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December 2006

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www.packagingdigest.com/info/visibility/

Converting Magazine names Innovator awards for 2006

PD's sister publication announces the winners, which recognize the achievements of converters and package printers that "do well by doing good." Full details are available at www.packagingdigest.com/info/innovations/





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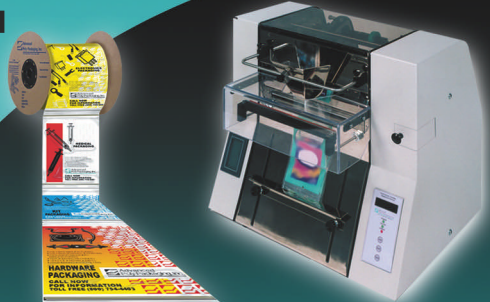
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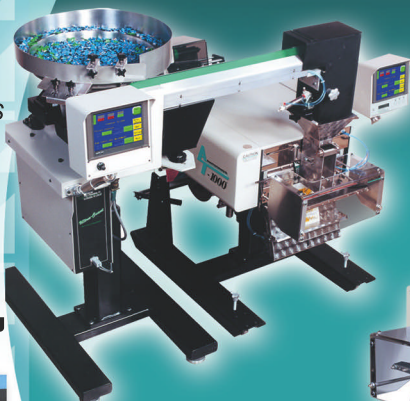
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Editorial/Production Offices

CHICAGO

2000 Clearwater Dr., Oak Brook, IL 60523

630/288-8000 Fax 630/288-8750

e-mail: packagingdigest@reedbusiness.com

staff



Mary Ann Falkman



Lauren R. Hartman

Mary Ann Falkman, Editor

630/288-8748

mfalkman@reedbusiness.com

Lauren R. Hartman, Senior Editor

630/288-8749

lhartman@reedbusiness.com



Anne Marie Mohan



Jack Mans

Anne Marie Mohan, Senior Editor

630/288-8746

amohan@reedbusiness.com

Jack Mans, Plant Operations Editor

630/288-8747

jmans@reedbusiness.com



Lora Lee Gelles



Grant Gerke

Lora Lee Gelles, Art Director

630/288-8566

lgelles@reedbusiness.com

Grant Gerke, Web Editor

630/288-8744

ggerke@reedbusiness.com

Bernard Abrams, Contributing Editor, BernieAbrams001@aol.com

Seth Rosner, Webmaster, seth.rosner@reedbusiness.com

Joy Tan-Pipilas, Production Editor, mtan@reedbusiness.com

Jackie Kenny, Web Assistant, jackie.kenny@reedbusiness.com

Mark DiVito, Group Research Director, mark.divito@reedbusiness.com

Quentin Brown, Production Manager, 630/288-8433, qbrown@reedbusiness.com

Rose Logusz, Classified Production, rlogusz@reedbusiness.com

Mary Ann Brockway, Ad Services Coord., mbrockway@reedbusiness.com

Tad Smith, CEO

Jeff Greisch, President, Chicago Division

John Poulin, Senior Vice President, Finance



Steven Reiss



Bob Heitzman

Steven Reiss, VP, Publishing Director

630/288-8807

sreiss@reedbusiness.com

Robert Heitzman, Publisher Emeritus

630/288-8735

rheitzman@reedbusiness.com

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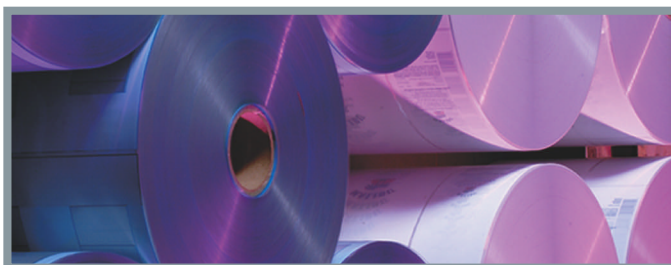
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design trends

Candle packs to light your fire

BleuBay candles from BleuBay aren't just candles. They're designed as a sumptuous aromatherapy experience. Captivating and alluring, the candles feature soot-free wicks and are made of "pure" waxes and essential oils. There are 16 different aromas, each available in 11 different stockkeeping units. The packaging includes a distinctive paperboard canister featuring thin, powder-blue stripes, embossed-border wraparound labels and hang tags secured with a raffia band. The look is upscale with a casual, country flair. With design and artwork created by **Studio Morris** (www.studiomorris.com) in Los Angeles, the tube-like canisters are printed on Carnival Felt Stellar by **Design Media** (903/938-8300). Inside is a heavy glass "goblet," filled with luxurious, aromatic food-grade wax. The recyclable packaging is printed with soy-based inks whenever possible, the company says. **Chicago Paper Tube** (www.chicagopapertube.com) converts the canisters. **McDowell Label** (www.mcdowelllabel.com) prints the labels, hang tags and bands. The gift-like packages convey the indulgent, relaxing, stress-melting message of the fragrant candles within.



Instant foam dispenser tops eyelid cleanser

New TheraTears SteriLid eyelid cleanser from Advanced Vision Research is now available over-the-counter throughout the U.S. in a handy container that incorporates **Rexam Airspray's** (www.rexam.com) one-touch foaming-pump technology. The M3 finger-pump, molded of polypropylene, is said to offer instant foam application of the delicate eyelid health application in a 0.4-mL output. The elegant 1.62-oz polyethylene terephthalate dispenser bottle, pictured on the product's outer carton,

is suitable for purse-sized personal care products. **Alpha Packaging** (www.alphap.com) provides the bottle. The eyelid cleanser, considered a market-leading OTC ophthalmic solution for the treatment of dry eyes, has recently been named by *Drug Store News* as the leading niche product in the eye-care category.

According to Advanced Vision Research, the new SteriLid Eyelid Cleanser makes eyelid health more effective, easier and more comfortable than ever, as does the packaging. The convenient, ready-to-use foam cleanses the eyelids and eyelashes and conditions delicate skin around the eyes with a hypoallergenic, pH-matched-to-skin formula. Advanced Vision Research develops and markets pharmaceuticals for dry eye and external eye diseases under the TheraTears brand. The line of products includes a preservative-free version and the cleanser in a bottle, a liquid gel, contact lens comfort drops, TheraTears Nutrition (an Omega-3 supplement for dry eyes) and the TheraTears brand SteriLid Eyelid Cleanser.



Hefty zipper bags take flight

Hefty® OneZip® brand bags are teaming with the nation's airports to keep airline passengers on schedule, and hopefully, on time. **Pactiv Corp.** (www.pactiv.com) has announced that it's offering more than 1 million of the clear, 1-qt slider zipper bags free to airport passengers across the U.S. to help keep passenger traffic flowing through security checkpoints. The company says it hopes the bags will help passengers comply with the new U.S. Transportation Security Administration (TSA) 3-1-1 carry-on guidelines for air travel. The 3-1-1 initiative allows liquid or gel toiletries, 3 oz or less in volume, to be stored inside a quart-sized, clear plastic, zip-top bag—one bag per passenger.

"Many holiday travelers have purchased Hefty OneZip bags to pack their carry-on toiletries, but others may not yet be aware of the 3-1-1 carry-on guidelines," says John Schwab, senior vp and general manager of Hefty Consumer Products. "Our goal is to help travelers comply with the guidelines by offering the bags for toiletries, enabling them and other travelers to zip through airport security checkpoints."

Airports participating in the slider bag program include: Atlanta; Baltimore; Chicago (O'Hare and Midway); Cincinnati; Columbus; Denver; Detroit; Houston (George Bush); Las Vegas; Los Angeles; Memphis; Miami; Nashville; New York (LaGuardia and JFK); Phoenix; Portland; Raleigh-Durham; Sacramento; San Diego; Seattle; Washington, DC; and many more. The film bags feature an easy-to-use slider that closes in one simple step, without pinching, pressing or lining up the tracks. Just slide the bag closed.

Rice Now in a retort pouch: Just heat and eat

A new microwavable, heat-and-eat line of rice products is on the horizon for working people, school children and busy seniors who are hungry for a hot meal, but who don't have the time or the inclination to cook. In early 2007, Now Foods, LLC, Pearl, MS, says it will introduce Rice Now®, a line of prepared rice dishes in pouches made from Sonotort™ Shatterproof™ technology from **Sonoco** (www.sonoco.com).

This is the first commercial application of Sonoco's Shatterproof coating, an organic polymer that replaces the oxide and glass coatings typically used on retort pouches. The material is a three-ply laminate of (inside to outside) cast polypropylene, nylon and barrier-coated polyester. A feature of the Sonoco material is its ease of tearing. Starting with a tear notch, the material will tear completely across the top of the pouch from one side to the other.

Sonoco's reports that its Shatterproof technology is highly resistant to flex cracking, an unsightly phenomenon in which the laminate becomes marked with stress fractures as a result of handling during converting, packaging and distribution. The coating is also more robust than previous types of coating, offering better barrier properties at similar cost, the company says. Sonoco is supplying the printed Sonotort rollstock, and **Floeter, Inc.** (www.floeter.com), Elk Grove Village, IL, is converting the film into pouches.

The 8-oz single-serving pouches of Rice Now will be sold at discount stores throughout the U.S. There are seven flavors: Asian Stir-fry; Beefy Rice; Black Bean Chipotle; Garlic Butter; Golden Chicken; Red Beans and Rice; and White and Wild.

Shelf appeal was a major concern of Rice Now partner R.J. Reed. "Because this is a new product, it was important that the graphics convey the heat-and-eat nature of the product," Reed says. "The package's eight-color rotogravure printing provides the mouth-watering realism." The Shatterproof coating used in Sonotort retort pouches protects the shelf appeal, and the pouches do not contain foil, making them safe to microwave.



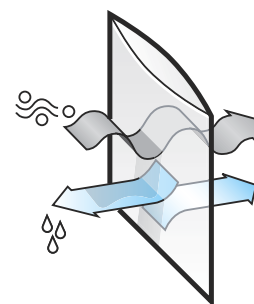


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design trends personal care

Take a tropical island approach to your hair



Vivid shrink-sleeve labels emphasize the papaya in a new line of haircare products from Freeman Beauty Labs of Beverly Hills. Supplied by Ameri-Seal, Inc. (www.ameri-seal.com), the four polyethylene terephthalate glycol labels have a tropical feel with papayas and palm trees, as well as cool shades of blue-green in the background. A small circle, also on the front label, with "Alcohol Free" printed in red on a bright-yellow background, helps grab the consumer's attention. The 8.5-oz spray bottles of shampoo and hair conditioner sell for \$4.99.

Ameri-Seal supplies the sleeves and shrinks them directly onto the high-density PE bottles at its Contract Sleeve Division in Chatsworth, CA. The PETG heat-shrinkable films offer 360-deg graphics enhancing packaging shelf appeal, and the heat-shrinkable sleeves can be printed in up to nine colors. They're suitable for manual applications, as well as for automatic and high-speed machinery.

Biodegradable packaging for Pangea Organics incorporates seeds that can be planted



Pangea Organics Ecocentric Bodycare is a leading manufacturer of organic personal-care products based in Boulder, CO. It specializes in 100-percent plant-based products. A year ago, Pangea Organics redesigned the packaging for its entire product line, and UFP Technologies (www.ufptech.com) provided the biodegradable and recyclable molded fiber packaging, including clamshells for its line of bar soaps. Now the company has gone a step further, and all of its product boxes are incorporating organic seeds like basil and amaranth. Simply slip off the label, soak the box in water and plant it in the earth.

Molded Fiber, a division of UFP Technologies, manufactures the customized shells, which are made from 100-

percent-recycled paper fibers and offer a cost-effective, environmentally friendly alternative to petroleum-based packaging materials. Molded fiber's inherent resilience and blocking and bracing capabilities enable it to outperform many plastics and corrugated designs, the company says. In addition, UFP's molded fiber has an inherent moisture content that does not fluctuate significantly.

In April, 2006, Pangea Organics was honored with Best New Packaging Award at Organic Products Europe in London. This is the second award Pangea has won as a result of the company's collaboration with internationally acclaimed branding firm IDEO (www.ideo.com). Pangea's new product innovation and design debuted in September 2005 in Washington, D.C.

Pangea products are sold in 17 countries and are found throughout the in Wild Oats and Whole Foods stores. Pangea Organics donates a portion of its profits to The Pangea Institute, which is dedicated to sustainable living and business practices.

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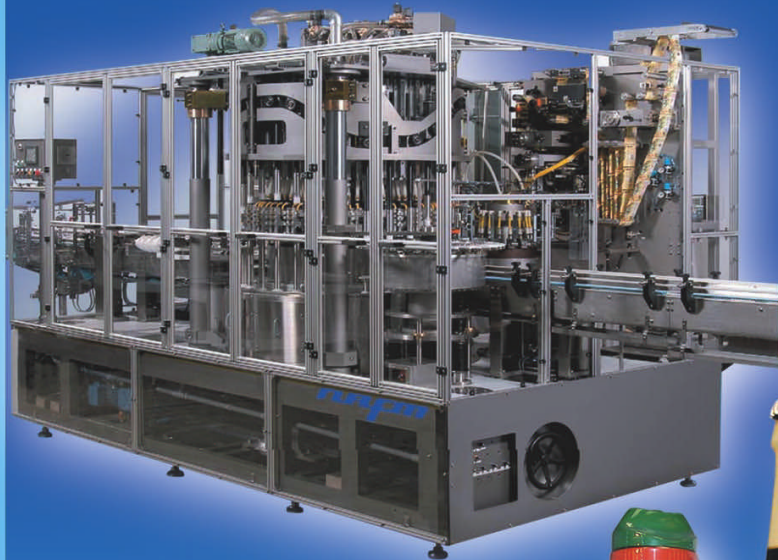
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design trends personal care

Starbrite whitening toothpaste debuts at Victoria's Secret



A cosmetic dentist's proprietary toothpaste formula promises "celebrity star power and a white smile." Since late November, shoppers at 71 flagship Victoria's Secret stores have been able to purchase the new toothpaste, an advanced whitening formula,

developed by Manhattan-based cosmetic dentist Dr. Debra Glassman, whose clientele includes celebrities such as Jessica Simpson, Randy Jackson and Usher. Starbrite whitening toothpaste, in a bright-pink tube and carton, aims to fit in with the Victoria's Secret

signature pink-branded stores. While other whitening toothpaste packages look medicinal and clinical, Starbrite's pink color scheme is a departure, and was chosen just for that reason: To distinguish the product's cosmetic appeal. The tooth-whitening business being an \$8 billion industry, Dr. Glassman hopes that Starbrite will make Victoria's Secret store shoppers smile.

Designed by **Moxie™** (www.moxietm.com), the bright-pink package features a Starbrite brand mark with a large silver star in place of the letter "a." The star becomes the symbol for the brand. Smaller silver stars are used as a design element for bullet points and borders around the package. The tagline, "for a white celebrity smile," and a photo of Dr. Glassman along with her signature completes the endorsement on the package. Inside, the carton is printed in a pink-and-black leopard design. Moxie also created sample-size packages that will be given out in select Victoria's Secret stores with every purchase during November and December.

By January 2007, the product will be sold in all Victoria's Secret stores for \$6.99. Future extensions of the line include a matching pink mouthwash and dental floss.

The Venetian and Wynn Hotels in Las Vegas will also be placing Starbrite toothpaste in its guest rooms and selling it in their hotel stores.

Ice cream packaging for Polish company

Last July, Kilargo, one of the top Polish ice cream producers, launched a premium ice cream in injection-molded and in-mold-labeled (IML) packaging from **Huhtamaki** (www.huhtamaki.com). "Kilargo wanted to create an exclusive ice cream package," says Joanna Grochowska, marketing manager for Consumer Goods Poland. "The role of the package was to differentiate the product from other ice creams and to convey a message of luxury and trendiness. We are very satisfied with the end product fulfilling the expectations put on it." The asymmetric shape and design of the 1-L premium packaging make it an eye catcher in the freezer. The matte, semi-transparent container and lid add value to the product and help consumers see how much ice cream the package contains. Both the container and lid are injection-molded of polypropylene. The advantages of injection molding are the high impact-resistance, high-end decoration by IML and the ability to make asymmetrically shaped packages. The shape of the Kilargo ice cream packaging supports the product brand and differentiates it from other similar products, the company says.

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design trends

Micro bowl serves up Heinz South Africa's pot pies



Heinz Foods South Africa has made pot pies dramatically more convenient for consumers there with the introduction of a new microwavable bowl designed by **Graphic Packaging Intl.** (www.graphicpkg.com). Replacing packaging that took 30 to 35 minutes to bake conventionally, the new paper-based

susceptor bowl can be used in the microwave and reduces preparation time by 85 percent. Made with GPI's new MicroRite™ Qwik-Crisp® material, the bowl's susceptor-coated polyester is laminated to a paperboard base. A special MicroFlex® Q patch is strategically placed on the inside of the outer carton to help

brown and crisp the pot pie crust and leave the filling moist and tender, while the rest of the packaging helps achieve texture, flavor and color. Heinz launched the microwavable bowl in June and has enjoyed a favorable response from stores and consumers. Sold under the Mama's Pies brand, the pies come in six flavors.



Customers flip over Anua's new line of haircare products

Alicorp, an international \$500 million company based in Lima, Peru, that is well known for its food products, such as pastas, ice creams and vegetable oils, has introduced its first haircare products to the South American market. Inspired by a local tradition of treating hair with natural plants and herbs, in September 2006, Alicorp launched Anua, a range of five shampoos and conditioners made from natural ingredients for each category of hair. The varieties are aloe vera and honey, avocado and oatmeal, lemon and coconut oil, lemon and green tea and wheat germ and egg. The target market is women from 15 to 45 years old who are urban and modern, but also concerned about getting the benefit of natural ingredients and healthy products.

Alicorp worked with **Raison Pure** (www.raisonpure.com) to design the bottles for the new products. Raison Pure's challenge was to create a shape that would enhance the natural aspect of the ingredients, as well as convey femininity and modernity. The soft curve of the 350-mL bottle gives life and movement, like the wind in plants or grass, and is an invitation to take the product in your hand. It also connotes the idea of active natural ingredients with white emphasizing the ingredient's illustrations and giving a pure, premium look. For the conditioners, the bottle is flipped, creating a duo of complementary products. The high-density polypropylene bottles are supplied by **Yobel Supply Chain Management** (www.yobelscm.biz), Lima. The standard cap, supplied by **Sequist Closures** (www.sequistclosures.com), comes in five colors, each matching the features and benefits of the various products.

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comment

Mary Ann Falkman, Editor



The 'anti-oyster' package challenge

When *Consumer Reports* published its first Oyster Awards article in March 2006, the editors poked more than just a little fun at packaging. Citing some amusing (and dismaying) real-life experiences that consumers have had trying to open tough packages—most often radio-frequency-welded clamshells—the article points out that the weapons-of-choice used in the quest to get at the product inside are often dangerous. Consumers have occasionally lost blood as well as time trying to “shuck” an impenetrable clamshell.

After the awards were published, a new media frenzy ensued, all of it targeted at the apparent crass nonchalance of companies that produce such annoying and even dangerous packaging. In the past nine months, I have been interviewed by countless newspaper reporters and columnists, magazines and even a television crew. The accusations are all the same: “Why can’t I open a CD without a knife that could cut me?” “Why can’t I get into a clamshell without using a [hacksaw, meat cleaver, box cutter—fill in the blanks yourself, depending upon how much your imagination can stomach] that could cut off my finger?” And to each of them I have replied: “I can answer that in one word: Theft.”

Retail theft is a multi-billion dollar problem. The major discount retail chains, operating on razor-thin margins, cannot afford to ignore this enormous drain on profits. The stores want sparsely manned aisles, but with product clearly visible for the shopper. Gone are the days of clerks waiting to show off their wares from inside locked glass cases. So these retail giants demand that consumer goods companies protect their products—especially those over a set price point—in clearly visible but secure packages. Unfortunately, the reality is that a package that is difficult to open in the store is going to be just as difficult to open at home. The corollary to that is: If it’s easy to open at home, it’s easy to steal.

So *Packaging Digest* would like to offer a challenge to the people who design and the companies that make these secure packages. There *are* packages that are easier to open while still maintaining protection—we’ve seen many and even tested some. If you send us your examples (either the packages themselves or a release with photo), we will include them in a special resource center on our website. We will make this resource center available to *Consumer Reports* and other media, as well as to consumer goods companies and the retail chains, to prove that packaging can be highly visible yet secure, safe to open yet protective. With luck, we may even convince the Oyster Awards editors to publish a link to this resource center in their second annual roundup, due out next spring. Then, we will publish a selection of the best examples in this magazine in the same month as *Consumer Reports* publishes its 2007 Oyster Awards.

