

# Handbook on Modern Packaging Industries (2nd Revised Edition)

**Author:-** NIIR Board

**Format:** paperback

**Code:** NI72

**Pages:** 848

**Price: Rs.1675US\$ 150**

**Publisher:** NIIR PROJECT CONSULTANCY SERVICES

Usually ships within 5 days

Packaging is a means of ensuring the safe delivery of a product to the ultimate consumer in a sound condition at the minimal overall cost. Packaging not only differentiates one brand from another but also, at times, gives a preview of the product being sold. Although it is a subject of recent technological origin, the art of packaging is as old as the primitive humans. Packaging is the science, art, and technology of enclosing or protecting products for distribution, storage, sale, and use, also refers to the process of design, evaluation, and production of packages and can be described as a coordinated system of preparing goods for transport, warehousing, logistics, sale, and end use. Packaging contains, protects, preserves, transports, informs, and sells. In many countries it is fully integrated into government, business, institutional, industrial, and personal use. The continual technological growth systems have undergone significant changes in recent years. A lot of packaging process has been streamlined to give a more scientific and rational approach. The role of packaging continues from the coordinated system of preparing goods to the end use. It has become a big tool for launching new specific products in different shapes and sizes. The packaging industrial growth has led to greater specialization and sophistication from the point of view of health (in the case of packaged foods and medicines) and environment friendliness of packing material. The demands on the packaging industry are challenging, given the increasing environmental awareness among communities. The packaging industry is growing at the rate of 22 to 25 per cent per annum thus is to play a unique role in preserving the wealth or value created by many industries.

This book describes the techniques and process behind packaging of different specific products which are used in our day to day life. The specific products include cereal, spices, edible oils, drinking water, chocolate and confectionery, fruits and vegetables, marine products and many more. Some of the vital contents of the book are adhesives for packaging industries, factors affecting adhesion, tin plate containers for foods, pharmaceuticals and cosmetics, tin plate usage in packaging, packaging of cereals and cereal products, trends in packaging of spices and spice products, packaging of edible oils, vanaspati and ghee, metal containers for food packaging, packaging aspects of sugar and chocolate confectionery, packaging for irradiated foods, packing of meat & meat products in tin containers etc.

This book is an invaluable resource for all its readers, entrepreneurs, scientists, existing industries, technical institution, etc in the field of packaging.

## 1. Adhesives for Packaging Industries Typical Application in packaging

Classification

(a) Loss of water or solvent

(b) Loss of Heat

Theories of adhesion

a. Mechanical Interlocking

b. Electrostatic Interaction

c. Diffusion Theory

d. Absorption Theory

Factors affecting adhesion

Spreading

Roughness

Porosity

Diffusion

Rheology

Thickness

Pressure

Starch

Degradation Products of Starch

Comparison between starch and Sodium Silicate

Polyurethane

Basic urethane chemistry

Acrylics

Casein

Natural Rubber

Polyvinyl Acetate

Polyvinyl Alcohols

2. Tin Plate Containers for Foods, Pharmaceuticals  
and Cosmetics

Manufacturing Process

Can Sealants

3. Tinplate Containers

Definition

Uses

Types

Open Top containers

General Line containers

Nomenclature

Manufacturer of Tinplate containers

Decoration

Sizing

Coating

Printing

Varnishing

Lacquering

Manufacture in Press Shop

Slitting

Component/end manufacture on presses

Ancillary operations

Manufacture of Assembly Lines

Slitting

Notching

Folding  
Forming  
Locking  
Soldering/Cementing  
Flanging  
End seaming  
Ancillary operations (if any)  
Packing/Palletising  
Flattened Cans  
Process Control  
Blackplate Containers  
Tinplate Closures

#### 4. Metal Container Industry In India

Raw Material  
Manufacturing Process

#### 5. Tin Plate Usage In Packaging

Round Ends tinplate Layout Systems And Procedures

Straight and Single

Double Row Staggered

Straight, Single Scrolled

Duble Row Staggered Scrolled

Multiple Row Fully Stagered Plain

Double Row Staggered With Primary (deep)

or Secondary Scroll

Coil Feed : Single Or Multiple Die Set up:

