

THE TOP
21 TIPS



For

Reducing ShrinkWrap Packaging Costs

Clysar

DID YOU KNOW...
the average shrink
operation wastes
between 10% and 30%
in total packaging costs?



ASK ABOUT PACESM—
The FREE Cost Checkup
with Guaranteed 10% Savings

But Now YOU Don't Have To!

At Clysar, we've worked with technical field specialists across the country to compile the 21 top tips and troubleshooting techniques that will help you make the most of every shrink packaging dollar. These proven tactics have helped thousands of Clysar shrink customers lower their total packaging costs.

Many of the ideas in this guide can be implemented by your own operators and maintenance staff. Others are best tackled with the help of a true "Shrinkaholic"—Clysar shrink packaging experts who bring you the best film and equipment solutions for the best bottom line.

Want to put actual dollars and cents to your shrink saving opportunities? Ask your distributor about Clysar's Packaging Area Cost Evaluation (PACESM). This FREE, confidential evaluation is conducted by an experienced shrink packaging expert at your site. It covers the cost-out options found in this booklet, and many more.

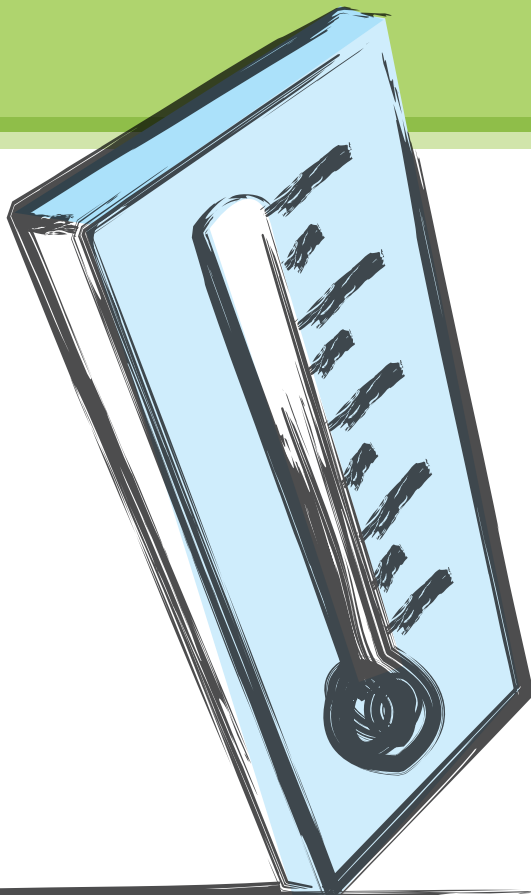
Worth \$1,000, your PACESM survey includes a comprehensive analysis, LEAN recommendations and quantified projected savings. Companies who participate in PACESM surveys typically uncover potential savings anywhere from 10%-30% in total packaging costs.

Visit www.Clysar.com/PACE for more information or to schedule a FREE PACESM survey.

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COST-SAVING TIP #1: ***Cool Your Reject Rates***

■ **Weak package seals can lead to expensive reworks, waste and returns.** Try turning down the heat on the seal bar—too much heat is the #1 cause of seal failure. Less heat will save on energy costs too. *(Check for film residue build-up on sealing surfaces, a sure sign your system is running too hot.)*





