TORVEKA PACKAGING MACHINERY

Nicotine Pouch Global Market and Packaging Equipment

2026 White Paper Expanded English Edition

13 November 2026



Example equipment arrangement. Final supply scope is project-specific.

International Context and Equipment Investment

Understand the economic backdrop, regional demand, industrial investment and national regulations. Translate the evidence into an equipment plan, accepted cans per shift and project acceptance criteria.

Includes seven international-context chapters, twelve data and process figures, real equipment photographs, TORVEKA product options and practical FAT and SAT records. Public facts, forecasts and illustrative calculations are identified separately.

Explore TORVEKA nicotine pouch equipment

01 BUYING DECISIONS

Executive Summary and Reading Guide

International demand, regulation and industrial investment determine which production projects can justify new capacity. This white paper connects those conditions with TORVEKA equipment selection, accepted finished cans per shift and line acceptance. It is written for brand owners, contract manufacturers, procurement teams and production engineers. The technical scope is nicotine pouches; traditional moist snus needs separate material trials.

Five conclusions for equipment buyers

1. Plan for regional divergence. Global economic and trade resilience coexists with differing brand shipments and national market conditions. Use recurring orders, existing capacity and inventory alongside industry signals when deciding how much new equipment to install.

2. Confirm lawful market access before allocating capacity. U.S. product authorizations and European national restrictions create different production briefs. Match each target market to its approved product, packaging and commercial route.

3. Read major investment programs as competitive context. New manufacturing capacity can change delivery and cost expectations. A multiyear factory or multicategory investment is not a measure of packaging-machine demand or a reason to commit capacity ahead of the business case.

4. Expect portfolio changes to affect line balance. At a constant usable pouch rate, moving from 15 to 20 pouches per can reduces theoretical can supply by 25%. Verify counting, actual packaging and changeover for each agreed format.

5. Choose and accept equipment against demonstrated project requirements. Compare TORVEKA configurations with actual material and packaging, include connected interfaces, and record accepted cans at the agreed final output point. Lane count or a short video cannot establish sustained line output.

Reader objective	Where to look
Understand the international outlook	Sections 02A-02G on economics, regional demand, investment, regulation and procurement scenarios
Choose equipment	Sections 03-07, including TORVEKA product options and model comparison
Plan output and investment	Sections 08-11 on pouch-to-can calculations, buffering and cost
Prepare purchasing documents	Sections 12-14 on FAT, SAT and the project inquiry

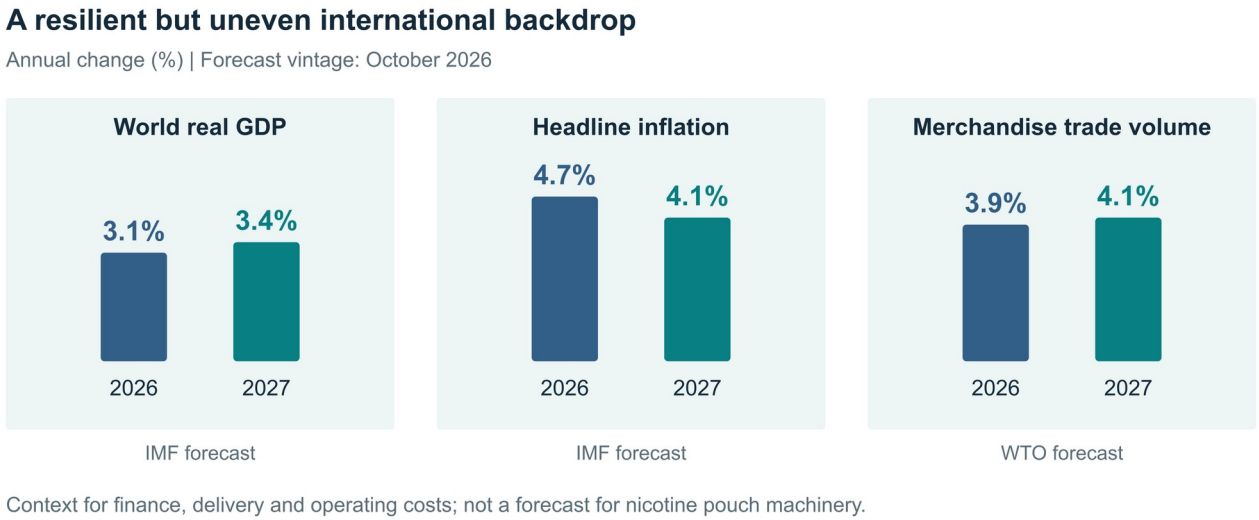
Evidence and scope

Public disclosures, configuration specifications, calculations and recommendations are identified separately. Section 05A links to TORVEKA pouching products; Section 10A covers downstream and complete-line options. Website categories and production-document models remain separate. Performance must be verified for the selected configuration and operating conditions.

02A INTERNATIONAL OUTLOOK

The Global Economy and Trade Environment

Nicotine pouch equipment projects enter 2027 against an uneven economic backdrop. The October 2026 IMF outlook projects world growth of 3.1% in 2026 and 3.4% in 2027, with headline inflation of 4.7% and 4.1%. It identifies conflict, renewed trade tensions and fiscal vulnerabilities as downside risks. [M1] These conditions affect financing, operating costs and the time buyers can afford to wait for a production ramp.



Macro Figure A. October 2026 forecasts. IMF for growth and inflation; WTO for merchandise trade volume. Sources M1 and M2. These are economy-wide indicators.

The WTO projects merchandise trade volume growth of 3.9% in 2026 and 4.1% in 2027. Its October update describes resilient goods trade alongside disruption to energy, transport and travel, with AI-related goods contributing heavily to trade growth. [M2] A stronger global goods forecast therefore provides limited evidence about demand for nicotine pouch machinery.

Implications for cross-border machinery projects

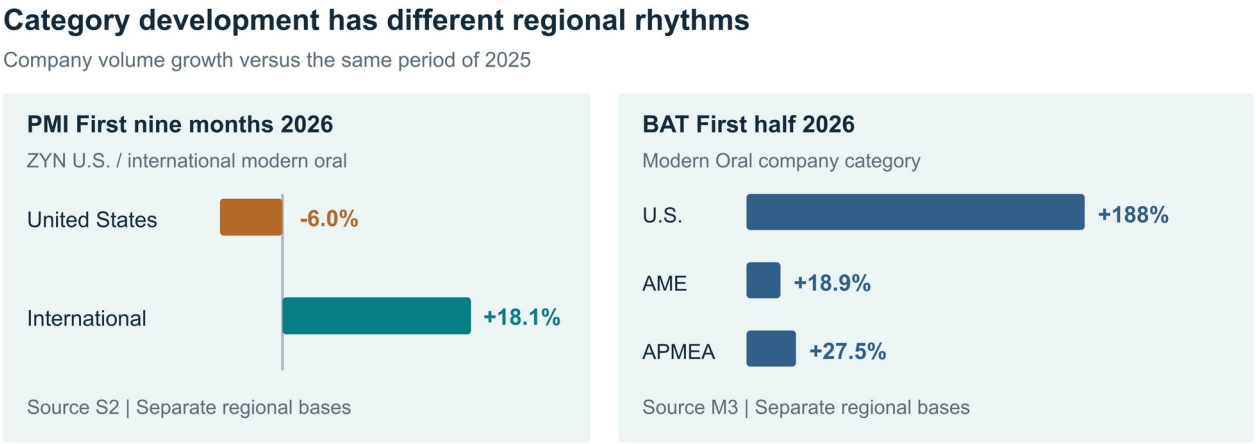
Our procurement assessment is that landed cost and delivery resilience deserve greater weight alongside machine price. Obtain dated freight and insurance quotations, confirm destination-specific import treatment, and separate equipment manufacture, transport, installation and site ramp-up in the schedule. Set payment milestones against reviewable deliverables.

