



## **Lidding Film Guide**

When it comes to food packaging, getting the seal right is just as important as the tray it covers. Lidding film plays a vital role in keeping contents fresh, extending shelf life, and ensuring a secure seal – whether that’s for ready meals, deli produce, or fresh ingredients. At SystemPAK, we offer a versatile range of lidding films to suit various tray materials and sealing requirements. Here, we break down the differences between weld seal and peelable seal options to help you choose the right solution for your packaging needs.

### **What is Lidding Film? Peelable Seal vs Weld Seal**

Lidding film is the top layer of a packaging system, designed to seal onto trays made from materials like APET, CPET, or pressed board. The film needs to create a secure seal during the packaging process, which is why factors such as sealing temperature, dwell time, and tray type all matter.

Let’s explore the lidding film options available at SystemPAK – and what makes each one suitable for different packaging applications.

When it comes to food packaging, getting the seal right is just as important as the tray it covers. Lidding film plays a vital role in keeping contents fresh, extending shelf life, and ensuring a secure seal – whether that’s for ready meals, deli produce, or fresh ingredients. At SystemPAK, we offer a versatile range of lidding films to suit various tray materials and sealing requirements. Here, we break down the differences between weld seal and peelable seal options to help you choose the right solution for your packaging needs.

### **What is Lidding Film? Peelable Seal vs Weld Seal**

Lidding film is the top layer of a packaging system, designed to seal onto trays made from materials like APET, CPET, or pressed board. The film needs to create a secure seal during the packaging process, which is why factors such as sealing temperature, dwell time, and tray type all matter.

Let's explore the lidding film options available at SystemPAK – and what makes each one suitable for different packaging applications.

## **Weld Seal Lidding Films**

Weld seal films are designed to form a strong, permanent bond with the tray. They're ideal when tamper-proof packaging or high-pressure sealing is required, offering durability and peace of mind for food producers.

### **1. ECOPET 12/15mu Weld Seal with Anti-Fog (PCJ)**

This high-performance film seals securely to APET, CPET, and rPET trays at temperatures between **140–160°C** with a dwell time of **1–3 seconds**. For pressed board trays, higher temperatures of **180–200°C** and dwell times of **2–5 seconds** are recommended due to the increased sealing pressure.

- **Material:** ECOPET with anti-fog
- **Sealing Range:**
  - 140–160°C for plastic trays
  - 180–200°C for board trays
- **Widths Available:** 140mm, 150mm, 185mm, 210mm, 430mm
- **Box Stock Codes:** 3930, 3931F, 3932, 3933, 3936

### **2. PET/PP 12/30mu Weld Seal with Anti-Fog (PCJ)**

Designed for all P-type trays, this PET/PP blend delivers reliable sealing at **110–145°C** with a **1–3 second** dwell time. It also includes anti-fog properties to maintain product visibility on shelf.

- **Material:** PET/PP
- **Sealing Range:** 110–145°C
- **Widths Available:** 150mm, 185mm, 210mm, 270mm
- **Box Stock Codes:** 3131F, 3912, 3920, 3906

## **Peelable Seal Lidding Films**

Peelable films are ideal when a user-friendly experience is essential. These seals hold securely during storage and transit but peel back cleanly when it's time to open the pack – with no mess or tearing.

### **3. PET/PP 12/30mu Peelable Seal with Anti-Fog (PCJ)**

This film gives you the best of both worlds – a strong seal and easy peel. It performs across a range of P-type trays at **95–145°C**, with a dwell time of **1–3 seconds**.

- **Material:** PET/PP with anti-fog
- **Sealing Range:** 95–145°C
- **Widths Available:** 150mm, 185mm, 210mm, 270mm
- **Box Stock Codes:** 3911, 3913, 3914, 3915

### **Universal Lidding Films**

For packers working with a variety of materials, a universal film offers the flexibility to seal to multiple tray types – making it ideal for mixed production lines or evolving product ranges.

### **4. Universal 101 AF PET23 35mu – Clear with PCR (30%)**

This film is designed to seal to most monolayer tray materials. It acts as a **peelable seal at shorter dwell times** but forms a stronger **weld seal as dwell time increases**.

- **Material:** PET with 30% recycled content
- **Sealing Range:**
  - 160–200°C for monolayer materials (1–3 secs)
  - 180–220°C for pressed board trays (3–5 secs)
- **Widths Available:** 140mm, 150mm
- **Box Stock Codes:** 3916, 3917 (printed version also available)

### **5. Universal 101 AF PET50 – 50/12mu Pre-Cut Lids with Pinseal Pattern**

This pre-cut option is ideal for specific diameters and tray types, using a clear pinseal pattern for improved grip and seal consistency.

- **Material:** Clear PET with pinseal pattern
- **Sealing Range:** 160–220°C
- **Dwell Time:** 1–2 seconds
- **Spec:** 115mm diameter
- **Box Stock:** Available in pre-cut format

### **Important Considerations**

At SystemPAK, we understand that every production line is different. Sealing temperatures and dwell times can vary depending on:

- – The sealing machine used
- – Tray formulation
- – Film type
- – Ambient conditions

That's why we always recommend carrying out your own in-house trials before full-scale production. Our technical team is on hand to offer advice and product samples to support your testing process.

### **Need Help Choosing the Right Film?**

Whether you're looking for a high-performance weld seal for tamper-proof packaging or a peelable option for consumer convenience, we've got a solution that fits. Our films are tested for quality, consistency, and shelf-life performance – helping you deliver the best possible product to market.

Weld seal films are designed to form a strong, permanent bond with the tray. They're ideal when tamper-proof packaging or high-pressure sealing is required, offering durability and peace of mind for food producers.

