



Laboratory Guidebook Notice of Change

Chapter **new**, revised, or archived: MLG 10 Appendix 4.00

Title: Glossary for Flexible Retortable Pouches

Effective Date: 01/10/22

Description and purpose of change(s):

This Appendix is glossary of terms for Flexible Retortable Pouches issued in association with MLG 10 Examination of Heat Processed, Hermetically Sealed (Canned) Meat and Poultry Products.

**United States Department of Agriculture
Food Safety and Inspection Service, Office of Public Health Science**

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**Appendix 4
Glossary for Flexible Retortable Pouches**

Adhesive: A substance applied to ply surfaces to cement the layers together in a laminated film: (a). Polyurethane adhesive for the outer layer (b). Maleic anhydride adduct of polypropylene for the inner layer.

Blisters: Bubbles/gaseous inclusions/particulate material, may be present between layers of laminate, usually are found in the seal area.

Bottom of Closing Seal: Portion of closing (packer) seal adjustment to the pouch contents.

Bottom Seal: A seal applied by heat and pressure to the bottom of a flexible pouch.

Cosmetic Seal: Area above the primary seal designed to close the edges of the pouch thus preventing the accumulation of extraneous material.

Cuts, Punctures, Scratches: Mechanical defects that penetrate one or more layers of the pouch.

Delamination: Any separation of plies through adhesive failure. This may result in questionable integrity of the package and safety of the product.

Dirty: Smearred with product or product trapped in top edges (where there are no cosmetic seals).

Disintegrated Container: Evidence of delamination or degradation after retorting.

Final Seal: A seal formed by heat and pressure by the packer after pouch filling and prior to retorting.

Foil Flex Cracks/Foil Roll Holes: Visible cracks in the aluminum foil layer caused by flexing of the pouch or pin holes (roll holes) in the foil caused through manufacture of the aluminum ply.

Foreign Materials: Any material (solid food, condensate, grease, voids, blemishes) that may be entrapped between the plies but usually found in the seal area.

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Fusion Seal: A seal formed by joining two opposing surfaces by the application of heat and pressure.

Hard Swell or Blown: Distention or rupture due to internal gas formation.

Inner Ply: Polypropylene coating bonded to the food surface side of the aluminum foil.

Laminate: Two or more layers of material held together by adhesive(s).

Leaker: Product leaking through any area of the pouch.

Outer Ply: The polyester film bonded to the exterior surface of the aluminum foil.

Over Carton: A separate container (usually cardboard) in which the flexible pouch is packaged for additional protection.

Package Dimensions: The measurements of retortable flexible pouches stated as length, the longest dimension (LGT), width the second longest dimension (W), and thickness, the shortest dimension (HGT). All are given as internal measurements.

Pin Holes, Roll Holes: Holes in the aluminum foil layer only, originating during manufacturing; usually do not leak.

Preformed Seals: Seals formed by heat and pressure, by the manufacturer of the pouches, along the sides and at the bottom of the pouches.

Primary Seal: A fusion seal formed by the food processor by applying heat and pressure immediately after filling.

Seal: A continuous joint of two surfaces made by fusion of the laminated materials.

Seal Width: The maximum dimension of the seal measured from the leading outside edge perpendicular to the inside edge of the same seal.

Severely Damaged: Punctures, cuts or ruptures which penetrate all layers of the pouch and expose the product to contamination.

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Side Seals: Seals formed by applying heat and pressure to the sides of the pouch's laminates to form the "preformed pouch".

Tear Nicks or Notch: Notches near the final seal to aid the consumer in opening the pouch.

Wrinkle: A crease or pucker in the seal (Packer or Factory) areas.