

# vinotwist

The secret of pure taste

30 x 60 mm screw cap

**Material** Deep-drawable aluminium  
Strength  $0.23 \pm 0.01$

**Seals** Optional: TIN-SARAN  
SARANEX  
EVOH  
EPE

Strength  $2.0 \pm 0.2$  mm  
Storage  $5\text{ }^{\circ}\text{C} - 35\text{ }^{\circ}\text{C}$   
Humidity 30 – 80 %

**Inner surface** High-grade protective lacquer

**Outer surface/Head** Printing according to the customer requirements  
up to 3 colours in offset or screen printing, hot  
printing or embossing (coloured or uncoloured)

**Locking guidelines**  
**Standard values**

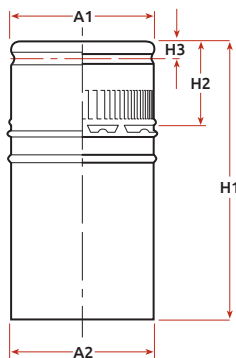
Head pressure	160 – 200 kg
Depth of draw	1.6 mm $-0.1 +0.2$ mm
Side pressure- thread rolls	9 – 13 kg
Side pressure- necking rolls	7 – 9 kg
Plunger diameter	27.5 mm

**Open** Opening torque 0.8 – 1.8 Nm

**Ø Weight\*** 1,000 pieces 4.6 kg

\*Dependent on lacquering type and liner

**Package** 1,200 pieces per box  
24,000 pieces per pallet



dimensions and tolerances

A1	29.75 mm	$\pm 0.15$ mm
A2	29.29 mm	$\pm 0.16$ mm
H1	59.5 mm	$\pm 0.50$ mm
H2	17.5 mm	$\pm 0.30$ mm
H3	4.0 mm	$\pm 0.10$ mm

## General recommendations

for a smooth process of screw caps

### 1. Inspection of the empty bottles:

Only use new glass! Check the mouth of the bottles for damage (splintering, cracks at the mouth, angle of the lip, orange peel surface, etc.)!

### 2. Adherence to the filling level:

The filling level can be seen on the edge or bottom of the bottle or on the data sheet and must be adhered to! Indication at  $20\text{ }^{\circ}\text{C}$  for example 47 mm.

### 3. Inspection of the closure machine:

Check that the head is tightly screwed on, all the moving parts move easily, the direction of rotation is correct and all settings have been made according to data sheet!

### 4. Visual inspection after closure:

The drawing depth must be present, the thread should be pronounced, the beading sufficiently deep and there should be no optical defects visible.

### 5. Storage

Keep bottles upright for 3 to 5 minutes after filling.

### 6. Inspection of closure quality:

The closure should be easy to open by hand. Check that the sealing disc is properly inserted and that the mouth is clearly visible.

### 7. Tests while running:

An optical and mechanical test should be repeated every 30 minutes.

### 8. When filling is finished:

Opened packages should be resealed airtight before storage.



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