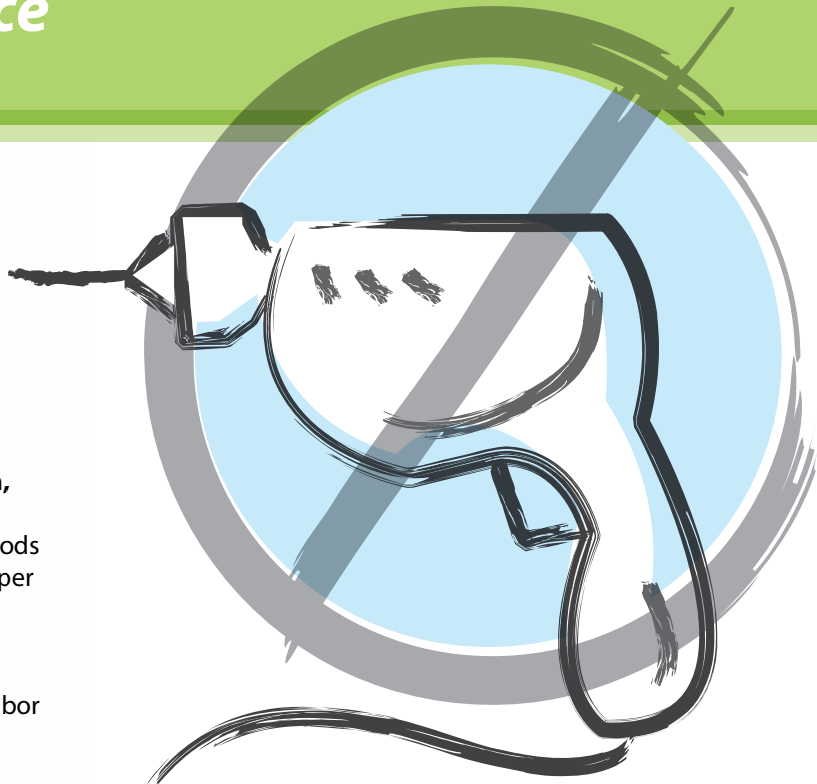
COST-SAVING TIP #2: **Think Thin**

- Today's thin, high-strength shrink films often make it possible to reduce film gauge and realize cost savings without sacrificing protection or shelf appeal. If you've "always used" 60-gauge film, you may save 20% or more downgauging to 50- or even 45-gauge options.

COST-SAVING TIP #3: *Perf Up Performance*

- If you are still hand-perforating film with drills, soldering irons or other tools for air evacuation, chances are you are experiencing bad seals, burnout and rework. That's because these methods typically fuse the film together and create improper air evacuation.

Instead, order pre-perforated film from Clysar—*it's the same cost as standard film*. You'll save on labor and gain great-looking, consistent packages.

