BLISTER AND TRAY SPECIFICATIONS
HIGH PERFORMANCE PACKAGING LINES

Purpose:
A guide in determining the Denesting possibilities of a particular tray and suggestions for improvements if they are necessary.

General Specifications:

I. The cavity corners should have at least a 1/8" radius.
II. Flange to cavity tolerance + or - 1/32".
III. Outside flange to outside flange tolerance + or - .015".
IV. Cavity to cavity size tolerance + or - .015".
V. Cut or punch one layer of trays at a time, do not a multiple stack cut.
VI. Adding a silicone emulsion release agent to one surface will improve Denesting.
VII. Trays are to be consistent in wall thickness and without wrinkled flanges or cracks.
IX. Shipping and handling: stacked in columns, under packed by 1% and laying on their sides.
X. A flange width of 3/8" is generally desirable.

Denesting Lugs:

I. Denesting Lugs are usually not required if:
    A. The tray has a 10E "non locking" tapered angle on all cavity walls.
        1. Some trays may denest with a 7E tapered wall.
        2. Trays less than 5/8" deep usually require a 15E taper.
II. Denesting Lug Specifications:
    A. Suggested Size:
        1. Semicircle with a minimum diameter of 3/32".
        2. Minimum depth 1/8".
    B. Suggested Locations:
        1. One Lug in each of the four corners.
        2. Larger trays (16 square inches and above) require additional Lugs in a matrix approximately 2" on centers.
        3. Provide at least four different die cavities, staggering the positions by at least 1/4".
        4. A common position reverse Lug could be used in some situations.

Denesting Tests:

I. Table Top Test: a 24" high stack is suggested.
    A. Separate and restack each tray (to insure that none of the trays is nested).
    B. Manually compress the stack approximately one inch.
    C. Slowly remove each tray, one at a time from the top of the stack, through the entire stack.
    D. If the tray=s separate (are not blocked) during this ADenesting@ process they are typically acceptable for high performance packaging lines.
II. Machine testing:
    A. If the trays fail the ATable Top@ test, a machine test will be required to calculate the efficiency.
    B. The actuated mechanical clips or the pneumatic assist may be required.

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