

# Data Sheet

30 x 60 mm aluminium screw cap

<b>Material</b>	Deep-drawable aluminium strength 0.23 ±0.01	
<b>Seals</b>	optional:	TIN-SARAN SARANEX SARANEX HIGH EVOH EPE
	strength	2,0 ±0,2 mm
	storage	5°C – 35°C
	humidity	30 – 80 %

**Inner surface** High-grade protective lacquer

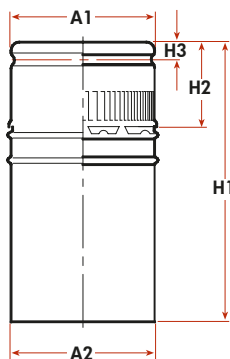
**Outer surface** Printing according to the customer requirements up to 3 colours in offset or screen printing, hot printing and embossing

<b>Locking guidelines Standard values</b>	Head pressure	1600 – 2000 N
	Depth of draw	1,6 mm –0,1 +0,2 mm
	Side pressure-thread rolls	90 – 130 N
	Side pressure-necking rolls	70 – 90 N
	Plunger diameter	27,5 mm

**Open** Opening torque 0,8 – 1,8 Nm

**Ø Weight\*** 1000 pieces 4,6 g  
\*Dependent on lacquering type and liner

**Package** 1200 pieces per box  
24000 pieces per pallet



dimensions and tolerances

<b>A1</b>	29.75 mm	±0.15 mm
<b>A2</b>	29.29 mm	±0.16 mm
<b>H1</b>	59.5 mm	±0.3 mm
<b>H2</b>	17.5 mm	±0.3 mm
<b>H3</b>	4.0 mm	±0.1 mm

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The secret of pure taste



**BT-Watzke GmbH**  
Griesstrasse 25  
8243 Pinggau, Austria

+43 3339 22201-0  
+43 3339 22201-3  
office@bt-watzke.at

[www.bt-watzke.at](http://www.bt-watzke.at)

## General recommendations

for a smooth process

### 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:

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.