

# vinotwist

The secret of pure taste

30 x 60 mm screw cap

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

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

Strength  $2.0 \pm 0.2$  mm  
Storage  $5^\circ\text{C} - 35^\circ\text{C}$   
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**

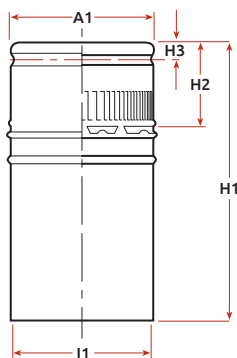
Head pressure	160 – 200 kg
Depth of draw	1.6 mm $-0.1 +0.2$ mm
Side pressure- thread rolls	9 – 13 kg
Side pressure- necking rolls	7 – 9 kg
Plunger diameter	27.5 mm

**Open** Opening torque 0.8 – 1.8 Nm

**Ø Weight\*** 1,000 pieces 4.6 kg

\*Dependent on use lacquer 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
I1	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 the smooth application  
process of screw capsules.

### 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! For example at  $20^\circ\text{C}$   
the indication will be 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 the  
data sheet!

### 4. Visual inspection after closure:

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

### 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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