#### **1. ECOPET 12/15mu Weld Seal with Anti-Fog (PCJ)**

This high-performance film seals securely to APET, CPET, and rPET trays at temperatures between 140–160°C with a dwell time of 1–3 seconds. For pressed board trays, higher temperatures of 180–200°C and dwell times of 2–5 seconds are recommended due to the increased sealing pressure.

- Material: ECOPET with anti-fog
- Sealing Range:
  - 140–160°C for plastic trays
  - 180–200°C for board trays
- Widths Available: 140mm, 150mm, 185mm, 210mm, 430mm
- Box Stock Codes: 3930, 3931F, 3932, 3933, 3936

## 2. PET/PP 12/30mu Weld Seal with Anti-Fog (PCJ)

Designed for all P-type trays, this PET/PP blend delivers reliable sealing at 110–145°C with a 1–3 second dwell time. It also includes anti-fog properties to maintain product visibility on shelf.

- Material: PET/PP
- Sealing Range: 110–145°C
- Widths Available: 150mm, 185mm, 210mm, 270mm
- Box Stock Codes: 3131F, 3912, 3920, 3906

## Peelable Seal Lidding Films

Peelable films are ideal when a user-friendly experience is essential. These seals hold securely during storage and transit but peel back cleanly when it's time to open the pack – with no mess or tearing.

## 3. PET/PP 12/30mu Peelable Seal with Anti-Fog (PCJ)

This film gives you the best of both worlds – a strong seal and easy peel. It performs across a range of P-type trays at 95–145°C, with a dwell time of 1–3 seconds.

- Material: PET/PP with anti-fog
- Sealing Range: 95–145°C
- Widths Available: 150mm, 185mm, 210mm, 270mm
- Box Stock Codes: 3911, 3913, 3914, 3915

## Universal Lidding Films

For packers working with a variety of materials, a universal film offers the flexibility to seal to multiple tray types – making it ideal for mixed production lines or evolving product ranges.

#### 4. Universal 101 AF PET23 35mu – Clear with PCR (30%)

This film is designed to seal to most monolayer tray materials. It acts as a peelable seal at shorter dwell times but forms a stronger weld seal as dwell time increases.

- Material: PET with 30% recycled content
- Sealing Range:
  - 160–200°C for monolayer materials (1–3 secs)
  - 180–220°C for pressed board trays (3–5 secs)
- Widths Available: 140mm, 150mm
- Box Stock Codes: 3916, 3917 (printed version also available)

#### 5. Universal 101 AF PET50 – 50/12mu Pre-Cut Lids with Pinseal Pattern

This pre-cut option is ideal for specific diameters and tray types, using a clear pinseal pattern for improved grip and seal consistency.

- Material: Clear PET with pinseal pattern
- Sealing Range: 160–220°C
- Dwell Time: 1–2 seconds
- Spec: 115mm diameter
- Box Stock: Available in pre-cut format

#### Important Considerations

At SystemPAK, we understand that every production line is different.

Sealing temperatures and dwell times can vary depending on:

- – The sealing machine used
- – Tray formulation
- – Film type

- – Ambient conditions

That's why we always recommend carrying out your own in-house trials before full-scale production. Our technical team is on hand to offer advice and product samples to support your testing process.

#### Need Help Choosing the Right Film?

Whether you're looking for a high-performance weld seal for tamper-proof packaging or a peelable option for consumer convenience, we've got a solution that fits. Our films are tested for quality, consistency, and shelf-life performance – helping you deliver the best possible product to market.

#### SUMMARY - LIDDING FILMS

The following information only applies to materials or equipment supplied by Systempak – we therefore cannot be held liable for 'sealing failures' resulting from the use or part use of third-party supplies

It is essential that you match the correct film to the tray being sealed – in order to achieve the desired seal

It should be noted that Sealing Temps & Dwell times are for guidance ONLY – as the type of machine, film, ambient conditions and actual tray formulation can cause variations in performance. It is therefore recommended that clients always conduct their own trials prior to mass production

Please note that our small manual Machines leave the factory with a default setting of 160 o/c - which is normally suitable for most PP trays – however, for thin wall trays this may cause the rim to 'ripple', which is a sign of too much heat – simply reduce by increments of 5 > 10 o/c until you reach a satisfactory result.

1. ECOPET 12/15 mu Weld Seal with Anti Fog

Sealing Temp: 135 > 160 o/c - dwell time 1 > 3 secs for Apet, Cpet & rPet

#	3930	3931F	3932	3933
3936				
Width/mm	140	210	150	185

## 2 PET/PP 12/30 mu Weld Seal with Anti Fog

Sealing temp: 110 > 160 o/c - dwell time 1 > 3 secs for ALL PP trays

#	3131F	3912	3920	3906
Width/mm	150	185	210	270

## 3 PET/PP 12/30 mu Peelable Seal with Anti Fog

Sealing Temp: 95 > 145 o/c - dwell time 1 > 3 secs for ALL PP trays

#	3911	3913	3914	3915
Width/mm	150	185	210	270

## 4. Universal 101 AF Pet23 35mu Clear PCR ( 30% Recycled material )

As the name suggests, this film will seal to most materials – peelable for short dwell time ...becomes more weld seal the longer the dwell time

Sealing temp: 160 > 200 o/c - dwell time 1 > 3 secs for most monolayer materials

180 > 220 o/c - dwell time 3 > 5 secs for Pressed board trays

#	3916	3917 ( Printed )
Width/mm	150	140



- 5 Universal 101 AF PET50 50/12mu 95 & 115 diameter - Clear Pinseal pattern PCR  
Pre-cut Lids

Sealing Temp: 160 > 220 o/c - dwell time circa 1 sec for most monolayer  
materials

#	3036	3037
Width	95od	115od