For a TORVEKA project, define the destination, commissioning location and commercial delivery term at RFQ stage. Ask for an installation plan, utilities, spare-parts scope and remote-support arrangements. Reserve expansion space where justified, while tying committed capacity to orders, approved SKUs and a realistic utilization plan.

02B MARKET STRUCTURE

Regional Demand and Uneven Category Growth

The evidence supports a growing nicotine pouch category with significant differences between regions, brands and reporting periods. Altria reported nicotine pouches at 61.2% of the U.S. oral tobacco category in Q3 2026, up 5.8 percentage points year over year. [S1] That measures category mix within oral tobacco; it is not penetration of all nicotine consumption.



Macro Figure B. Company-reported volume growth versus the same period of 2025. Each panel has its own scale and coverage. Sources S2 and M3. Do not add these series or treat them as a global market forecast.

Read each region through a different demand question

In the United States, category momentum must be assessed alongside share shifts, promotions and distributor inventories. For Europe, examine national market access and channel demand before allocating capacity. In newer markets, a brand launch establishes commercial presence; repeat orders and local sell-through establish the production requirement.

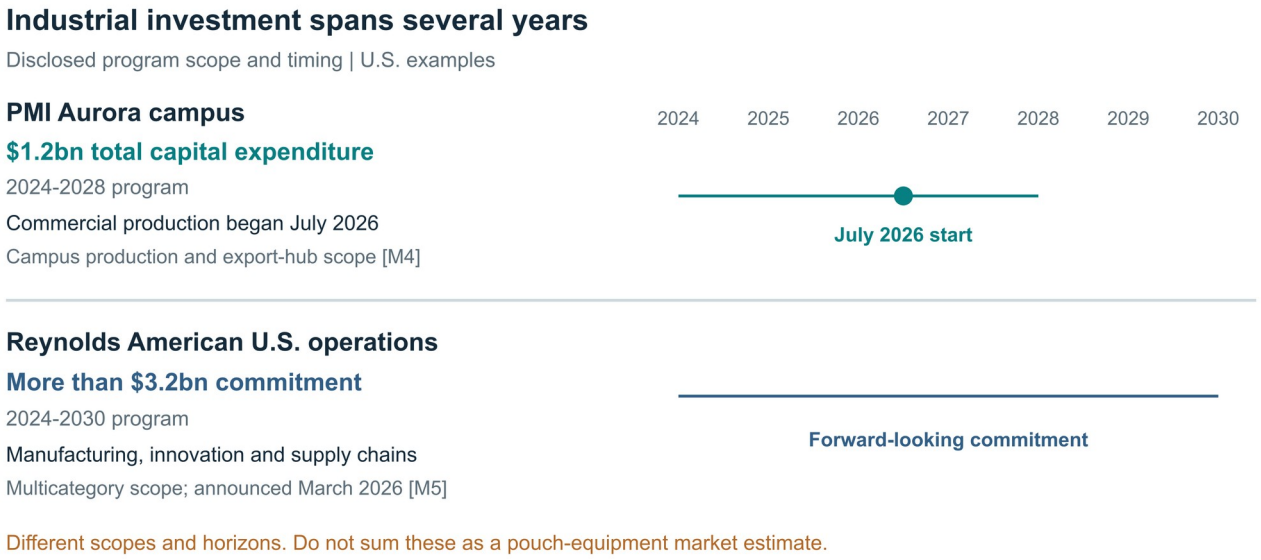
PMI reported ZYN availability in 62 international markets in Q3 2026, highlighting Poland and the Philippines among growth locations. [M11] Geographic expansion can create more localized SKUs and smaller production batches before it creates large, stable orders.

For equipment planning, distinguish retail demand, brand shipments and factory output. Check existing capacity, outsourcing, inventory and the intended customer portfolio before specifying additional machines. A contract manufacturer serving several markets may value changeover and batch traceability as much as a higher listed pouch rate.

02C CAPITAL AND PRODUCTION

Industrial Investment and Competitive Pressure

Large brand owners are strengthening manufacturing networks and funding broader nicotine portfolios. PMI announced the opening of its Aurora campus in July 2026, with $1.2 billion of total capital expenditure over 2024-2028 and commercial production starting that July. The company positions the site as both a U.S. production and export hub. [M4]



Macro Figure C. Two disclosed investment programs with different scopes and time horizons. Sources M4 and M5. Amounts are company programs, not nicotine pouch machine orders.

Reynolds American announced a commitment exceeding $3.2 billion across U.S. operations by 2030, beginning in 2024. It covers manufacturing, innovation, supply chains and workforce capabilities across a multicategory portfolio. [M5] Neither disclosure identifies TORVEKA as an equipment supplier.

What this changes for independent producers

Our assessment is that expanding industrial capacity can increase pressure on delivery reliability, product consistency and conversion cost. It may also raise the risk of idle assets for entrants that build ahead of demand. These investments do not establish the amount, timing or destination of equipment purchases available to other suppliers.

An independent brand can stage investment around validated formulation, recurring orders and line utilization. A contract manufacturer should assess customer concentration, SKU mix and line clearance between batches. A producer with established demand can prioritize accepted output, repeatable quality and maintenance response.

TORVEKA sample, standalone pouching, downstream and complete-line categories provide different starting points for these discussions. Confirm the technical interfaces and the scope of any future expansion in writing; availability of a product category does not establish that a later upgrade will be a direct fit.

02D MARKET ACCESS

Regulation Creates Distinct National Markets

Market access must be checked for the specific product and destination. The examples below show why a single European or international SKU assumption is insufficient. Status was checked on 13 November 2026; the table summarizes selected requirements rather than a complete legal review.

Market	Verified position	Production planning consequence
United States	FDA lists product-specific marketing orders, including ZYN ULTRA on 21 August and VELO products on 30 October 2026. [M6]	Match the intended SKU to its applicable regulatory route; retain specification and batch records. A machine purchase grants no product authorization.
United Kingdom	Under-18 sales and proxy purchasing restrictions for nicotine pouches took effect on 29 October 2026, with restrictions on giveaways, discounts and vending. [M7]	Confirm the lawful channel and approved commercial brief before scaling its production allocation.
Denmark	Rules cover nicotine content, ingredients and standardized packaging. The sell-through transition ended on 31 March 2026. [M8]	Validate the current pouch, can and label specification; include obsolete-pack segregation and changeover approval.
Netherlands	RIVM states nicotine pouches may no longer be sold from 1 January 2025. [M9]	Do not include Dutch consumer sales in a base-case capacity plan without a verified lawful basis.
France	Official guidance describes prohibitions on import, possession, supply, acquisition and use from 1 April 2026. [M10]	Assess destination sales separately from manufacture for export; the guidance notes court suspension of manufacturing, production and export provisions.