Feel free to send comments on your own experiences in designing and making secure packaging—consumers aren’t the only people with a story to share.

I’m mfalkman@reedbusiness.com.

Mary Ann Falkman



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new products spotlight

Labelers Available from the co. are p-s labelers to suit a range of needs, including RFID, print-and-apply and apply-only standalone machines. It also offers the Model 1600 front/back and wrap system, the Model 1500 pharmaceutical wraparound labeler, corner-wrap and side-panel labeling capabilities for cartons, tabletop semi-automatics and bar-code scanners.

Labeling Systems, Inc., 201/405-0767.

www.labelingsystems.com

Sleeve To its list of high-performing shrink-sleeve applicators, the co. adds the MSA-180. This newest addition is reportedly capable of applying primary labels at speeds to 175/min and, in the co.'s words, is priced competitively for any player to enter the world of shrink-sleeve labeling.

Tripack Sleever,
866/900-1255.

www.tripack.net

P-s labelers Two approaches to bottle labeling are available through the co.'s MASTER tradename. One uses stepper motorization with programmable bottle-plate rotation technology; the second features servo motorization with the same technology. The co. notes that both offer more labeling accuracy and flexibility, applying up to four p-s labels at speeds to 200/min. The co. also offers the ROLLMATIC hot-melt rotary labeler, which applies rolled labels to cylindrical and shaped bottles.

P.E. USA, Inc., 513/771-7374.

www.pe-us.com



Flexo printer A new printing system suited for medical device applications, the Micromax/HP (MMP/HP) flexo-printing system with a traversing Hewlett-Packard ink-jet cartridge produces high-quality, in-line printing in up to four colors. As an alternative to rotary flexo printers, the MMP/HP is designed to provide the flexibility of ink-jet printing variable information, including expiration dates, lot numbers, bar codes and product data, using the thermal ink-jet cartridge. This means elimination of the need to insert slugs into a plate for each new date or number. To give this traversing flexibility to a traditional rotary flexo machine, a stepper motor would be needed. Combining the two functions, the co. piggybacks the cartridge on the existing traversing mechanism of the Micromax.

Greydon, Inc., 717/848-3875.

www.greydon.com



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www.khs.com

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new products equipment



PLA film shrink wrapper The new Bio-Wrapper is said to be the world's first shrink-wrapper series built specifically for use with biodegradable, compostable PLA shrink film. The series was developed to accommodate the lower shrink temperatures of PLA and can produce both total-closure (form/fill/seal) retail packs and bullseye wraps for distribution applications. The machine uses EarthFirst® brand PLA film from Plastic Suppliers, Inc., made from NatureWorks LLC's PLA resin. Features of the machine include the ability to produce ultra-high-clarity shrink wraps in nearly any product configuration and an all-stainless-steel construction for easy cleaning. The Bio-Wrapper is engineered as a complete unit with a double-insulated shrink tunnel that is said to reduce energy consumption. **Polypack, Inc.**, 727/578-5000. www.polypack.com
Plastic Suppliers, Inc., 800/722-5577. www.plasticsuppliers.com
NatureWorks LLC, 877/423-7659. www.natureworkslc.com



Filler/capper A new filler/capper, its product tank made of either titanium or HDPE, with the product circuit and shroud made of titanium, has been developed by the co. as a solution for packaging corrosive products without destroying the equipment while doing the job. The capper, the co. discloses, is over-pressured, and capping spindles are protected by bellows. Usually, the full enclosure is made of PP. For products such as bleach, the co. says, stainless-steel machines don't last more than a couple of years, but its titanium/plastic equipment can last 20 years in a very corrosive environment, it relates. **Serac Inc.**, 630/510-9343. www.serac-usa.com



Gripper chain The Tsubaki Gripper Chain™ combines high-performance roller chain with a choice of conventional or innovative, new side-swivel gripper attachments for easy film engagement for form/fill and vacuum-seal wrapping operations. Recessed, riveted pins are said to allow quick, easy length adjustments to keep production moving. Another plus: reduced maintenance. **U.S. Tsubaki, Inc.**, 800/323-7790. www.ustsubaki.com

Detection/inspection The new Apex™ high-performance metal detector improves metal detection sensitivity by up to 20 percent over the previous generation of products. Also new is the co.'s Prox contaminant-inspection system, as well as the Crystalvision, a CO₂ concentrate in-line monitoring system used during the brewing process for beer, sodas and carbonated water. **Thermo Scientific**, 763/783-2500. www.thermo.com



Ink-jet printer The PXR Series small-character ink-jet printer is said to feature an improved, 10.4-in. touchscreen, which increases clarity and contrast. The co. says the printer meets all RohS requirements and is the most environmentally friendly printer on the market today. **Hitachi America, Ltd.**, 914/524-6615. www.hitachi.us

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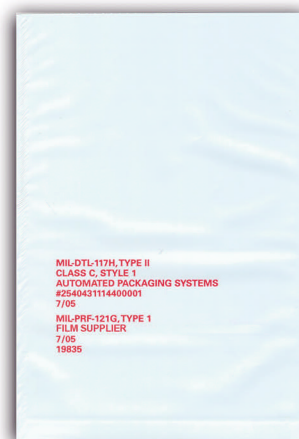
Visit our website @ www.satoamerica.com/gtepg/pd for your FREE GTe Product Guide

new products equipment

Inverted wrapper, cartoners The Doboy Linium 801 is a new, inverted, horizontal flowrapper for handling soft, flexible or shaped products. The machine ensures a smooth transfer of product from the infeed conveyor to the film-tubing section. Also from the co., fully integrated cartoning systems developed to provide turnkey solutions in complex applications from the pharmaceutical division are brought under the same roof with the company's Doboy BaggerBoss™ and PouchBoss™ automatic baggers and bag-closing machine.

Bosch Packaging Technology, 715/246-6511.

www.doboy.com



Military spec film The co. introduces new MLT1 and MLT2 heat-sealable packaging films that conform to military specification MIL-DTL-117H. Available in multiple variations, these high-barrier, multilayer coextruded films offer water- and grease-resistance and are extremely strong. A sealant layer facilitates a high-quality seal on the co.'s packaging systems.

Automated Packaging Systems, Inc., 888/288-6224.

www.autobag.com

Convey pneumatically to/from multiple discharge/inlet points

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Dust-free bulk bag untying, retying, removal

Revolutionary discharger features a SPOUT-LOCK® clamp ring* that creates a high-integrity, clean seal between bag spout and hopper, preventing contamination and dust during hook-up and discharge. TELE-TUBE® telescoping tube* raises the clamp ring to make connection, then lowers, applying continual tension to keep spout taut as bag empties/elongates, preventing dead spots and flow restrictions. POWER-CINCHER® flow control valve* cinches the spout concentrically for easy, leak-proof retying of partially empty bags. BAG-VAC® dust collector creates negative pressure within dust-tight system to collapse empty bags prior to retying and disconnection, eliminating dust from manual flattening of empty bags.



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New SWING-DOWN™ bulk bag filler* lowers and pivots the fill head, stopping it in a vertically-oriented position that places the bag inlet spout inflatable connection, inflator button, and four bag loop latches within one arm's length of an operator standing on the plant floor, allowing safe, rapid bag connections. Eliminates danger of stepping onto and over roller conveyors to access rear bag hooks and spout connection collars, standing on the conveyor with head and arms inserted beneath operational fill head components, and straining to pull bag spouts upward over inflatable collars while reaching for bag inflator buttons. Available to industrial, food, dairy and pharmaceutical standards with numerous performance enhancements.



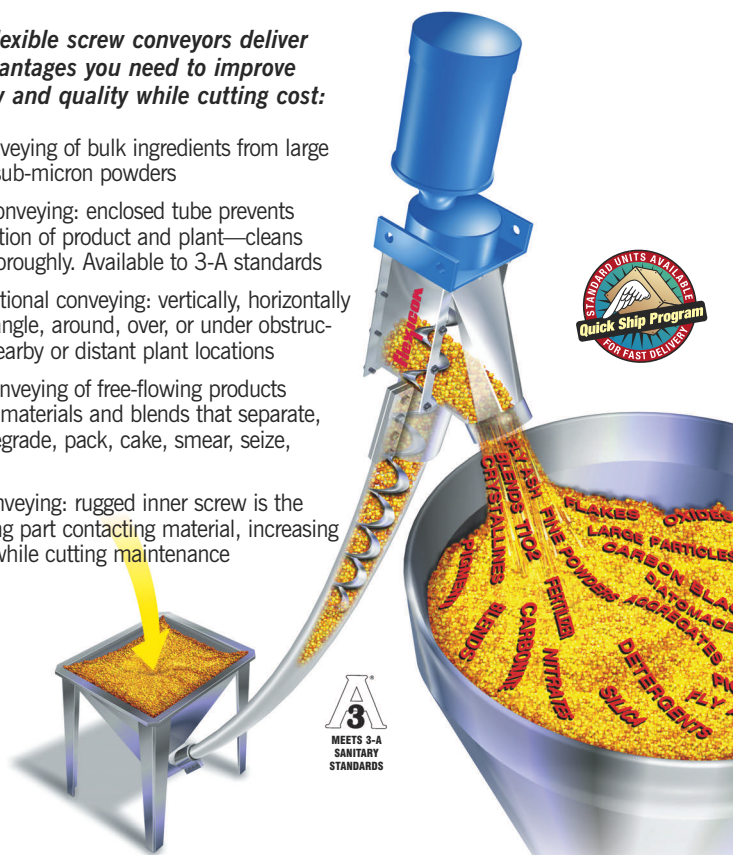
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T-0620

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- Simple conveying: rugged inner screw is the only moving part contacting material, increasing reliability while cutting maintenance



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Flexicon conveyors offer solutions to problems that can exist with other types of conveyor systems:

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- Separation of blends
- Problematic conveying of materials that fluidize, degrade, plug, pack, cake or smear
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new products materials

Bottles & Closures

Bag-in-box The Jerribox™ jumps into the bag-in-box market with a 2-component structure promising increased efficiency and packaging quality while decreasing waste and supply-chain costs.



Designed to run on current rigid filling equipment, the package comes in sizes from 10 to 20 L, plus nonstandard capacities, and consists of a cartridge and a box. In the plant, the case is erected and the flaps are glued, and the cartridge containing the bag and spout is picked and inserted manually or robotically with an air pulse, breaking the seal and

releasing the bag within the case as low pressure inflates the bag. A large, non-glugging spout is said to eliminate splashing of the contents.

Scholle Packaging, 708/562-7290.

www.scholle.com/jerribox



PET resins ParaStar PET resins are introduced using the co.'s IntegRex technology, reportedly making it possible for converters to create bottles using fewer processing steps. The resin offers unprecedented clarity, improved bottle-to-bottle consistency and acetaldehyde levels lowered by 25 percent or more. Particularly cited for bottled water use, the resins are described as drop-in replacements for standard PET on bottle-making equipment and are fully recyclable, with Q1 '07 availability.

Eastman Chemical Co., 423/224-0528.

www.eastman.com



Chemical dispensing DrumQuik® PRO debuts as a chemical dispenser, designed to provide safe, easy and economical extraction of chemicals from drums, jerry cans and other bulk-transfer containers while helping to reduce spills and contain hazardous fumes. The closed system is said to combine in one unit a recyclable bung closure and a diptube with a reusable quick-disconnect coupler, with no special tools required to connect the coupler to the system.

Colder Products Co., 866/671-9165.

www.colder.com

If You Want To Maximize Control In Your High-Speed

Often the bottleneck of the labeling process, open glue pots and roller wheels require frequent maintenance and adjustment, impeding productivity and wasting adhesive. Until now, labelers were stuck without an alternative.

The packaging industry spoke. And Nordson listened.

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Our patent pending system maximizes production efficiency without compromising line speed or accuracy in magazine-fed labelers.

More Reliability

Dependable PatternJet technology brings process control to your operation. Precise temperature control and accurate adhesive deposition delivers more consistent label pick-up and drastically reduced downtime.



Non-contact wraparound labeling system accurately applies adhesive to containers.

Two separate guns apply adhesive to the container and label, respectively; the non-contact pick-up gun accurately jets adhesive spirals onto the container while the lap gun evenly dispenses adhesive onto the label. Precision application eliminates common labeling issues such as unsightly adhesive squeeze out, flagging labels and pop-opens.

Accurate, repeatable adhesive application increases overall production efficiency by reducing the downtime associated with unscheduled line stoppages.

More Savings

Did we mention our labeling system cuts adhesive consumption by more than half? Wheel pots are known for messy application and an abundance of waste. The PatternJet system is a cleaner, more reliable



Closure Developed for carbonated soft drinks, water, malt beverage and other applications is the 28-mm Xtra-Lok mini, said to offer many of the same features and performance as standard-size closures, but in a lower-profile design. The 2-pc closure reportedly enables reduced system packaging cost and maximizes product freshness with its XT™ liner while providing easy opening via the co.'s sure-grip knurl.

Alcoa Closure Systems Intl., 773/380-7717.
www.alcoa.com/csi



EDP label stock EDX9512 makes its bow as a premium EDP label stock for packagers and converters. Said to feature excellent quick-stick to corrugated substrates and ease in label converting, the product reportedly uses a premium #50 uncoated, smudge-resistant paper stock with a high degree of brightness and whiteness, exhibiting good internal strength characteristics and print receptivity and ST-95 wide-web converting acrylic emulsion permanent adhesive for excellent tack on a wide variety of surfaces, with semi-bleached, super-calendered kraft liner, suitable for die-cutting and stripping.

MACTac Roll Label, 800/548-3456.
www.MACTac.com



CD trays Combining a starch-based fiber material that's injection-molded with recycled paperboard, the co. introduces PaperFoam® 5-in. CD trays, which were reportedly first used in the U.S. by Universal Music Enterprises. With technology from PaperFoam BV, the package is said to be recyclable, renewable and biodegradable when composted. The co. says the structure is available in various colors, can be embossed and printed, and provides excellent dust-free, scratch-free protection.

Shorewood Packaging, 212/508-5662.
www.shorewoodpackaging.com

Production Efficiency And Gain Process d Labeling Application, Keep Reading.

solution, that performs consistently, dispensing the optimal amount of adhesive every time, at any speed.

Open pot systems also expose adhesive to contamination from air, moisture and dust, which rapidly degrades adhesive. First-in, first-out systems eliminate adhesive circulation and prevent fumes and adhesive contamination.

Closed systems deliver a significant reduction in adhesive consumption, fewer product rejects and lower overall maintenance costs.



Clean, reliable system optimizes adhesive usage and increases production efficiency.

More Flexibility

Easy-to-install PatternJet labeling systems quickly retrofit into wheel pot configurations and the flexible design provides for user-friendly format changes.

Non-contact adhesive application also allows for more options in label and container materials and thickness.

Warm, hot, cold and/or wet containers pose no problem for PatternJet's adhesive delivery system and deformed, irregular or odd-shaped containers do not affect accurate label application.

The PatternJet system delivers superior flexibility in high-speed packaging applications.

Why settle for less when you can have so much more? The industry's leading packaging companies are making the switch to Nordson's non-contact labeling systems—call us today to find out why you should too.

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Flagging, misaligned and double-pulled labels are common issues with wheel pot applicators.



Many standard cap closures will not protect your company, your customers or your employees from possible spills or accidents. RD Industries has developed SafTflo, an inexpensive built-in protection at the packaging level.

SafTflo is a self-venting chemical containment system designed specifically for your existing product containers.

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sustainability

Sustainable packaging: new questions to ask

Anne Johnson

Typically packaging design balances performance and marketing appeal against the constraints of materials and cost. The ideas behind sustainable packaging do not override or eliminate any of these critical and important concerns. Quite the opposite: Traditional market criteria are key components of any sustainable packaging system.

Including sustainability considerations at the level of design expands the definition of quality for packaging. So in addition to the traditional considerations, the definition of sustainable packaging asks companies, packaging designers and engineers to evaluate the potential and quality of any given package design using an expanded framework.

We have always asked, "Does the package protect the product?" Now, we also ask, "Are the materials in my package healthy for people and the environment throughout its life cycle?"



Including sustainability considerations at the level of design expands the definition of quality for packaging.

We have always asked, "Is the package design cost-effective?" Now, we also ask, "Are my materials responsibly sourced?"

We have always asked, "Does the package sell the product to the consumer?" Now, we also ask, "Does my package educate consumers on what to do with it after use?"

Conventional design considers performance, cost, appearance and regulatory compliance. Sustainable packaging adds optimization of resources, responsible sourcing, material health and resource recovery.

So why would any business bother asking these additional questions? I am sure many think they are burdensome or costly, and they certainly challenge the status quo. The answer is responsible business practice and future business sustainability.

I recently attended a meeting of **Incpen - The Industry Council for Packaging and the Environment** (www.incpen.org), which is a packaging group similar to the SPC based in the U.K. Dax Lovegrove of **WWF** (formerly known as the **World Wildlife Fund**, www.panda.org) made a presentation on WWF's One Planet Living initiative. His main point: There is only one planet, and we are already exceeding its capacity. Climate change is only one signal out of many of the growing strain. With the addition of 3 billion citizens in the upcoming decades, operating conditions for business will change because the denominator most certainly won't. As businesses, we can either rise to the challenge now or find ourselves chasing those who have figured out how to respond better—or worse.

Up until this point, business has enjoyed ready access to resources and benefited from being able to externalize many costs associated with environmental impact and waste that often result from a limited focus of design considerations. In Europe, Japan and Canada, regulations are increasingly driving these costs back onto businesses as societies with constrained resources bump into limitations.

Expanding the questions we ask is part of sustainable packaging design and part of the process of planning for business sustainability. The challenge before us is to figure out how to do it—how to innovate and improve our performance across these expanded categories, balancing our performance today with that of tomorrow, because the denominator is not changing.

Anne Johnson is the director of the Sustainable Packaging Coalition, a project of GreenBlue (www.greenblue.org).
For additional information, email info@sustainablepackaging.org.

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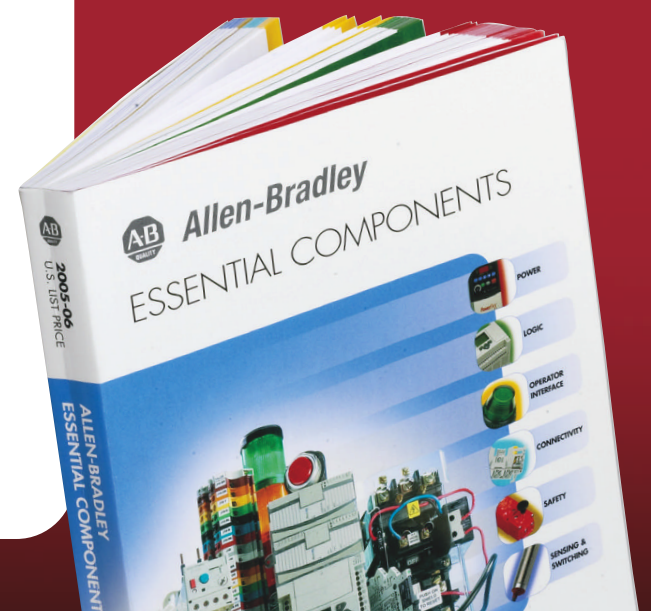
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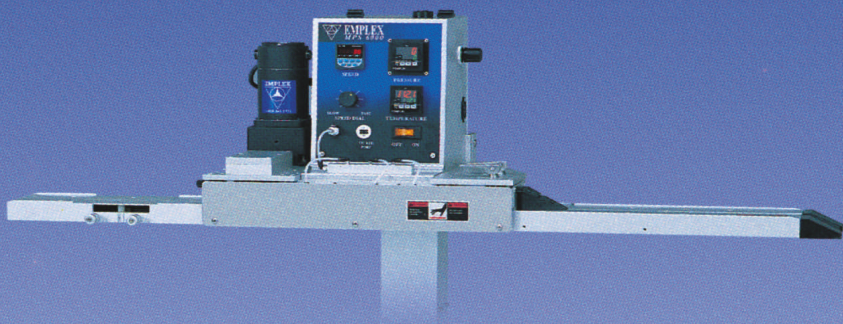
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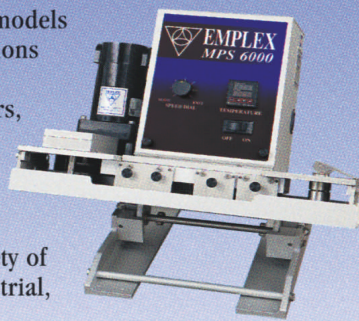


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system integration

System integration automation alternatives

Vance J. VanDoren, Ph.D., P.E.