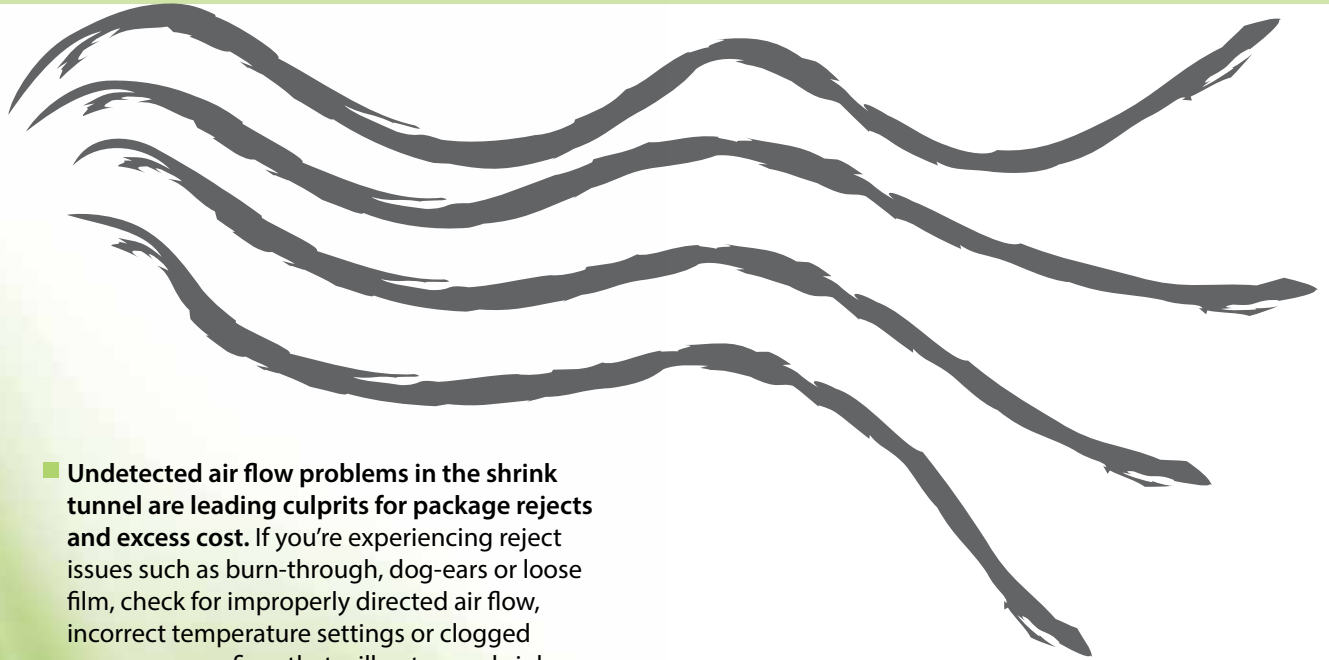


COST-SAVING TIP #4: *Get Oriented*



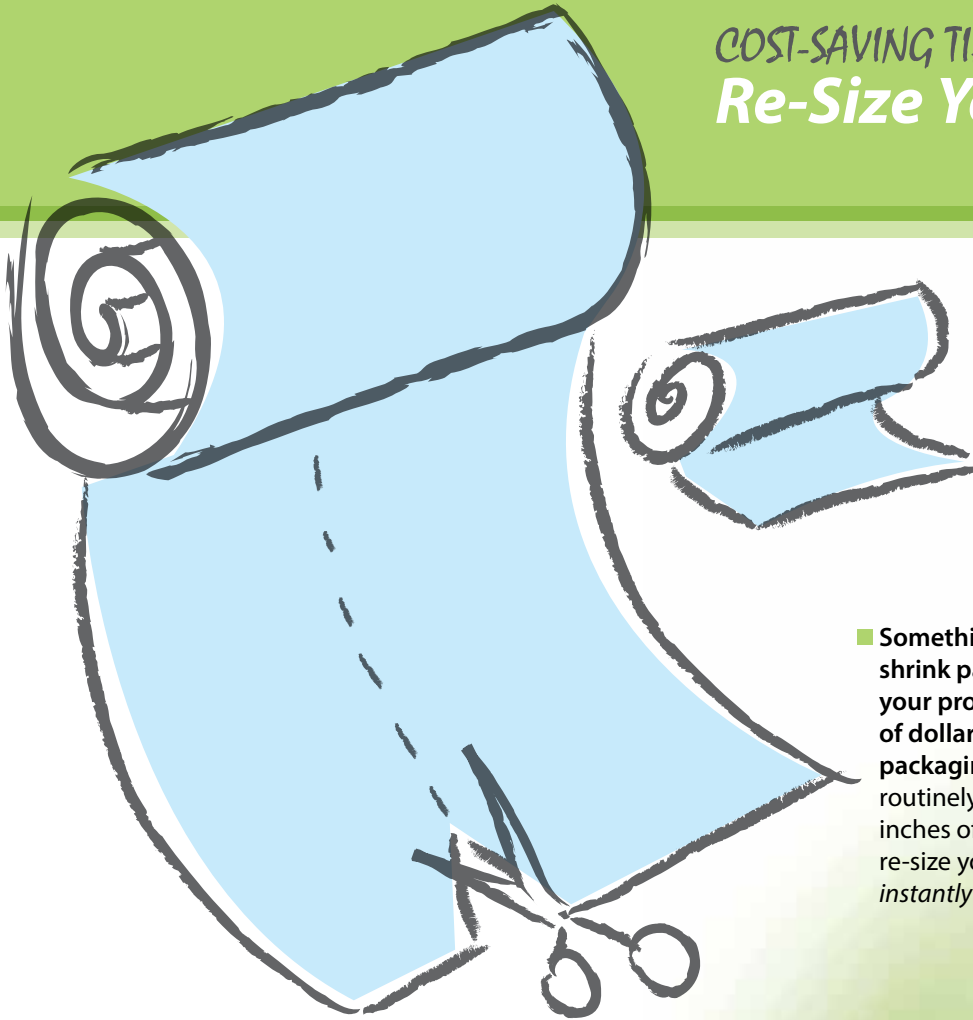
- Are you running products in the most efficient position to take maximum advantage of film yield? Simple changes in product orientation—such as finding the best wrapping configuration, or most efficient product placement for length, width and height—can give you more packages per roll and reduce your per-package cost.

