Heat Seal Pouches

How to seal a Heat Seal & Roll Type Pouch

Heat Sealing the Pouch

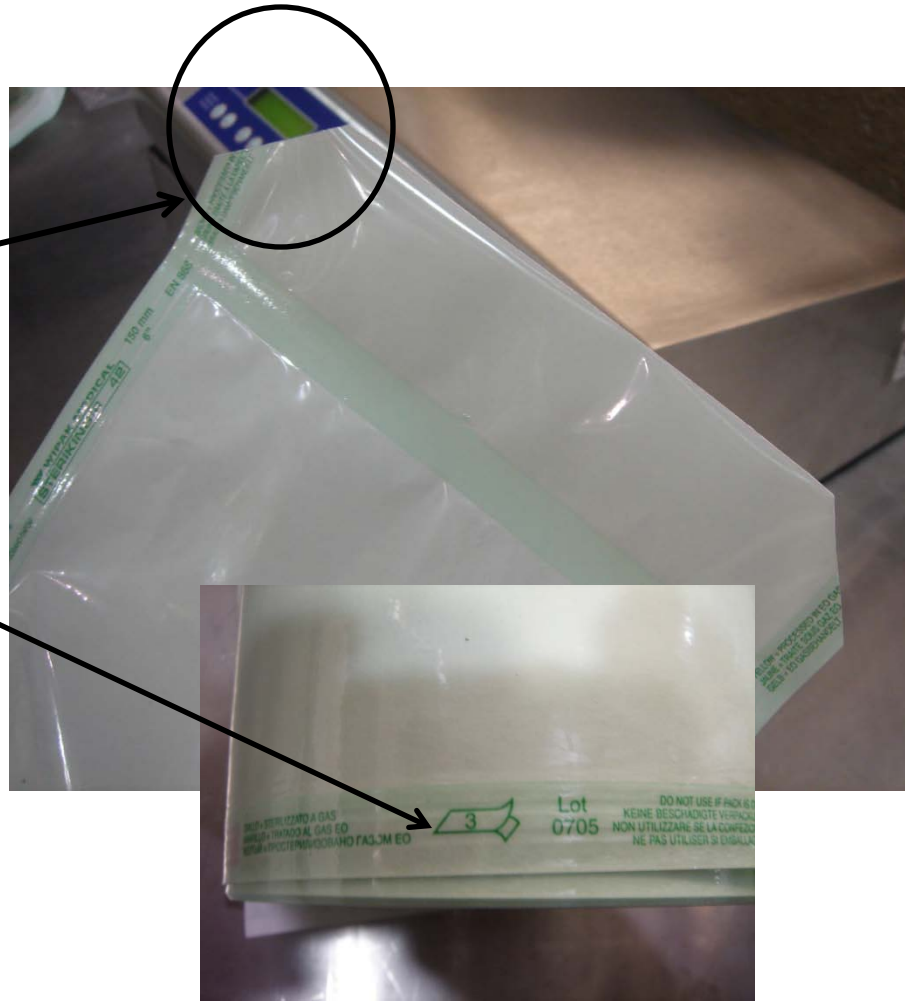
- Follow general Guidelines for all pouches
- Ensure that the proper sealer conditions are used. (temperature each peel pouch has a temperature range to provide maximum sealing, if a heat seal type pouch)
- To prevent injury keep fingers away from sealer bars/ rollers