Convert legal requirements into controlled specifications

Have the project owner confirm the lawful product, nicotine content, ingredients, warnings, packaging and route to market. Carry the resulting specification into recipe control, label approval, batch records and first-off checks. Do not assume that a product authorization, notification or packaging rule in one market applies elsewhere.

This paper addresses equipment procurement. Product-market authorization, machinery conformity and final site approval are separate workstreams with different evidence requirements.

02E PRODUCT AND PACK TRENDS

Portfolio Changes Reach the Packaging Line

Competition is changing the production brief through pack counts, formulation variants and market-specific packaging. These changes can alter the line balance even when annual pouch demand is unchanged. The engineering impact should be calculated for each SKU before choosing upstream and downstream equipment.

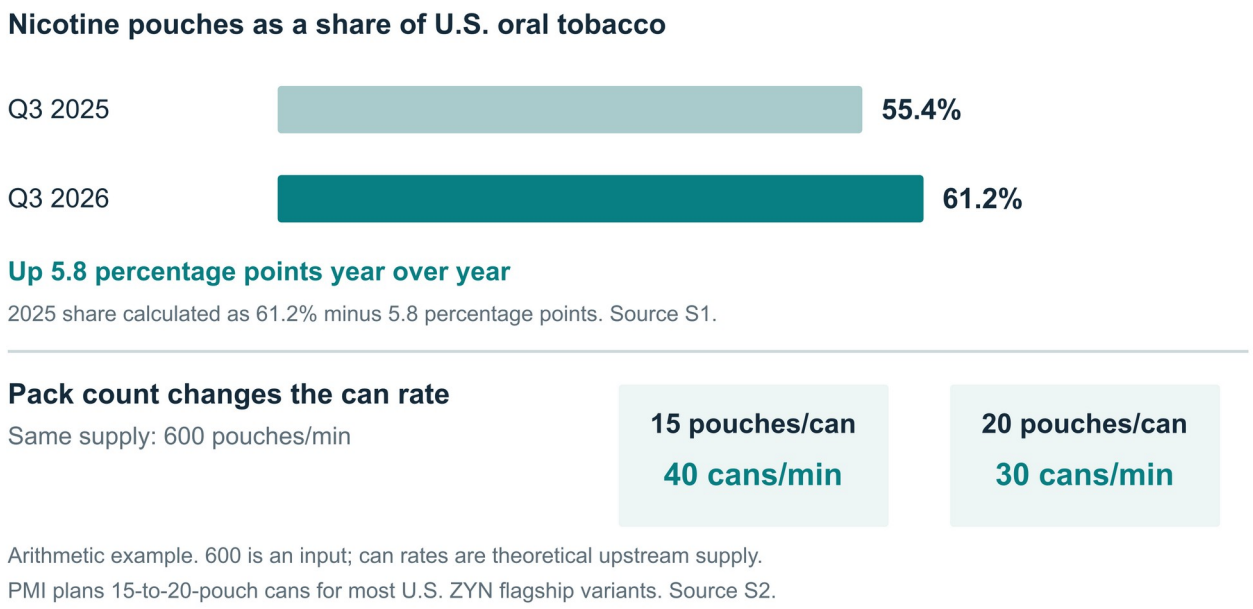


Figure 1. U.S. category mix and an illustrative pack-count conversion. Sources S1 and S2. The 600 pouches/min input is an arithmetic assumption.

PMI outlined a planned Q4 2026 transition of most U.S. ZYN flagship variants from 15 to 20 pouches per can. [S2] At an unchanged usable pouch rate, this requires one-third more pouches for the same number of cans, or gives 25% fewer cans for the same number of pouches. This calculation is not a demand forecast.

Specify flexibility that the project can demonstrate

For multiple pack counts, validate counting recipes and test the actual can, lid and label. For a new formulation or moisture condition, trial dosing, web handling and sealing again. A nicotine-strength change does not by itself define a new pouch weight or demonstrate that the existing dosing process will remain suitable.

For TORVEKA, request separate accepted-output criteria for each agreed format. Include the time from the last accepted old-format can to the first accepted new-format can, with retained samples and recorded waste. Evaluate complete-line options when the change affects several connected stages.

Explore TORVEKA complete-line configurations

02F CROSS BORDER EXECUTION

Supply Chains and the Economics of Localization

Regional manufacturing can shorten replenishment routes to some customers, but location alone does not settle total cost or resilience. Materials, packaging, utilities, staffing, service access and lawful market reach all affect whether a site can deliver dependable accepted output. The Aurora production and export-hub disclosure illustrates that local supply and cross-border distribution can form part of the same network. [M4]

Build the investment case around delivered and operating cost

Exposure	Evidence to request	Decision to make
Import and delivery	Destination classification, origin, dated duty/tax assessment, freight, insurance and delivery term	Compare landed installed cost; identify who bears each transport and customs responsibility.
Currency and finance	Quotation currency, validity, payment dates, financing cost and exchange-rate assumptions	Recalculate cash requirements at agreed sensitivities; avoid treating one quoted rate as permanent.
Materials and packaging	Approved web, cans, lids and labels; supplier lead times and tolerances	Test proposed alternatives with actual batches before calling them interchangeable.
Service and spares	Critical parts list, stock location, expected replenishment time, support scope and training	Define an operating response for faults and consumable replacement before startup.
Installation and ramp	Site utilities, technician access, trial materials, handover records and operating staff	Separate shipment arrival from the date the line can deliver accepted production.

These are procurement recommendations, not measured savings or jurisdiction-specific tariff advice. Update the assumptions at quotation, order placement and shipment. A general packaging-machinery export series or broad customs heading cannot establish the size or growth of the nicotine pouch equipment market.