COST-SAVING TIP #5: ***Air Out Your Tunnel***



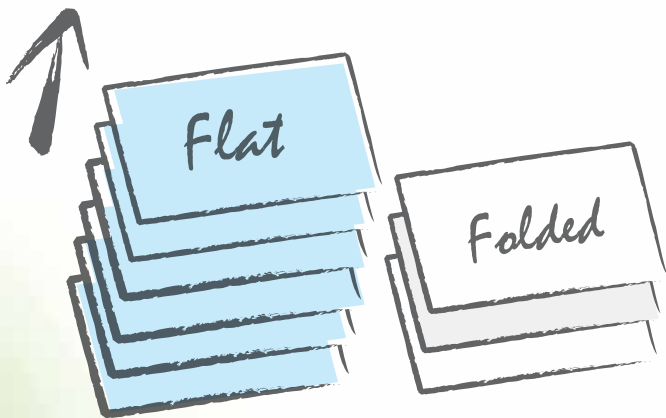
- **Undetected air flow problems in the shrink tunnel are leading culprits for package rejects and excess cost.** If you're experiencing reject issues such as burn-through, dog-ears or loose film, check for improperly directed air flow, incorrect temperature settings or clogged screens—easy fixes that will get your shrink tunnel back up to speed...and lower waste.

COST-SAVING TIP #6: *Re-Size Your Roll*



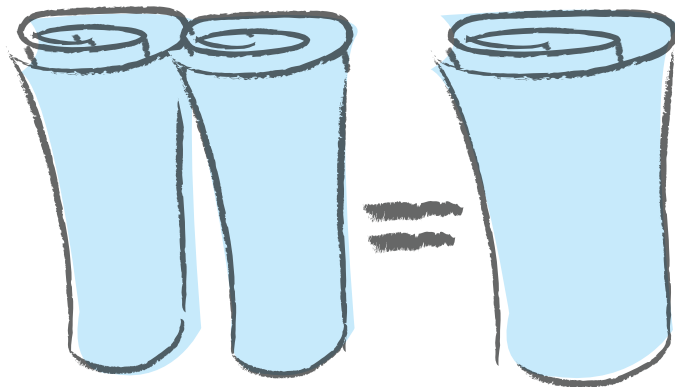
- **Something as simple as right-sizing shrink packaging film width to fit your product can save thousands of dollars annually in your shrink packaging operation.** If you're routinely getting more than two inches of trim waste, it's time to re-size your film. *(A move that will instantly reduce your roll price!)*

COST-SAVING TIP #7: *Go Flat*



- **Switching from centerfolded to flat film offers two great ways to save.** First, you'll save an average of 6% in film cost. Second, you'll get more feet per roll, which translates to more packages per roll of film, plus longer run time thanks to fewer changeovers. *(Note that flat film requires an automated folder, which can be added easily and cost-effectively to most shrink lines. Ask your Clysar distributor—a shrink specialist—for a cost analysis.)*

COST-SAVING TIP #8: *Order a Double*



- **What's one of the best ways to save on labor at no extra cost?** Switching from single- to double-length film rolls! When you run double-length rolls, you cut changeover time in half—and eliminate unproductive downtime. You'll run your shrink line longer, and get twice the number of packages to a roll. *(Quad rolls are also available for high-volume applications.)*

