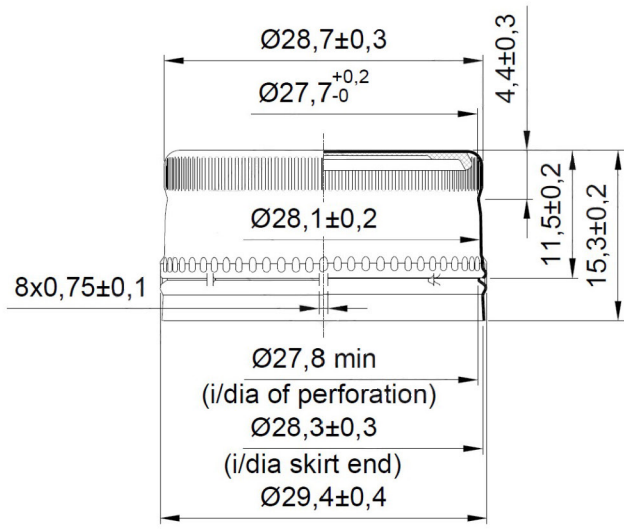


Product:	
1. Shell material:	
Al composition	EN AW-3105A
Al condition	H16
Tensile strength R_m , MPa	150-190
Elongation A50, %	≥ 3
Anisotropy, % max	≤ 2
Material thickness, mm	0,21 \pm 0,01
Note: Mechanical properties after simulated lacquer stoving treatment	
2. Lacquers and inks	
Internal lacquer type	Mod. polyester
External lacquer type	Polyester/Mod. polyester
External inks type	Alkyd
3. Liner	
3.1. PVC-free sealing compound for sensitive mineral water, CSD and wine (still and sparkling)	
Internal pressure	0,6 MPa
Max. mom. internal pressure	0,8 MPa
3.2. PVC-free sealing compound for lemonade, beer and fruit juices	
Internal pressure	0,6 MPa
Max. mom. internal pressure	0,8 MPa
Pasteurization: approx. 20 min at 85°C	
Hot filling: approx. 95°C with cooling	
4. Recommended application details (Glass) – for PET bottles adjust according to the bottle manufacturing specification:	
Head pressure force, N	1900-2300
Thread roller pressure force, N	100-120
Under-tuck roller pressure force, N	90-110
Note: These values are starting ones and can be varied according to the results to be achieved	
5. Capping tray dimension:	
Depth of draw plunger, mm	2,60
Drawing diameter, mm	26,0
Pre-centering diameter, mm	28,4 ^{+0,1}
6. Relevant bottle neck finishes:	
Type of bottle finish:	Rollers radius, mm
MCA 1 CE.T.I.E. GME 32.00	0,8-0,9
MCA 2 CE.T.I.E. GME 32.00	0,7
MCA 3 CE.T.I.E. GME 32.00	0,8-0,9
MCA 7,5R CE.T.I.E. GME 32.00	0,8
MCA 7,5RF CE.T.I.E. GME 32.00	0,8
28 bassa UNI 7564:1988	0,7
Note: for MCA 2 and 28 bassa neck finishes it is important to use the correct thread rollers as detailed above to ensure correct application	
7. Opening torques (dry neck finish):	
The torque needed to start the closure rotation (slip torque), lbs in (Nm)	5,5-16,0 (0,618-1,797)
The torque needed to break the tamper evident band (break torque), lbs in (Nm)	5,5-12,0 (0,618-1,348)
Over torque, lbs in (Nm)	$\geq 12,0$ ($\geq 1,348$)
Note: The break torques depend from the particular application, from the torques applied by the capping heads, the type and the bottle neck finish quality, etc.	
10. Storage and usage	

Pilfer-proof HSC 28×15,4	
8. Closure drawing: Drawing ID – 28×15,4_D1_143	
	
Number of flutes/knurls	45 \pm 2
Weight, g	1,33 \pm 0,04
9. Packaging specification:	
Quantity, pcs	5800
Box dimensions – external, mm	600×400×360
Cardboard type	Corrugated five layer cardboard
Polyethylene sack	MDPE – non-toxic, anti-static, <100 ppm Pb, Cd, Hg, Cr ⁺⁶
Adhesive strip (Scotch)	48 mm
Product identification	Labeling
Pallet type – Euro pallet	Dimension: 1200×800×*
* the overall pallet height may vary according to the customer's requirements	
Outside packing	Stretch wrapped
Pallet identification	Labeling

The closures shall be stored in well-ventilated area, away from direct sunlight, strong vapors and odors at temperatures (5-30)°C for the period of 2 (two) years after a date of production. The closures should be used following the principle “first to come – first to go” (FIFO). Pallets should not be double stacked.

