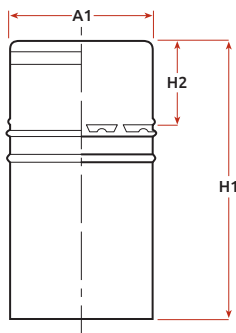


# vinotwist

## PREMIUM

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

<b>Material</b>	Deep-drawable aluminium Strength $0.23 \pm 0.01$	
<b>Seals</b>	Optional:	TIN-SARAN® SARANEX®
	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 machine related values</b>	Head pressure	60 – 90 kg
	Screwing torque	1.1 – 1.8 Nm
	Side pressure-necking rolls	7 – 12 kg
<b>Opening</b>	Opening torque	1.6 – 3.0 Nm
<b>Ø Weight*</b>	1.000 pieces	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

<b>A1</b>	29.75 mm	$\pm 0.15$ mm
<b>H1</b>	59.50 mm	$\pm 0.50$ mm
<b>H2</b>	17.50 mm	$\pm 0.30$ 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  $20\text{ °C}$  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:

Check that the beading is sufficiently deep and there should be no optical defects visible.

#### 5. Storage

Keep the bottles upright 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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