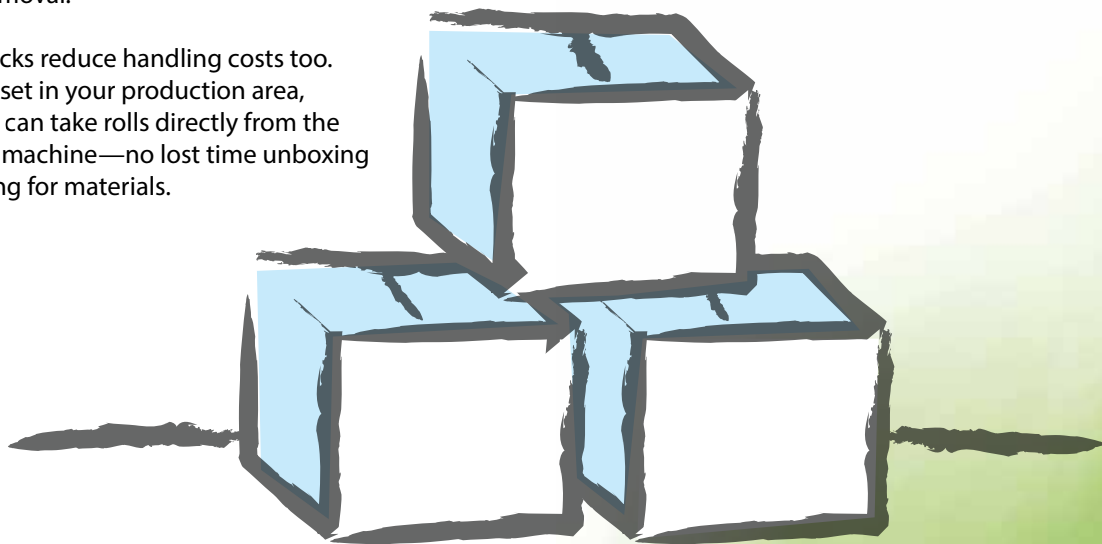
COST-SAVING TIP #9: Reduce Disposal, Material Handling

- **With the rising cost of corrugate disposal, the cardboard boxes used to ship shrink film cost you money every trip to the dumpster.** If you use an average of 1-3 rolls of film per day, per line, ask about Clysar's corrugate-free Efficiency Packs for your film—a waste management solution that really adds up if you're in a municipality with high-priced corrugate removal.

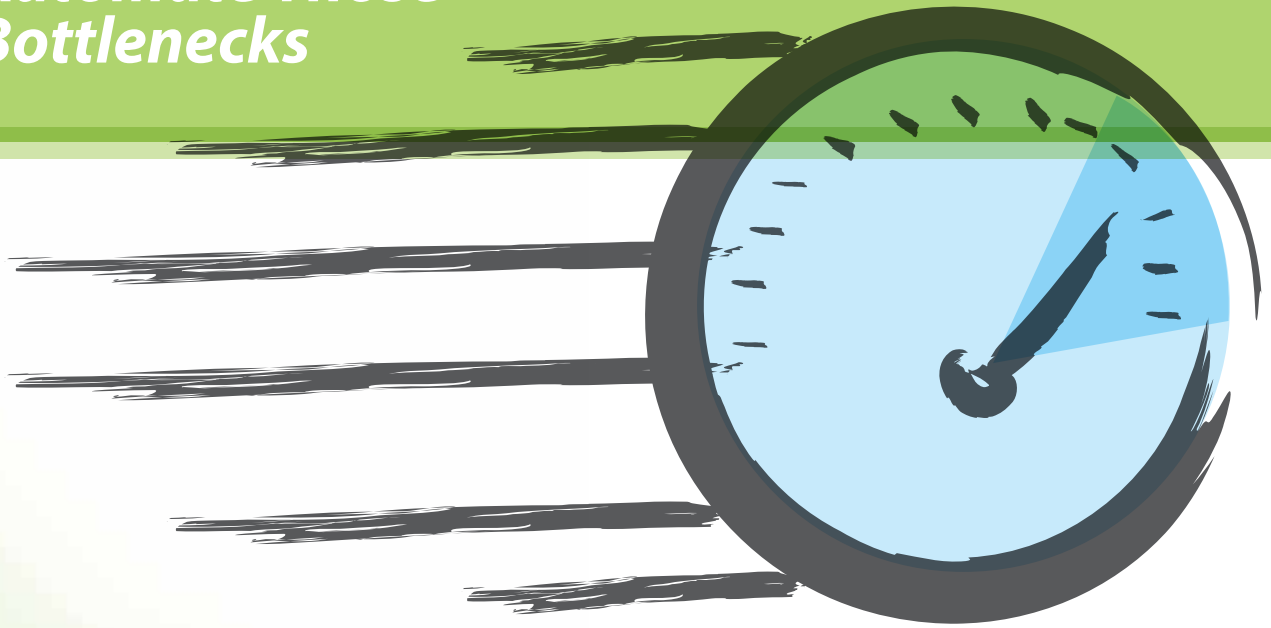
Efficiency Packs reduce handling costs too. They can be set in your production area, so operators can take rolls directly from the pallet to the machine—no lost time unboxing film or waiting for materials.