#### 6. Packaging of Cereals and Cereal Products

Spoilage Factors

Whole Grains & Split Pulses

Jute Bags

Advantages of Jute Bags and Jute Fabrics

High mechanical strength

Soft surface with high resistance to friction

Porous structure

Disadvantages of Jute Bags

Availability

Mineral oil contamination

Insect breeding

Cost

High Density Polyethylene (HDPE)/

Propylene (PP) Woven Sacks

Manufacturing Process of HDPE Woven Sacks

Extrusion Of Slit Film

Looming

Lamination

Cutting

Stitching

Printing

Bale Pressing and Packing

Advantages of HDPE & PP Woven Sacks

Disadvantages of HDPE & PP Woven Sacks

Quality Parameters to be Considered for Woven Sacks  
Consumer Packs for Whole Food Grains  
Milled Grain Products (Flours)  
Bulk Packs  
Consumer Packs  
High Molecular High Density Polyethylene (HMHDPE)  
Co-Extruded Films  
Biaxially Oriented Polypropylene Film : (BOPP)  
Laminates  
Processed Cereal and Pulse Products  
Cereal Based Convenience Foods  
Weaning Foods

## 7. Trends in Packaging of Spices and Spice Products

Packaging of Ground Spices  
Bulk Packaging and Storage of Whole Spices  
Packaging of Oleoresins and Volatile Oils  
Insect Infestation and Fumigation  
Literature Data on Packaging  
Future Trends

## 8. Packaging of Edible Oils, Vanaspati and Ghee

Introduction  
Spoilage Factors  
Distribution Pattern  
Packaging Systems/Types of Pack  
Package Types  
Tinplate Containers  
Glass Bottles  
Semi-Rigid Containers  
HDPE (High Density Polyethylene) Containers  
PET (Polyethylene Terephthalate) Bottles  
PVC (Poly Vinyl Chloride) Bottles  
Other Semi-rigid Packs  
Flexible Pouches  
Analysis of Needs and Shifts  
Structures and Critical Polymers  
Critical Polymers  
Polyester  
A Closer Look  
Flexibles as Economical Media  
Flexibles as Effective Solid Waste Reducing Media  
Indian Standard for Packaging of Edible Oils, Vanaspati and Ghee  
Legislations  
Conclusion

## 9. Metal Containers for Food Packaging

Abstract  
Introduction  
Tinplate Containers  
Developments in Tinplate Manufacture  
Structure of Tincoating  
Light tin coated steel (LTS)

Developments in can fabrication  
Two Piece Cans  
Drawn Thin Redraw (DTR) and precision sidewall thickness control (PSTC) process  
Plain Cans  
Acid resistant lacquered cans  
Sulphur resistant lacquered cans  
High Tin Fillet (HTF) can  
Corrosion problem in food cans and its inhibition  
Quality control tests  
Thickness of tinplate  
Grain structure of tincoating  
Coating continuity (porosity) test (ISV)  
Tin oxide  
Chromium in passivation layer  
Special property tests  
Tincoating  
Tin Free Steel Cans  
Manufacture  
Cansuper  
Hinac coat  
Hi-top  
Stainless weirchrome  
Fabrication of TFS cans  
Mira seam  
Conoweld  
Forge welding  
Advantages and Disadvantages of Tin Free Steel  
Physical characteristics of HI-Top Plate  
Corrosion resistance  
Lacquering quality  
Formability  
Weldability and solderability  
Canning Food Products in Tin-free steel cans  
Fish products  
Meat products  
Fruit and Vegetable products  
Aluminium containers  
Package forms  
Aluminium closures and ends  
Conventional closures  
Easy open ends are of two types  
Packaging of Food Products in Aluminium Cans  
Fruit and vegetable products  
Lacquered cans  
Meat products  
Marine products  
Milk products  
Alcoholic drinks  
Corrosion in Aluminium cans  
External decoration and Printing  
Future Scope  
Evaluation of indigenous electrolytic tinplate

Assessment of differential tinplate  
Evaluation of indigenous aluminium cans for processed foods  
Acknowledgement