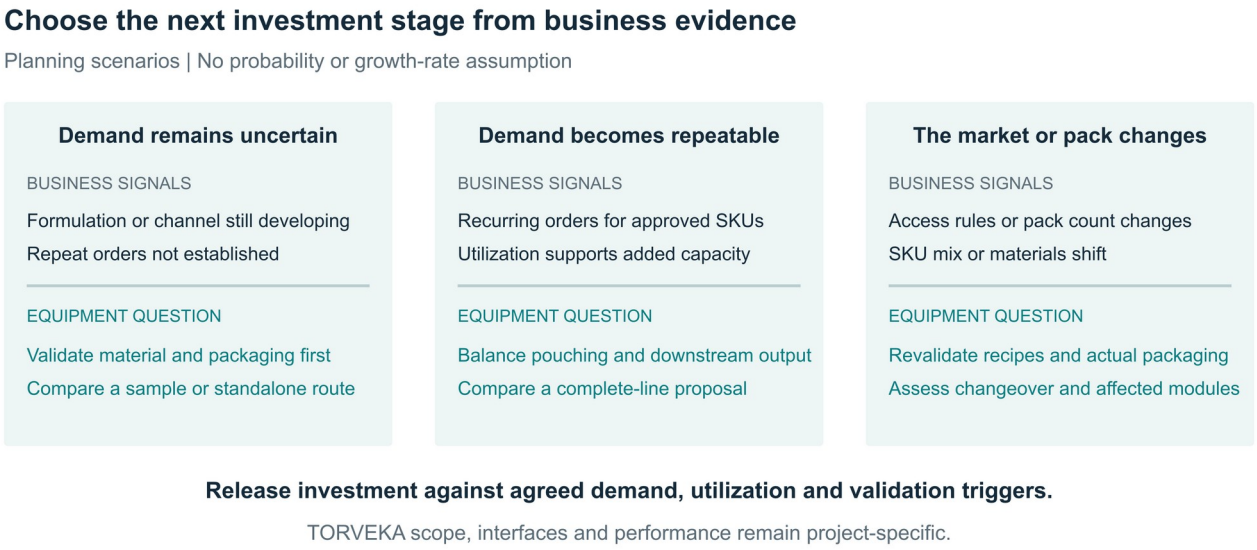
Use modular investment with defined interfaces

A staged TORVEKA purchase can begin with sample validation, add pouching capacity or complete an existing downstream route. Request drawings, transfer conditions, controls and acceptance responsibilities for the intended final layout. Compare the cost and disruption of each stage with a complete-line proposal before committing.

02G IMPLICATIONS FOR 2027 PLANNING

A Scenario Based Equipment Investment Plan

The evidence reviewed here supports planning for continued category development alongside regional restrictions, stronger competition and uncertain execution costs. It does not support a single global growth rate for equipment orders. The scenarios below are planning tools for the next investment cycle, with no assigned probabilities or promised outcomes.



Macro Figure D. A procurement decision framework derived from the evidence in Sections 02A-02F. Scenarios are analytical assumptions, not forecasts or verified customer cases.

Define evidence that releases the next investment stage

For each project, track lawful addressable markets, repeat orders, retail sell-through where available, customer concentration, usable installed capacity, changeover losses and packaging availability. Use these inputs to set the accepted-can target and the minimum utilization that makes the investment viable.

Revisit the plan when a major customer changes pack count, a market changes access rules, a line reaches its agreed utilization trigger or a materials change affects trial results. Agree the trigger using the business case; this paper does not prescribe a universal utilization percentage.

The TORVEKA project brief

State the target market and project stage, validated material and pouch format, pack counts, expected SKU mix, accepted cans per shift and site conditions. Request the sample, pouching, can-finishing or complete-line route that meets those inputs. Then use Sections 03-14 to compare configurations, balance the modules and define FAT and SAT.

Start a TORVEKA equipment selection discussion

03 PROCESS AND INTERFACES

TORVEKA Line Stages and Supply Scope



Figure 2. Example line arrangement. Modules, dimensions and layout are project-specific.



Figure 3. Functional route from dosing to finished-can discharge. Confirm inspection and rejection at each interface.

TORVEKA complete-line options combine pouch production, transfer, can handling and downstream operations. [S10] Work backward from the final acceptance point. If labeling is included, count accepted cans after labeling and the relevant quality checks. For a pouching-only purchase, define pouch condition and the downstream handover.

Interface	Specify in the layout or contract
Pouching to counting	Pouch orientation, acceptable accumulation, transfer point and stop signals
Can supply to filling	Can tolerances, missing-can response, distribution and buffer capacity
Filling to lidding	Physical pouch count, lid type, placement and nonconforming-can handling
Lidding to labeling	Can spacing, label orientation, inspection, rejection and final counting point

Ask TORVEKA to identify whether can feed, lid feed, inspection, buffers and conveyors are included, optional or buyer-supplied. Agree commissioning responsibility. For a retrofit, provide the existing pouching machine output condition and control interfaces.

View the TORVEKA complete packaging line

04 POUCH AND CAN QUALITY

Translate Pack Requirements into Inspections



Existing pouch sample | Web feed and forming area

Figure 4. Product and equipment photographs. The pouch image illustrates appearance, not completed weight or seal tests.

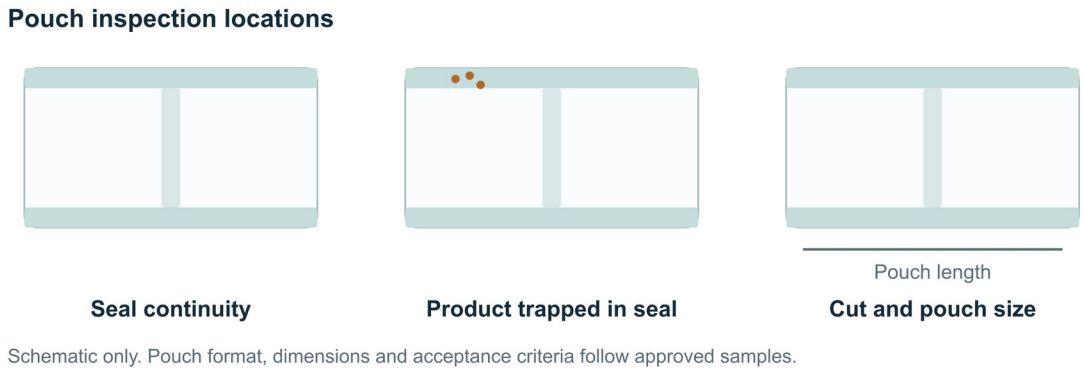


Figure 5. Schematic inspection locations. The drawing does not define actual dimensions.

Give TORVEKA an approved pouch sample and agree seal, cut-edge and defect criteria. If each inner pouch needs an individual outer wrap, consider a bag-in-bag system. This route differs from counting a fixed number of pouches into a can.

Inspection	Record	Agree the method
Pouch weight	Net fill, lane, sampling time, target and variation	Use the agreed balance and pouch tare; retain the mean and extremes
Seal and appearance	Trapped product, openings, wrinkles, damage and cut edges	Use approved samples and a repeatable inspection method
Finished can	Physical pouch count, lid closure and label position	Check each requirement; total can weight does not replace every inspection

For seal-strength or integrity testing, agree the method and limits. For individually wrapped products, evaluate the TORVEKA bag-in-bag option with the actual inner pouch and outer web.

