

Graco helps ZZ2 save 64% glue in their fruit packaging process

Farming enterprise and fresh produce company ZZ2 was facing two problems with their hot melt delivery system to seal cardboard boxes. They were spending too much money on glue. And nozzle blockages were causing liability problems. Switching to Graco's InvisiPac proved to be the answer.

ZZ2 produces and exports various crops, such as tomatoes, apples and pears. It's one of the biggest farming conglomerates in SA, with numerous packhouses spread across the country. It was in one of these packhouses that the first tests were carried out with InvisiPac. That was back in 2020. Since then, they have converted all their high-flow packaging lines to InvisiPac.

Packaging Manager Ferdi Jacobs explains the results.

"On average – across all our different lines and for all different boxes, we now save 64% on glue," begins Ferdi. This is possible because InvisiPac is a tank-free hot melt system with melt-on-demand

technology. It feeds granules to the melter based on the required output. So, only the required amount of adhesive is transferred to the melter, making sure no material goes to waste.

This melting on demand comes with another advantage: there is no need to keep large amounts of adhesives at high temperatures. That means there is no risk of char. Thus, InvisiPac eliminates the main cause of hot melt equipment failure and downtime.

With their previous glue dispensers, ZZ2 suffered nozzle blockages daily. "All that downtime was preventing our lines from reaching full capacity. With InvisiPac there are no more unexpected shutdowns. This has enabled us to increase our capacity: what we were doing with two lines before, now can be handled by one. And we needed all the capacity we could get, as we had to increase our output to meet growing client demand."

"Although our fruit packaging lines vary in

size and we have different brands of packaging machines, replacing our old glue systems with InvisiPac was pretty straight forward," says Ferdi, adding: "This is because this unit is designed as a drop-in replacement; it fitted onto the same platform as our previous systems."

About InvisiPac

It's a tank-free hot melt system with melt-on-demand technology. This sealing unit is designed and built specifically for case and carton packaging. Find out how InvisiPac can make your end-of-line packaging faster, safer, and more cost-effective: www.graco.com/invisipac

About Graco

Graco designs and manufactures premium equipment to move, measure, control, dispense and spray a wide variety of fluid and powder materials. Companies in over 100 countries trust the solutions that Graco provides.

Left: One of ZZ2's packaging lines with Graco's InvisiPac. "Thanks to this unit, there are no more unexpected shutdowns," says packaging manager Ferdi Jacobs.



"What we were doing with two lines before, now can be handled by one."

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Extension briefs for

OCTOBER AND NOVEMBER 2024

Integrated pest management (T.G. Grout and S.D. Moore)

Thrips management

During October and November citrus fruit is highly susceptible to damage from citrus thrips. Therefore, orchards should be scouted at least once a week for this pest, being sure to look under the sepals. Citrus thrips larvae cause more serious damage than adult thrips. So, low numbers of adults in the absence of larvae may not require immediate intervention. The intervention threshold for citrus thrips larvae on fruit is 2% for the first four weeks after petal fall, 3% for five to six weeks after petal fall, then 4% for seven to eight weeks after petal fall. These thresholds can be roughly doubled if the population comprises mostly adults. Citrus thrips are genetically predisposed to developing resistance to pesticides, so avoid spraying two consecutive sprays of the same active ingredient. Treatments that give six to eight weeks' thrips control will eliminate natural enemies of false codling moth (FCM), mealybug, and scale insects for at least a month. With this degree of required control, it is best to spray these at petal fall and to follow up with softer options when necessary.

Parasitoid releases

Growers planning to augment parasitoids for mealybug, (i.e., *Coccidoxenoides perminutus* or *Anagyrus vladimiri*), red scale (i.e., *Aphytis melinus*) or FCM (i.e., *Trichogrammatoidea cryptophlebiae*) control, should initiate releases as early in the new season as possible. Augmentative releases of parasitoids are not a corrective option, and growers should therefore not wait until the pest reaches a problematic level. Research trials with mealybug and FCM parasitoids indicate that better suppression of the pest is achieved with releases initiated as early as October, or at the latest, November. However, first ensure that sufficient time has lapsed since application of pesticides that would be detrimental to parasitoids. This information

is available from CRI and the biocontrol agent producers/suppliers. Lastly, if releasing parasitoids against mealybug, you need to be sure that the mealybug species is indeed susceptible to the parasitoid being released; for *C. perminutus*, this is only citrus mealybug, whereas for *A. vladimiri*, this is citrus and oleander mealybug.