System integrators can specify, procure and install the components of an automation system and make them all work together with a client's production equipment. But independent integrators aren't the only source of system integration services available to automation users.

As noted here last month, many automation vendors provide system integration services along with their products. Distributors have also gotten into the integration business as a means of bolstering their own product sales. A deal that includes the services of a local engineer who can understand and install the product is often more appealing to a prospective client than the product alone.

Moreover, many distributors have been feeling competitive pressure from low-cost vendors who take orders exclusively over the web and ship directly to the end user. By adding system integration services to the mix, some distributors are hoping to compete on value even if they can't compete on price.



The ambitious end user may find that employing the best talent from all of these sources is the way to go... At every step, individual experts may be needed to tackle specialized jobs.

Large firms and small

There are the giant architectural, engineering and construction (AE&C) firms that are capable of building entire factories and automation that rarely describe themselves as "system integrators," but they can often achieve the same results. Some have entire divisions that do nothing but provide automation engineering services for their sister divisions' projects.

On a smaller scale, many custom machine builders can construct what amounts to a "factory in a box" with all of the production equipment, controls and operator interfaces integrated into a single unit. They often employ the same brands of hardware and software that traditional system integrators use, but the name on the box is theirs.

At the other extreme, individual engineers can provide some (though generally not all) of the services required to implement an integrated automation system. These are often former employees whose jobs as in-house engineers were eliminated to cut costs. Their former employers sometimes realize that no one else is quite as good at handling that particular factory's automation needs, so they end up back on the job as consultants.

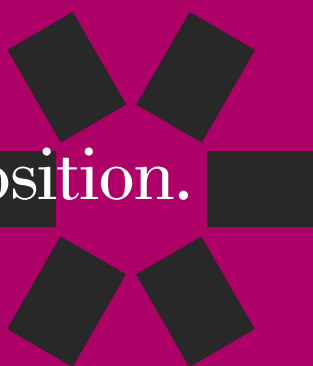
Individual consultants may not know how to handle all aspects of all systems integration projects, but the tasks they do know, they know well. Traditional systems integrators often employ consultants when the job calls for engineers with specific or unique skills, especially skills related to a particular industry or technology.

The right combination

The end user may find that employing the best talent from all of these sources is the way to go. An AE&C firm might be hired to construct the factory building, providing the necessary electrical and mechanical superstructure on which the automation system can be built. An independent may work with automation vendors and local distributors to implement the controls for the processes and so on. At every step, individual experts may be needed to tackle specialized jobs.

Consulting Editor Vance J. VanDoren, Ph.D., P.E., contributes articles on process control, advanced control and system integration. Dr. VanDoren also edits Control Engineering's and Packaging Digest's annual Automation Integrator Guide. Dr. VanDoren previously served the industrial automation industry as an applications engineer for General Electric and as a product marketing and development engineer for Texas Instruments' Industrial Automation Division. He currently manages a firm of consulting engineers in Lafayette, IN, where he develops custom control strategies for advanced process-control applications.

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Making Safety Smarter, Easier, and Less Expensive

Manufacturing engineering organizations are becoming aware of the strategic value of safety, recognizing that the use of intelligent safety systems can increase machine uptime and limit liability exposure. As a result, many have come to view an intelligent safety strategy as a competitive advantage rather than a cost burden.

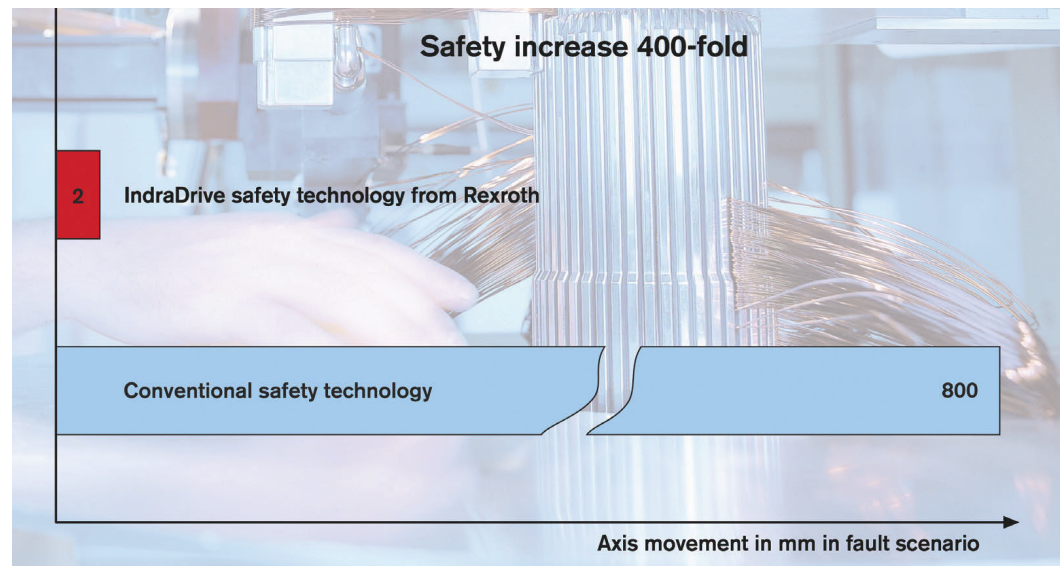
The objective:

keeping operators safe

Conventional safeguarding systems emphasized operator safety at the expense of productivity. However, despite the efforts to make equipment “absolutely safe,” operators seeking productivity improvements may override a conventional safety system because they need access into the machine working area. All too often, an accident results.

A smarter solution

A more modern, effective safeguarding strategy evaluates how the operator interacts with the machinery. Modern, intelligent safety solutions are usually associated with safety PLCs that replace conventional hard-wired safety relays. However, it is far more important to avoid unintended axis movement and create safe motion that reduces the risk of operator injury by



allowing continued but limited axis movement. In addition, the use of freely programmable safety logic greatly increases the flexibility of a safety system.

The Rexroth IndraDrive’s “Safety on Board” feature offers a reliable safety solution that incorporates the most advanced integrated safety functions and complies with the latest international standards for safe stopping and safe motion. These capabilities are available on a common platform that functions as a servo-drive or frequency converter, thus lowering the overall cost of integration and deployment for the machine builder while providing the latest safe motion technology to the end user.

Faster reaction times

The IndraDrive also has reaction times that are 400 times faster

(see graphic) as opposed to technology like Rockwell Automation’s DriveGuard, a conventional solution that uses contactors to produce a safe stop.

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Because IndraDrive’s Safety On Board safe motion technology is integrated directly into the drive, motion controllers regardless of manufacturer are able to leverage safe motion technology. The IndraDrive has enough I/O for the safeguarding logic needed to interface to safety gates, panel switches, and interlock switches. Thus, machine builders only need to learn one safety solution for an application.

For the only modular, controller-independent safe motion solution from a global motion control company, choose Safety On Board on the Rexroth IndraDrive.

A 'butter' way to palletize



California Dairies installs two robotic palletizers to handle 275,000 lb of butter a day. The plant's vast range of butter products includes more than 170 skus in case sizes ranging from eight to 55 lb.

California Dairies, Inc. is the number-one dairy cooperative in California and the second largest in the U.S. It is owned by more than 650 California dairies that ship nearly 17 billion lb of milk annually to its five (soon to be six) processing plants. This equates to 45.5 million lb of milk/day, and that will soon increase to more than 50 million lb/day when the new Visalia, CA plant begins production. In addition to fluid milk processing, California Dairies and its subsidiary companies produce dry milk and butter-milk powder, butter and cheese and make a variety of vacuum-condensed and ultra-filtered dairy products.

California Dairies' plant in Turlock, CA, processes up to 5.7 million lb of milk/day and produces more than 110 million lb of butter/year, which is about 275,000 lb of butter/day. The plant produces more than 170 skus of butter in case sizes ranging from eight to 55 lb. To help keep so much product moving through its plants, the company is implementing more and more automation, including a new robotic-palletizing system. "The cows don't take time off for weekends or holidays, so the plant operates twenty four hours a day, seven days a week, year around," says

Eric Snoke, vp of operations of both the Turlock and Los Banos, CA, plants.

Last year, Turlock automated the entire butter-line palletizing operation with a system that includes two four-axis EPL160 Expert Palletizing robots from **Motoman, Inc. (www.motoman.com)**. Motoman also provided the overall systems integration, working in



A Motoman robot at **ALIMENT PUTTER'S FOOD, INC.**, Sainte-Sophie, Quebec, runs up to 12,000 cases of pickles per day, each weighing up to 20 lb. Read about it at www.packagingdigest.com/info/putters

close partnership with **Prime Conveyor, Inc. (www.primeconveyor.com)**, which supplied the conveyors and some of the controls work per Motoman's design. Snoke was discussing this project with several robot companies, when Doug Hill, president of Hill Packaging Systems (www.hillpackagingsystems.com) suggested he call Motoman. "It turned out that Motoman had the best system for us," says Snoke.

"Formerly, all of the palletizing was done manually, but at the rate we produce butter—three cases/min on eight lines for a total of 24 cases/min—this was

backbreaking work," says Snoke. "When operators got tired, it would slow the packaging room down, which would slow down the line. We'd have to shut a few machines down until they could catch up. We knew that we needed to automate the operation to improve productivity and reduce costly worker compensation claims from back injuries."

In addition to fully automating the packaging line, project goals included creating more consistent and stable loads and maximizing system throughput by eliminating downtime. "We calculated that the payback for the system would be two years or less, based on direct labor savings alone, and that does not take into account the reduction in workmen-compensation claims," Snoke says. "We haven't had any back injuries in that department since we put the robots in. Strains and back injuries, in general, are our biggest concerns. When lifting 55-pound boxes, one slip can cause you to throw your back out. Claims in the past were costly."

"We need eight or nine fewer direct-labor people per day now that we have the robots. Once we knew we were going to put in the robots, we let normal attrition reduce the headcount, and we covered with overtime. We didn't give anybody pink slips because of the robots. Our people like the robots a lot. This is a



When butter is first made, it is soft, so custom end-of-arm tooling was developed specially to handle it. The paddle-type gripper is very gentle on the product, and it adjusts the air setting automatically for each type of box, so that each one gets just the right amount of pressure.

union shop, and the robot-operator jobs were bid. We had quite a bit of competition for the jobs to run these robots. Machine operators have a higher pay scale, so our people like that, too.

"We had no doubt that the robot system would work, but it was surprising how smoothly everything went in. Within a couple of days of bringing up the first line, the production crew's skepticism about getting it all to work was replaced with excitement about getting it all on line."

"The robot system has improved our ability to run in a consistent manner. Our packaging department has tried to push the limits, but the robots don't even break a sweat. We wanted to over-engineer the system by at least twenty percent. If every machine in the plant was running at maximum capacity, we could still have twenty percent robot capacity to do catch up. For example, if a line went down for some reason, such as a bad pallet, we always have a little capacity to do catchup."

Adding robotic automation to the butter-palletizing line at Turlock was a challenging proposition. "When this project was first proposed, I thought it was crazy. With so many different products and the high level of complexity involved, I never thought it would be possible," says Keith Gomes, California Dairies' senior vp and COO. "But the success of this robotic-palletizing system at Turlock made a believer out of me, and it has had a major impact on how California Dairies will operate in the future.

"Traditionally, our industry has been fairly labor-



Did you know?

Did you know: Whole milk contains approximately 3.5 percent butterfat. The cream portion is separated and concentrated to 40-percent to 42 percent butterfat content. This cream is then churned into butter, which by definition, contains at least 80 percent butterfat. Salt and/or food coloring can be added to produce a multitude of varieties.

Source: California Dairies.

intensive. We still have some jobs that cannot be automated, due to antiquated and outdated U.S. Department of Agriculture requirements and regulations. Washdown requirements, the wet environment and corrosive chemicals in our butter-production room are other barriers to automation. For example, the salt that is added to many types of butter is excessively corrosive to machinery. However, due to safety concerns, productivity requirements and reliability considerations, we will be trying to automate as much of our process as possible as we move forward. Both case packing and palletizing will be fully automated in our new Visalia plant."

The robots stack product onto four-way **Grocery Manufacturers Assn. (www.gmabrands.com)** wooden pallets in a multitude of different patterns. The robots also handle tier sheets and top sheets. Not all case

patterns require tier sheets between layers. However, every pallet has a tier sheet on the bare pallet and a top sheet on the last layer. Only one major customer requires tier sheets on every layer.

"Pallet loads can be up to sixty-inches high, excluding the pallet. Stacks need to be tight, and labels need to be facing out whenever possible to facilitate bar-code reading," Snoke says. "Having the labels facing out is especially important for the display pallets used by the 'Big Box' stores."

Reliability is also extremely important. "Any downtime is incredibly problematic for our plant," says Snoke. "We have to keep running, and we have to have contingencies in place. One of our design criteria for the robot system was to have the ability to go back to manual palletizing in a dire emergency. We also wanted one party responsible for all aspects of the entire automation project, including the robots, controls, sortation systems, scanning systems and conveyors; all the way through to the printer that labels the stretch-wrapped pallets."

Butter has some unique properties that make palletizing it uniquely challenging. "When it is first made, butter is soft," Snoke explains. "Motoman developed custom end-of-arm tooling just for us. The paddle-type gripper is very gentle on the product. It adjusts the air setting automatically for each type of box, so each one gets just the right amount of

Continued on page 30

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pressure. We also sell large amounts of butter to 'Big Box' stores that use display cases that are open at the top. We needed a gripper with jaws that handle the boxes from the sides."

The paddle gripper is equipped with vacuum cups to assist in handling some products. When picking slipsheets, the robot gripper drops down onto a stack of slipsheets, and arms rotate out of its sides. After it picks up the slipsheet and drops it off, the arms fold back up, and the robot goes back to palletizing product. "It is a very

active system, particularly when we are running all eight lines and the robots don't have to stop and wait for product to accumulate. They are fascinating to watch. We sometimes have to shoo people away, because they like to stand around and watch everything work," Snoke continues.

Cases of product from up to eight production lines are combined onto two trunk lines that convey the cases to top and bottom flap-detection stations. Barcode scanners at these stations validate the bar code's readability and identify



The robots stack product onto four-way wooden pallets in a multitude of different patterns. The robots also handle tier sheets and top sheets.

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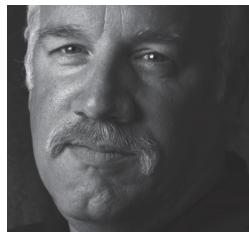
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the case's assigned conveyor-lane destination prior to flap detection.

Cases that do not pass due to unreadable bar codes or are unglued or have bad flaps are rejected down a manual line, keeping problem cases within the cold room. Cases that pass the checkpoints travel up an inclined belt and continue overhead through the wall that separates the cold box from the palletizing room. Cases then travel down a decline belt and are transferred onto a belt-sortation system. They make a 180-deg turn, after which another barcode scanner again reads which of the eight downline conveyors used to queue product for robotic pickup has been designated as the destination for that particular case.

If the bar code on a particular case is

The robot supplier is the most professional group we've ever worked with.

not readable or its designated downline conveyor is full, the case is directed onto a recirculation conveyor. Cases on this conveyor are accumulated, are reintroduced into the sortation process and then are either directed to the previously full down-line conveyor or diverted onto the manual "nored" line.

Normally, a case travels to its designated downline accumulation conveyor. Each of the two Motoman robots services four of these infeed accumulation conveyors, which are equipped with case-crowding mechanisms and bump-turn devices. Once enough cases of a particular sku have accumulated for a pick cycle, the system signals the appropriate robot that product is present. As soon as the robot is available, it moves to that line and starts palletizing the load according to the pre-programmed stacking pattern.

The robot generally grasps two cases

Sainsbury's helps 'mooove' the U.K. dairy industry forward

The dairy industry in the U.K. may be able to look forward to a less volatile, less pressure-driven market, with Sainsbury's new pledge to work directly with hundreds of dairy farmers. Announced in October by *Dairy Reporter.com*, the deal, among other changes in the industry, should help to stabilize the supply chain and increase milk prices for producers. The Milk Development Council's (MDC) new Supply Chain Margins Report says that pressure on milk producers there may ease off next year.

Cuts to farmgate milk prices this year are likely to see 2006 remembered as a gloomy year for U.K.-based farmers, but some stability may return in 2007, according to the report. The news followed a partnership announcement by Sainsbury's, which formed a new collaboration with farmers, and England's National Farmers' Union (NFU) said it would collect invoices to reveal the true extent of producer losses.

Concerns surrounding the county's milk supply system has put unsustainable pressure on farmers. Nearly three farmers per day have left the sector in the last year, some estimates say.

Reduced market support and prices under the EU Common Agricultural Policy reform made milk prices more volatile in 2006, notes Ken Boyns, head of economics at the MDC.

"The period of intense change may be coming to an end in the short-term, and those who are focusing on improving their farm productivity and maximizing the price of their milk at the moment may start to see better returns compared to the present," Boyns says. Farmers may also be helped by greater efforts to make the supply chain more stable.

Dairy Crest, a top U.K. dairy firm, indicates that it would raise the price it pays to direct milk suppliers by 0.2 pence/L and Sainsbury's, which recently signed an 18-month supply deal with Wiseman and Dairy Crest, said it would work directly with 450 farmers, linked to processing firms Robert Wiseman and Dairy Crest, in a new dairy development group. The retailer sells about 420 million L of milk each year. Both dairy firms, the MDC and the NFU welcomed the move as a way of bringing the supply chain closer together.

per pick cycle. The custom paddle-style gripper is designed with two separate zones, providing an asynchronous placement capability. For example, the robot could be programmed to pick up two cases (one in each zone), and then release the case facing in one direction before reorienting and releasing the remaining case. "Right now, though, cycle times are such that we just have the robot pick up a single case and place it individually," Snoko says.

The robot palletizes cases of product onto one of four designated pallet-

load/build conveyors and also adds the slipsheets and tier sheets from dunnage carts as required. These dunnage carts are loaded by an operator and locked into place within the palletizing cell. Spare dunnage carts allow the operator to have the appropriate stack of sheets available, reducing downtime during the replenishment process.

A common dual conveyor-bed transfer-car (T-Car) system shuttles empty pallets, singulated from an automatic pallet dispenser, into the robot-palletizing cell. Once the robot

loads the pallets, the T-Car system transports full pallets to the stretch-wrapper infeed conveyor that leads to the Model S1501 stretch wrapper from **Lantech.com, LLC (www.lantech.com)**. The stretch-wrapped pallets are automatically labeled with multiple copies listing the contents, and are then conveyed back through the wall into the cold box. There, loads accumulate and are removed by forklift truck for shipment or storage. Whenever a load is moved, a portion of the label is torn

Continued on page 32



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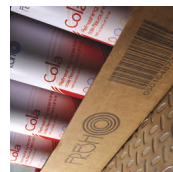
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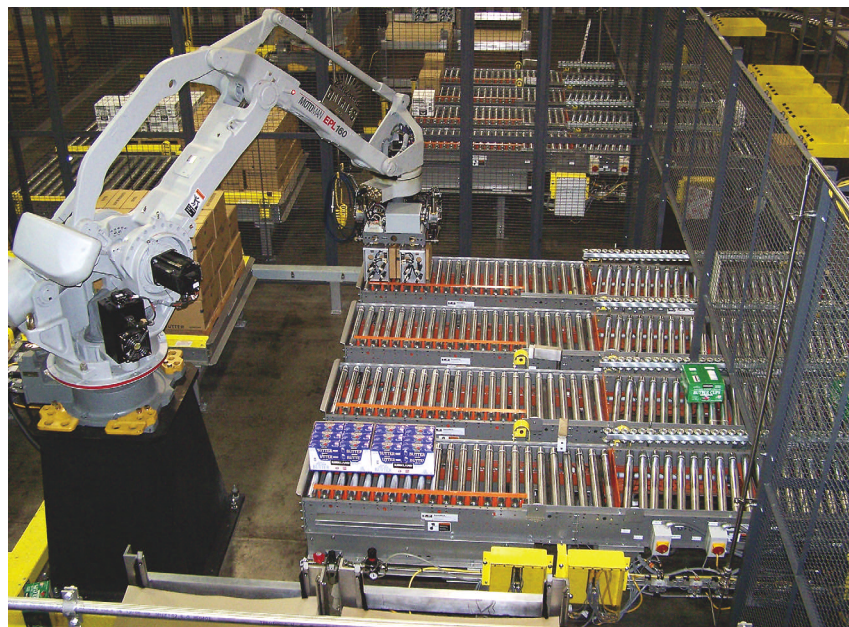
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off. These ticket labels provide a simple way to track the movement of each pallet. One or two are always left on the load, so the customer has a receipt. The T-Cars, conveyors and automated pallet dispenser were supplied by Prime Conveyor, Inc. Hill Packaging Systems installed the robots, as well as all of the equipment supplied by Prime Conveyor. **Industrial Electric Co.**, (www.i-e-c.net) did the electrical and control wiring for this project.