TORVEKA bag-in-bag packaging equipment

05 EQUIPMENT SELECTION

Select a Configuration for the Project

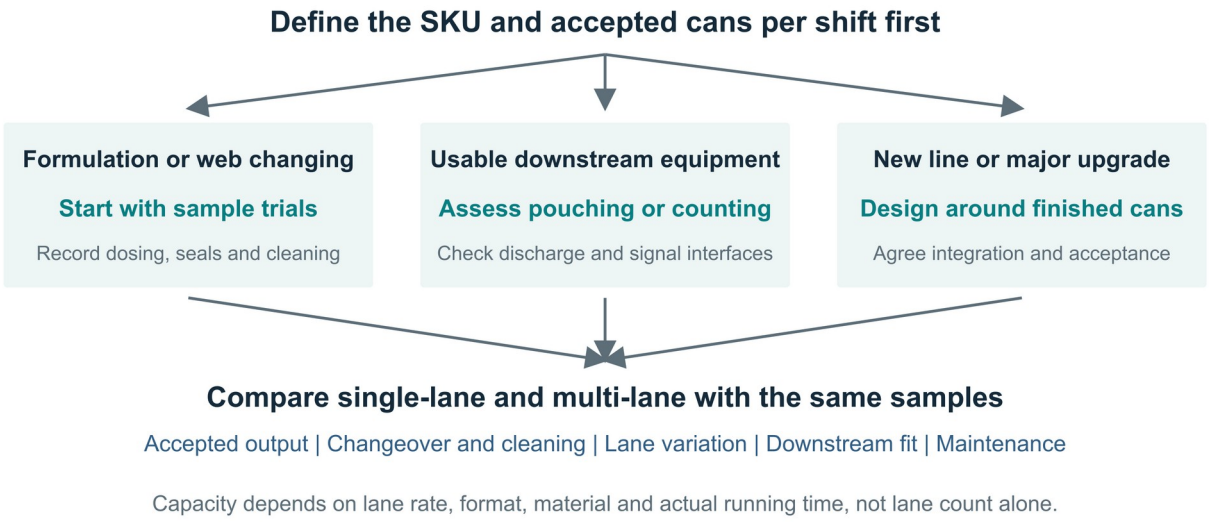


Figure 6. Three purchasing starting points and a common sample-validation step.

Single-lane and multi-lane tradeoffs

Compare	Single-lane checks	Multi-lane checks
Speed basis	Total machine rate and stable operating conditions	Per-lane rate, active lane count and combined rate
Quality variation	Weight and seal results over time	Results by time and lane to identify local variation
Changeover and cleaning	Format parts, product-removal route and first-off approval	Adjustment consistency, access and approval across lanes
Fault handling	Treatment of pouches remaining after a stop	Lane-specific detection and control if a lane stops
Downstream fit	Discharge timing, orientation and counting input	Multiple-stream merging, buffering and can-filling interfaces

TORVEKA high-speed single-lane and four-lane products support different production arrangements. [S10] For sustained runs of one established format, start by evaluating the single-lane route. For parallel production, compare lane-level quality, merging and maintenance. Lane count cannot replace net-output verification.

If the formulation or pouch web is still changing, consider a TORVEKA sample machine first. If individual outer wrapping is required, assess the bag-in-bag route. Section 05A connects these four product categories to their purchasing contexts.

05A PRODUCT OPTIONS

TORVEKA Pouching Products by Application

Choose the equipment category around what the project needs to validate. Product names in the table link to TORVEKA pages with the relevant process, listed specifications and inquiry route. [S10]







Sample machine | Single-lane equipment | Four-lane equipment

Equipment examples. Confirm the exact model and revision in the quotation; Section 06 compares separate production specifications.

TORVEKA product	Purchasing context	Selection reason and validation focus
Sample machine	Formulation, web or sealing method still in development	Validate actual samples with the chosen dosing and sealing configuration. Trial speed does not establish production-scale performance.
Bag-in-bag equipment	Each inner pouch needs its own outer wrap	Connect inner-pouch forming with outer-web wrapping. Validate both webs and seals; distinguish this route from can filling.
High-speed single-lane	Established pouch format for continuous production	The website describes an SK200 single-lane configuration. Confirm its conditions and compare other documented models separately.
Four-lane machine	Several pouching lanes must run in parallel	The website describes M180L4-SYB. Check per-lane rates, weight variation and multiple discharge streams.

Carry trial results into production selection

Provide TORVEKA with the same material batch, pouch web and approved samples, plus the planned shift and pack count. Establish the pouch format and quality criteria before comparing single-lane, multi-lane and individually wrapped routes.

Website pages describe categories and listed configurations. The purchasing specification should identify the supplied model. SK40, SK160-4, SK250 and SK350 values in Section 06 remain tied to their own production documents.

06 CONFIGURATION DATA

TORVEKA Model Specification Comparison



SK250 reference photo | SK160 four-lane reference | SK350 reference photo

Figure 7. Model reference photographs. Final appearance and configuration follow the contract drawings.

The following production documents support configuration comparisons for TORVEKA projects. [S3, S4, S5, S6] The website single-lane page lists SK200 and the four-lane page lists M180L4-SYB. Keep those specifications separate from SK250 and SK160-4 below. All rates are document-listed values, not continuous-trial results.

Model document	Lanes and listed rate	Weight or dosing range	RFQ focus
SK40 laboratory unit [S3]	Single lane 20-40 pouches/min	0.5-1 g/pouch	Confirm the dry screw or moist rotary dosing option and selected range
SK160-4 moist-process [S4]	4 lanes at 30-40 each 120-160 pouches/min combined	0.55 g target 0.4-0.6 g cup range	Acceptance by lane and interfaces for multiple pouch streams
SK250 high-speed [S5]	Single lane 120-200 pouches/min	0.55 g target 0.4-0.6 g rotary range	Actual moist-granule sample, web and continuous-run conditions
SK350 high-speed [S6]	Single lane 300-350 pouches/min	0.55 g target 0.4-0.6 g rotary range	Refilling, sealing, web splicing and downstream capacity

Using the 600 pouches per minute figure

Promotional material refers to 600 pouches/min. [S8] The production documents compared here do not establish the exact model and configuration behind that figure. This edition therefore uses 600 only as a clearly labeled calculation input. A model-specific speed commitment needs the matching specification and trial record.

Dosing-accuracy figures in the original documents also depend on material and speed. Specify the actual target net fill, permitted range and sampling rules in the contract. Assess both average deviation and variation.

07 PROCESS CHOICES

Validate Dosing and Sealing Options



Sample-machine dosing area | Sample-machine forming area

Figure 8. Existing sample-equipment details. Compare processes with actual samples, not appearance alone.

Match the material to the dosing module

The TORVEKA sample-machine page describes dry-material screw dosing and moist-material rotary dosing, with heat-seal or ultrasonic configurations selected by project. [S10] The SK40 production document defines its own module ranges. [S3] Confirm the process using actual material and web before selecting production equipment.

Use one material batch for continuous sampling after stabilization, around refilling and near the end of the run. Retain lane numbers for multi-lane equipment. An average alone can hide variation between individual pouches or lanes.

Test the actual web for each sealing route

Route	Validate	Request
Heat sealing	Heat-seal compatibility; temperature, pressure and contact time; seal condition during continuous running	Actual web samples, settings, approved pouches and run records
Ultrasonic	Weldable material content; tooling and settings; resulting seal and cut edge	Actual-web test results, tooling configuration and maintenance requirements

Ultrasonic joining uses mechanical vibration to generate heat at the joint; compatibility depends on material and process. [S9] For a TORVEKA trial, compare seal results, speed and cleaning/changeover with the same web batch. A process name alone does not establish cost or performance.