## 10. Packaging of Drinking Water

Brief History

Main Processing System

Packaging Materials

Bottle Filling

Bottle Labelling

## 11. Bottle Labelling

Introduction

The Product Group

Packaging Materials for Snack Foods

Packaging Systems

Gas flushing

Compensated vacuum

## 12. Packaging Aspects of Sugar and Chocolate Confectionery

Introduction

Packaging Requirements

Packaging Requirements

Sugar Confectionery

Chocolates

Packaging Materials and Packages

Packaging Materials

## 13. Packaging for Biscuits

Protection Presentation, Information and Convenience

The Wrapping Materials

The Packaging Styles

## 14. Packaging Trends for Cheese and Other Dairy Products

Milk Powder-Bulk

Milk Powder-Retail

Butter

Yogurt

Ice Cream

Cheese

Cheese - Retail

## 15. Packaging of Milk

## 16. Packaging of Fish

Introduction

Important Quality Aspects of Fresh Fish

Packaging Concepts

Vacuum Packaging

Modified Atmosphere Packaging

Active Packaging

Packaging Requirements

Examples

Conclusion

Final Remarks and Future Developments

## 17. Packaging for Irradiated Foods

Food Borne Illness is a Global Concern

Commercialization of Food Irradiation Worldwide

Food Irradiation in the U.S.A.

Barriers to Widespread Commercialization of

Food Irradiation in the U.S.A.

The Consumer Acceptance Barrier

The Cost Barrier

The Capacity Barrier

The Regulatory Barrier

Pasteurized Milk Case History

Packaging for Irradiation

Packaging Materials for use during Irradiation of Food

What action should Food Processors Take?

## 18. Development in Modified Atmosphere Packaging Of Meat, Poultry and Fish

Introduction

Historical Development

Modified Atmosphere Technology

Equipments and Films For MAP

Patents Available

Effects of Gases on MAP Foods

Effect of MAP on the Quality of Fresh Meats

Effect of Map on Processed Meats

Package Integrity and Quality of MAP Foods

Safety Concerns of MAP Muscle Foods

Cost Benefit Relationship

## 19. Packing of Meat & Meat Products in Tin Containers

Raw Materials

Cans and Lids

Coating

Vinyl Lacquers

Phenolic Lacquers

Corrosion

Internal Corrosion

Filling Operations

Can Seaming

Dehydrated Meat Products

## 20. Aseptic Packaging

Microbiological Aspects of Aseptic Packaging

Sterilization of the Packaging Material Food Contact Surface

The Tetra Classic Aseptic System (TCA)

The TBA/3-System

The TBA/8 and TBA/9 Systems

The TBA/10-System

## 21. Aluminium Cans for Heat-Sterilized Food Products

Summary

Current Usage  
Characteristics  
Recent Innovations  
Material Recyclability  
Conclusion

## 22. Aluminium Container for Fish Canning

Introduction  
Materials and Methods  
Results and Discussion  
Conclusion

## 23. Aluminium in Flexible Packaging

Introduction  
Benefits of Aluminium based Packaging Materials  
Technical properties of Aluminium Foil  
Some Technical Applications of Aluminium Foil  
Other way of Classifying Applications  
Various Popularly known product groups and structures  
Why Aluminium is preferred in Various Applications  
Machines and Equipment for the manufacture of Flexible Packaging Material  
Wet Laminating Machine  
Dry Laminating Machine  
Hot Coating Laminating Machine  
Extrusion Laminating Machines  
Coating Machine  
Printing Machines  
Various QC Test Relevant to Applications  
Modern Trends in Packaging  
X. New Technologies  
Solventless Lamination  
Advantages of Solventless Lamination  
Digital Printing

## 24. Aluminium Foil in Pharmaceutical

Packaging-Recent Developments  
Influential factors on pharmaceutical products  
The Alu-Alu blister (Formpack)  
Multi Axial Dehnung (Stretching)  
Lidding foils  
Summary and outlook

## 25. Aluminium Foil

Standard Conditions of Bare Aluminium Foil  
Standard Finishes of Bare Aluminium Foil