Preventative sprays for mealybug

Pre-harvest blemish analyses or winter inspections of trees might have indicated that preventative spraying for mealybug is unnecessary. This can be confirmed or refuted by inspecting fruit in October and November for the presence of mealybug. Sprays applied before calyx closure will be more effective than those applied thereafter. An infestation level exceeding approximately 5% at petal fall, or up to 20% six weeks after petal fall, requires immediate chemical intervention. At this later stage, the organophosphates and buprofezin, with which we are so familiar, can no longer be used. However, trial work indicates that some of the newer options, particularly spirotetramat and sulfoxaflor, are at least as effective. Anything short of a thorough full cover film spray will compromise the effectiveness of a chemical treatment. Furthermore, early season treatment is far more effective than corrective treatment (after November), so if at all in doubt, treat preventatively for mealybug. If citrus mealybug is not the dominant species, then augmentative releases of *Coccidoxenoides perminutus* should be considered unsuitable.

Bollworm

In many regions, it might already have been necessary to treat bollworm during September. However, routine spraying for bollworm is generally not necessary. Monitoring the percentage of blossom clusters infested, enables determining if a spray is necessary. A treatment should be applied when more than 20% of blossom clusters are infested with larvae or mature

By Hannes Bester, MC Pretorius, Wayne Mommsen, Coenraad Fraenkel, André Combrink, Natasha Jackson, Jan Landman, and Rudolph Strydom (Citrus Research International)

eggs. Enlarged navel end problems in Navel oranges can be further exacerbated by bollworm attack. In which case, a threshold of 11% of clusters infested should be used.

Four biocontrol options are available for the control of bollworm. These are DiPel (Bt), Helicovir, Bolldex and Graboll (all viruses). To be effective, these biological products should be applied immediately after egg hatching, but certainly not once larvae are longer than one centimetre in length.

Citrus flower moth

Moths of the citrus flower moth (or lemon borer moth), *Prays citri*, are attracted to lemon blossoms. Growers should inspect these blossoms in spring to determine if they are infested with larvae or pupae. These can be identified by their colouration, which is usually greenish and the association of webbing with pupation. Even if the damage to, and loss of blossom are not considered sufficiently severe to justify control measures, no intervention will allow the development of a second generation. It is the moths of this second generation that lay their eggs on the lemon fruitlets. Hatching larvae can potentially cause severe damage. Therefore, it is more effective to control the first generation. Infestation of 5% of blossoms with this first generation will lead to approximately 5% fruit damage and would warrant a spray. No plant protection products are registered for use against the lemon borer moth. However, several pesticides that are registered for other pests on citrus are effective, including Bt (DiPel), mevinphos and spinetoram (Delegate).

FCM

Importantly, as was the case since 2018, all growers intending to export citrus to the EU must implement the FCM Systems Approach (now abbreviated as the FCMSA), which includes the FCM Systems Approach.

Effective control of FCM from early in the season must be done. Otherwise, FCM could escalate to undesirable levels, which will be far more difficult to bring under control. As soon after harvesting as possible, all out of season fruit must be removed from trees and destroyed. Within the FCMSA, it is mandatory that this be completed within 14 days after harvesting the orchard. If not done, this fruit can act as a reservoir for FCM and fruit flies, enabling particularly the former, to carry over onto the new cropset in spring. Do not neglect orchard sanitation early in the season. Infested fruitlets can contribute significantly to the build-up of FCM populations later and any extra labour required is well worthwhile.

FCM pheromone traps should be hung no later than November. It is imperative that these traps be hung strictly according to the recommendations on the label.

Growers wishing to control FCM with Cryptomax, Cryptogran, Cryptex or Gratham (FCM granulovirus) should apply the first

treatment no later than the end of November or early in December – applied shortly after the flight peak, which occurs at this time in all production areas. Cryptomax is a new FCM granulovirus formulation, consisting of two distinct virus isolates, thus increasing the probability of good efficacy against multiple FCM populations, and decreasing the possibility of resistance development, even though such a possibility is negligible.