TORVEKA sample machine and sealing options

08 CAPACITY CALCULATIONS

Convert Pouch Rates into Can Output

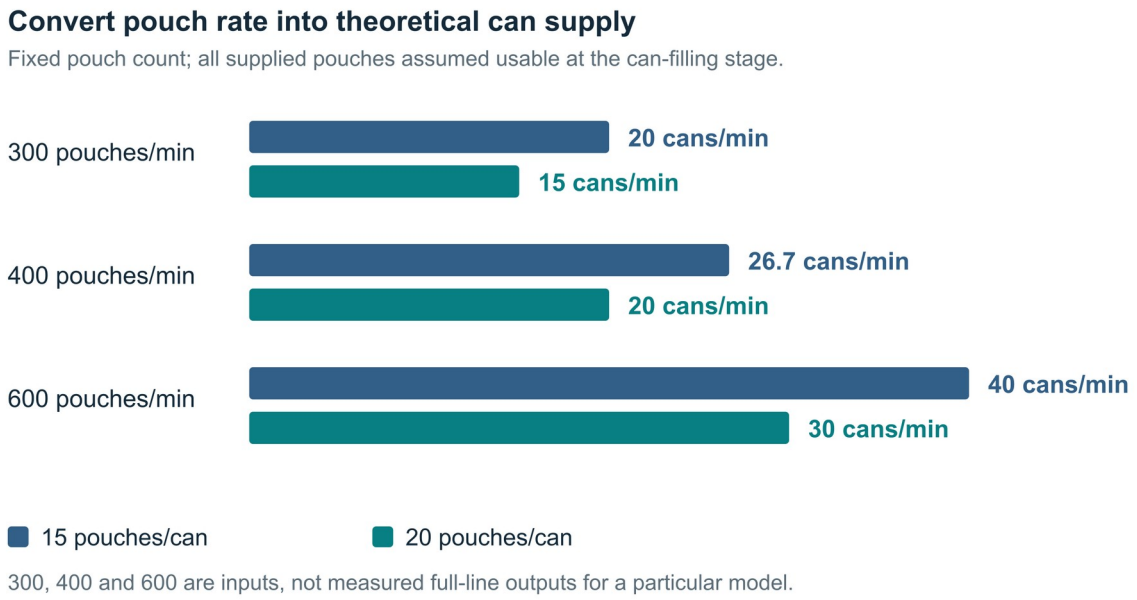


Figure 9. Theoretical can supply at illustrative pouch rates and pack counts.

Theoretical can supply equals usable pouch output divided by pouches per can. When several machines feed one downstream route, add their usable pouch outputs first. If the input already excludes rejected pouches, do not deduct the same loss again.

Measure	Calculation	Conditions
Upstream can supply	Usable pouches/min ÷ pouches/can	Keep units consistent
Theoretical line limit	Lowest capacity across pouch supply, counting, lidding, labeling and other included stages	Use the same SKU and conditions for every module; actual output is generally at or below this limit
Accepted cans per shift	Average total can rate while running × running minutes × acceptance rate	Use when the total rate still includes nonconforming cans
Direct accepted output	Accepted cans counted in the agreed window	Quality assessment is already complete; do not multiply by acceptance rate again

A TORVEKA line proposal needs a module balance. For example, four SK250 units at the document-listed 120-200 pouches/min yield an arithmetic supply of 480-800 pouches/min, or 24-40 cans/min at 20 pouches/can. [S5] Check the selected lidding, labeling and transfer stages next. These values are not verified line output.

09 OUTPUT SCENARIO

Calculate Accepted Output per Shift

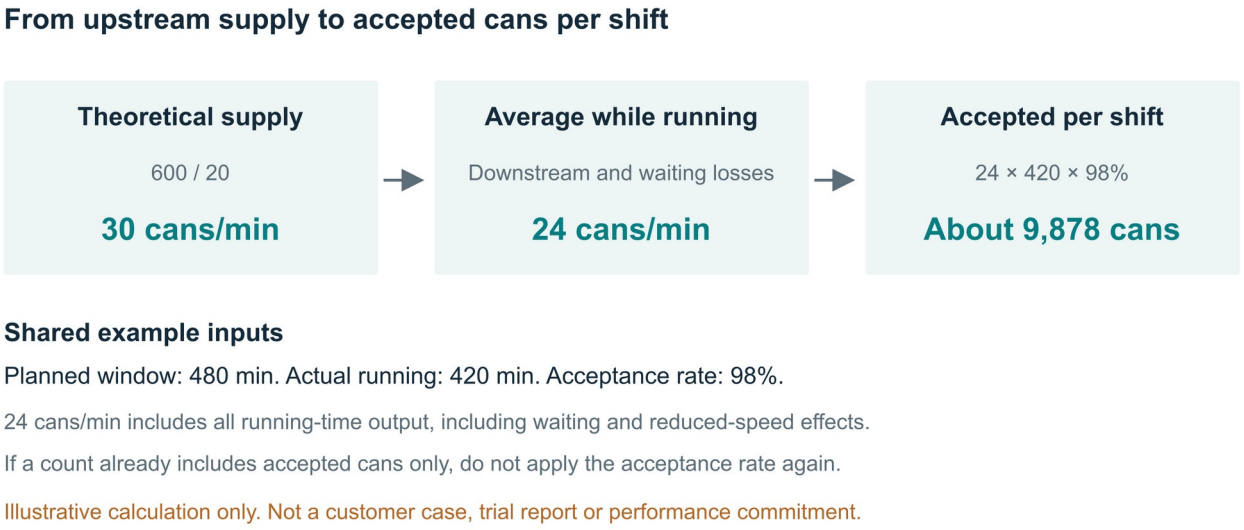


Figure 10. Shift-output calculation. All inputs are assumptions or arithmetic values.

Record the planned window and running time separately

In this example, the planned window is 480 minutes and actual running time is 420 minutes, or 87.5% of that window. Classify the remaining 60 minutes by refilling, changeover, cleaning or faults, without double counting events.

Example record	Value	Meaning
Total while running	24 × 420 = 10,080 cans	Includes cans awaiting acceptance
At 98% acceptance	10,080 × 98% = 9,878.4 cans	Approximately 9,878 accepted cans
Across the planned window	About 20.58 accepted cans/min	For shift delivery planning
Running-time ratio	420 ÷ 480 = 87.5%	A time measure, not a complete OEE metric

For a TORVEKA line, request both the pouching-stage rate and accepted-can output at the final measurement point. Use downtime, reduced-speed and quality records to explain the difference and identify the stage that should be improved first.

This is a calculation scenario. Actual project results should identify the model, SKU, material and packaging batches, witnesses, date and complete measurement window before being used for configuration comparisons or shift planning.

