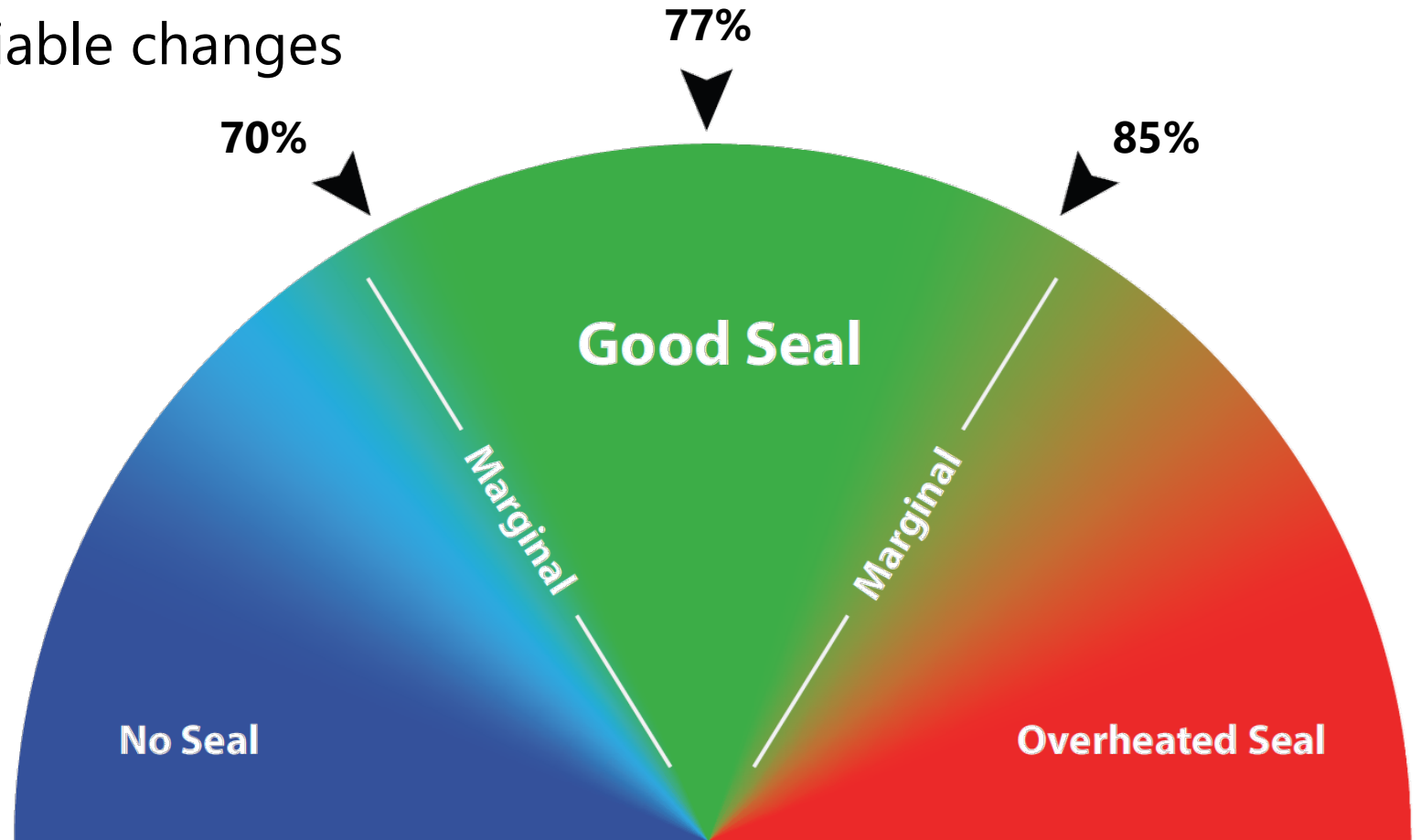


Why an Operating Window is Important

Ensuring success

Compensate for slight variable changes

- Cap Torque
- Container Centering
- Line Speed
- Foil Height



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Troubleshooting Tips



Super Seal™ Cap Sealer Range



Super Seal™



Super Seal™ Pro



Super Seal™ Max



Super Seal™ Junior

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Review: Tips to Achieving a Perfect Seal

- Why induction?
 - Leak prevention
 - Shelf-life extension
 - Tamper evidence
 - Consumer Confidence
 - Pressure Equalisation (venting)
 - Package lightweighting
 - Meet meet e-commerce requirements
- 3 ingredients for sealing success: Pressure, Heat, and Time
- Why Sealing Head Design Matters
- Optimising power level for each sealing application
- Troubleshooting Tips for No Seal, Partial Seals, and Overheated Seals



Our European Agents & Distributors



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Questions?



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Thank you!



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