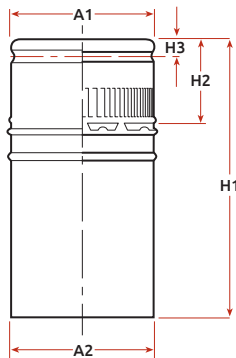


# vinotwist

The secret of pure taste

BVS 30 x 60 mm screw cap

<b>Material</b>	Deep-drawable aluminium Strength $0.23 \pm 0.01$	
<b>Seals</b>	Optional:	TIN-SARAN® SARANEX® EVOH EPE ALKOVin™ active
	Strength	$2.0 \pm 0.2$ mm
	Storage	$5\text{ °C} - 35\text{ °C}$
	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>Capping guidelines Standard values</b>	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
<b>Open</b>	Opening torque	0.8 – 1.8 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>Bottle</b>	bottle mouth according to DIN EN 16293	



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  $20\text{ °C}$  for example 47 mm.

### 3. Inspection of the capping 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 bottle mouth is clearly visible.

### 7. Tests while running:

An optical and mechanical test should be checked frequently.

### 8. When filling is finished:

Opened packages should be resealed airtight before storage.



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