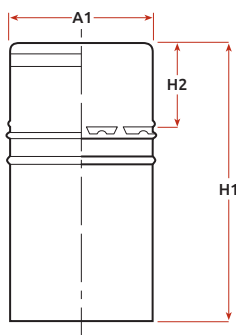


# vinotwist

## PREMIUM

30 x 60 mm screw cap **with inside thread**

<b>Material</b>	Deep-drawable aluminium Strength 0.23 ± 0.01	
<b>Seals</b>	Optional:	TIN-SARAN SARANEX
	Strength	2.0 ± 0.2 mm
	Storage	5 °C – 35 °C
	Humidity	30 – 80 %
<b>Inner surface</b>	High-grade protective lacquer	
<b>Outer surface/Head</b>	Printing according to the customer requirements up to 3 colours in offset or screen printing, hot printing or embossing (coloured or uncoloured)	
<b>Locking guidelines Standard values</b>	Head pressure	70 – 90 kg
	Application torque	8.5 – 11 kg
	Side pressure-necking rolls	7 – 12 kg
	Opening torque	1.6 – 3.0 Nm
<b>Ø Weight*</b>	1,000 pieces	4.6 kg
*Dependent on lacquering type and liner		
<b>Package</b>	1,200 pieces per box 24,000 pieces per pallet	
<b>General recommendations</b>	Use new glass Store the bottles in an upright position after filling Reseal opened bags carefully before storage	



dimensions and tolerances

<b>A1</b>	29.75 mm	± 0.15 mm
<b>H1</b>	59.50 mm	± 0.50 mm
<b>H2</b>	17.50 mm	± 0.30 mm

### General recommendations

for a smooth process of screw caps with inside thread

#### 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 °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:

Check that the beading is 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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