NORTH LAKES COPACKING
SPRING PARK · MINNESOTA

Roll Stock Film Specification

Requirements for printed laminate supplied to our horizontal form-fill-seal pouch line.

REV 1.0 **EFFECTIVE** OCT 21, 2026 **LINE** HMC POUCHMASTER HFFS

Please share this spec with your film supplier and have them confirm each item with their quote. Film that meets it runs clean on the first roll. Film that doesn't costs everyone time.

CORE ID	MAX ROLL OD	FILM WIDTH	WIND
3 in	**18** in	**4–21** in	**Print out** **Sealant in**
Fiber or paper, cut flush	Outside diameter	Min to max web width	Unwinds off the bottom

Pouch styles Sachet · Stand-up gusset · Zipper

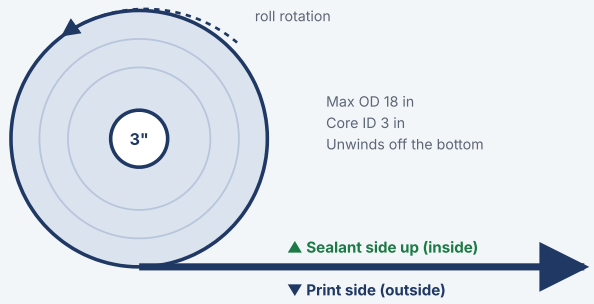
Products Powders

Repeat = pouch width ±1/32 in

Eye mark Centered on side seal, high contrast

01 ROLL FORMAT & WIND

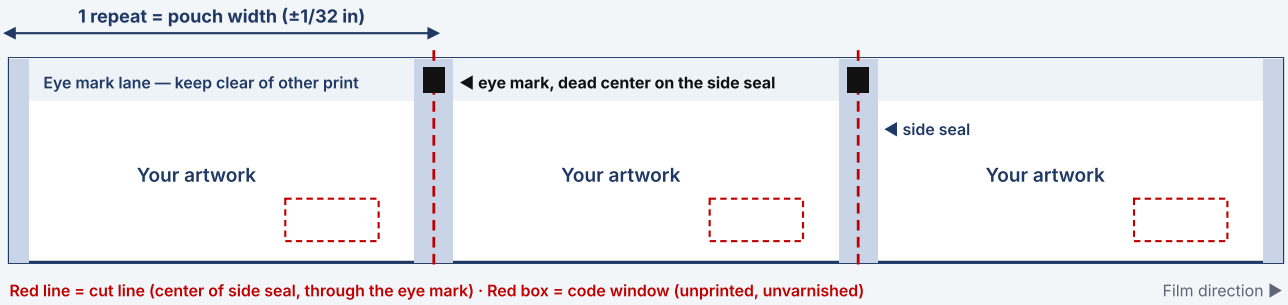
- **Core:** 3 in inside diameter, fiber or paper. Cut flush to the film width, no overhang.
- **Roll diameter:** 18 in maximum outside diameter.
- **Film width:** 4 in minimum, 21 in maximum. See section 03.
- **Wind:** print side out, sealant side in. The film unwinds off the bottom of the roll and enters the former sealant side up.
- **Wind chart:** include your wind-direction chart position with the quote. We confirm copy orientation on the trial roll.



Film leaves the bottom of the roll and travels to the former with the sealant side up.

02 PRINT & REGISTRATION

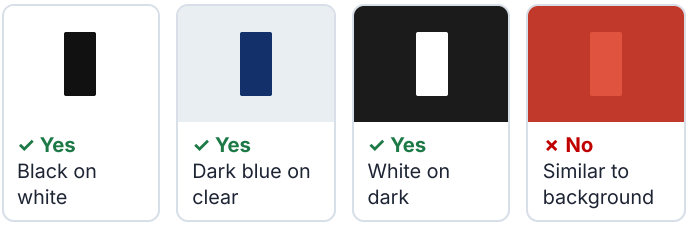
The film travels horizontally, so one pouch width equals one print repeat. Our machine registers off a printed eye mark on every repeat and cuts right through it, at the center of the side seal.



- **Placement:** one eye mark per repeat, centered on the side seal, in a lane along one edge of the web. We cut through the center of the mark.
- **Size:** solid mark, about ¼ in × ½ in.
- **Clear lane:** no other print, text or graphics in the eye mark's lane.
- **Repeat tolerance:** ±1/32 in.
- **Code window:** an unprinted, unvarnished area for our lot and date codes. Agree size and location with us before artwork approval.

EYE MARK CONTRAST

The mark must stand out sharply from the area around it. A dark mark on a clear or white background, or a white mark on a dark background. It can never be a color similar to the surrounding packaging.

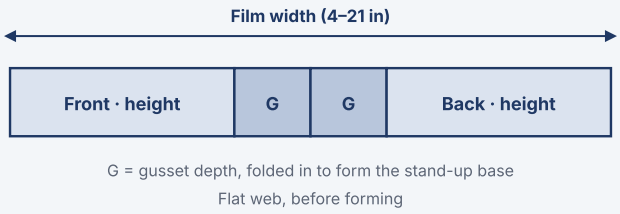


03 FILM WIDTH

For a stand-up pouch with a bottom gusset, film width is about twice the pouch height plus twice the gusset depth, plus any top trim. For a sachet with no gusset, it's about twice the pouch height plus trim.

Film width ≈ (2 × height) + (2 × gusset) + trim

Example: an 8 in tall stand-up pouch with a 1.5 in gusset needs about 19 in film plus trim. Film wider than 21 in won't run on this line. We confirm the final width against the approved pouch dieline.



04 MATERIAL

Item	Requirement
Structure	Heat-sealable laminate suited to horizontal form-fill-seal, e.g. PET/foil/LLDPE or PET/metallized PET/LLDPE. Barrier to suit the product.
Sealant layer	Seals cleanly on side, bottom and top seals. For zipper pouches, compatible with the zipper tape's sealant.
Slip (COF), sealant side	Supplier to state; suited to horizontal form-fill-seal
Thickness	Supplier to state; typically 3–5 mil for stand-up pouches
Barrier	Supplier to state moisture (MVTR) and oxygen (OTR) transmission rates
Food contact	Letter of guarantee for 21 CFR food-contact compliance
Documentation	Certificate of analysis (COA) with each lot

05 ROLL QUALITY

- **Splices:** 2 per roll maximum, butt-spliced, in registration, flagged with colored tape visible at the roll edge.
- **Winding:** even tension, no telescoping, no gauge bands or wrinkles.
- **Roll label:** lot number, wind position, roll length or pouch count, and splice count.
- **Packaging:** rolls wrapped and palletized to protect edges in transit.

06 BEFORE THE FIRST PRODUCTION RUN

Quote 1
Send your technical data sheet and wind-chart position with the quote.

Artwork 2
Approve final artwork and dieline with us, showing eye mark location, code window and film width.

Trial roll 3
Send a trial roll of a few hundred pouches. We run it on our line to confirm wind, registration and seals before production ships.

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Questions on this spec?
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