System controls include a two-door control panel in the cold box and a three-door panel in the palletizing

room containing the Allen-Bradley CompactLogix PLC from Rockwell Automation (www.rockwell.com). Two Motoman MotoHMITM provide operator interfaces in the rooms. Each HMI includes an industrial PC running RSView ME software on the 15-in. color touchscreens. The overall system utilizes DeviceNet as the communication protocol between devices, as well as for communication with the two Motoman NX100 robot controllers. The MotoHMIs contain an Ethernet interface with the California Dairies' server that allows the



Two robotic palletizers handle more than 170 skus of butter in case sizes ranging from eight to 55 lb.

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introduction of new products as well as tracks the status of the system.

Motoman also provided all cell guarding, including wire safety fencing, four dunnage access gates with positive-break safety switches, two light curtains separating the T-Car from each of the two robot cells and one set of self-muted light curtains at the stretch-wrapper infeed conveyor. Dual-channel safety hardware for access gates and light curtains meets the American National Standards Institute/Robotic Industries Assn. R15.06-1999 safety standard.

"Every 24 to 30 hours the production room goes down for a cleanup that includes a complete wash of the whole room," Snoke says. During that time, the robot-palletizing room gets swept and everything gets cleaned up and put away, Turlock is a shielded plant, which means that we have a resident USDA inspector. The production room is always under close USDA scrutiny, and the robot room is also inspected regularly."

California Dairies is very serious about bio-security and lot traceability. "The robot system allows us to track product by time and date stamp, so we can trace the production of each lot and sub-lot in great detail. Each operator has a code, so we can tell who was running the machinery at any given time," Snoke explains. "We actually do six mock recalls a year, which involve tracing back through every aspect of production—from where the lot originated, and where it was sent, all the way up through the distributor. All products are marked 'Hold and Ship.' The microbe count must come back within specifications before the butter can be shipped.

"I've been involved in building entire plants from the ground up and have been involved in a lot of automation projects, but I've enjoyed this one more than any I've ever done. I'm as proud of it as I've been of any installation. We work as a team here at California Dairies, so it was important for us to have all areas of the plant involved in the project. For example, Glen Dortch, our warehouse manager, put

Each of the two robots services four infeed-accumulation conveyors, which are equipped with case-crowding mechanisms and bump-turn devices.

together all the information Motoman needed on the multitude of different boxes the robot system needs to handle. Tom Baldwin, our butter-production manager, provided critical information about product consistencies, packaging, etc., that Motoman needed for gripper and system design. Jon Sylvia, our plant-maintenance manager, was directly in charge of the system installation. John Bos, plant manager, was key to getting workforce buy-in and in streamlining all of the organizational elements.

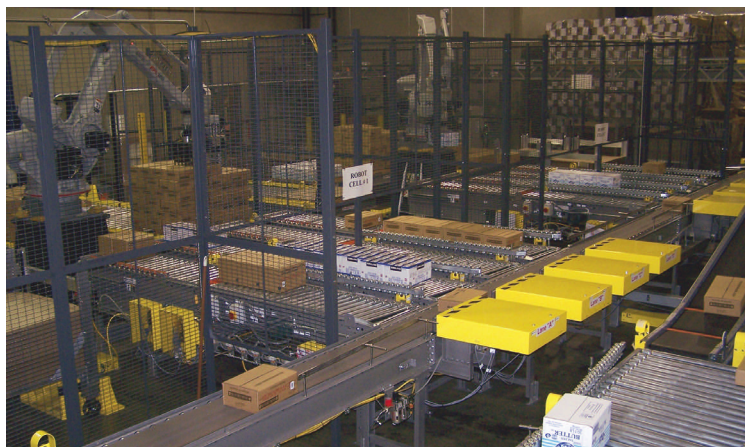
"Motoman is the most professional group we've ever worked with. They really impressed us right from the start, when they sent a group of eight extremely talented and dedicated people here to investigate every single avenue of the project. Right off the bat, we got a good feeling about what we could expect from them.

"Every aspect of the project,

Every aspect of the project, from concept through installation, programming, and training, went extremely well, and we've been incredibly happy.

from concept through installation, programming and training, went extremely well, and we've been incredibly happy. Motoman did the initial robot programming and still provides support whenever we need it. For example, Motoman's regional support specialist has been invaluable in super-fine tuning the programs. If we need something, we just call, and he's right there."

The plant is looking ahead to future automation projects. "We're considering replacing an existing, non-Motoman four-axis robot used to palletize bags of powdered milk, with a new Motoman palletizing robot that is smarter and much more user-friendly," Snoke says. "Additionally, we're talking about things that we're trying to automate at all of our facilities. Our new Visalia plant will be the most automated plant in our system. It will also be a bulk butter/powder plant and undoubtedly will use robots. Anywhere in the process where people potentially could get hurt, we're looking at using robots and automation."



More information is available:

Motoman Inc., 937/847-6200. www.motoman.com.

Hill Packaging Systems, 209/456-3379.

hillpackagingsystems.com.

Industrial Electric Co., 209/527-2800.

www.i-e-c.net.

Lantech.com, LLC, 502/267-4200.

www.lantech.com.

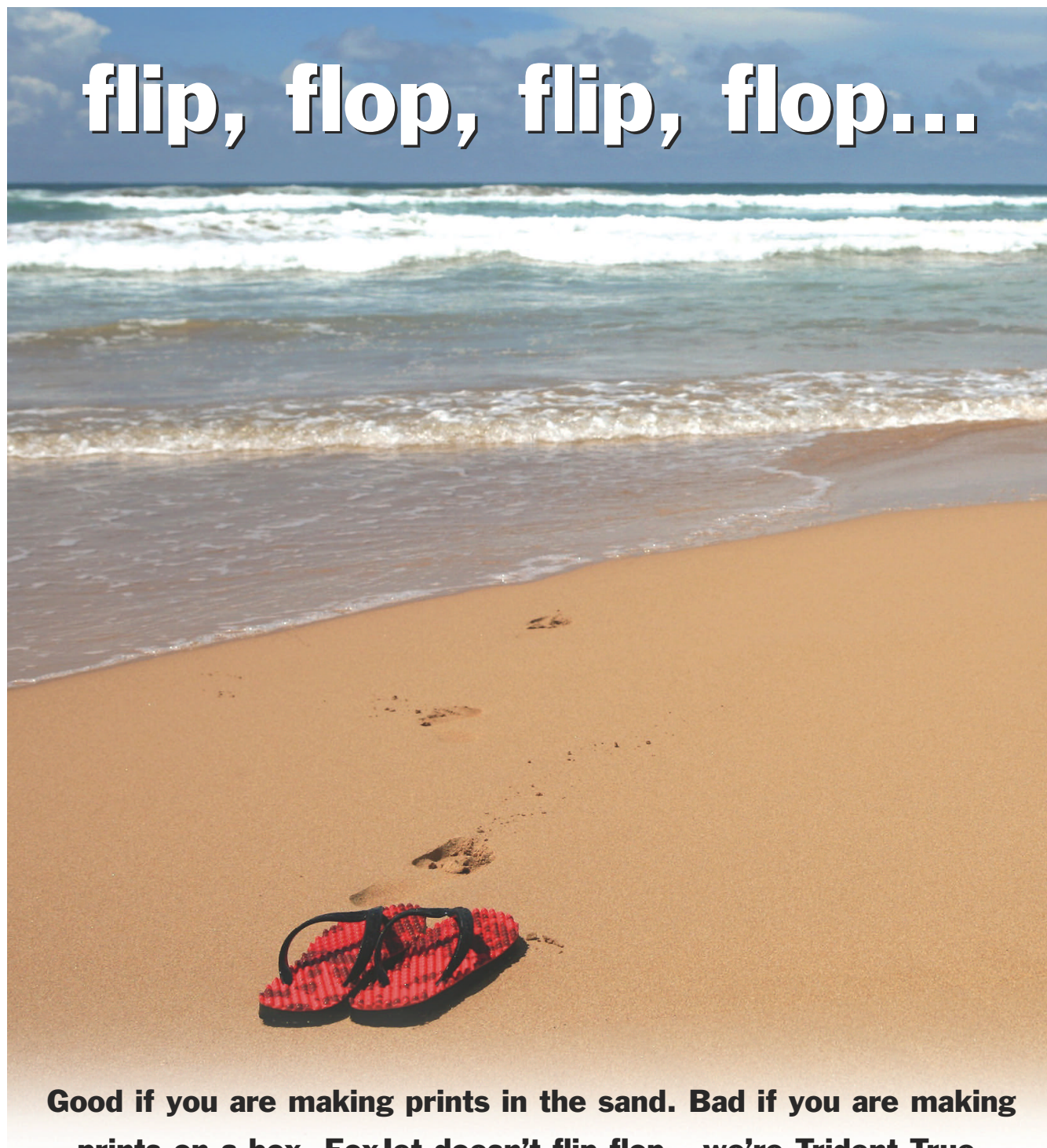
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www.primeconveyor.com.

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RFID labels let Cingular Wireless send the right signals

The wireless communications carrier 'Raises the barSM', with an automatic print-and-apply system that has allowed it to integrate radio-frequency identification smart labels within its warehouse and material-handling operations.

Lauren R. Hartman, Senior Editor

Cingular Wireless carries voice and data communications for more than 54 million customers around the world each day. But the Atlanta-based wireless carrier found itself facing a challenge in getting radio-frequency identification (RFID) smart labels to encode correctly for cellphones and subscriber identity modules (SIM, or a smart card, sized similarly to a postage stamp, that securely stores the key identifying a mobile-phone service subscriber, as well as subscription information, saved telephone numbers, preferences, text messages and other information) that it ships to Best Buy and Wal-

The multiprotocol RFID print engines above, can be configured for Gen 2 through a firmware download. The cases receive RFID labels as they pass.



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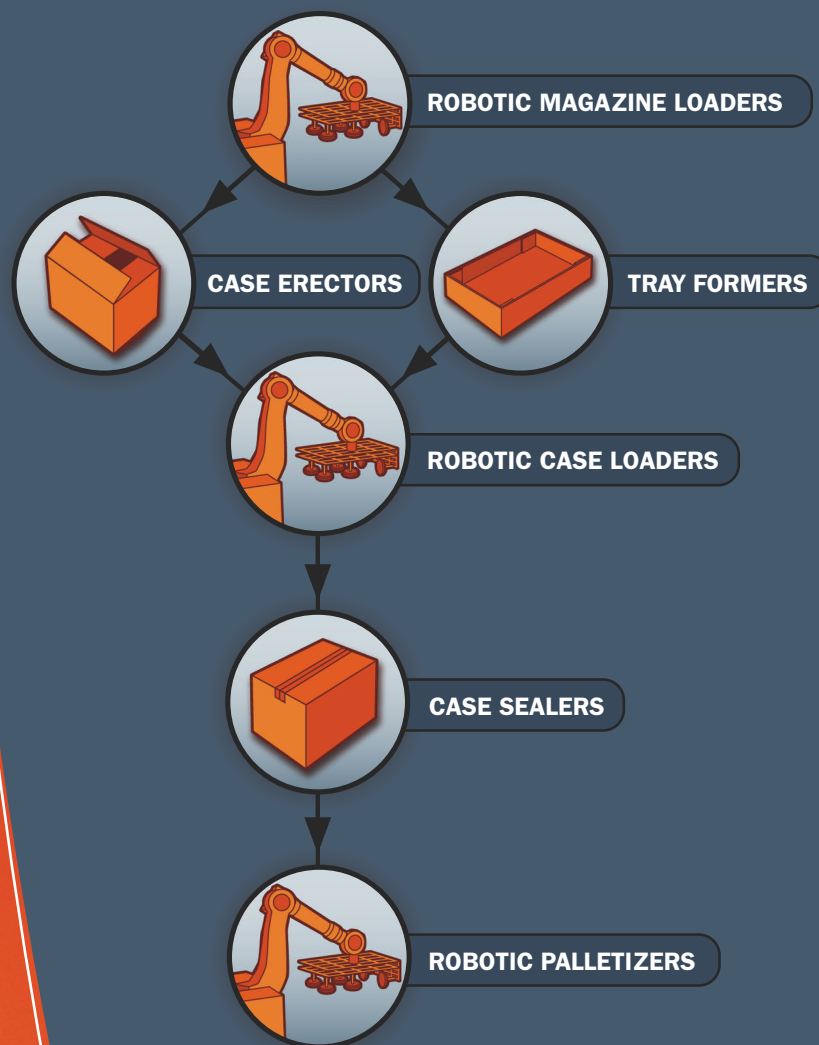
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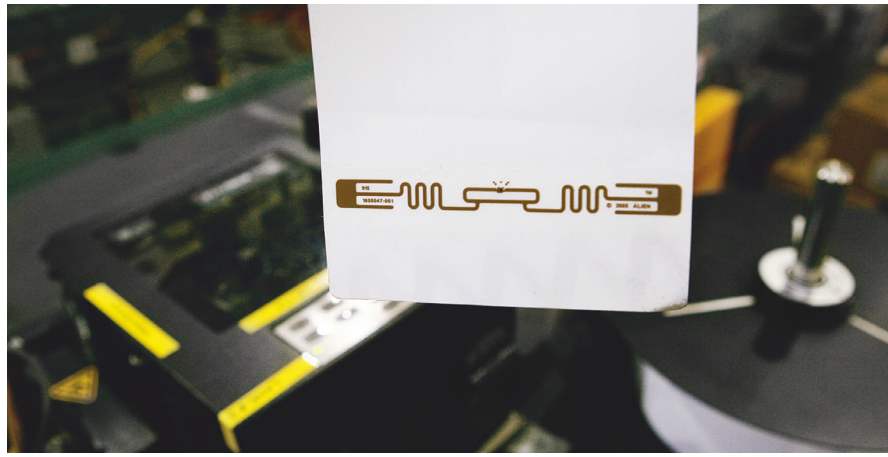
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Mart from its distribution center facility in Memphis.

Considered one of the largest wireless companies in the U.S., with more than 58 million subscribers who use the nation's largest digital voice and data network, Cingular says it's dedicated to providing wireless technology designed to enrich its customers' lives. The company wanted to begin automatically tagging its shipping cases with RFID labels and replace its manual label-application operation in order to expedite and facilitate its picking, printing and shipping processes.

"We had to operate at a speed of fifteen cases per minute without errors, and had to be able to fix errors quickly, without impacting our production," explains Tracy Yee, IT systems analyst at Cingular, who is heavily involved with the smart-labeling system. "The printer/applicator needed to be RFID-compatible, offer label verification and apply a shipping label, a packing list label, and a UCC-128 label. The entire PNA [print-and-apply] area needed to be able to process forty-five cases per minute."

Cingular worked with **Zebra Technologies** (www.rfid.zebra.com), single-source software/conveyor provider **Fortna** (www.fortna.com) and **ID Technology** (www.idtechnology.com) to design and implement an automatic smart-label print-and-apply system that could be tightly integrated with its warehouse and material-handling operations. With the RFID



One element for a successful RFID implementation is finding the right media to ensure that the chip and antenna inlay within the label are positioned correctly to work with the printer/encoder. After testing various label media, Cingular chose this smart-label version.

Matching smart labels to the printer/encoder is very important. We tried to do it ourselves, but it got really challenging.

idtechnology.com) to design and implement an automatic smart-label print-and-apply system that could be tightly integrated with its warehouse and material-handling operations. With the RFID

equipment, networks and warehouse-management system (WMS) interface in place, finding the right smart label was the final detail that made the whole system run reliably and efficiently. Cingular installed an R110PAX4 printer/encoder engine and an ID Technology Model 250 printer/applicator on three conveyor lines set up for in-line print-and-apply label application on packed cases. The R110PAX4 validates that the inlay was encoded prior to being applied. Each line produces 15 cases/min and all three produce 45 cases/min total. Says Yee, "This [equipment] was the best fit for our existing software applications, and we get the best service from our vendors."

The company then turned to **Mid-South Marking Systems** (www.midsouthmarking.com), another Zebra partner, to find suitable smart-label media that would work well with its packaging, products and processes. Mid-South provided custom RFID roll labels outfitted with inlays and also synchronized the plant's conveying arrangement with the new labeling equipment, and Zebra provided a smart-label material that best suit Cingular's needs.

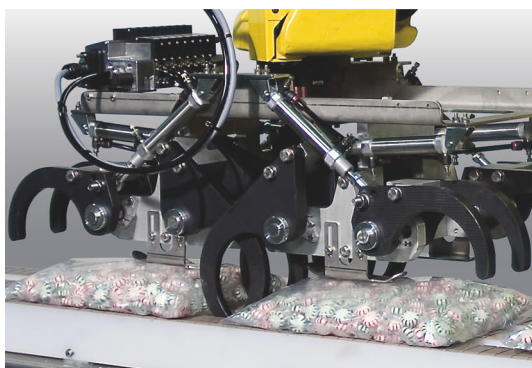
"Matching smart labels to the printer/encoder is very important," adds Yee. "We tried to do it ourselves, but were going through labels left and right. It got really challenging."

Continued on page 36

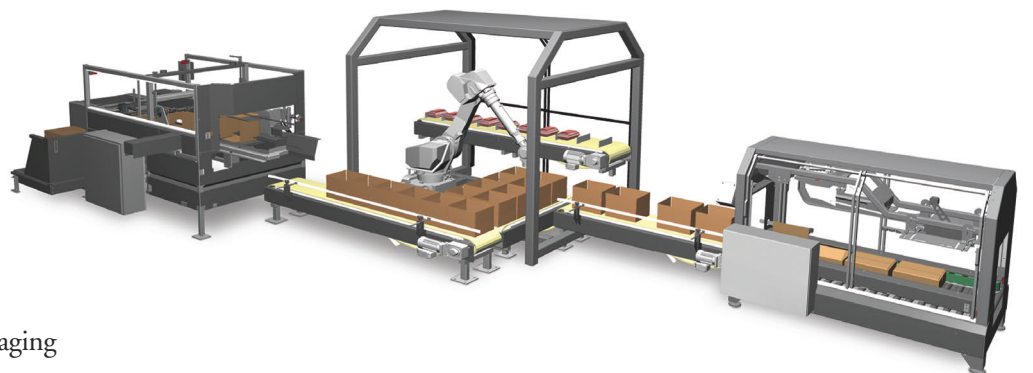
Pearson delivers modern-day case packing system

Traditional methods of case packing have dominated the packaging industry for decades. Yet, when manufacturers have to keep up with changing package styles, case/tray designs, and packing configurations, a traditional case packer can become a roadblock to meeting production demands. Robotic case packing with a multi-axis articulated arm robot is an emerging alternative. When faced with the need to keep up with an ever changing array of products and case packing configurations, robotic case packing provides unmatched flexibility.

As in any case packing system, accurate and consistent product handling is critical. The Pearson RTL-MX Robotic Case/Tray Loader utilizes a



mechanical gripping end-of-arm-tool, line tracking, and custom product conveyor. As a result, the RTL-MX yields superior product handling and up to 30% higher throughput when compared to a vacuum based system.



This innovative approach was achieved by Pearson through collaboration with their customers and by utilizing state-of-the-art technologies to develop new products that are real solutions.

The RTL-MX, integrated with the industry recognized Pearson case erector, tray former and case sealer, results in the modern day end-of-line case packing solution. This system is adaptable to future changing environments and operational requirements with minimal investment or equipment modifications.



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As Cingular discovered, though smart-label printer/encoders and media may support the same standards and RFID protocols, they aren't necessarily

the position of the inlay isn't carefully matched to the specific make and model of a printer/encoder the inlays are being used with, the smart labels may fail to encode properly. Cingular learned this after trialling 30 to 50 unencoded inlays per roll of 800 labels.

Yee points out, "If we hadn't called Mid-South, we might still be working on this. Mid-South and Zebra got us. Mid-South were the only ones that we tried that had the knowledge and level of expertise that we required."