10 CONTINUOUS OPERATION

Buffering and Restart Behavior

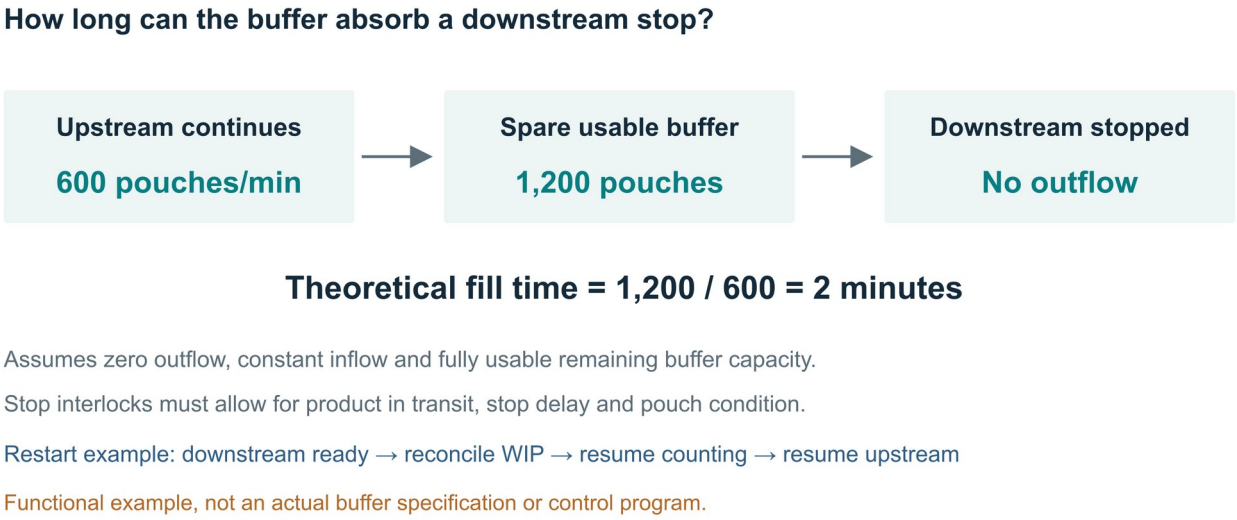


Figure 11. Illustrative buffering and downstream-stop calculation.

A buffer absorbs an imbalance only for a limited time. Use its remaining usable capacity, excluding pouches already accumulated or unusable areas. Also assess whether stacking, compression or dwell time affects pouch handling and counting.

Fault scenario	Observe in the trial
Downstream stops accepting	When the upstream stop signal arrives, where work in progress goes and whether material overflows
Missing can or lid	Whether pouch feeding continues and how nonconforming items are identified and isolated
Counting or inspection fault	How rejection works and whether failed rejection triggers a stop or alarm
Restart after clearance	How pouches and cans in transit are reconciled and the first restarted output is approved

TORVEKA lidding and labeling modules provide starting points for downstream selection. [S10] Acceptance should still include actual missing-can, missing-lid and blockage scenarios, with action sequences, work-in-progress handling and restart time recorded. Section 10A connects these needs to product options.

10A PRODUCT OPTIONS

TORVEKA Downstream and Complete Line Options

Once pouch production is stable, identify the stage limiting accepted-can output. Assess TORVEKA complete-line, lidding and labeling options against that gap. [S10]



Automatic lidding equipment | Automatic labeling equipment

Downstream equipment examples. Confirm can, lid and label compatibility, transfer and control interfaces for the project.

TORVEKA product	Configuration need	Confirm first
Complete packaging line	Plan pouching, transfer, can handling and downstream operations together	Pack count, final output point, module scope, floor plan and commissioning responsibility
Automatic can lidding	Feed and press lids onto filled round cans	Physical can/lid samples, tolerances and incoming flow; specify missing-can/lid detection and handling
Automatic can labeling	Apply the required top, base and wraparound labels	Label stock and dimensions, can stability, required surfaces, inspection and rejection scope

Projects retaining an existing pouching machine

Give TORVEKA the discharge condition, usable pouch rate, existing counting method and control signals. Then establish which stage to add. A lidding or labeling product page does not mean counting and can filling are included; list each item in the quotation.

New lines and major upgrades

Use the complete-line route to discuss a coordinated layout for pouch supply, counting, can filling, lidding and labeling. Set accepted cans at the final exit as the common target, with linked-equipment acceptance testing based on Sections 12 and 13.

11 ECONOMIC COMPARISON

Compare Cost per Can and Expansion Options

Compare purchase scope alongside deliverable output. A lower machine price can require additional can feeding, counting, conveyors or format parts, increasing initial expenditure and integration work.

Cost component	Inputs to obtain
Initial investment	Machines, options, format parts, spares, installation, training, freight and applicable taxes
Product and packaging	Average net fill, pouch web, cans, lids, labels, trial and changeover waste
Operation	Electricity, compressed air, operating and cleaning labor, consumables
Maintenance and downtime	Planned maintenance, wear parts, repair response and lost production time
Output denominator	Accepted finished cans during the same accounting period

Use consistent unit-cost boundaries

Calculate cost per accepted can from the material, packaging, operating and maintenance costs for the same period divided by accepted-can output. Apply a consistent treatment of depreciation, finance or lease costs. Show initial cash investment separately from accounting cost.

A checkable material calculation

An average extra fill of 0.01 g per pouch adds 10 kg of material over one million pouches. This is net-fill arithmetic only; it does not establish active-ingredient content, product compliance or achievable savings. Fill settings must first meet the approved product specification.

Compare two expansion routes

Ask TORVEKA to distinguish retaining existing pouching equipment and completing the downstream route from configuring a new complete line. The first requires legacy-interface checks; the second requires coordinated output, layout and commissioning scope. Compare both using the same SKU and accepted-can measure, rather than machine price alone.

TORVEKA complete-line configuration and inquiry

12 FAT METHOD

Plan the Factory Acceptance Test

Before factory acceptance testing (FAT), agree the model revision, supply scope, SKU, material and packaging batches, pack count, measurement point and assessment method. If substitute material is used, identify what the trial can establish and what requires a repeat test with actual product.



Figure 12. Suggested sampling and event records during a continuous run. Sample counts are examples.

Test stage	Execution and records
Continuous running	Start/end times, total window, running time, total cans and accepted cans
Dosing and pouching	Raw weight data by lane, seal-defect categories and sample times
Counting and can filling	Open cans to verify physical counts; confirm handling of abnormal pouches and cans
Lidding and labeling	Use actual packaging; check closure, label position and missing-component detection
Faults and changeover	Trigger agreed faults, time recovery and record changeover and first-off approval for specified SKUs

Include the selected TORVEKA pouching and downstream modules, plus their interfaces, in one FAT plan. Request raw weights, finished-can counts, stop logs and retained approved samples for the actual SKU. New formulations or webs need separate validation. This is a recommended method, not a record of brand test results.

Acceptance Records and Site Verification

The following structure can be copied into an acceptance plan. Each record needs conditions, expected action or limit, measured result, conclusion and sign-off. Retain an owner and retest date for unresolved items.