Note these important principles, if using mating disruption (e.g., Isomate, Checkmate, Splat, X-Mate):

- Application must be initiated early in the season, before FCM levels begin to rise – preferably October, but not later than November.
- However, trial results indicate that initiation as early as July in the warm northern production regions may be more effective in simultaneously protecting late hanging Valencias and suppressing the first FCM generation of the new season. But first, check with your product supplier that their registration permits such a practice.
- The product must be applied (or hung) as high as possible in the tree.
- Large areas (at least 5 ha, but preferably larger) must be treated. The presence of any untreated areas on the farm will negatively affect the efficacy of mating disruption, as it is a population suppression technology, rather than a crop protection technology. It is advisable to apply it on an area-wide basis for optimal efficacy.

Crop and fruit quality management (P.J.R. Cronjé)

Fruitset treatments must be applied according to cultivar requirements. Treatments include the application of gibberellic acid (GA₃) and girdling, especially for parthenocarpic cultivars. General guidelines cannot be given, as fruitset treatments differ by cultivar and

orchard. Avoid moisture stress during full bloom, fruitset, and early fruit growth.

Fruit growth must be optimised during Stage 1 of fruit development with optimal nutrition and irrigation practices. During this phase of fruit development, the rind (flavedo and albedo) is formed. It is important to ensure optimal uptake of essential nutrients such as Ca and Mg, which play an important role in the structural integrity of cell membranes. In addition, fruit thinning practices need to be applied to reduce inter-fruit competition and to optimise fruit growth.

The **acidity** of fruit at harvest is largely determined within the first six weeks of fruit growth and development. Thereafter, only minor modifications to acidity can be achieved. Under conditions of anticipated high acidity mono-ammonium phosphate (MAP) or mono-potassium phosphate (MKP) can be applied at 1%, i.e., 1 kg per 100 l of water, six weeks after full bloom. Please note that these phosphate sources have not been tested on all citrus cultivars; until now 1% MAP or MKP has reduced acidity on Valencia orange and Temple tangor, but not on grapefruit.

Pruning of late cultivars should be done as soon as possible after harvest. All the following should be removed during pruning: old, broken, and dead shoots/twigs; weak and entangled shoots crossing each other or hanging downwards; as well as any rootstock regrowth. Thin out, cut back, or remove regrowth on the inside of the tree. Light levels above 30% are necessary for optimal photosynthesis. Enough windows should be cut to allow adequate light distribution and to improve bearing wood within the tree. This will lead to increased fruit size and internal fruit quality (Brix°), better fruit colour, increase in rind integrity, as well as a more uniform fruit size distribution. Pruning can be used as a thinning technique: Prune more heavily after a light crop if the orchard has a history of alternate bearing. A follow-up prune of regrowth in the summer is of critical importance. Pruning tools should always be sanitised with 10% Jik.



Coenraad Fraenkel



Jan Landman

Grondgedraagde siektes (MC Pretorius en J.M. van Niekerk)

Aalwurms

Grond- en wortelmonsters kan nou in die lente getrek word en vir ontleding na die Diagnostiese Sentrum in Nelspruit gestuur word, sodat die status van die aalwurmpopulasie in die wortels bepaal kan word. Die resultaat sal dien as 'n bestuurshulpmiddel om 'n koste-doeltreffende aalwurmbeheerstrategie daar te stel.

Die gebruik van chemiese aalwurmdoders vir die beheer van die sitrusaalwurm word nie aanbeveel alvorens ten minste 30 mm reën geval het nie (Oktober). Elke aalwurmdodertoediening behoort op nat (veldkapasiteit) grond toegedien te word en met 'n behoorlike besproeiing opgevolg te word. Dit verseker dat die middels deeglik in die grondprofiel ingewas word. Toedienings behoort slegs volgens etiket-aanbevelings toegedien te word. Afwykinge van die geregistreerde dosisse, om kostes te bespaar, word sterk afgeraai.

Phytophthora

Phytophthora wortelvrot – die gebruik van fosfonaatprodukte wat sistemies is, is 'n uiters effektiewe en bekostigbare beheermaatreël wat suksesvol deur produsente gebruik word. Om effektiwiteit te verseker en fitotoksiteit te voorkom, is dit van uiterste belang dat die etiket deeglik bestudeer word asook die waarskuwings voordat die produk gebruik word. Indien kraagvrotletsels voorkom, kan 'n stamverf of blaarbespuiting aangewend word, drie aanwendings per seisoen met ses tot agt weke intervalle. Vir wortelvrotbeheer word 'n blaarbespuiting van ten minste twee of verkieslik drie blaarbespuitings met ses tot agt weke intervalle aanbeveel. Fosfonaatbehandelings behoort jaarliks as 'n standaardtoediening op nie-draende bome toegedien te word. Let asseblief daarop dat sekere fosfonaatprodukte as grondtoedienings vir die beheer van kraag- en wortelvrot geregistreer is.