COST-SAVING TIP #10: Say Goodbye to Corrugate Shippers

- **Leaner, lighter, high-abuse ShrinkBox® packaging film can replace corrugate for shipping and merchandising.** Great for irregular-shaped products, ShrinkBox® film minimizes shipping and storage cost, as well as lowers total packaging costs. In addition, the system solves costly corrugate disposal at the retail level.

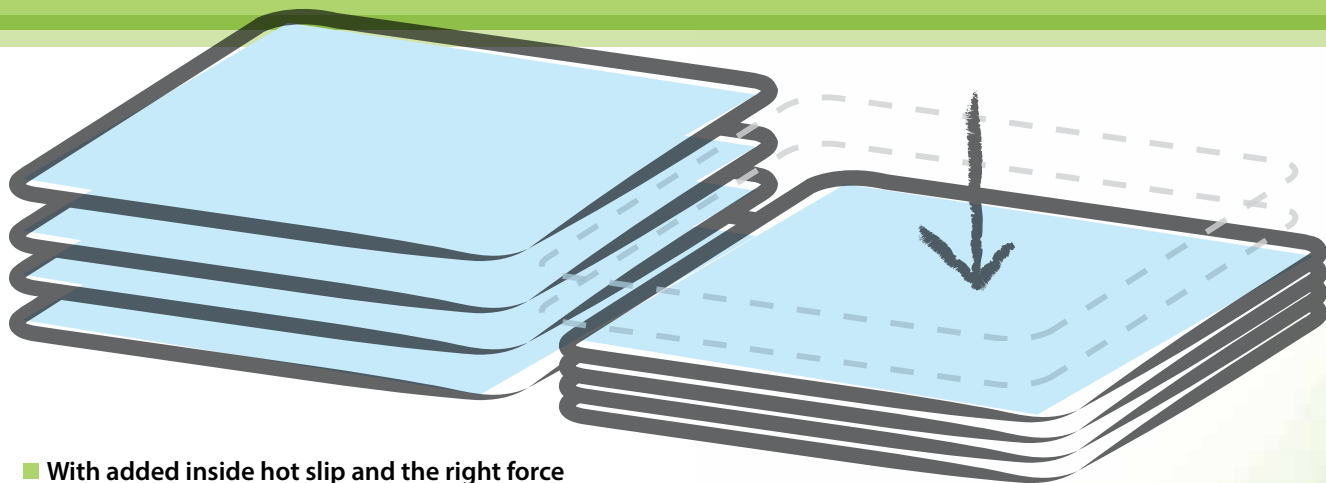


COST-SAVING TIP #11:
***Automate Those
Bottlenecks***



- **Time is money.** So ask your Clysar distributor about automating time-consuming manual operations such as labeling, product loading, feeding, folding or other labor-intensive tasks. Often, inexpensive automation solutions can reduce the number of people needed on the line and pay for themselves in a matter of months. Plus, flexible financing programs exist for low-cost ways to improve productivity.

COST-SAVING TIP #12: ***Pinch an Inch of Package***



- **With added inside hot slip and the right force shrink film, you can often reduce the size of your wrapped package by as much as an inch*—without spending an extra cent!** This right-sizing may not seem like much, but even this small reduction in space adds up to more efficient pack-out and can save thousands in shipping, postage and transport a year.