## 26. Aluminium and Foil Production Methods

How Aluminium is Made  
Rolling Aluminium Foil

## 27. Aluminium In Packaging : Current Scenerio



## 28. The Process of Producing Collapsible Aluminium Tubes

Accumulator

Producing Tubes of different Diameters and Forms

Chains in Dryers and Ovens

Lubrication of Machines

Technical Developments

## 29. Aluminium Cans in Packaging

Introduction

Aluminium

Properties

Manufacturing Process

Coating and Decoration

Recycling

Easy Open Ends

Lacquers and Coating

Testing and Quality Control

Future

## 30. Aluminium Foils for Composite Containers

Aluminium Foil Membrane on Tin Cans

## 31. Aluminium Collapsible Tubes

## 32. Aluminium collapsible tubes their suitability-reliability-availability

## 33. Pharmaceutical Packaging Collapsible Tubes

Pharmaceutical Containers

Collapsible Tubes

Advantages of collapsible tubes

Pharmaceutical Forms Packed in Collapsible Tubes

Selection in metal collapsible tubes

Testing of collapsible tubes

Eye Ointment tube

Shelf life tests

Filling of collapsible tubes

## 34. The Birth of an Aluminium Collapsible Tube

## 35. Embossing Aluminium Foil

## 36. Wooden Containers

Classification of Timbers

Seasoning of Wood

Physical and Mechanical Properties of Timber

Mechanical Properties

Methods of Preservation of Timber

Form and size of Each Component

Thickness of Components

Size and Spacing of Nails

Number of Planks in a Shook

Type of Joints

Style of Container

Reinforcements  
Workmanship  
Consideration for a Design of the Box  
Easy Load  
Average Load  
Difficult Load  
Grouping of Indian Timbers  
Plywood Boxes - Battened Construction

### 37. Tinplate Container for Packaging of Fruit and Vegetable Products

Abstract  
Introduction  
Standards for Metal Containers  
Summary

### 38. Tetra Pak Application in Food Packaging

Introduction

### 39. Printing on Foil

### 40. Aerosol

A Pressurised Form of Packaging and Dispensing a product

### 41. Foil Bag, Pouch and Envelope Production

Envelope making  
Pouch making  
Folding Carton Production  
Foil/Fibre can and Drum Production

### 42. Packaging of Cashew Kernels in Tin Plate Containers

### 43. Packaging of Paints in Tin Plate Containers

### 44. Application to Food Packaging-Form-Fill-Seal Machines

### 45. Shrink Packaging-Food Products

### 46. The Aerosol Package-Container Manufacture

### 47. Sterilization Methods for Packaging Materials used in aseptic systems

Testing Procedures  
Requirement of Aseptic Systems

### 48. Blow Moulded Containers for Food Packaging

Basic Process Concepts  
Technology Development for Food Packaging  
Aseptic Containers  
Barrier Containers  
PET Containers  
Newer Developments

### 49. Thermoformed and Blow Moulded Containers for Food Packaging Applications

Introduction

Polypropylene  
Polystyrene

## 50. Role of BOPP Films in Food Packaging

Introduction

Manufacture

Properties of BOPP Films

Advantages

Role of BOPP Film in Food Packaging

New Developments in BOPP Films

Conclusion

## 51. Modified Atmosphere Packaging of Fresh Fruits and Vegetables

Factor Influencing Shelf-life of Fruits and Vegetables

Respiratory Metabolism

Controlled Atmosphere (CA) Storage Technology

Advantages of MAP Technology

Limitations of MAP Technology

Dynamics of Gaseous Exchange in MAP

MA Package Design

Mathematical Modelling of Gaseous Exchange in MAP

Computer-Aided Design of MAP

Verification of Predicted Values

Tailored Plastics Film-Laminates

## 52. Plastics

Distinction Between Plastics, Fibres and Elastomers

Techniques of Polymerization

Processing of Plastics

Compression Moulding

## 53. Plastic Corrugated Board

## 54. Polyester Film

## 55. Nylon-6 Film - A Revolution in Packaging

## 56. Plastic Woven Sacks

Introduction

Plastic Woven Sack Materials

High Density Polyethylene (HDPE)

Polypropylene (PP)

Method of Making Woven Sacks

Flexible Intermediate Bulk Containers (FIBC)

Construction of FIBC

Use of Woven Sacks/FIBC

Conclusion

## 57. Low Density Polyethylene

Additives

## 58. High Density Polyethylene

59. PVC in Packaging

60. Biaxially Oriented Polypropylene Film

61. Expanded Polyethylene Material

62. Expanded Polystyrene  
Properties of EPS

63. Shrink and Stretch Wrapping  
Shrink Packaging  
Stretch Wrapping  
Pilfer- Proof Packs  
Pallet Stretch Wrapping

64. New Developments Paper pulp Based Moulded Containers for Fruits and Vegetables  
Apple Tray Packaging Concept  
Consumer Pack Trays  
Tray Hand Wrapping Machine  
Conclusion

65. Solid Fibre Board Box as a Transport Pack  
B. Combination Board-What is it?  
C. Solid fibre board with moisture/water proof inner or outer lining  
D. Solid Fibre Board with Hessian Lining  
Conclusion

66. "Quality Control-Specifications and Performance Requirements of Fird Boxes"  
Quality Control  
Quality Control on Cor  
Specifications and Performance Requirements of Fibreboard Boxes

