

RULES AND DIRECTIONS FOR THE USE OF ASEPTIC BAGS

The good preservation of the product is directly related to connect with the correct utilisation of the aseptic bags.

The following instructions are of importance:

PRESERVATION AND HANDLING:

If the carton containing the aseptic bags is received damaged, to such extent that the contents are exposed, do not use the bags. Keep the aseptic bags in protected warehouses and under correct environmental and hygienic conditions. Bags must be stored between 5°C (41° F) and 32°C (90°F).

In particular keep bags away from:

- high temperatures,
- direct sun,
- poisonous or ill smelling articles.

The bag will remain aseptic if not tampered with. Be careful not to damage the bags when opening the boxes. Collect the bags from their boxes individually only at the moment of the filling process, carefully avoiding any possible damage.

All bags remaining after filling operations must be carefully packed in the original cartons in order to avoid bag damage.

It is the expectation that unfilled bags will be suitable for use 36 months from the date of Manufacture, provided that the storage and warehousing conditions detailed above are adhered to. It is recommended that the principle of 'First in First out' should be applied on unfilled bags. If this time period is exceeded it is a requirement to contact your bag manufacturer prior to usage.

IRRADIATION:

Cartons are identified with an irradiation indicator. Always check that the irradiation indicator dots (indication the bag aseptic conditions) are of the correct colour, which is red. Never use boxes with a yellow dot (bags are not irradiated). In case of doubt, please contact your supplier in writing within 7 days after receipt of the bags.

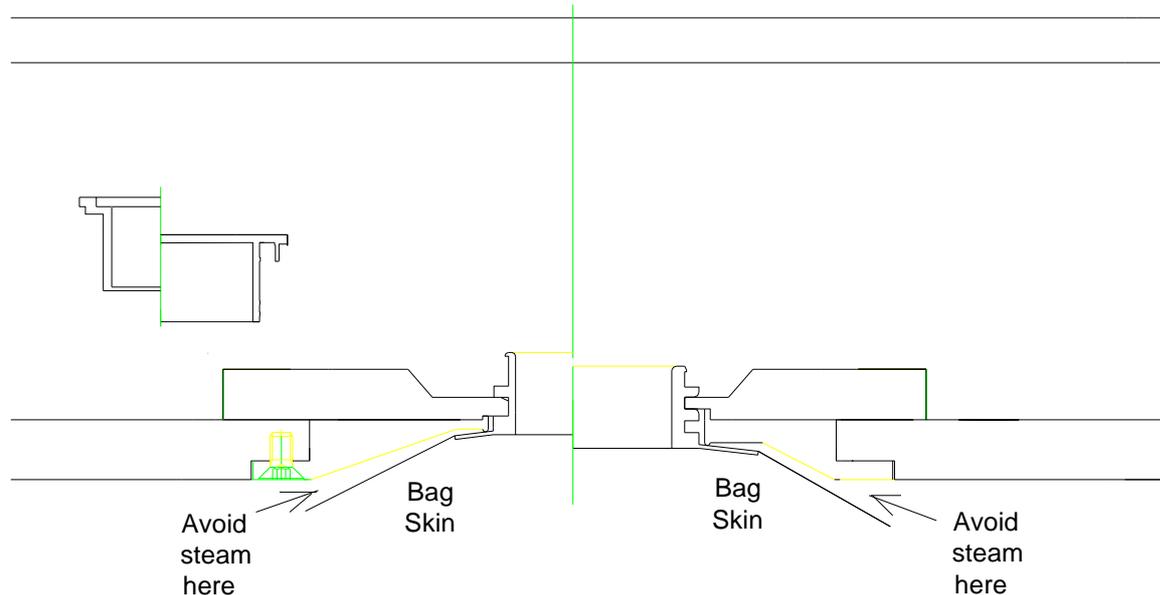
OUTER CONTAINERS:

The dimensions of the bags are proportionate to the size of the outer container. The dimensions of the bags will have to be determined by suppliers' technicians: the internal size of the outer container must be advised upon placing the order for aseptic bags.

The inner side of the outer container must be free from cutting edges, scratches or impurities, in order to avoid damage to the bag (cuts, holes) during filling and transport operations.

FILLING:

Handle the aseptic bag with care during the filling operation ensuring the bag is correctly held by the pincer/clamps to minimise the strain applied to the fitment (see schematics attached). During filling, the bag film should not be in direct contact with hot parts on the fill head. Avoid steam or hot condensate from flowing on to the bag film during the filling process.



The container lift system or fill head movement should ensure that the product load is supported by the container during the complete filling process. The establishment of the correct sequence of outer container lift or fill head movement steps should minimize the weight carried by the fitment with the pincer/clamp only releasing at the end of the cycle. It is particularly important to check that the closure is correctly placed in the spout. After filling, carefully fold the empty corners of the bag towards the centre, taking care to avoid creases and smoothing the surface. Make sure that the filled bag is completely supported by the outer container.

CLOSING:

Avoid the introduction of any foreign bodies which may damage the aseptic bag. Take care not to pinch the bag with the cover when closing the outer container. The cover of the outer container must close tightly. It is important to keep a record of the production date, the filling head number, the temperature of the filling head and the bag number going with each outer container. This will avoid handling of all outer containers in case of accidents, because it will enable you to identify and to sort out the claimed lot, thus saving time and money and allowing immediate control and evaluation of eventual damages.

IMPORTANT: For Liquid Product Bags

Avoid head space between the filled bag and the top cover of the drum or other outer container. Should head space exist, it should be completely filled in order to prevent excessive movement of the bag within the outer container.

When the viscosity is less than 500 CP (at 200°C, BROOKFIELD) it is necessary to consult the supplier's technicians.

STERILISING PROCESS DURING THE FILLING OPERATION:

STERILISING LIQUIDS:

The under-mentioned conditions are to be respected in case of the use of sterilising liquids. The chlorine salts, which are used in solution for sterilisation in the filling areas, must have chlorine concentration not higher than 250PPM and they must be buffered so as to keep the PH of the solutions at 7 + 1. Carefully remove excess sterilising liquid once the bag has been closed. Metal attack which may occur as a consequence of not respecting the above conditions, will not be recognised. Usage of other sterilisation liquids will be subject to approval of both bag and filler supplier.

HOT STEAM STERILISATION:

In case of steam sterilization up to 105°C, only bags with suitable fitments and films for this particular system must be used.

STORAGE AND TRANSPORT OF FILLED CONTAINERS:

In order to get a good result, the filled containers must be adequately protected against sun, rain, dust and excessive temperatures.

The filled containers must be placed and tied firmly together on proper pallets during factory shifting and shipping, to avoid any kind of movement.

Do not transport filled containers at temperatures below 1°C, to avoid ice forming on the surface of the product, which could irreparably damage the bag.

GENERAL REMARK:

The aseptic bag is only one of the elements of a system for the preservation of a product. It is clear that any stage before the filling operation (for example during the sterilization of the product) can cause problems that are not related to the bag. It is therefore essential, in case of a claim, that suppliers technicians are allowed to verify the production process and records (in particular records of temperatures in the filling head during production) and also maintenance actions on the filling machine before the aseptic season, in order to identify the true origin of the problem. No damage claims will be accepted without proper documentation on part of the customer