**Applications include thin, flexible and printed materials such as calendars and paper products*

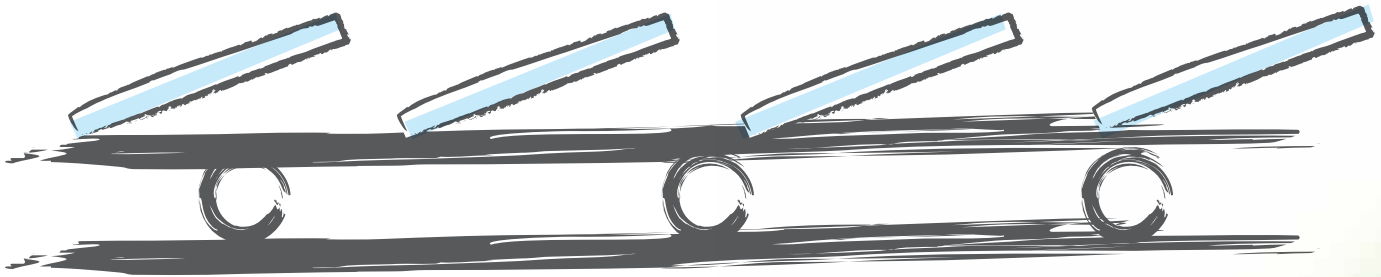


COST-SAVING TIP #13: *Stay Grounded*

- **Static generated by film and equipment can gobble up profits, thanks to issues with matted film, film tracking and tension problems, and safety liability.** Make sure your machine is grounded by using proper three-prong plugs. Also, double-check that the machine frame is connected to a grounding source like a metal pipe or drain.

Look for shiny, static-producing, worn grounding plates that create film drag—then just rough them up with a few swipes of sandpaper. And consider adding static eliminators, like electronically powered static eliminators, tinsel or static string.

COST-SAVING TIPS #14 & #15: *Eliminate Tension Headaches*



L-Bar Seals

- **Film tension can literally pull seals apart—a leading cause of rework and lost profit.** If you seal products on an L-bar table, and your package is lifting up when sealed, you have tension! Make sure your table is adjusted properly up or down so the seal is formed at the halfway point of the package and the film is slack before bringing down the sealing jaw.

Cross Seals

- **Tension is also a profit-buster on automated shrink packaging lines, where weak or failed cross seals drag down productivity.** To relieve the tension, allow more space between packages. You can do this by adjusting the speed of the infeed conveyor on your wrapper to automatically create more time between packages. It's a fast, easy solution to improve throughput and gain strong, reliable seals.

COST-SAVING TIP #16:
Give 'Em the Slip

COST-SAVING TIP #17:
Gain More Traction



- Adding a hot-slip treatment to your shrink film—which costs nothing extra—helps you get more products in the carton faster, with fewer film tears and damage. No more waiting around for warm, sticky packages to cool: your products will slide right in. Simply adding a fan at the pack-out station can also cool packages for faster cartoning.

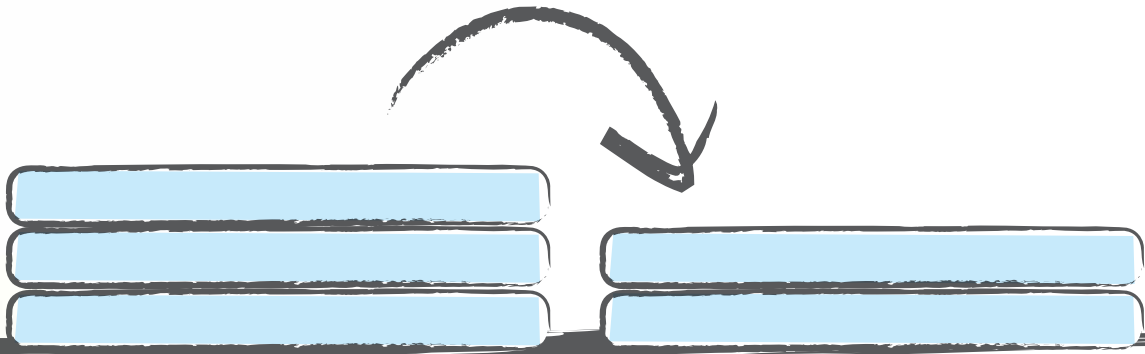
- If slippery conditions are creating excess time and work for wrapping products, especially on slick or uneven or oddly shaped items like binders, use a hot-slip treated film with the treated side against the product. You'll gain traction in product handling, which adds up to better productivity.