Currently, Cingular receives orders

from Best Buy, Wal-Mart and other national retailers through an electronic data interface (EDI) that links directly into its WMS from **Red Prairie** (www.redprairie.com). Workers pick cases of cellphones using a pick-to-light system and place them on automated conveyors (from **Hytrol** [www.hytrol.com]) that route them to a sorting area. At this stage, Cingular's WMS creates shipping label information and generates a Serial Shipping Container Code (SSCC) shipping label for each order, assigning a unique electronic

 Read how Magnet, a healthcare group purchaser, chose Zebra's **BAR-CODE AND RFID PRINTERS AND LABELS** to reduce medication dispensing errors in hospitals at www.packagingdigest.com/info/magnet

compatible. The position of the RFID chip and antenna inlay within the label stock isn't the same in all media. So, if

RFID marches on at the DOD

The U.S. Department of Defense (DOD) is expanding its use of radio-frequency identification technology for military use in the American armed forces. The DC Velocity website reported in early November that by late September, the DOD had equipped 19 defense distribution centers with RFID-capable readers and has already begun to accept shipments supplied with RFID tags.

ODIN Technologies (www.odintechnologies.com), Dulles, VA., installed RFID hardware under a \$7.7-million DOD contract that it was awarded in May, with the company proclaiming that it completed the RFID installation in just under 130 days. That's considered an industry record, the report says, even though each site required extensive acceptance testing before the equipment was approved for use. Notes Patrick Sweeney, ODIN's chief executive officer, "We had to demonstrate 100-percent accuracy on read rates at the case level before we could get paid for each portal. Each portal had to read twenty different Gen One and Gen Two tags on the pallet at 100-percent levels. We were required to do ten trials of acceptance testing for each pallet. It's more complex than Wal-Mart, which is just trying to read one pallet tag."

In September, the DOD began issuing contracts for deliveries of products that include a requirement for passive RFID tags on cartons and pallets, according to a report in *Modern Materials Handling Magazine*. The first shipments began arriving at Defense Distribution Depots in Susquehanna, PA, and San Joaquin, CA, last January. But the program is quickly rolling out beyond those two sites, and by Jan. 1, 2007, all DOD manufacturers and suppliers will be required to use RFID tags on all shipments. The transition has apparently been a smooth one. Implementing the technology is becoming easier than it was when Wal-Mart's top 100 suppliers began working with RFID technology—a result of experience and lessons learned by early adopters and new Gen 2 standards for passive RFID in the supply chain. What's more, the DOD gained experience working with RFID through strategic relationships with its key suppliers prior to an official rollout, including Lockheed Martin, Boeing and General Electric. "The technology is just more robust," says Damon Bramble of **Alien Technology** (www.alientechnology.com), which the report indicates has developed an RFID program to help small companies understand and comply with the DOD's requirements.

The Navy and Air Force are also getting on the RFID bandwagon, says Greg O'Connell, manager of government sales for Zebra Technologies.

More information is available:
Alien Technology, 408/782-3900.
www.alientechnology.com.
ODIN Technologies, 703/968-0000.
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An overview shot of the RFID conveyor lines at Cingular Wireless in Memphis, above, shows three RFID print-and-apply case-conveying lines that together run 45 cpm.

product code (EPC) serial number to each case of cellphones and SIMs.

From there, the WMS transmits the pick-file details and label information over Ethernet to the FortnaPlus™ real-time warehouse-control software. Fortna led the system design and integration and engaged ID Technology to provide label printing/applying equipment and related expertise for the project. The warehouse-control software then sends a pick-light signal/message to a particular picking zone to alert the picking operator of a specific number of cases to pick for a stockkeeping unit (SKU). Once the SKU has been picked and scanned, the case is routed down one lane of a set of print-and-apply label lines equipped with the R110PAX4 RFID print engines and the Model 250 label printer/applicators. The data goes into the FortnaPlus software, which inserts the data into the order line and sends another message out to search for the case.

"Smart labels take about 150 milliseconds longer to produce than conventional bar-code labels because of the time required to encode the RFID tag," explains Mark Bowden of ID Technology. "We needed to account for that when we designed a print-and-apply system to work with automated conveyors. Having reliable equipment and supplies are key. If you have a reliable printer/encoder and good tags, you can meet the challenge."

The messages from the WMS to the conveyor system also direct the automated print-and-apply system to detect the cases traveling down the line and to print and encode the RFID smart labels for the particular case SKU and affix it to the case as the case travels by. The Zebra R110PAX4 print engine validates that the RFID tag inlay is properly encoded before the label is applied to the case. After the case is labeled, it moves downline and passes through a set of RFID readers that track and check the smart labels, read them and report the information back to the WMS for a second check. Cingular

also uses several Zebra R110Xi tabletop printer/encoders as backups for the higher-speed printer/applicator system, but the R110Xi units have rarely been used, since the company has the "right media selection, which prevents 'bad' tags from being applied to the cases," according to Yee.

With tags in place on the cases, the FortnaPlus control then sends the WMS a "print and apply (PNA) complete" message, which initiates further

processing by the WMS as the cases make their way to the end of the line en route to the shipping area where they are loaded onto trucks for shipment.

All of the printer/encoders were upgraded after their original installation in October 2005 to support Cingular's planned transition to the EPC Gen 2 RFID protocol in May 2006. "The transition to Gen Two was completely seamless," notes Yee. "We can't afford disruptions in the warehouse, and didn't have any. We have used Zebra bar-code

Continued on page 38

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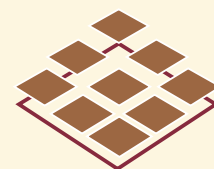


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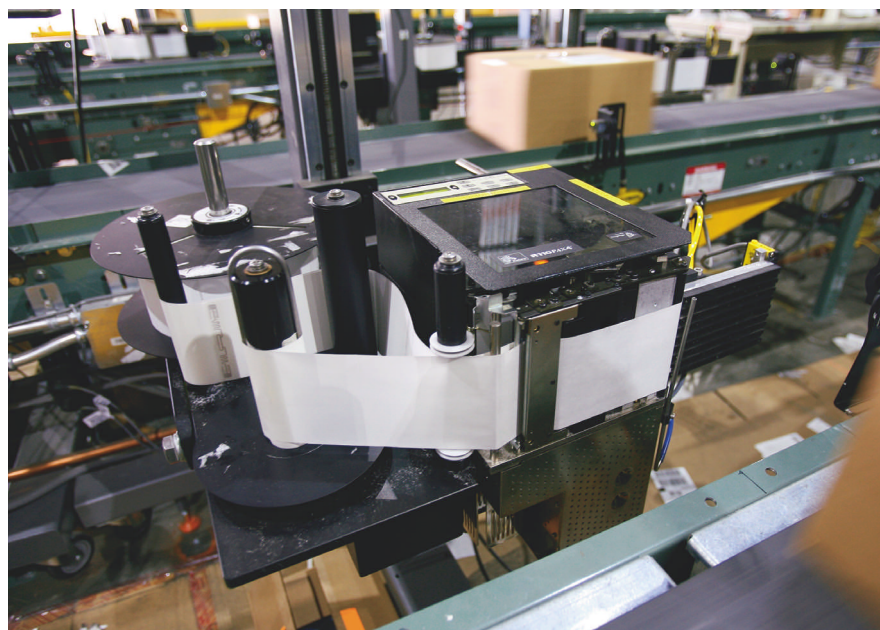


printers for a while with great results, so expected that their RFID printer/encoders to work as well."

The R110Xi and R110PAX4 have software-defined radios that can be upgraded to support new protocols with a firmware download and can be configured remotely. No replacement parts or hardware changeovers were needed for Cingular to upgrade the printer/encoders to support Gen 2, and the printer/encoders can also still encode other protocols. Cingular also takes advantage of the network connectivity

built into its smart-label printer/encoders to view configurations and conduct other management activity.

"Cingular is generating more volume than many other smart-label applications, but this still isn't considered high-volume for automatic print-and-apply systems," notes Bowden. "Print-and-apply systems are capable of much higher speeds. With RFID smart labeling, the key is to prevent a bad tag from being applied to the container. The Zebra print engine has an automatic safeguard for this, so it's a very good fit



Once the cellphones are picked and packed, the case-label data is transmitted to one of the RFID print engines integrated with an automatic label printer/applicator, above.

for an automated system."

Zebra and Red Prairie say they have also collaborated for some time to ensure that the printing/encoding systems Zebra brings to the table can tightly integrate with the WMS software environment. "We weren't going to bring in a printer that hadn't been thoroughly tested and proven with the Red Prairie WMS," Yee says. "We were looking for a way to speed up and automate our shipping/labeling process so that we could more effectively ship to customers. The system we found helps increase our accuracy and productivity. Our operations have been helped tremendously by the PNA area. We are able to pick orders faster and route them down the three lanes that print shipping and packing lists." The results of the RFID equipment and system upgrades have been dramatic, affirms Yee. "Now, we're pretty much running trouble-free. Read rates on the conveyors are close to 100 percent, and the number of inlays that fail to encode is minimal."

Yee says a good way to prevent problems on the packaging lines is to work with printing and media specialists up front. "If we had to do this again, we would have involved Mid-South and Zebra a lot sooner," she says. "We'd rather pay three or four cents more for [an RFID] label and know that it's right for our printer/encoders, than try something less expensive that doesn't work as well and takes a lot of time to correct."

More information is available:

Zebra Technologies, 847/634-6700.
www.rfid.zebra.com.
Fortna, 615/376-1919. www.fortna.com.
ID Technology, 888/438-3242.
www.idtechnology.com.
Mid-South Marking Systems,
 901/360-8207.
www.midsouthmarking.com.
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DVD box set is a 'grave' undertaking

HBO Video creates the complete experience for 'Six Feet Under' fans with a DVD boxed set that is deadly authentic.

Anne Marie Mohan, Senior Editor

The plot thickens for Home Box Office, Inc.'s family funeral parlor television series, "Six Feet Under," with the launch of a cleverly conceived DVD boxed set replicating a gravesite with headstone. Released in mid-November, "Six Feet Under: The Complete Series" DVD gift set from HBO Video is secondarily packaged in a carton produced and printed by New York City-based **Ivy Hill, a Cinram co. (www.ivyhill-cinram.com)**, to look—on the top—like a burial plot, with the six feet of what's under comprising the body of the box.

Relates Nick Ciallelo, vp of creative services at HBO Video, "Our aim is always to provide fans with packaging that creates a strong connection with the shows they know so well."

The fittingly designed box holds 25 cased DVD discs that include all five seasons of the darkly comic series, as well as two discs of series soundtracks and a guide that lists "obituaries" for the show's characters. To hold the series' "body of work," the carton is made from .080 chipboard covered with a laminated paperboard stock, both from proprietary suppliers, that is printed by Ivy Hill in four-color offset plus a water-based coating.

SanPan Design (www.sanpandesign.com), also of New York City, designed the box's earth and headstone graphics, which are tastefully overprinted with the epitaph, "Six Feet Under, The Complete Season, 2001-2005." Surrounding the grey-marbled "headstone" on the top of the box is the pack's crowing glory—faux grass, supplied by a proprietary German manufacturer of grass for model train sets.

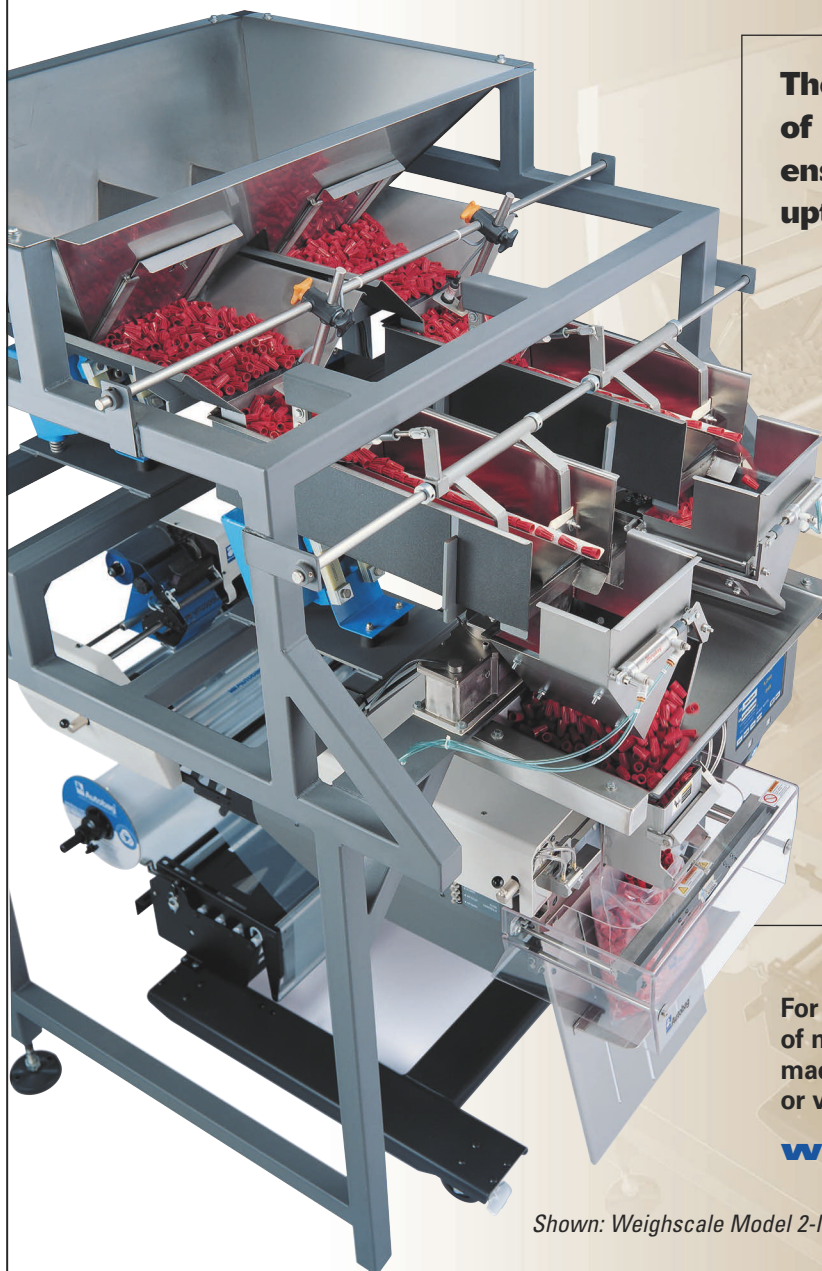
"Six Feet Under: The Complete Series" DVD gift set is available for \$279.99 through the HBO website, as well as in retail stores nationwide.

More information is available:
Ivy Hill, a Cinram co., 646/834-1500.
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Compact machines get tea retail-ready

With the installation of 15 new tray former/shrink wrappers, Twinings has the versatility to create shelf-ready retail packs that fit numerous customer requirements to a 'tea.'

Anne Marie Mohan, Senior Editor

For 300 years, Twinings has been a leader in the blending of high-quality teas that today are enjoyed in more than 100 different countries around the world. Not content to rest on its laurels, the company constantly strives to innovate and create new beverages to meet consumer expectations and changing tastes. From everyday, traditional and specialty teas, to fruit and herbal infusions, aromatic teas, healthy green teas and iced teas, Twinings offers flavors and varieties to suit virtually any predilection.

Conscious not only of its end-users' preferences, Twinings also makes every effort to meet the requirements of its retail distributors, as is evidenced by the installation over the past two years of 15 new Europack tray formers/shrink wrappers from **Bradman Lake Group (www.bradmanlake.com)** at its tea-bag plant in North Shields, Tyneside, England. The machines are part of a \$1.9-million-plus makeover of the plant's end-of-line packaging systems. The investment, which is the result of Twinings' in-depth evaluation of future market needs, provides the company with the capability to produce a full range of shelf-ready packaging options.

According to Twinings, supermarkets have been a major driver in the growth of shelf-ready packaging, as retailers attempt to cut the in-store costs of unpacking and shelf filling, maximize product display and reduce waste disposal. Before investing in new end-of-line packaging equipment, Twinings was supplying its

retailers with bundles of shrink-wrapped cartons or cases of product, both of which had to be manually loaded onto the retail shelf, carton-by-carton.

One method of shelf-ready packaging now being requested by retailers of brand owners such as Twinings are shrink-wrapped trays of product that can be placed in their entirety onto the shelf once the film wrap is removed. While this format is not new, in the past, the brand owner determined the size of the tray according to their production capabilities. Today, retailers are setting the specifications, and these may vary from one supermarket chain to another. In addition, some smaller supermarkets still prefer receiving unsupported shrink-wrapped packs.

In January 2005, Twinings installed two new Europack machines custom-designed by Bradman Lake to enable carton collation, tray forming and shrink wrapping of twin-face packs in one, compact unit (13.73×9.84 ft) that could work within Twinings limited floorspace.

"Two Europack machines proved the three-in-one machine design on shrink/tray twin-packs for our specialty tea range," says Twinings project engineering manager Keith Darroch. "Then, market demand switched once again to single-face packs, and we decided to invite tenders for a whole new end-of-line operation."

Eight machinery companies competed in an open





The all-in-one carton collation, tray-forming and shrink-wrapping system, above, saves valuable floorspace. At right, Keith Darroch, Twinings project engineering manager, left, and Europack sales director Ivan Reeve hold two of the eight possible package formats.



"The features of the RTSW that are particularly beneficial to Twinings are that the machines are very compact and needed to be so to be installed into existing floorspace where only a shrink-wrapper had previously operated. They are also very flexible in providing many packaging formats using quick but accurate size-changing features."

More information is available:

Bradman-Lake Group, 704/588-3301.
www.bradmanlake.com.

tender, from which Twinings considered three: one German, one Italian and Bradman Lake. "On speed and performance, size, delivery to our time scale and cost, the Europack machines were the best," says Darroch.

To accommodate the products currently run at its North Shields plant as well as new product launches, Twinings has installed 15 Europack model RTSW machines with integral collating and tray-wraparound assemblies. The RTSW is a side-fed, fully automatic "Tight"-style wrapper. According to Bradman Lake, the Tight wrapper applies film to the product so that it just fits without applying any tension. Since less film is applied, less heat energy is reportedly required to shrink the film. This, coupled with improvements in the shrink-tunnel design, has resulted in a smaller, more-efficient heat chamber, the company explains. In contrast, the company says, with conventional shrink wrappers, film is loosely applied around the product, and a large, high-energy shrink tunnel is required to shrink the

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Some of the U.K.'s favorite ice cream pops are being shrink-wrapped in a new, £7-million plant addition at **RICHMOND ICE CREAM** in the U.K. on a system that saves energy and is durable at 40 deg C. See www.packagingdigest.com/info/richmond

film sufficiently to fit the product.

Each RTSW machine at Twinings can collate cartons and produce tight film shrink wraps or can erect minimum-depth trays, load and shrink-wrap them in single- or twin-face packs at speeds up to 30/min. The machines are capable of producing eight possible carton collations, ranging from single-face, 1×4 to 2×6 twin shelf-ready formats. Changeovers, including change parts for the tray-forming tool, take only 15 minutes, Bradman Lake reports.

Confirms Ivan J. Reeve, U.K. sales director of Bradman Lake Group,



Foaming ink has BAWLS bouncing into new markets

A unique, new ink technology lets energy drink marketer Hobarama, LLC extend its BAWLS Guarana brand to a 16-oz can that replicates the tactile feel of its trademark 'bumpy,' cobalt-blue bottle.

Anne Marie Mohan, Senior Editor

Hoby Buppert, CEO of Hobarama, LLC, Miami, admits that as a youngster, he had no need for caffeine. "I was a very energetic child," he relates. "My mom used to refer to me as her 'bouncing ball.'" As an adult, however, Buppert has made his name with caffeine, introducing nearly a decade ago a high-energy beverage that boasts the same amount of caffeine as a cup of coffee and three times that of traditional sodas.

BAWLS Guarana, now distributed in about 40 states, is a non-alcoholic, premium carbonated beverage with a citrus-infused, cream-soda flavor that uses the stimulant properties of the Amazonian guarana berry to provide an energy-drink kick. Over the last decade, the BAWLS brand has gained a devoted following among niche groups such as computer gamers, not just because of its taste, but also because of its distinctive packaging.

According to Buppert, the BAWLS brand identity has been built around the beverage's cobalt-blue, 10-oz glass bottle,



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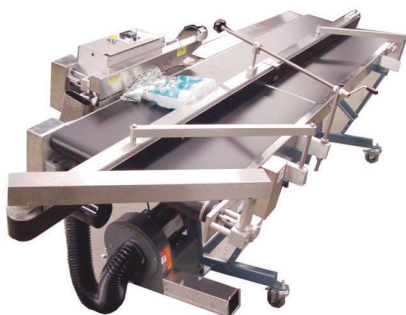
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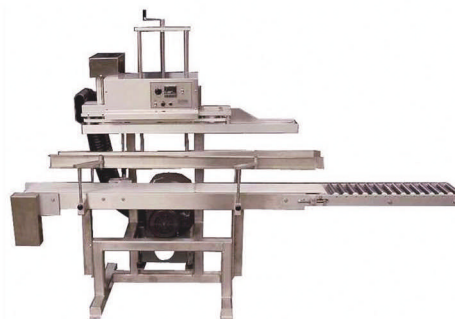


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which sports raised bumps around the entire body that are meant, he explains, to convey the idea of "bouncing balls inside the bottle punching their way out." Thus, when selecting a complementary beverage can style earlier this year for distribution at the numerous events it sponsors, Hobarama was eager to find a unique design.