Fruit and foliar diseases (P. Moyo)

Alternaria core rot

Alternaria core rot, also known as navel end rot or black rot, affects navel oranges, lemons and mandarin types, causing dark brown to black rot at the stylar end (navel). The disease generally occurs on fruit with poorly formed navels. Fruit can develop *Alternaria* core rot without showing any external symptoms until after harvest. Fruit with large navel-end openings is more susceptible to *Alternaria* core rot and physiological disorders such as fruit splitting. Also, fruit splitting or microcracks at the stylar end during early fruit development after petal fall, provide entry points for fungal spores that infect young fruit and form infections. The latter remain dormant, until favourable environmental conditions stimulate further fungal growth. Application of 2.4-D, during full bloom reduces the size of the navel as well as that of the

navel-end opening. Fungicides, including difenoconazole and tebuconazole, applied at 50 and 100% petal fall reduce the incidence of Alternaria core rot.

Black spot

Citrus fruit are susceptible to citrus black spot infection (CBS) from 80% petal drop (traditionally mid-October). Therefore, it is recommended that CBS fungicide sprays commence from this period and follow through until the end of the susceptibility period (four to five months after petal drop). In cases where fungicide sprays commence later than the date of 80% petal drop, it must be demonstrated that no CBS infection periods occurred during the period between the date of 80% petal drop and date of spray commencement, by using either CRIPhytRisk or spore trap data. Fungicides used in the spray programmes must be registered for CBS control and

used according to the recommendations specified on the label. The maximum residue level (MRL) restrictions of different fungicide products, for different markets, must be adhered to. Poor control of CBS is largely attributed to poor spray coverage. Therefore, it's very important that spray equipment is properly maintained and calibrated to achieve proper canopy coverage. Cultural practices that reduce the fungal inoculum in the orchards (removal of leaf litter, shredding of pruning debris and removal of sickly trees/orchards if/where possible) are also important in the management of CBS, as they complement its chemical control. Refer to CRI Cutting Edges 351 and 352 for further information regarding the overall management of CBS and timing of the first CBS sprays.

Postharvest pathology (W. du Plooy and L. Mamba)

By now most of the crop has been harvested, packed and shipped. Consider these factors regarding vital changes to improve disease management next season:

- **Timespan from harvest to the first fungicide treatment**
 - The shorter this period, the younger any infections will be. Therefore, fungicide treatments will be much more effective resulting in less rotten fruit in the degreening room and/or at the packhouse. Less rotten fruit will reduce the strain on your sanitation protocol and pre-sorters.
- **Strength of drench applicator flow**
 - Were you able to apply at least 250 Ñi per bin per minute? A more effective drench application will curb disease development, leading to fewer rotten fruit arriving at the packhouse, and again, less pressure on the sanitation protocol.
- **An adequate packline facility**
 - You need enough packline facility to sort and remove rotten fruit in the very first part of the packline, at, or just after,

tip. Most packhouses have insufficient sorting in the beginning of the packline, resulting in packhouse access for rotten fruit, and widespread contamination.

- **Installation of a second sanitation treatment**
 - This should be a total loss system, positioned at the point in the packline after rotten fruit had been removed from the export fruit. This will protect the packline from contamination.
- **Sanitation of dip tank/flooder**
 - Do you have a pasteurisation protocol (heating overnight)? Heating the solution to 60°C for one hour and letting it cool down overnight will reduce the build-up of bacteria, as well as *Rhizopus* and other pathogen spores in the solution. Coliform counts that seem to skyrocket can often be traced back to poor sanitation of reused water.
- **Be proactive at the end of the season**
 - This is the time to thoroughly sanitise the entire packhouse from the roof beams to the floor, but only after all fruit (rotten or healthy) has been removed from the packhouse environment. A quaternary ammonium product can be used, after which surfaces where fruit may contact treated surfaces are rinsed off thoroughly with clean water. Postponing this cleaning until the next season will only add to the pressure of preparing for the new season, resulting in substandard sanitation. Time consuming jobs such as cleaning dry tunnel rollers must also be done during this time. Cleaned machinery and equipment can be covered with plastic to protect them from dust during the off-season.
- **Thorough examination**
 - An examination of all the equipment should be done right after the season ends, when problems are still fresh in the packhouse manager's mind. This is also the time to do any upgrades, changes, or replacements. Brushes, donuts, and chains are of particular importance to evaluate and replace, if necessary.

