

Filling Ranges - Liquids



Cosmetic



Medical/Pharma



Chemical



Bio-Based



Recyclable

| EXAMPLE SACHET SIZES FOR FLUIDS (MM) | FILLING (ML) | FILLING WITHOUT REMAINING AIR (ML) | FILLING (ML) | FILLING WITHOUT REMAINING AIR (ML) | FILLING (ML) | FILLING WITHOUT REMAINING AIR (ML) | FILLING (ML) | FILLING WITHOUT REMAINING AIR (ML) | FILLING (ML) | FILLING WITHOUT REMAINING AIR (ML) |
|--------------------------------------|--------------|------------------------------------|--------------|------------------------------------|--------------|------------------------------------|--------------|------------------------------------|--------------|------------------------------------|
| AVERAGE VISCOSITY AT 20° - MPA.S | 84 | | 1.500 | | 10.000 | | 50.000 | | 100.000 | |
| SACHET EXAMPLES | OIL TYPES | | CREAM TYPES | | GEL TYPES | | HONEY TYPES | | BUTTER TYPES | |
| 40x50 | 0.2 - 1.0 | 0.7 | 0.2 - 1.2 | 1.0 | 0.2 - 1.2 | 1.0 | 0.2 - 1.5 | 1.2 | 0.2 - 1.6 | 1.3 |
| 50x50 | 0.3 - 1.2 | 0.8 | 0.3 - 1.3 | 1.1 | 0.3 - 1.3 | 1.2 | 0.3 - 1.5 | 1.3 | 0.3 - 1.6 | 1.4 |
| 40x80 | 0.5 - 3.0 | 2.5 | 0.5 - 4.0 | 3.5 | 0.5 - 4.0 | 3.5 | 0.5 - 6.0 | 5.0 | 0.5 - 7.0 | 6.0 |
| 50x80 | 1.0 - 5.0 | 3.5 | 1.0 - 6.0 | 4.0 | 1.0 - 6.0 | 5.0 | 1.0 - 7.0 | 6.0 | 1.0 - 8.0 | 7.0 |
| 60x100 | 2.0 - 12.0 | 10.0 | 2.0 - 12.0 | 10.0 | 2.0 - 14.0 | 12.0 | 2.0 - 16.0 | 15.0 | 2.0 - 16.0 | 15.0 |
| 85x100 | 5.0 - 22.00 | 19.0 | 5.0 - 25.0 | 20.0 | 5.0 - 26.0 | 22.0 | 5.0 - 28.0 | 25.0 | 5.0 - 29.0 | 27.0 |
| 100x100 | 10.0 - 30.0 | 25.0 | 10.0 - 32.0 | 27.0 | 10.0 - 35.0 | 30.0 | 10.0 - 38.0 | 30.0 | 10.0 - 40.0 | 30.0 |

NOTES:

1. ANY SACHET SIZE BETWEEN 40X50 MM AND 100X100 MM IS POSSIBLE. SACHETS CAN ALSO BE MADE IN ROUND SHAPES
2. MINIMUM FILLING VOLUME IS 0.2 ML, MAXIMUM FILLING VOLUME IS 40 ML, DEPENDING ON PRODUCT CATEGORY AND SACHET SIZE
3. IN PRODUCTIONS WHERE SACHETS ARE FILLED WITH REMAINING SPACE AND AIR, THE AIR CAN BE EXCHANGED WITH GAS
4. MACHINE PRODUCTION SPEED MAY VARY DEPENDING ON VISCOSITY OF FILLING MATERIAL; VISCOSITY CAN BE REDUCED BY OPERATING TEMPERATURE
5. IF THE MATERIAL USED IS A FULL ALU BASED (TOP AND BOTTOM), CONSIDER A SUGGESTED AVERAGE FILLING OF 0.1 ML LESS BECAUSE THE ALUMINIUM IS NOT ELASTIC
6. STANDARD FILLING PRECISION IS ± 0.2
7. ML PHARMACEUTICAL-GRADE FILLING SYSTEM IS AVAILABLE FOR FILLING VOLUMES BELOW 0.5 ML THAT REQUIRE MORE PRECISION
8. HIGHER FILLING VOLUMES ARE POSSIBLE THROUGH HIGHER FLEXIBLE TOP MATERIAL
9. FILLING VOLUMES AND SACHET SIZES FOR POWDERS NEED TO BE DETERMINED PER PRODUCT TYPE, BASED ON GRANULATION, MECHANICAL VISCOSITY, SPECIFIC WEIGHT AND DEGREE OF DUSTINESS
10. FOR HIGHER SHELF LIFE REQUIREMENTS, BARRIERS OF ALUMINIUM AND SIOX SILICA COATING ARE AVAILABLE



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