With help from **Crown Holdings, Inc. (215/698-5100)**, Hobarama introduced a corresponding, 16-oz can that uses a new foaming-ink technology from **INX Intl. Ink Corp. (www.inxink.com)** to simulate the bumps of the 10-oz bottle.

As Neill Mitchell, director of marketing for Crown Beverage Packaging USA, recalls, when Hobarama first approached Crown in early 2006, the beverage marketer was interested in exploring various can technologies to differentiate its packaging. Crown suggested the use of foaming ink—a technology introduced by INX a year earlier, but never used—to provide the can with a tactile feel.

Says John Corelli, manager of graphics planning, customers and technical service for Crown in North America, "We looked at all the innovations available to us, and we saw that foaming ink is one that causes a texture when it's printed. It has a low gloss, and it can be applied to whatever area of the can you want to have the effect."

After approval by Hobarama of the concept and of some prototype can samples, Crown began manufacturing the can at its plant in Montreal. The result is a slim, 16-oz aluminum can

runs on-press to ensure it runs optimally."

Introduced in May at a paintball tournament, the BAWLS can soon made its way to retail distributors who Buppert says clamored for the opportunity to sell the new format. "We really honestly never thought we'd sell the cans at retail," he notes. "We only intended to use them for distribution at events where glass is inconvenient."

In response to retailer pressure, Hobarama test-launched the can with three Midwest distributors serving

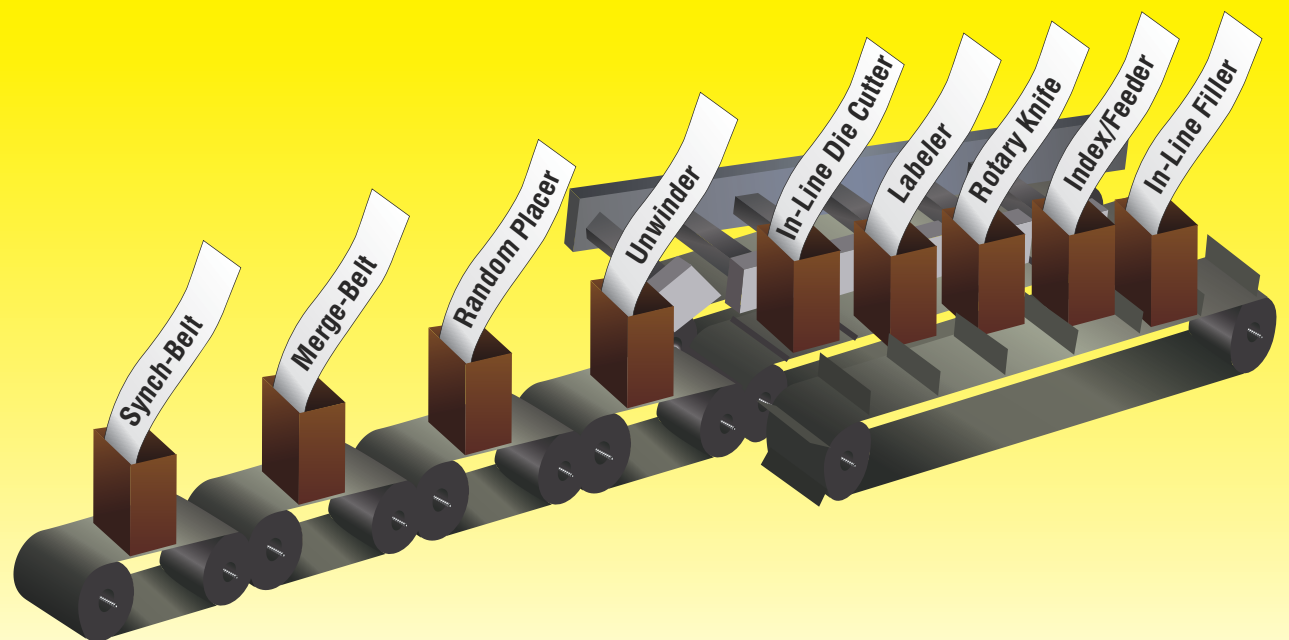
markets where the BAWLS bottle was already well established. "We didn't want people's first exposure to the product to be to the can," Buppert says.

According to Hobarama and to Illinois-based Folsom Distributing, which handled the launch of the cans in the St. Louis metro area, the introduction of the cans into the convenience store sector has been very successful, with can sales actually winning new customers rather than cannibalizing existing bottle sales. "BAWLS Guarana is the best-tasting

product we carry, and these unique cans offer the premium packaging that stores want," says Folsom CEO Jim Folsom. "The entry of these cans is not inundating existing BAWLS retailers, but instead is opening up more shelf space for the BAWLS portfolio."

More information is available:
Crown Holdings, Inc., 215/698-5100.
INX Intl. Ink Corp., 800/631-7956.
www.inxink.com.

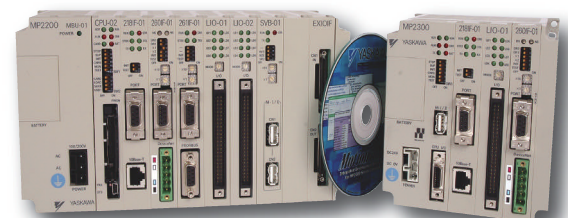
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printed in either the BAWLS cobalt blue for the Guarana version, or in white for sugar-free Guaranexx, that is spot-applied with the foaming ink in circular patterns that replicate the bumpy surface of the BAWLS glass bottle. The foaming ink—produced by an additive that swells when heated—leaves a slightly raised, velvety feel to the can.

While Crown cannot reveal the specifics of the printing process used to add the foaming ink, Corelli relates that it requires reduced press speeds of approximately 1,400 cans/min versus the industry-standard speed range of 1,720 to 2,000 cans/min.

Jonathan Ellaby, vp of international operations for INX, adds that the challenges of running the foaming ink are the same as those encountered with any novelty inks. "Because it's a different technology," he says, "press operators have to be more vigilant in watching how it

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Massillon, OH, easy-open can-end manufacturing plant speeds steel-end production for products such as Baxters Food Group Ltd.'s soups. Go to: www.packagingdigest.com/info/baxters



New packaging line at Surefil

Contract packer Surefil LLC has installed a new high-speed packaging line to run personal-care products.

Jack Mans, Plant Operations Editor

Surefil LLC is a Grand Rapids, MI-based company dedicated to providing custom filling solutions to the personal care and medical industries. Surefil provides formulation support, manufacturing, supply-chain management and logistics of branded personal care and medical liquids, lotions and gels. "Every industry is starting to think of manufacturing as a service," says Bill Hunt, CEO of Surefil. "Today, numerous marketing companies in multiple industries outsource their manufacturing."

Last April, Surefil installed a new, high-speed packaging line to service its contract-packaging customers. "The high speed and dependability were key considerations in selecting this new equipment," says Jeff Bevis, chief engineer for Surefil. "In addition, because of the diversity and number of different

packages that we run, the line has to be extremely flexible and able to be quickly and easily changed from one package to another," he says. Surefil runs more than 75 different skus in 17 different packages, and that number is growing continually. Another new packaging line expected to be operational in January 2007 will add another 85 million units to Surefil's capacity.

Surefil worked closely with systems integrator **Integrated Packaging Machinery (www.callipm.com)** to design the new line. IPM developed the line layout, helped select equipment and assisted with the equipment installation. It also arranged the supply of the complete conveyor system including the vacuum conveyor from the bottle unscrambler to the filler/capper. In addition, IPM developed and installed the control sequence for the entire line, which has standardized on controls from **Rockwell Automation (www.rockwell.com)**.

During PD's visit, the new line was running White

Rain® Energizing Citrus shampoo in a 15-oz clear vinyl bottle supplied by **GK Packaging, Inc. (www.gkpackaging.com)** at a speed of 180 bottles/min. To start the operation, the bottles are dumped into a floor-level hopper of a Model NEHCP bottle unscrambler from **New England Machinery, Inc. (www.neminc.com)**. An elevator drops them into a rotating bowl, from which the bottles enter a vertical wheel that sets them on the exit conveyor. If the bottle is in the proper orientation with the bottom leading, a finger mounted on the wheel slips off the bottom of the bottle.

However, if the open end is in the leading position, the finger slips inside of the bottle and flips it over so it is properly oriented when it is set on the conveyor.

Because the bottles are so light and tippy, Surefil installed a tabletop conveyor that uses a vacuum to keep the containers from tipping. A vacuum chamber runs beneath the conveyor, and slots in the tabletop conveyor enable the vacuum to hold the bottles as

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they are transported. The conveyor is covered for sanitation purposes.

The bottles then enter a monobloc filler/capper system from **Ronchi America, LLC** (www.ronchiamerica.com) that incorporates an 18-head Exacta R rotary filler and a six-head Sirio-M rotary capper. In this monobloc machine, the filler and capper are mounted on a single base and are driven by a common motor and drive system. This has many benefits. By eliminating extended feedscrews and unnecessary bottle handling, and by precisely matching the pitch between filler and capper, the monobloc configuration enhances the transfer process, thus eliminating feedscrew spills and jams. It also enables both machines to have a common control cabinet and operator station and reduces floorspace requirements.

The "R" designation on the filler identifies it as a stainless steel-machine designed to handle viscous, abrasive or foamy products. Among other things, this includes nonfoaming nozzles that have screens inserted inside of them that minimize foam. The machine has many features that smooth its operation and changeover. The height of the upper part of the filler is adjusted by a servo control, so the machine can accommodate a variety of bottle sizes. The machine speed is adjusted automatically depending on the bottle flow and is controlled by sensors located on the infeed and outfeed bottle conveyors. The bottle-transfer star wheels are all equipped with safety devices that stop the machine in case of overload.



Contract packagers in this issue

The following companies have a marketing message in this issue:

Aldelano, www.aldelano.com
Compact Industries, www.compactind.com
Cup Pac, www.cuppac.com
LF of America, www.lfweb.us
Maple Island Inc., www.maple-island.com
Millers Tech, millerstec@cs.com
P.J. Noyes, www.pjnyes.com
Primeline Filling, www.primelinefilling.com
QLC, www.qlc-labeling.com
Subco, www.subcofoods.com
TCX Juice, www.tcxjuice.com
THEM, www.them.net

Each fill nozzle incorporates an individual magnetic flowmeter for precise filling. All of the flowmeters are typically adjusted as a group for each product, but nozzles can also be adjusted individually if they are out of specification. This enables Surefil to achieve a ± 0.2 -percent standard deviation in fill accuracy.

Bottles leaving the filler enter the Sirio-M capper, which is equipped with positive mechanical cap-handling chucks. Torque is controlled by carbon-fiber discs with micrometer torque adjustment. Caps are loaded into a floor level-hopper, and an elevator lifts them to an overhead chamber from which a track carries them down to the capping area. A photoeye

checks the caps on bottles leaving the capper and rejects bottles on which the cap is cocked or missing.

The monobloc unit is controlled by a personal computer and has an operator panel on a swiveling arm, where the adjustments and data for different types of bottles or products are input. The operating parameters are retained in memory and can be recalled by identifying the item.

The polypropylene caps used on the White Rain bottles were supplied by **O-I** (www.o-i.com). They feature O-I's Contour™ hinge-closure technology, which can flip back more than 170 deg, thus staying out of the way of the product being dispensed.

From the capper, the bottles enter a Model 500 Autocap sealer from **Marburg Industries, Inc.** (www.marburgind.com) that applies tamper-evident bands. Bottles enter the continuous machine through a wheel that spaces the bottles properly for the band application. A photoeye after the wheel senses the presence of a bottle and triggers the band application. Band material is supplied on a roll, and a servo drive moves it through the cutting operation. The tube of material is opened by cross creasing, and it is then cut to the proper length by a guillotine-style cutter. The opened, cut band is held by vacuum in a slightly cocked orientation above the conveyor so the leading edge of the moving bottle catches its front edge, and the band is then pushed fully onto the bottle by a plate attached to a descending air cylinder. This design provides continuous bottle movement without requiring the machine to be stopped for band application. The machine is controlled by a programmable logic controller that is programmed with the length of the band and controls the servo drive. After the band is applied, the bottles travel through a heat tunnel that shrinks the bands.

From the heat tunnel, the bottles are conveyed to a labeler from **Shorewood Engineering, Inc.** (www.shorewoodengineering.com). The plant has two Shorewood pressure-sensitive labelers—a 15-head Model 5600 rotary unit to run round bottles and a Model 400 in-line unit for nonround bottles. During PD's visit, the line was running round White Rain

The monobloc filler/capper has 18 filling heads and six capping heads. Each fill nozzle incorporates an individual magnetic flowmeter to achieve a 0.2-percent standard deviation in fill accuracy.

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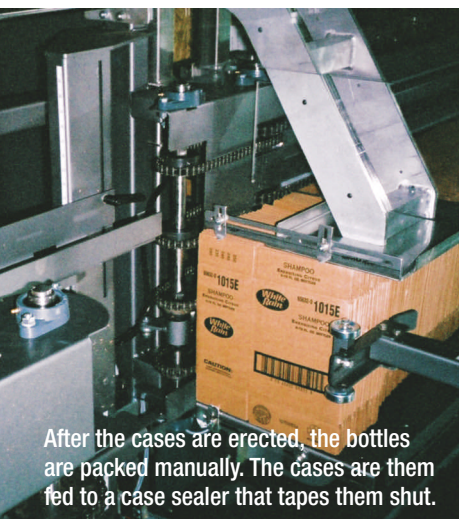
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After the cases are erected, the bottles are packed manually. The cases are then fed to a case sealer that tapes them shut.



shampoo bottles through the rotary unit, so the in-line labeler was not in use. The rotary labeler uses pucks and cap fixtures to control the bottles as they travel around the machine. Bottles enter the labeler through a feedscrew that separates them to a 6-in. pitch and then enter a starwheel. They pass over a stationary plate and drop into shallow cavities in the pucks. Simultaneously, one of 15 cap fixtures on the rotating top

descends onto the cap.

The labeler can do two types of labeling. For bottles like the White Rain bottle, which require the front and back labels to be aligned with the hinged lid on the cap, a small gear attached to the bottom of the puck rotates the puck until a lug on the bottom of the bottle is oriented for proper labeling. If the line is running a bottle that requires only front and back labeling without orientation,

the puck is turned 180 deg after the first label is applied so the second label is applied directly opposite.

The labeler has two labeling heads driven by stepper motors, although servos are also available. When a bottle reaches a certain point in the table rotation, a sensor triggers the stepper motors to energize and pull the two label webs into the machine. Each web travels past a plate that strips a label from the web, and they are picked up by the rotating bottle. The bottle then travels past a wiper that finishes the application.

After labeling, the bottles travel over a Model A300 ink-jet printer from **Domino Amjet, Inc.** (www.dominoamjet.com) that applies a date and lot code to the bottom of the bottles. They are then conveyed to a casing operation that includes a Model I CE35 case erector and Model CS40 case sealer from **Pearson Packaging Systems** (www.pearsonpkg.com). The CE35 erector features a low-level, vertical magazine that holds the blanks in a horizontal stack. A lift elevates the stack as vacuum cups come down and slide individual blanks into the forming zone.

An arm swings down and opens the blank to form the case, which is laying on its side. The case then travels through a section of timed flights where the bottom minor and then the major flaps are closed. The case then continues through the machine while tape is applied to the bottom.

Workers place the bottles into the cases manually, after which the cases are conveyed to the Model CS40 sealer.

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Sample filler



As Surefil worked with potential customers to develop packaging solutions, a need arose to fill small numbers of bottles for test-market and other requirements. To meet this need, chief engineer Jeff Bevis designed a unique three-head unit dubbed the "Bevis filler" by his coworkers. The filling heads are mounted above a conveyor, and product is delivered by a peristaltic pump. Bottles are conveyed beneath the filling heads, where a brake holds them back. A worker trips a switch to release the bottles that have just been filled, admit empty bottles and initiate filling. Despite its simplicity, the system can run bottle sizes from 2 to 33 oz at flow rates up to 40 units/min.

SureScrap drives down costs

Surefil LLC has introduced SureScrap™, a premium service for customers who are focused on driving down material costs and maintaining tighter control of their supply chain. The program is a comprehensive approach to leveraging new plant design, sophisticated equipment, information systems and operating philosophy.

To integrate SureScrap, Surefil designed its new plant with lean manufacturing in mind, minimizing the distances between compounding, holding and filling. All of the plant's new piping systems utilize minimal pipe diameter while maintaining the capability for high-volume flow. Each pipe operates on a slope, and the Surepig™ pigging system ensures that minimum product is left in the transfer piping. The SurePig system consists of a flexible "pig" that is launched through the transfer pipe. The pig pushes all of the product in the pipe to a receiving vessel, which allows the capture of the product. The pigging system captures at least an additional 1 percent of product.

Surefil also uses the SureStick™ adhesive system to reduce packaging scrap. The adhesive system allows for rapid label stripping on any misplaced or bubbled labels and facilitates high-quality relabels. With SureStick, a label can be stripped off for up to six hours after labeling, saving the bottle, cap and product while achieving a first-quality product.

Operational strategy initiatives include the enforcement of a strict quarantine of all incoming materials to ensure no material enters the "available for production status" in the warehouse. This quarantine dramatically reduces scrap in the packaging area.

A braking system at the inlet of the sealer holds cases back until an operator releases a case with a foot pedal. A plow closes the leading minor flap as the case enters the unit, and a servo-driven rotating arm pushes the trailing minor flap into place. The case travels through plows that close the major flaps and then travels past the top-tape applicator. Side-compression rollers in the tape-application zone ensure that the case remains square during sealing. Cases are supplied by **Packaging Corp. of America** (www.packagingcorp.com).

Cases leaving the case packer travel past a Domino Amjet Model C6000 case printer and are manually palletized, after which the pallets are carried by a lift truck to a stretch wrapper from **Robopac** (www.aetnagroupusa.com).

Change Parts, Inc. (www.changeparts.com) supplied change parts for a number of the pieces of equipment.

With business growing continually,

Surefil has ordered a capper from **E-Pak Machinery** (www.epakmachinery.com) that will be installed after the Ronchi to apply snap-on/press-on caps and a ps labeler from **Universal Labeling Systems** (www.universal1.com) that will be installed after the Shorewood labelers to apply specialty labels. These specialty labels are sometimes referred to as violators by the retail trade. They draw extra attention to products on the shelf. Typical violators may carry messages like "33 percent more product," "wow, "new product" or simply "try me!"

More information is available:

Change Parts, Inc., 231/845-5107. www.changeparts.com.
Domino Amjet, Inc., 800/323-4754. www.dominoamjet.com.
E-Pak Machinery, 219/393-5541. www.epakmachinery.com.
Integrated Packaging Machinery, 616/531-7758. www.callipm.com.
GK Packaging, Inc., 614/873-3900. www.gkpackaging.com.
Marburg Industries, Inc., 760/727-3762. www.marburgind.com.
New England Machinery, Inc., 941/755-5550. www.neminc.com.
O-I, 419/247-5000. www.o-i.com.

Packaging Corp. of America, 800/456-4725. www.packagingcorp.com.
Pearson Packaging Systems, 509/838-6226. www.pearsonpkg.com.
Robopac, 678/473-7896. www.aetnagroupusa.com.
Rockwell Automation, 414/382-2000. www.rockwell.com.
Ronchi America, LLC, 201/802-1901. www.ronchiamerica.com.
Shorewood Engineering, Inc., 952/935-3819. www.shorewoodengineering.com.
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Knorr's Loosdrecht plant in The Netherlands case-packs and palletizes some of Unilever's biggest food brands. The plant replaced an older pallet-labeling and shipping operation with an automated, highly computerized system that meshes well with its new global productivity initiatives.

Automating traceability meets Knorr's needs and EU regulations

Lauren R. Hartman, Senior Editor

One of the world's leading suppliers of fast-moving consumer products in the food, home and personal care categories, Unilever's portfolio includes some of the leading and best-known brands. Knorr is Unilever's biggest food brand, with €3 billion in sales per year and a strong presence in more than 80 countries. Knorr's product range includes a wide variety of soups, sauces, bouillon, noodles and complete meals. Packing and selling dried soup mixes since 1873, the early Knorr Co. created the bouillon cube, among many other key prepared-food developments.