Heat Sealing the Pouch continued

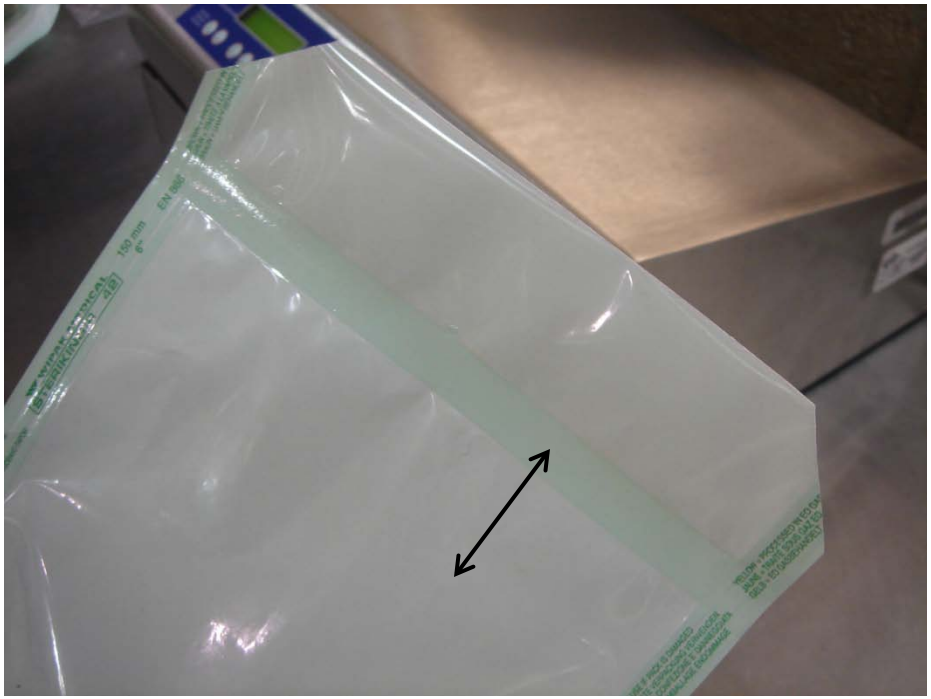
- Hold the pouch taut in the sealer, to prevent wrinkles or air bubbles from forming in the seal. If using a rolling type sealer let the peel pouch move along the guide on it's own.
- When heat sealing " tubing/ roll" type pouches, always leave enough material beyond the seal for the opener to easily grasp (usually 1-1/2 to 2 inches)

General Information

- Pouches and roll stock are commonly used for small instruments, light weight devices and porous items
- Roll stock is cut to fit
- Scallop cut opening end.
- Make Sure scallop cut recognizes the correct opening direction.
- Must be pinhole free and non-toxic
- Must be resistant to tears and punctures



Sealing the Pouch Continued



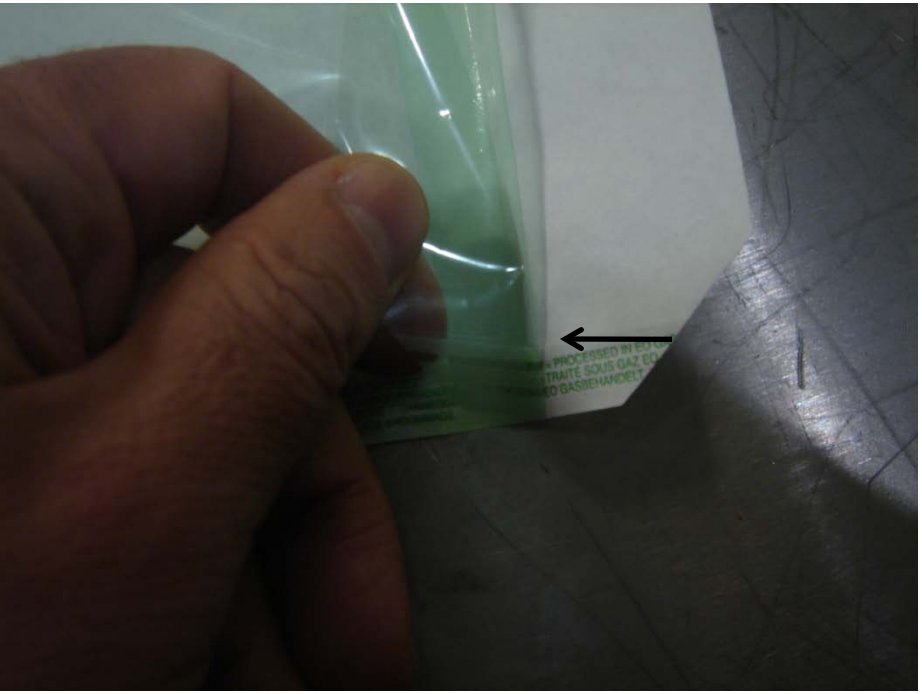
- Hold the pouch taut in the sealer, to prevent wrinkles or air bubbles from forming in the seal. If using a rolling type sealer let the peel pouch move along the guide on it's own.

- **Always leave enough material beyond the seal for the opener to easily grasp (usually 1-1/2 to 2 inches) critical to allow for aseptic presentation**