67. Folding Board Cartons and Coated Cartons Manufacture  
Introduction  
Relevant Properties of Paper/Board for Carton Manufacture  
Grammage  
Caliper  
Bursting Strength  
Shade  
Grain Direction  
Folding  
Moisture Content  
Stiffness  
Manufacturing Process  
Computer Controlled Inking

68. Cellulosic Films

69. Multiwall Paper Sacks

70. Speciality Papers for Packaging

71. Flexible Packaging Laminates and Coatings Application

Disaster Relief Packages  
Snack Food Packaging  
Corn Chips  
Cross Laminated Film  
Modified Atmosphere Packaging  
Fresh Red Meat  
Fish  
Cold Seal Adhesives for Flexible Packaging  
Hot Melt Adhesives  
Metallising Film/Paper

72. Adhesive Tapes  
Introduction

73. G.I. Drums-Oil Drums-Closures  
Introduction  
Capacity  
Type of Drums  
Standardisation of Metal Container  
Selection of Drums  
Manufacture of Drums  
Reconditioning Industry  
Quality Control  
Closures  
Essential Functions of Closures  
Recent Development in Drums  
Market Analysis  
Market Share and Competitors Activities

74. Packaging in Glass Containers  
Testing

75. Laminated Tubes  
Introduction  
Market Trends

76. Converting Materials and Methods  
Coatings  
Adhesives  
Laminating Materials  
Laminating Aluminium Foil  
Coating Aluminium Foil

77. Aseptic Packaging Materials and Package Forms

78. Printing Inks for Food Packaging  
Printing Processes and Printing Inks  
Dispersion  
Hue and Strength  
Drying Time  
Strength (Concentration of Pigment): Reduction Test

79. Closures in Food Packaging

Introduction  
Functions of a closure  
Components involved in a good seal  
Materials used in the manufacture of closures  
Resilient Materials  
Facing Materials  
Compatibility of closures and migration limits  
Factors Effecting A Good Seal  
Types of closures  
Roll-on-Pilferproof Closures  
Screw Caps  
Lug Cap  
Crown Caps  
Plastic Closures  
Epilogue

## 80. Packaging Laws and Regulations

SWMA  
PFA Rules  
Ingredients  
Other Labelling Rules under PFA  
FPO Rules  
MFPO Rules  
Agmark Rules

Directory Section  
Suppliers of Machinery & Plants  
Suppliers of Raw Materials

## About NIIR

**NIIR PROJECT CONSULTANCY SERVICES (NPCS)** is a reliable name in the industrial world for offering integrated technical consultancy services. NPCS is manned by engineers, planners, specialists, financial experts, economic analysts and design specialists with extensive experience in the related industries.

Our various services are: Detailed Project Report, Business Plan for Manufacturing Plant, Start-up Ideas, Business Ideas for Entrepreneurs, Start up Business Opportunities, entrepreneurship projects, Successful Business Plan, Industry Trends, Market Research, Manufacturing Process, Machinery, Raw Materials, project report, Cost and Revenue, Pre-feasibility study for Profitable Manufacturing Business, Project Identification, Project Feasibility and Market Study, Identification of Profitable Industrial Project Opportunities, Business Opportunities, Investment Opportunities for Most Profitable Business in India, Manufacturing Business Ideas, Preparation of Project Profile, Pre-Investment and Pre-Feasibility Study, Market Research Study, Preparation of Techno-Economic Feasibility Report, Identification and Section of Plant, Process, Equipment, General Guidance, Startup Help, Technical and Commercial Counseling for setting up new industrial project and Most Profitable Small Scale Business.

NPCS also publishes various process technology, technical, reference, self employment and startup books, directory, business and industry database, bankable detailed project report, market research report on various industries, small scale industry and profit making business. Besides being used by manufacturers, industrialists and entrepreneurs, our publications are

also used by professionals including project engineers, information services bureau, consultants and project consultancy firms as one of the input in their research.

Our Detailed Project report aims at providing all the critical data required by any entrepreneur vying to venture into Project. While expanding a current business or while venturing into new business, entrepreneurs are often faced with the dilemma of zeroing in on a suitable product/line.

---

**NIIR PROJECT CONSULTANCY SERVICES**, 106-E, Kamla Nagar, New Delhi-110007, India.

**Email:** [npcs.india@gmail.com](mailto:npcs.india@gmail.com) **Website:** [NIIR.org](http://NIIR.org)

Sat, 17 May 2025 10:06:13 +0000