So that Unilever drives business, productivity, compliance and protection for this top brand as well as for the many other brands in its mix, the corporation began a new global productivity initiative called One Unilever. The initiative was designed in 2004 to eradicate duplication, leverage its scale and make improvements in its focus on consumers, customers and the marketplace.

Unilever automates the pallet-labeling and shipping operations at its production sites, including the Knorr plant in Loosdrecht, The Netherlands, as part of a global productivity initiative to improve logistics, simplify compliance and cut costs.

All of Unilever's production facilities participated in this productivity initiative, including the Knorr sauce and soup mix plant in Loosdrecht, The Netherlands. Previously, the Loosdrecht production site was operating with an older, manually-based pallet-labeling and shipping system that required significant support and manual data entry. The staff there says it felt that significant productivity improvements and cost savings could be achieved by automating the system, so it chose **MARKEM Corp.** (www.markem.com) for assistance in finding a labeling solution. Unilever wanted to integrate the system with its standardized inventory forecasting

and planning functions within its software system from supply-chain, customer relationship system and enterprise resource planning (ERP) software provider **SAP** (www.sap.com/usa) to unify its infrastructure and processes and to provide enhanced product traceability and process control (MARKEM was recently awarded SAP® interface certification for its CoLOS™ Exchange™ Interface, another part of the CoLOS lineup. The certification helps ensure that manufacturers obtain dependable connections between SAP and the factory floor).

Knorr felt that automating its labeling operation would also mesh well with the One Unilever initiative as well as other Unilever business strategies, and would provide a way to help meet changing customer requirements and European Union (EU) traceability regulations. Having worked with MARKEM and its support services before, Knorr and Unilever were familiar with the performance of MARKEM traceability systems at two other Unilever production sites. MARKEM worked as a single-source supplier, responsible for all of the software, hardware devices and related interfaces that the Knorr project required.



Above, a closeup of a printed, bar-coded pallet label for fish soup mix. An easy-to-use pallet software interface to the printer/applicator, left, makes pallet labeling simple and helps Knorr meet updated EU regulatory requirements, that include the creation of the European food law.

The integrated solution includes MARKEM's CoLOS™ Pallet software, three MARKEM Cimpak label printer/applifiers that apply enterprise data onto Knorr's pallet loads and are equipped with



Natural Springs Water Group, Johnson City, TN, has opted for **LASER CODING** to improve code clarity, equipment reliability and production-line efficiencies for its many water brands in PET bottles. Read about how **MARKEM'S** digital laser coding system plays a key role, at www.packagingdigest.com/info/natural

fixed bar-code readers from **SICK** (www.sick.com) and wireless radio-frequency data terminals with scanning capability from **LXE** (www.lxe.com), which are used at a loading-dock station.

The system architecture includes management, shipping, control and report software modules under the CoLOS banner.

Information entered into the SAP system by the Loosdrecht staff determines what percentage

of a specific product that goes to which distribution center, to ensure adequate inventory at each DC. The CoLOS system also transmits information about what has been produced and shipped per the SAP system's original instructions so that Knorr can keep better track of order fulfillment, allowing the plant to optimize its product-demand forecast planning.

The scalable CoLOS software package allows the plant to automatically create an accurate, unique identity for its pallet loads in the Serial Shipping Container Code (SSCC) format required by Unilever's customers. Linking the pallet-labeling operation directly with the SAP enterprise resource planning system (ERP), it downloads production and inventory data, providing data consistency across systems. The pallet-labeling system is integrated to SAP using CoLOS Sync software. Unilever integrated the system to SAP to download production orders, using this to create unique SSCC codes for labeling pallets and then to upload shipping information for traceability purposes. The pallet-

Continued on page 50



Three label printer/applifiers are in place in the caged area of Knorr's palletizing area, above. They're integrated with SAP using specialized software, so that Knorr can download production orders to create unique SSCC codes for pallets.

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The fully applied, single-source packaging-line management, product identification and traceability system is illustrated at far left. Bulk shipments of the cartoned sauce mixes in Knorr's warehouse, near left, are labeled with the bar-coded product/plant and production information. The new systems have the reliability and functionality Unilever needed.

Stoffel Seals Corporation
800.344.4772 • www.stoffel.com



new products equipment

Pouchmaker The Vega 610 pouchmaking system's modular design allows it to adapt to various converting process needs. The machine applies servo technology to enhance control and real-seal time control. The system is capable of producing zipper pouches at 280 pouches/min and self-gusseted, standup pouches at 100 pouches/min.

Mamata USA, Inc., 630/801-2320.
www.mamatausa.com



Knife holder The Gold Series knife holder can slit webs down to as narrow as 2 in. into material weights up to 800 gsm at speeds up to 5,000 fpm. It features a calibrated depth knob for precise blade-anvil overlap and tool-free cant angle adjustment. These characteristics reduce dust, increase blade life, ensure maximum spatial nip-point stability and increase the quality of the cut, the co. says.

Mario Cotta USA, 800/792-9302.
www.mariocotta-usa.com



Speed gauge The LaserSpeed® Series gauges use auto-correlation, a digital signal processing algorithm and single-chip integrated circuit technology to produce accurate, noncontact speed and length measurements. The gauges have no moving parts, use 100-percent, solid-state digital technology and are permanently calibrated. They have an accuracy better than ± 0.05 percent. These gauges are suited for measuring the length and speed of paper and corrugated products, nonwovens and plastic films and tapes.

Beta LaserMIKE USA, 937/233-9935.
www.betalasermike.com

Inserter The US1000 PouchPlus® inserter has fewer parts and is 20-percent smaller than its predecessor. Machine additions include a color touchscreen operator interface with large icons for easier menu navigation and storage of multiple groups of parameters. **Unique Solutions**, 847/540-1200.
www.unique-solutions.com

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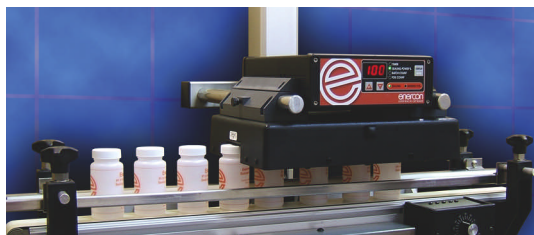
High-speed retorquer The beltorque™ is a high-speed retorquer that reapplies cap torque after induction sealing. Unlike conventional retorquers that use discs or spindles to tighten caps, this device uses a belt to tighten caps, eliminating cap damage and achieving more consistent torque values. Works with caps up to 5 in. in diameter and at speeds to 300 cpm.

NJM/CLI, 603/448-4810.
www.njmcli.com

Portable sealer

The Super Seal™ Jr offers sealing capability, portability and production flexibility in a footprint one-fifth the size of its predecessor, the Compak™ Jr. Sealing applications range from small closures to 120-mm wide-mouth containers. The flexible sealing system can be upgraded and seamlessly integrated with the co.'s high-performance sealing head for automated production lines. An operator-friendly display provides users with a digital sealing timer.

Enercon Industries Corp., 262/255-6070.
www.enerconind.com



Printer combo The co.'s new Imaje 9040 continuous ink-jet printer keeps the S8 Master's most valuable attributes by incorporating features of its successful 9020 and 9030 printers. The new Imaje 9040 reportedly offers easy integration into virtually any production line and can be used for numerous applications with the aid of single- and bi-jet printheads, one or two printheads, three different resolutions, several umbilical lengths and enhanced connectivity. Standard printing capabilities include up to four lines of text and character heights ranging from 0.7 to 18.2 mm, printing all types of codes, including Datamatrix.

Imaje USA, 770/421-7700.
www.imaje.com



Stick-pack machine The new DMV 4 stick-pack machine is a vertical f/f/s machine that reportedly handles a wide range of heat-sealable materials, simultaneously filling four to 10 lanes, as slitter knives cut films into individual strips synchronized to mechanically take a cylindrical shape around forming collars, with a horizontal heat-seal bar creating two seals at once. The four-lane configuration is said to be rated to 200/min.

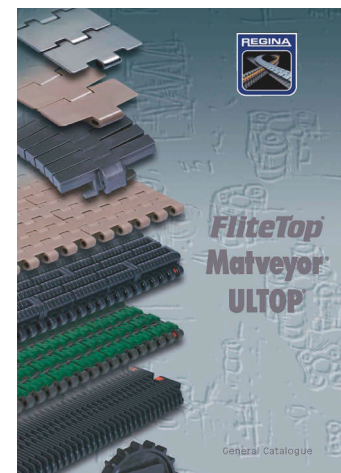
Duma Packaging Machinery, 941/360-8833.
www.dumapackaging.com

Conveyors The co. says that its custom modular packaging solutions bring conveying to a new level with system design, parts sales and service/installation of adjustable product guiderails on straight or corner conveyors. Available from the co. are FlexLink tabletop aluminum and stainless-steel conveyors, air conveyors, Titan and mk roller and belt conveyors, Shibuya Hoppmann centrifugal feeders and integrated controls.

Flex-Line Automation, Inc., 618/826-5086.
www.flex-lineautomation.com

Industrial/conveying chains, belts Supplying industrial and conveying chains and modular belts for almost 90 years, the co. says it uses materials to provide consistent, innovative products for reliable and high-efficiency operations. Along with market-standard materials like LW and UP, the co.'s FliteTop, Matveyor and ULTOP lines reportedly feature DK material (Delrin® with Kevlar®) for exceptional life and reduced lubrication requirements.

Regina USA, Inc., 410/221-2800.
www.reginausa.com



Control equipment A comprehensive line of pneumatic and vacuum-control equipment is available from the co., including sensing and input elements, control elements, output interface devices and complete air-supply systems. The control elements alone include both fluidic and moving diaphragm control components, with pressure and vacuum switches, miniature quick disconnects and plastic fittings.

Air Logic, 262/639-9035.
www.air-logic.com



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Accumulator/robotic arm combination

The co. has formed a partnership with KUKA Robotics. The focal point of this endeavor is KUKA's KR-40 PA robot which—depending on product and end-of-arm tooling—reportedly cycles at rates to 80/min with payloads to 40 kg, working in conjunction with the co.'s Rolco Serpentine Accumulator. This accumulator is said to provide first-in/first-out functionality and allows products to be received at any rate, while products are being discharged at the same or different rates. The co. says consistent product flow to downstream equipment creates increased efficiencies for the entire line.

Nercon Eng. & Mfg., Inc.,
920/233-3268.

www.nercon.com



Test systems

The new PAC CHECK® Model 820 package integrity test system is described as the first-ever unit to measure both residual-headspace O_2 as well as package leak rates. The PAC CHECK Model 333 is said to be the first hand-held headspace analyzer to measure CO levels in modified and controlled-atmosphere and case-ready meat packaging. The co. also offers the AQUATRAN Model 1 ultra high-barrier water-vapor permeation test instrument and the low-cost PERMATRAN-C Model 10, which reportedly nondestructively measures the CO_2 transmission rate of individual plastic carbonated beverage bottles.

Mocon, Inc., 763/493-7231.

www.mocon.com

Inspection systems

The TapTone 1000 is described as a multiple inspection system for PET, metal and glass containers. The system is available floor-mounted and has a small footprint so that it can be situated virtually anywhere on the production line to help ensure product quality and downstream equipment protection. Also said to be capable of detecting micro leaks, under/over-fill conditions, internal pressure/vacuum and cap or label defects, the unit includes as features Ethernet communications, a color touchscreen, remote diagnostics and multiple rejector capabilities.

Teledyne TapTone, 508/563-1000.

www.taptone.com



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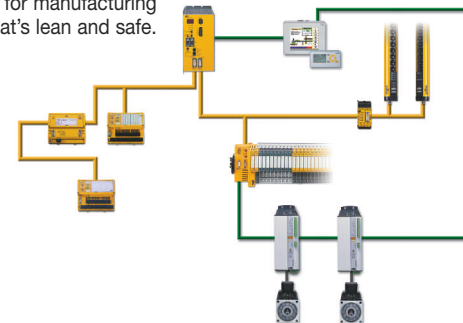
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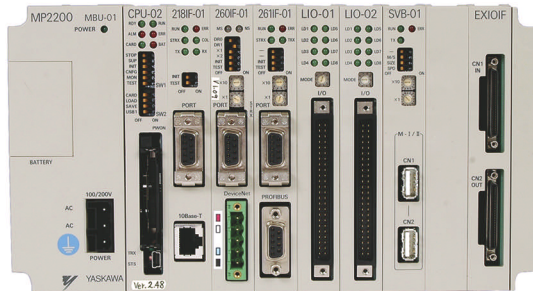
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more than automation
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Platform integration The MP2200 machine controller synchronizes motion control and sequence control in one tightly integrated platform. The MP2200 is said to control up to 256 axes of linear, rotary and direct-drive servos, VFDs and massive quantities of I/Os. This system, the co. notes, incorporates an automatic routine that configures network devices. MotionWorks v6 programming software is said to be easy to use and features three IEC611-3 style languages, with the intuitive layout guiding users through all features in the development environment.

Yaskawa Electric America, Inc.,
800/932-7359.
www.yaskawa.com

Palletizing software Version 5.60 of TOPS Pro package design and palletizing software is now available. New features on the release include the

MixPro Auto Load Generator, advanced container loading, support of unit-load labels, blister-packs, inverted nesting, slave pallets, shipcase costing, enhanced reports and more. This new release is free to all TOPS Pro customers with a current maintenance



contract. Also new, the RFID Location Optimizer for TOPS Pro will suggest the best shipcase location for RFID tag placement for maximum read.

TOPS® Eng. Corp., 972/739-8677.
www.topseng.com

Stretch wrapper

What's described as "the world's fastest stretch wrapper," the WRING 500 has been added to the co.'s other series of stretch-wrapping equipment and services.

Wulftec/M.J. Maillis Group,
847/931-5742.
www.wulftec.com



Palletizers A low-infeed palletizer, the GS-series is recommended for speeds to 20 cases/min, with a pattern-utility function allowing pattern changes as required. Priced at \$50,000, the palletizer is built in manual and automatic models. New design and interface options have been made to the A-780 case palletizer, structured for low- to mid-speed applications, that reportedly increase capacity up to 30 percent, with changes including a recirculating row pusher for improved flow, a high-level infeed and right-angle pattern formation. Added flexibility is also said to derive from close-center rollers and a bi-parting apron. All machines offer compactness through small footprints for space-restrained plants.

FKI Logistex, 877/935-4564.
www.fkilogistex.com



Bulkhead spacer

Developed for load protection is the bulkhead spacer, which can be used with the co.'s Solution separator pad.

Together, they are designed to evenly space loads in order to balance weight distribution on a trailer.

The co. cites their patented interlocking design, with labor-saving hand holds, as being able to withstand up to 10 tons of force, as well as being lightweight and recyclable.

Fabri-Form Co., 800/837-2574.
www.fabri-form.com



Combination weigher The co. is aiming for unmatched product control with its Triangle Selectacom belt-feed combination weigher. The co. describes it as ideal for fresh poultry and sticky, hard-to-handle products.

Moreover, it cites superior weight accuracies and control with the possibility of more than 4,000 combinations with each weigher cycle. It traces ease of cleaning and maintenance to a sanitary design incorporating frame standoffs, no sharp angles, a water rolloff configuration and the ability to withstand caustic washdowns. Finally, it notes, the machine offers smart controls using an Allen-Bradley ControlLogix platform for easy setup of all package sizes.

Triangle Packaging Machinery Co.,
773/889-0200.
www.trianglepackage.com



F/f/s A new line of fully automatic f/f/s machines designed to perform with exceptional speed, precision and reliability are offered by the co. Functioning with laminated or PE bags are the C-50 and C-100, their numerical designations describing their rated per-min output. Both operating with a servo-drive system, the machines are also said to share structural simplicity for easier maintenance, lower power consumption and quick changeover. The co. reports that the compact machines are designed to provide dependable productivity for a wide range of products, including automotive, hardware, baked goods and other foods, paper, pharmaceuticals, sporting goods, textiles, pet items, toys and toiletries.

Bodolay Packaging Machinery, 813/754-9960.
www.bodolaypackaging.com



Compression belt Developed for the co.'s ACS semi-automatic bag-sealing systems is a compression belt that replaces foam as the compressible material. At 12 in. W, the new equipment has a larger overlapping belt that is layered upon the main compression drive belt in waves, the co. says, adding that the new laced belt—sliced into 3/4-in. fingers to perfectly conform to products—can be added to existing systems easily.

Emplex Systems, 800/265-1775.
www.emplex.com

new products materials

RFID pallets Plastic pallets, some equipped with radio-frequency identification transponders, are introduced into the North American market. The Craemer pallets, molded in one shot, including some developed for the logistics industry, are said to be lightweight and durable for transportation and storage of products.

Granville Composite Products Corp., 800/350-4660.
www.granville.cc/

Folding cartons Said to blend plastic and paperboard is a new series of folding carton structures dubbed Diamondessence™ combination packaging. The co. says a wide variety of styles and materials includes custom die-cuts and such techniques as hot foil stamping, embossing and specialty coating for the utmost in design flexibility, to enhance brand identity in three-dimensional structures. Website visitors will also reportedly have the option of requesting a free mockup sample with their graphics.

Diamond Packaging, 800/333-4079.
www.diamondpackaging.com/combination

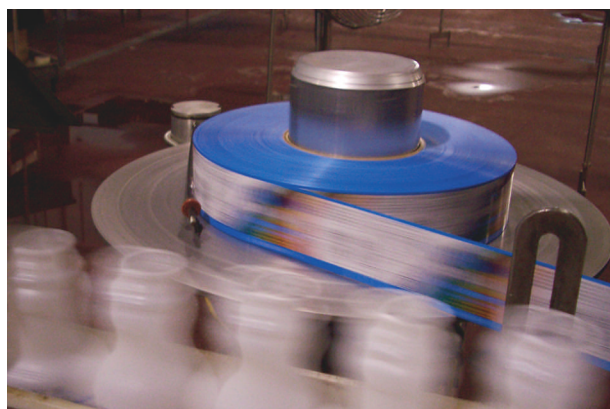
Box clips Developed to eliminate strapping and taping are box clips, or fasteners, said to make corrugated packages reusable. The co. says the clips save time in repackaging, and are ideal for export and large corrugated packs on pallet bases.

Leco Plastics, Inc., 201/343-3330.
www.lecoplastics.com



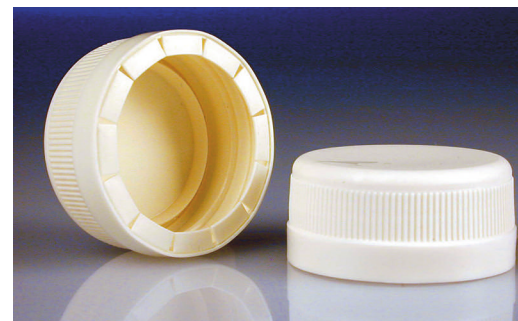
Labeling adhesive Designed to create the “no label” look on clear film, the co. has introduced ETI-MELT™ 396, which it describes as a high-tack, light-color labeling adhesive for superior adhesion on wraparound glass, PVC, HDPE and PET bottles with paper or PE labels in both pickup and overlap applications. The co. cites adhesive's thermal stability: It meets the composition requirements of indirect food additives regulations with a suggested running range of 275 to 315 deg F.

National Adhesives, 866/266-5565.
www.nationalstarch.com



Closure The new 38-mm TIFF closure is aimed at maximizing the tamper-indicating effectiveness for food and beverage products, the co. says. Noting a proprietary, flexible bead design that allows for minimal interference during capping and maximal tamper-indicating effectiveness during removal, the co. makes the closure with valve seal or folding bead linerless sealing, or with induction, foam or other liner materials. The closure also is said to have a “folding finger” feature for significantly reduced application torques and the reduction or elimination of heat.

