



Fluted Baking Cups Storage and Handling Guidelines

Fluted baking cups are produced from papers that have very specific and special qualities. These qualities include minimal grease migration, low slip values and low air permeability. The following guidelines will help insure that after the raw material is converted into paper cups and they leave our facility that these qualities are not compromised. Sun-America produces baking cups for the high speed denesting bakery industry. The paper used in this production is the first step to quality machine denesting. The second step to insure repeatability denesting at high percentages is accomplished by Sun-America's intellectual tooling properties and production process. Each case of paper baking cups is custom built to order and is specific to each customers denesting machinery. The specification of the cup flare diameter is determined by the denesting equipment and the variance between the minimum and maximum flare diameter is subject to said specification. Proper storing and handling of the cups will minimize machine denesting inefficiencies.

1. Storage of Baking Cups

- a. Cases or pallets of baking cups should be stored in an area with a relative humidity no greater than 50%. Storage area should be monitored for R/H percentage by use of a digital or dial type humidistat.
- b. Cases and pallets of baking cups should never be stored at or in close proximity to any wash down stations or anywhere that water would be dispersed into the atmosphere.
- c. Storage in a cool area is preferred but not in an area where removal from said area into the production area would not induce sweating or condensation.
- d. Depending on the atmosphere, storing cups near the production machine should be minimized to a set number of cases that will be consumed in a period of 2 to 6 hours.

- e. During wash down in the production area, all cups should be removed and returned to a drier climate. This includes cups that have been removed from cases and inserted into the denesting magazine.
- f. During long shut downs or in the event that cups are to be left in magazines overnight the above procedure “e” should be followed.
- g. A fan near the denester or cup storage will help keep air circulating thus moving moisture away from product.
- h. As with any product that is made to tight tolerance and specifications proper first in stock rotation is a must.

2. Cup Handling at Denester and Production Line

- a. Cases should be kept closed and cups in sleeves until ready for magazine loading.
- b. The protective outer sleeve should never be removed until ready for magazine loading.
- c. The protective outer sleeve has an easy pull tear strip that runs the entire length of the sleeve. The entire sleeve of cups should be inserted in the magazine, the tear strip removed and then the outer sleeve removed.
- d. Cups stacks should never be squeezed or compressed before loading into magazine.
- e. The top nest of cups in each sleeve should be removed and inserted into the middle of the stack before loading into magazine.
- f. The stack of cups in the magazine should never be higher than that of the magazines cup brackets. A 20” stack of cups is maximum height for most denesting machines.
- g. When a scheduled shutdown or end of day is approaching operator should not fill cup magazine to capacity, but should relocate cups from other magazine to insure a minimal amount of cups are left in machine at said shutdown.
- h. Distorting the cups in any way will reduce the efficiency of both the cup and the denesting equipment and should not be tolerated by operating personnel.
- i. In most cases the denesting equipment will pull cups efficiently whether the magazine stack is low or high. In higher humidity times, keeping the amount of cups in the denesting magazine at a lower level will shorten the time that the cups are exposed to the moisture thus keeping the cups flare close to specification for quality denesting.
- j. Cups in denesting magazine should never be pushed on or weighted.

3. Summary

- a. The ability for this product to run as efficient as possible in denesting machinery the above guidelines should be implemented at the plant level and followed.**
- b. Sun America cannot be held responsible for poor cup performance without the cooperation of its customers in the storage and handling of this product as listed in this document.**

- i. Key Points**

- 1. 50% or less humidity Storage.**
- 2. Proper Rotation of Inventory.**
- 3. Keep Product Separated from Wash-down Areas.**
- 4. Do Not Over Fill Cup Denester Magazine**
- 5. Keep Cups in Sleeves and In Cases Until Needed to Load into Denester Magazine**