COST-SAVING TIP #18: *Lose the Label*



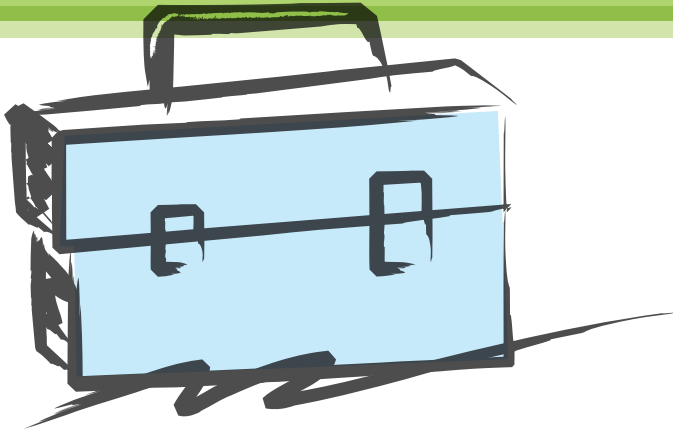
- **Each time you eliminate a process or a packaging element, you lower cost.** Printed film is an excellent example. Ask about corona-treated, printed shrink films, which can eliminate the cost of secondary labels. Options include flexographic printed film for full surround graphics, or in-line inkjet printing for bar codes, expiration dates and other variable data.

COST-SAVING TIP #19: *Eliminate Layers*



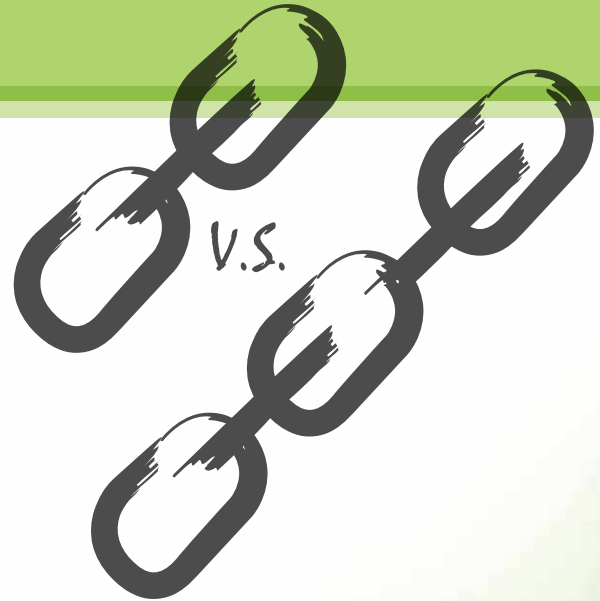
- If you're using chipboard to stabilize products prone to curling, try the latest low-force shrink films. Products like Clysar® LE Gold will stabilize your products while eliminating chipboard altogether, cutting material cost and taking out an extra packaging step.

COST-SAVING TIP #20:
***Practice an Ounce
of Prevention***



- **Machine wear and tear is a leading cause of slowed shrink production and poor package appearance.** Preventive maintenance is an easy—and often overlooked—remedy to lowering total cost. Get your shrink line back at peak operating condition by replacing worn seal pads, cutting knives, rollers or perforators; replacing missing machine clamps; cleaning clogged screens and connections; and correcting improper machine modifications.

COST-SAVING TIP #21:
LEAN Your Supply



- **Vendor-managed supply can significantly reduce the cost of carrying film stock, inventory damage and waste, administrative time and logistical errors.** Your Clysar distributor can manage your inventory based on your purchase patterns, with just-in-time supply that delivers just the right amount of film, when and where you need it. You'll save space, money and time.

Beautifully wrapped packages, produced for the lowest total cost, aren't the job of a generalist!

Clysar distributors are true shrink wrap specialists. They have the expertise to marry the right films, processes and equipment for the best value...and the best bottom line.

Ask your Clysar distributor for more information on these cost-saving tips—they'll be glad to follow up with specific recommendations for your shrink application.

To find a Clysar distributor near you, contact Clysar at 888-4-Clysar or visit www.clysar.com.

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Your Preferred Clysar Shrink Packaging Specialist