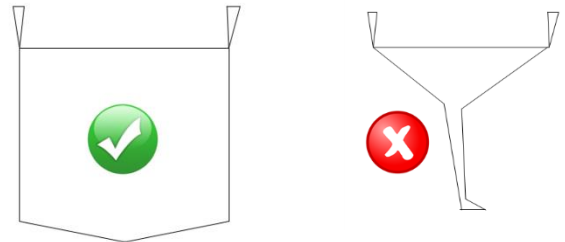


## Filling of big bags.

To get a stable big bag with high fill ratio and without folds, IBC lists five useful tips for big bag filling.

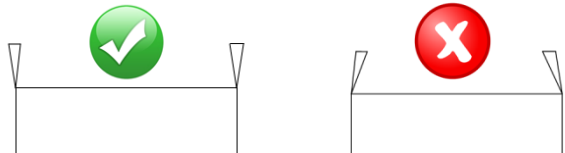
### 1. The inflation

For a high fill ratio and a stable bag, the big bag should be inflated before filling. An inflated bag improves the filling in the big bag corners and the folds in the bag are minimized. Also the operator can easily see if the filling spout is twisted compared to the bag.



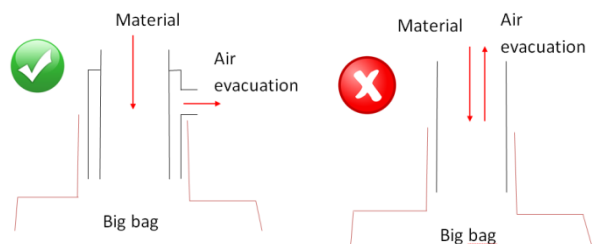
### 2. The suspension of bag loops

With the 4- and 2-loop big bags, the loops should hang vertically or outward to achieve optimum filling ratio. They should **not** hang inwards. How a 1-loop big bag's loop should be suspended depends on the material and the equipment.



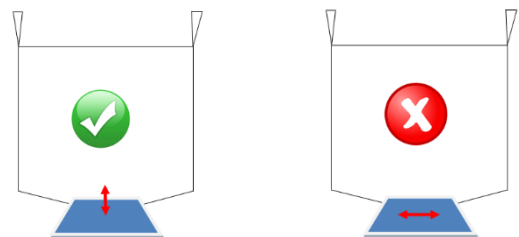
### 3. The evacuation of air

To minimize the risk of fluidised material, dusting, that the big bag breaks and to achieve a good filling ratio, the air is evacuated from the bag during the filling. This should not be done through the material flow instead it is recommended to have a double-walled filling tube.



### 4. Vibrations

Many materials should be compacted in the big bag to obtain a stable bag, and get the desired filling ratio. This can be done by hanging the big bag for a long time, or the time can be reduced by supplying vertical vibration in the bottom of the bag. A further advantage with vibrations is that the material's top angle is equalised. The conical vibrating table does this more efficiently than a vibrating plate.



### 5. Bag support

The bag should either hang freely, or a bag support which touches the bottom of the filled bag. The bag should **not** rest heavily against the bottom support, if so the bag folds and decrease the filling ratio.

For more information on ergonomics, dusting, etc see IBC's other product brochures about filling machines.