Rexam Closures & Containers, 812/867-6671.
www.rexam.com/closures



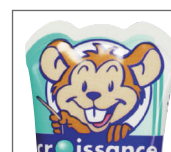
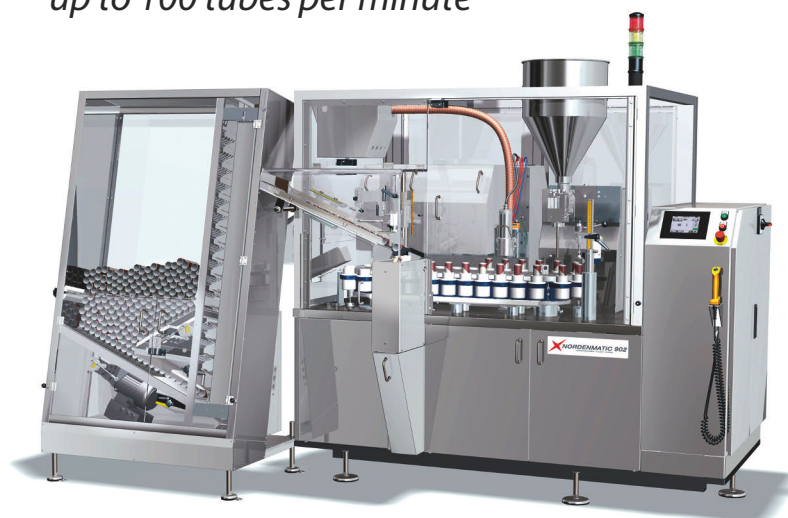
Fin-sealed ‘slider’ pouch A new Slider™ pouch format for wipes, cookies and other products packaged on overwrap equipment was developed by the co. with a shrouded zipper that's said to provide ultimate tamper-evident protection. Said to be the first of its type, the format includes a tearaway header that can be easily removed to protect products en route and at the store.

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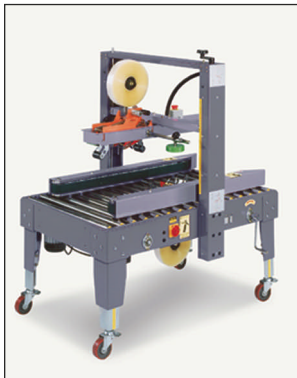
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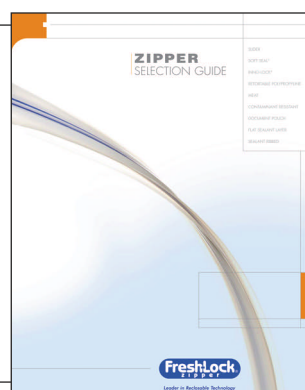
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Presto Products Company Introduces Zipper Selection Guide for Fresh-Lock® Zippers

Presto Products Company, a Business of Alcoa Consumer Products has recently introduced a new Zipper Selection Guide which is a comprehensive reference tool illustrating over 60 types of zipper styles, from cost-effective single track to high-performance patented sealant rib technology. The Zipper Selection Guide is easy to utilize to find pertinent information to locate a zipper style that will fit a specific packaging application and will be compatible with equipment requirements.

Presto Products Company; (800) 265-0750; www.fresh-lock.com



New Brochure for SKINETTA's New Stretchbanding Machine

This brochure highlights SKINETTA Pac-Systems' new FilmTeq 3030, a new fully automated stretchbanding machine for collating and bundling products in PE film. The servo-driven jaw has a fully automatic height adjustment and the Ultra-Pulse sealing system is temperature controlled and heats and cools in milli-seconds. The FilmTeq 3030 can make up to 60 bundles per minute and allows for rapid film exchange.

SKINETTA Pac-Systems

(574) 254-1950, F: 574-254-1955, www.skinetta.com

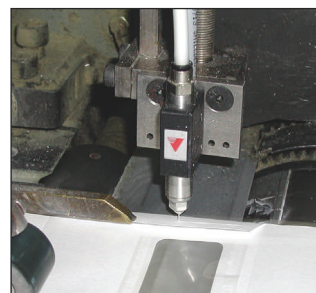
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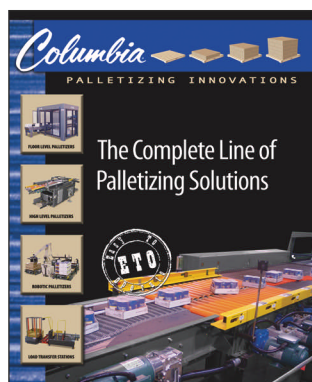
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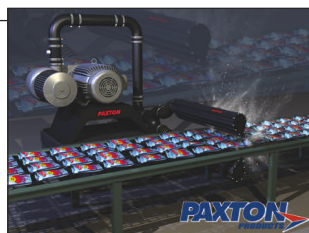
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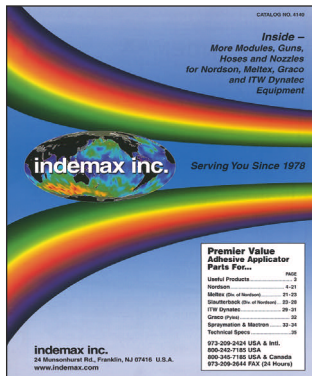
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Dec. 12-14 Fundamentals of Packaging Technology—Semester 4.

Hyatt Regency, Schaumburg, IL. 630/696-4010. www.iopp.org.

Dec. 13-15 Biocides in Plastics.

Sheraton Safari, Orlando, FL. www.pira.co.uk.

Dec. 14-16 FlexPackCon (Society of Plastics Engineers).

Renaissance Resort at SeaWorld, Orlando, FL. 404/460-7315. www.4spe.org.

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Jan. 8-11 ProMat 2007.

McCormick Place, Chicago. 800/345-1815.

Jan. 25-26 Flexible Packaging Assn. Environmental Summit.

TradeWinds Island Grand Resort, St. Petersburg Beach, FL. 410/694-0800. www.flexpack.org.

Jan. 30-Feb. 1 Package Design 2007 Conference & Technology Center.

Sheraton World Resort, Orlando, FL. 610/935-2183. www.packstrat.com.

Feb. 1-2 Interphex Puerto Rico.

Puerto Rico Convention Center, San Juan, PR. 888/745-2529. www.interphexpuertorico.com.

Feb. 12-15 WestPack 2007.

Anaheim Convention Center, Anaheim, CA.

310/445-4200. www.westpackshow.com.

Feb. 27-Mar. 1 Packaging Strategies 2007.

Renaissance Vinoy Resort & Golf Club, St. Petersburg, FL. 610/935-2183. www.packstrat.com.

Feb. 28-Mar. 2 Flexible Packaging Assn. Annual Meeting.

Fairmont Turnberry Isle Resort & Club, Aventura, FL. 410/694-0800. www.flexpack.org.

Mar. 6-7 Global Plastics

Environmental Conference. The Florida Hotel & Conference Center, Orlando, FL. 800/798-1241. www.sperecycling.org.

Mar. 6-8 2007 Sustainability in Packaging.

The Doubletree Castle Hotel, Orlando, FL. 207/781-9610. www.packagingdigest.com/info/sustainable.

Mar. 16-18 10th International Molded Fibre Product Seminar.

Town & Country Resort, San Diego, CA. 414/527-4829.

Mar. 24-27 Snaxpo.

Westin Diplomat Resort & Spa, Hollywood, FL.

800/628-1334. www.snaxpo.com.

Mar. 26-27 PETnology Europe

2007. Munich, Germany. 49 941 870 2374. www.petnology.com

Apr. 2-5 GulfPack.

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Apr. 16-17 FUSE: Brand Identity & Package Design.

Pier 60, Chelsea Piers, New York City. 212/661-3500, X 3151.

Apr. 24-26 SouthPack 2007.

Georgia World Congress Center, Atlanta. 310/445-4200. www.southpackshow.com.

Apr. 24-26 Interphex 2007.

Jacob K. Javits Convention Center, New York City. 888/334-8704. www.interphex.com.

May 1-3 World Batch Forum

Conference. Tremont Suites Hotel, Baltimore, MD. 919/314-3970. www.wbf.org.

May 2-4 International Assn. of Diecutting and Diemaking and Foil Stamping and Embossing Assn.

Odyssey. Midwest Airlines Center, Milwaukee, WI. 800/828-IADD. www.iadd.org.

May 15-17 Packaging Summit & Conference.

Donald E. Stephens Convention Center, Rosemont, IL. 262/782-1900. www.pkgsummit.com.

May 15-18 TOTAL Processing & Packaging.

National Exhibition Centre, Birmingham, UK. 203/840-4800. www.totalexhibition.com

May 21-24 Chinaplas 2007.

International Exhibition on Plastics and Rubber Industries. Guangzhou Exhibition Centre, Pazhou, Guangzhou, China. 852/2516-3320. www.2456.com/chinaplas.

June 4-7 CMM Intl.

Donald E. Stephens Convention Center, Rosemont, IL. 603/891-9469. www.cmmshow.com.

June 12-14 EastPack 2007.

Jacob K. Javits Convention Center, New York City. 310/445-4200. www.eastpackshow.com.

June 26-29 ExpoPack Mexico.

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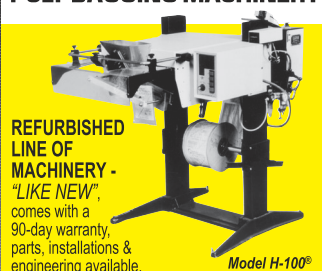
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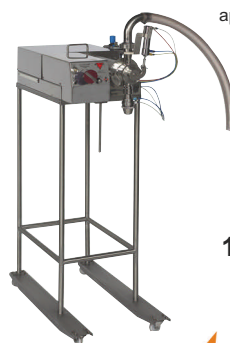
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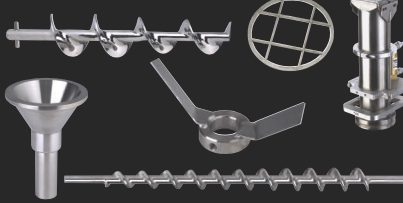
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newsmakers

MOVERS & SHAKERS

Alcoa hires Jeffrey Kellar as president of its Alcoa Flexible Packaging business,



Jeffrey Kellar
Alcoa

based in Richmond, VA. Kellar had been vp Strategic Development and Marketing for Tetra Pak, Inc., USA.

Alcan appoints Ilene Gordon president and CEO of Alcan Packaging

and senior vp of Alcan, Inc. Mike Schmitt succeeds Gordon as president of Alcan Packaging Food Americas sector.

Zip-Pak promotes John Schneider to vp and gm. Schneider is responsible for overseeing new product development, manufacturing and commercial activities for five Zip-Pak businesses in North America as well as increasing Zip-Pak's presence in the markets it serves.

Multivac, Inc. appoints Jan Erik Kuhlmann as president and CEO.

Barry-Wehmiller Companies names Don Boyer to the newly created position of director of international human resources, and **Barry-Wehmiller Design Group,**



Peter Lapins
Barry-Wehmiller
Design Group

Inc. appoints Peter Lapins and Darren DeAnda as partners.

Hartness International realigns its North American sales team. Keith Cooper is named director of sales for the northeastern U.S., Canada and the Caribbean. Erin Boles is promoted to director of sales for the southern U.S. She will also continue to serve as key account manager for Anheuser-Busch. Jim Soenke is

the new director of sales for the western U.S., which includes the midwestern U.S. and the West Coast. Tony Elrod takes the position of director of technical sales. Scott Smith is named vp of sales and marketing.

M&H Plastics appoints Kurt Nyberg as CEO of M&H Plastics USA.

Sonoco elects M. Jack Sanders senior vp – Global Industrial Products and names Eddie L. Smith vp - Industrial Products and Paper-Europe. Sanders and Smith will continue to serve as members of the company's executive committee

TURCK, Inc. appoints Dean McCaskill



Dean McCaskill
TURCK, Inc.

as president of North American operations. McCaskill assumes complete responsibility for TURCK's operations, including its manufacturing facilities.

Owens-Illinois, Inc. appoints C. Roy Shipp to the newly created position of director of Owens-Illinois Prescription Products, Inc., and Mike E. VanderPol to director of sales for Prescription Products.

Cadmus announces that David Phillipies rejoined the Cadmus Whitehall Group team as director, business development.

Weighpack Systems, Inc., a Canadian manufacturer of weighing, filling and packaging machinery, names Marcel LaChambre as operations manager.

M.J. Maillis Group North America appoints Thomas Oleksy as vp and gm. He will be responsible for leading



Tom Herold
Maxcess
International

the activities for both Maillis Strapping Systems and Wulftec International, Inc.

Maxcess International promotes Tom Herold to national sales manager and hires Jerry Skerven to provide local sales and support for Fife, MAGPOWR and Tidland customers in MN, east WI, IA, ND, SD and NE.

Nordson Corp. hires Eric Luftig as marketing manager for the Adhesive Systems Group. He will be responsible

for developing and managing marketing efforts for the Packaging and Product Assembly business group, as well as overseeing domestic marketing functions, including marketing communications, pricing, training and tradeshow support.

GROWING & GOING

PolyOne Corp. opens a new research and development color lab at its Avon Lake, OH, facility.

Tom Zosel Associates, Ltd. opens an office in Atlanta.

Adalis Corp. opens a new packaging development center in Minneapolis. The new facility complements Adalis' packaging development capabilities to now include prototype development, packaging sample production, and

sales staff

Sales and Marketing Offices

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Robert W. Heitzman, Publisher Emeritus
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INTERNATIONAL REPRESENTATIVES:

Europe **Anthony Rochman**
anthonyrochman@btinternet.com 44 7939 151592
Germany/**Bettina Nubel** eisenacher@t-online.de
Australia/**Philip Brandon** pbrandon@partnerstoo.com
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lizhi@reedbusiness.com.cn
Israel/**Asa Talbar** talbar@talbar.co.il
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Singapore and Southeast Asia/**June Tan**
june.tan@rbi-asia.com
baretella@exportwerbung.ch
Taiwan/**Robert Yu**
sales@wwstaiwan.com

Mary Williams, Marketing Services Manager
630/288-8745
mwilliams@reedbusiness.com

Hilde Diestl, Publisher's Assistant
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thermoforming.

Sonoco may close up to 12 plants and cut 540 jobs. The moves will be fully phased in through the remainder of 2006 and 2007.

Thermo Fisher Scientific is the new name for Thermo EGS Gauging.

Pliant Corp. opens new 10,000-sq-ft R&D expansion in Chippewa Falls, WI.

Lowry Computer Products opens new RFID center in Orange County, CA, to serve West Coast manufacturers. The lab offers RFID hardware and tag selection services, testing and RFID certification classes.

vps Video Print Systems GmbH announces that it has changed its name to vps ID Systeme GmbH.

Acrotech, Inc., Lake City, MN, purchases the Di-Acro name and the manufacturing of the remaining product line.

Altivity Packaging discontinues operations at its North Kansas City, MO folding carton plant.

BUYING & ALLYING

Printpack, Inc., a flexible packaging and specialty rigid-container manufacturer, acquires **Seal-It, Inc.**, a supplier in the U.S. packaging market of sleeved and heat-shrink PVC, PLA, PET-G and OPS films.

Applied Manufacturing Technologies Inc., a leading supplier of factory automation design, engineering and process consulting services, announces its strategic alliance with Perceptron, Inc.

Thiele Technologies, Inc., a manufacturer of high-speed packaging equipment, acquires certain assets of Streamfeeder, LLC.

Baldor Electric Co. buys the power systems business of Rockwell Automation,

Inc. for \$1.8 billion, in a deal expected to close in early 2007.

Alcan sells its Wheaton Science Products business to River Associates Investments, LLC.

Heidelberg Asia and **Esko-Graphics Asia Pacific** enter into a reseller agreement enabling Heidelberg Asia to distribute Esko's Scope packaging software modules DeskPack, Plato and ArtiosCAD and the Kongsberg XE10 folding carton cutting table.

ASSOCIATION ACTIONS

The Institute of Packaging Professionals (IoPP) is bringing the "Fundamentals of Packaging Technology" seminar west for the first time since 2003. It will take place in Newport Beach, CA, in Spring of 2007.

The Healthcare Compliance Packaging Council opens its competition for the 2006 HCPC Compliance Package of the Year Awards. Entries will be accepted until March 15, 2007.

The Flexographic Technical Association is accepting entries for all of its awards programs, including the 2007 Excellence in Flexography Awards Competition. Deadline is Jan. 19, 2007.

CHEERS

Northwestern University's Forum for People Performance Management & Measurement honors Nordson Corp. with its 2006 Performance Through People Award.

Kuka Robotics Corp., a leading global manufacturer of industrial robots, awards its top system-partner awards to AMEC, Forte Automation Systems and AMF Automation Technologies.

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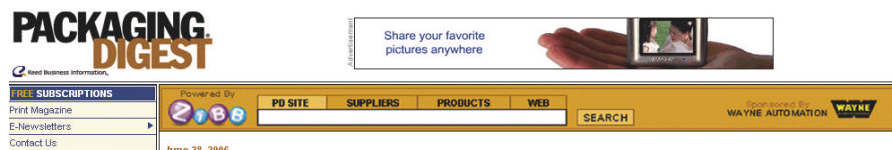
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PACK EXPO Intl: Attendance up from 2004

PACK EXPO International 2006, the most comprehensive packaging tradeshow in the world's largest packaging market, delivered 45,741 buyer attendees, up 553 from the 2004 show. The show saw increases in all attendance levels, including buyers, exhibitors and international attendees. In addition, the number of exhibiting companies and net square footage increased over 2004.

Baldor to buy Rockwell Automation division

Baldor Electric Co. has agreed to purchase the power systems business of Rockwell Automation Inc. for \$1.8 billion, in a deal expected to close in early 2007. Baldor, a manufacturer of electric motors, drives and generators, says that it will pay \$1.75 billion in cash and about \$50 million in stock for the Rockwell unit, which sells its products under the Reliance Electric and Dodge brand names.

FDA to explore functional food standards

As enhanced foods grow more popular, the FDA is examining the standards for functional foods with a public hearing. Functional foods are expected to reach \$49 billion by 2010, according to a 2000 study by the then-General Accounting Office.

Degradable plastic demand to reach 500 million lb in 2010

Starch-based plastic demand will grow nearly 18 percent per annum to 180 million lb in 2010 due to the availability of lower priced and improved resin blends.

Forget the cake, how about a chocolate beer?

With consumer demand turning toward drinks with vodka and rum, the beer industry is getting creative with new beverage ideas. Recent years have seen vitamin- and caffeine-infused beer and Miller announced Wednesday it will introduce a chocolate-flavored beer this holiday season.

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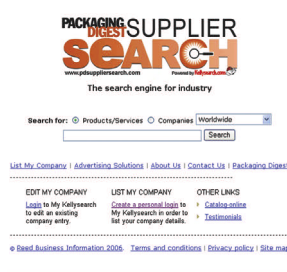
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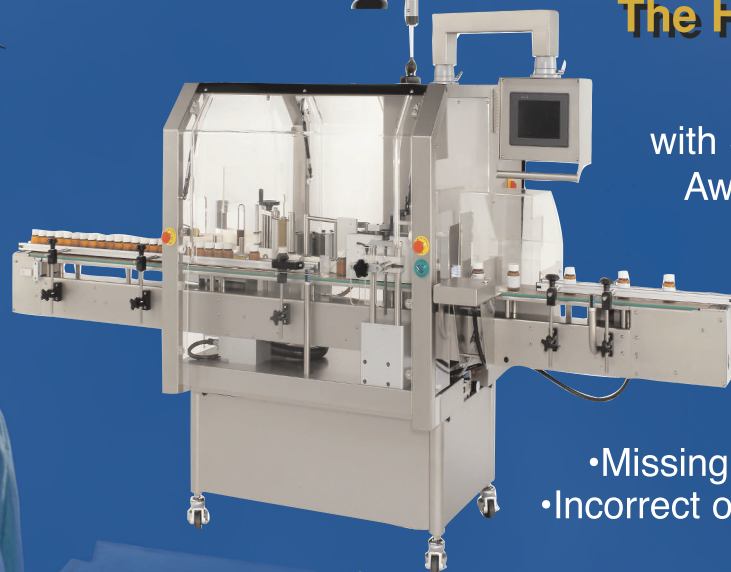
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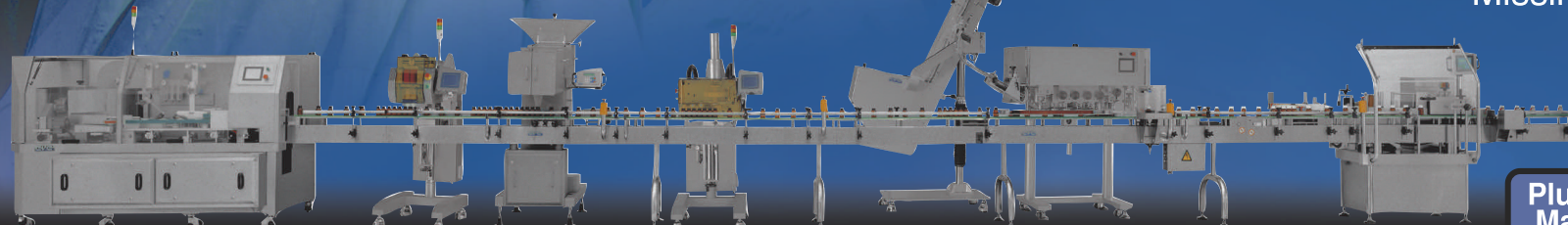
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