

# Manufacturer's Recommendation for Routine Operation

Frequency	Check/action	Criteria
Daily before operation	Making and checking a sample seal seam	<p><b>Visual check:</b></p> <ul style="list-style-type: none"> <li>The seal seam should be distinct and even and not contain any creases or defects.</li> <li>The sealing seam should be almost identical with the works sealing seam, i.e. an industrial seal with an identical edge in terms of colour.</li> </ul> <p>If the sealing seam is too light, → the sealing temperature and/or the contact pressure (sealing force) is too low; If the sealing seam is brown, → the sealing temperature is too high or the sealing duration too long</p> <p><b>Mechanical check</b></p> <ul style="list-style-type: none"> <li>Tear-resistance check: the strength required to open the seam must be exactly equal to that required to open the factory-produced seam → Peel test<sup>1)</sup></li> <li>When peeled off, the paper should free itself from the film, leaving almost no residue</li> </ul>
Following every sterilization	Batch-related check of the seam	<ul style="list-style-type: none"> <li>Control the entire packaging for dryness and integrity.</li> <li>Clearance after sterilization, documentation within the scope of process clearance</li> <li>Check for dryness and integrity once again, before using the instruments.</li> </ul>
Weekly	Checking the seal seam with aids	Perform a visual control using MELAG seal check and document the results - for criteria and further information, see the MELAG seal check operation manual
Annually	Check the seal seam for tear-resistance in accordance with DIN EN 868-5, Appendix D.	See the supplementary instructions of the MELAG seal seam strength test
After 50,000 cycles or 2 years (MELAseal 200, MELAseal Pro)	Maintenance	Perform the maintenance in accordance with the MELAG maintenance instructions, including the replacement of wear parts
Upon malfunction messages or obviously faulty seals	Remedying the fault	Do not operate a defective sealing device. Notify the authorized customer services
<p><sup>1)</sup> Performing the peel test:</p> <ol style="list-style-type: none"> <li>Seal the sterilization packaging in the sealing device.</li> <li>Place a sealed sterilization packaging in a sterilization cycle.</li> <li>Slowly pull apart (by hand) the sealing seam in the direction of peeling. The visual check is to verify whether the sealing seam extends along the whole width and length. No paper residue greater than 10 mm is permitted on the seal seam. Document the results.</li> </ol>		

## MELAG seal seam strength test

For validating your sealing processes MELAG provides a seal seam stability test for a cost price of 125.00 € plus V.A.T. (state 01/2015)

After the film test strips have been tested, MELAG will issue verification of testing and if successful, a certificate. This certificate confirms conformity of the seal seam with the standard DIN EN 868-5, Appendix D. Use the MELAG seal seam strength test application form (<http://www.melag.de/en/service/download-center/recommendations>).