



**Resin formulation for  
Side gusseted tubing for FFS,  
made of monoaxial oriented film**

**Film structure (blocked film):**

Borealis Borstar® FB2230 and ExxonMobil Exceed™  
1018CA /

Borealis Borstar® FB2310 and Ampacet 11898I /  
DuPont™ Elvaloy® 1125 AC /

Borealis Borstar® FB2310 and Ampacet 11898I /

Borealis Borstar® FB2230 and ExxonMobil Exceed™  
1018CA

**Film thickness:**

80 µm MDO film (blocked blown film, oriented 1 : 6),  
layflat width: 1,150 mm

**Film layer distribution:**

20 % / 22.5 % / 15 % / 22.5 % / 20 %

**Tubing dimensions:**

Final width : 400 mm, Gusset depth : 76 mm

## TECHNICAL DESCRIPTION

- **UNWIND STAND :**
  - Working width : 1,200 mm
  - Max. reel diameter : 800 mm
  - Central drive with servo motor, reverse unwinding
  - Edge control
  - Web tension control by force transducer
  - Hydraulic roll lift
  - Automatic stop at roll end
- **TUBE FORMING AND SIDE GUSSETING :**
  - Continuously tube forming and side gusseting, Lap joint
  - Side gusset depth max. 90 mm, infinitely variable
  - Quick format change
  - Seam pressing with 2 rollers, rubber/steel
  - Nip unit
- **EXTRUSION SEALING :**
  - Continuously extrusion sealing in machine direction, lap joint
  - Extruder 20 mm diameter, 25 L/D, water cooled grooved feeding section
  - Multiaxial adjustment of welding die
- **SEAM COOLING AND EDGE SETTING :**
  - Seam cooling with water cooled contact bar
  - Edge setting with heated contact bars
  - Nip unit

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# HOSOKAWA ALPINE

**PROCESS TECHNOLOGIES FOR TOMORROW<sup>SM</sup>**