Fertilisation and irrigation (P. Raath)

During this time of the year, following sufficient nitrogen (N) fertilisation, a healthy anthesis has been established and emphasis should be put on fruitset and phase one of fruit growth. Phase one is characterised by intensive cell division in the developing fruitlets and, ultimately, sets the trend for targeted fruit size. After full-bloom, cellular division starts, and the developing ovaries need carbohydrates and N for protein biosynthesis. It's also important to take note of vegetative growth, fruitset and leaf colour as indicators of the effectiveness of the current fertilisation programme and to re-evaluate and adjust if necessary.

Macronutrients

During this period the tree has a high demand for N, calcium (Ca) and potassium (K) in relation to phosphorus (P) and magnesium (Mg). Though, the demand of P and Mg is relatively constant. By now P – and if corrective Mg was required – should have been applied, especially on heavier textured micro-irrigated soils. On lighter textured soils, drip irrigated soils, application can be divided into a few instalments throughout the season. Most N should have been applied, with the last instalment due during Oct/Nov. Even fertigated orchards, where N is applied deep into summer on sandy soils, should have received the bulk of its seasonal N (up to 85%) by the end of November.

After fruitset and physiological fruitdrop have occurred, it is important to take note of final fruitset and to re-adjust the fertiliser programme accordingly. A lower set than had been predicted, may result in over fertilisation due to a reduction in fruit acting as carbohydrate and nutrient sinks. There is a risk of applying excessive N, especially, which can lead to reduced fruit quality and rind colour. During phase one of fruit development Ca plays a central role in cell division, which ultimately affects fruit size and rind integrity. Since Ca is exclusively



Wayne Mommsen



Rudolph Strydom

taken up with the transpiration stream, any factors affecting transpiration (i.e., overcast days, cold conditions, or sudden heat waves that cause stomatal closure) will reduce Ca uptake. On the other hand, excessive transpiration rates (i.e., constant warm weather with low humidity) can result in preferential transport of Ca to the leaves instead of the fruit. Despite sufficient Ca in the soil, insufficient Ca supply during phase one can consequently occur resulting in an increased incidence of creasing and/or fruit splitting. If periods of reduced uptake are suspected/expected, an attempt to increase Ca-uptake can be made by using CaNO₃ as the N source. Apply the CaNO₃ as soil application and not as foliar application. Due to various antagonisms between Ca and other nutrients, do not apply large, once-off instalments of K or Mg during this stage. However, most of the season's K should be applied during this period; and 100% of the annual requirement should be applied by end November on heavy soils, while up to

60% of the annual requirement should have been applied on sandy soils. In addition, KNO₃ foliar sprays can be applied from end October through to beginning December if low leaf K levels is expected. This will help improve fruit size.

Micronutrients

Their availability is a function of soil pH and should be applied as foliar treatments on alkaline soils. Zinc (Zn), manganese (Mn) and boron (B) can be applied between bud-swell and balloon phase, during October when the spring flush is still young with thin cuticles expediting uptake. In soils with optimal pH levels, i.e., 5.0 - 6.5, ZnSO₄ can be applied to the soil to raise the levels to 10 mg/kg. Since there tends to be a poor correlation between soil Zn and Mn concentration and uptake by the tree, foliar applications of Zn and Mn are commonly recommended. If Mn-containing fungicides were used, foliar application should not be necessary. Boron deficiency is common on acid sandy soils where foliar application just before, during flowering, or during October, is advised.

Irrigation

During phase one of fruit development any factor that might reduce cell division can have irreversible effects on fruit size. Therefore, care should be taken not to induce any stress through poor irrigation management. During Oct/Nov a 30% depletion of plant available water (PAW) between irrigation cycles is recommended. However, over-irrigation can also be detrimental to root activity and nutrient uptake. Therefore, accurate irrigation scheduling during this period is critical, to ensure optimal fruit size. ▶