Record	Raw information to retain	Agree between the parties
Test identity	Date, model revision, SKU, batches and witnesses	Supply scope and final measurement point
Continuous output	Start/end times, stop events, total and accepted cans	Test window and minimum accepted output
Pouch weight	Sample number, lane, net fill and sampling time	Target, permitted range and decision rule
Seal and appearance	Photos, defect category and sample count	Approved sample and test method
Can count	Can number, physical pouch count, fault and response	Pack count, sampling and abnormal handling
Lid and label	Closure, position, missing components and rejection result	Included stages and defect criteria
Changeover and cleaning	Last accepted old-format unit, first accepted new-format unit, labor and waste	Timing boundaries and first-off approval
Retesting	Issue, owner, corrective action, date and sign-off	Closure conditions for unresolved items

Site acceptance after installation

Site acceptance testing (SAT) checks the installed line. After FAT, verify power, compressed air, layout, connected equipment, environment and operators at the site. Recheck the agreed measures with the same SKU so changes in installation conditions can be distinguished from machine issues.

If material, pouch web or downstream equipment differs between FAT and SAT, identify each difference and repeat affected tests. Sign-off concerns specific conditions and results, with operating boundaries attached to the rate.

Questions the signed record should answer

What was tested, for how long, and at which final output point? Where did nonconforming product go? Which issues remain open? The original records should answer these questions directly.

14 PROJECT INQUIRY

Prepare a TORVEKA Project Inquiry

Start by describing the project stage: sample development, additional pouching, downstream completion or a new complete line. Combine product, packaging, output and site conditions in one brief so the response can identify an appropriate model and module scope.

Project input	Describe	Provide where available
Material	Dry/moist condition, flow, clumping and target net fill	Actual sample, batch details and relevant test results
Pouch	Length, width, web, seal, cut and permitted defects	Web roll, approved samples and drawings
Can, lid and label	Pack count, dimensions, tolerances and label positions	Physical components and an assembled sample
Production plan	Shift window, accepted-can target, SKUs and changeover frequency	Expected schedule and expansion plan
Supply scope	Existing equipment, required stages, inspection and buffers	Floor plan and upstream/downstream interface list
Acceptance and service	Trial conditions, installation location, training and spares	FAT/SAT plan and project timing

Request a defined configuration proposal

Ask the TORVEKA quotation to identify the exact model and revision, included and optional modules, interfaces, layout, utilities, sample trials and acceptance conditions. Establish technical fit and net output before comparing budgets.

Choose the right inquiry route

For a defined standalone need, follow the product links in Section 05A or 10A. For line selection, use the complete-line page and provide material, pack count, shift target and existing equipment details.

Discuss a TORVEKA complete-line project

Attach the capacity definitions in Sections 8-10 and the acceptance structure in Sections 12-13. Require competing quotations to use the same SKU and final measurement point.

15 SOURCES AND METHOD

Sources and Compilation Notes

Global market edition dated 13 November 2026. Equipment chapters build on the English product-focused edition. Sections 02A-02G add international economic and industry context. Public facts, forecasts, calculations and TORVEKA procurement recommendations are distinguished where used.

S1 Altria Q3 2026 Form 10-Q. U.S. oral-tobacco category share for nicotine pouches and year-over-year change.

Read the original source

S2 Philip Morris International Q3 2026 Form 10-Q. U.S. ZYN shipments and the planned transition of most flagship variants to 20-pouch cans.

Read the original source

S3 SK40 laboratory pouch-machine production specification. Supplied document dated 22 October 2026; rate, fill range and dosing options.

S4 SK160 four-lane heat-seal line production specification. Supplied document dated 7 March 2026; per-lane rate and dosing range.

S5 SK250 high-speed one-to-four line production specification. G2 revision dated 29 April 2026; machine rate, dosing and listed configuration.

S6 SK350 pouch-to-can line production specification. Includes revision marks dated 20 June 2025; machine rate and dosing range.

S7 Supplied equipment and pouch-sample photographs. Illustrate equipment, layout and pack appearance; not evidence of accepted customer-project results. Equipment and customer-site images were not AI-generated for this paper.

S8 Promotional material labeled 600 pouches/min. Evidence of a previously stated figure, not a matched continuous-trial record for the models compared here.

S9 Herrmann Ultrasonics on ultrasonic bonding of nonwovens. Used for the process principle only; generic speeds and benefits are not TORVEKA specifications.

Read the original source

S10 TORVEKA product pages. Sample, bag-in-bag, single-lane, four-lane, complete-line, lidding and labeling pages checked on 13 November 2026. Product links appear in Sections 05A and 10A.

Read the original source

Sources M1-M11 on the following pages support the expanded market chapters. This paper provides no equipment-market size, supplier ranking or investment-return guarantee. Product suitability and performance require the selected specification, actual samples and agreed project records.

16A MACRO SOURCES

International Sources and Data Definitions

Sources checked on 13 November 2026. Company figures describe their own portfolios and reporting boundaries. Forecasts remain forecasts; do not combine different periods or definitions into an industry total.

M1 IMF World Economic Outlook October 2026. Global growth, inflation and downside risks; forecasts published 13 October 2026, with an information cutoff of 1 October.

Read the original source

M2 WTO Global Trade Outlook October 2026 update. Merchandise trade volume forecasts and the differing effects of AI investment, conflict and transport disruption; published 8 October.

Read the original source

M3 BAT Half Year Report 2026. Company-reported Modern Oral pouch volumes for the six months to 30 June. BAT reporting definitions and regions apply; figures are not total industry demand.

Read the original source

M4 PMI Aurora campus opening announcement. Published 27 July 2026. Total campus capital expenditure over 2024-2028 and July commercial-production start; includes more than pouch packaging machines.

Read the original source

M5 Reynolds American U S investment commitment. Published 5 March 2026. Forward-looking commitment across U.S. operations through 2030, beginning in 2024; multicategory scope.

Read the original source

M6 FDA Tobacco Products Marketing Orders. Product-specific PMTA orders, including August and October 2026 nicotine pouch decisions. Check the linked orders for the precise product and conditions.

Read the original source

16B MACRO SOURCES

Regulatory Sources and Interpretation

Regulatory examples describe selected requirements and effective dates. The project owner should verify the current rules for the exact SKU, destination and activity before committing production capacity.

M7 U K Department of Health and Social Care sales restrictions. Published 29 October 2026; commencement of age-of-sale, proxy-purchase and specified sales-promotion restrictions.

Read the original source

M8 Danish Safety Technology Authority regulatory guidance. Rules from 1 July 2025 and the transition ending 31 March 2026; ingredients, nicotine content and standardized packaging.

Read the original source

M9 Netherlands RIVM supplier questions. Official guidance states the nicotine pouch sales prohibition from 1 January 2025.

Read the original source

M10 France Service Public oral nicotine guidance. Updated 12 March 2026. Restrictions from 1 April and the noted judicial suspension affecting manufacturing, production and export provisions.

Read the original source

M11 PMI Q3 and nine month results announcement. Published 21 October 2026. ZYN international market presence and named growth locations. S2 supports the separate volume and pack-count figures.

Read the original source

How the market evidence is used

Macroeconomic forecasts provide context. Corporate disclosures show selected demand and investment signals. The equipment implications and scenario framework are TORVEKA procurement analysis, not statements made by the cited organizations. No relationship between TORVEKA and the named nicotine brands is implied.