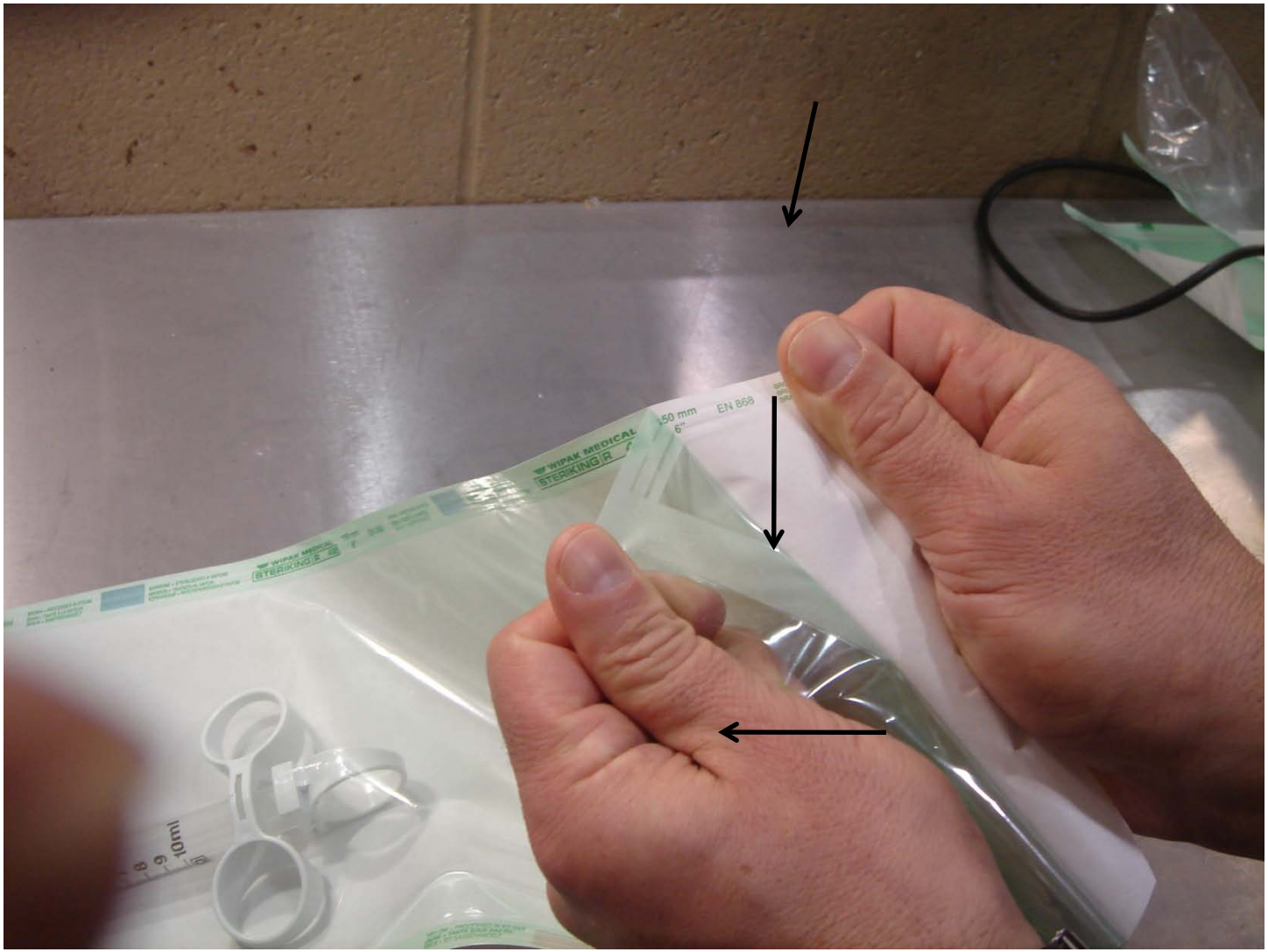
Opening Roll Stock

- Open at scalloped end
- (Verify your opening in the correct direction)

Peel Down Top-Side Seams (Thumb Tabs)



Grab & Roll Down Top Seam (4th side user created) - pulling film away from paper



Once Top Seam is released open the package using proper aseptic technique

Peeling the film from the paper side of package for Sterile Presentation

Verifying the seal

- **In 2006 ISO 11607 was updated. This is a two part document concerning packaging. To complement the release of this new standard, the AAMI guidance document, Technical Information Report – TIR 22:2007 was updated.**
- **Under the new ISO Standard 11607-2: 2006 a process validation program is required to validate the efficacy and reproducibility of all sterilization and packaging processes, and this validation must be documented.**

Verifying the seal

- **Commercial products available**
- **The Steriking® Seal Control Sheet SC250 is made of ESPP film and medical grade paper. It simulates the sealing process very effectively and is suitable for the rotosealers and impulse units in widespread use.**

Heat Sealing the Pouch

- Ensure that the proper sealer conditions are used.
- Use a sealer designed for medical packaging
- Each brand may have a slightly different melt point.
- Be sure to test your brand.
- Green tinted 320 – 356 F (160-180 degrees C)