

STF- 1031/ 47 TE NR

Technical Specifications

Date: 26/03/2019

Production plant of Jerez

Page: 1 of 2

Closure: 1031/ 47 TE NR

Customer:

Bottled product:

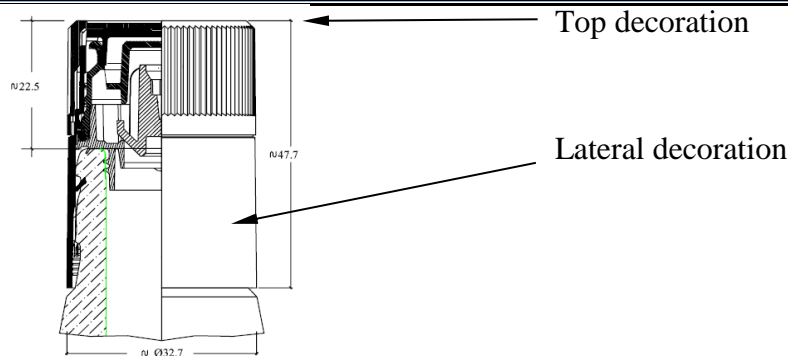
Customer's Product Code:

Guala Closures's Product Code:

§ Ref. (1)	Section 1: Characteristics			
	Dimensions	Units	Ref. values	Ref. Drawing
5.1	Diameter of the top closure (not included ovalization)	mm	32,7 ± 0,3	GUALA 1031 T.E./47 NR (Rev.D)
5.1	Height of closure	mm	47,7 ± 0,8	
5.1	Total height above the perforation	mm	~ 22,5	
Dimensions are only for general reference. Functionality is the criteria for cap evaluation.				
5.1	Type of neck-finish	Nº E-350		Internal: 19±0,3
5.5	Functionality		Units	Ref. values / Notes
	Opening torque (laboratory conditions with dry glass) (2)		Nm Nm	12 to 35
	Slip torque (disengagement of liner from the glass sealing face)			
	Break torque (break of bridges)			
	(2) : 5% of measured values may be up to a maximum of 20% over maximum limit above reported.			
5.7	Max vertical load per bottle during storage	Kg	80	
5.6	Tamper Evident behaviour	-	Breakage of the plastic ring in two sectors	
5.3	Pouring Rate (with 1 litre whisky)	s	<85	
5.4	Minimum free head space (3)	-	Min. 3%	
(3) : Empty space is calculated considering a Delta temperature from 16 to 40°C.				
(3): In case of bottled products the technical specifications set for herein are valid as far as the functionality of the closures is neither affected nor impaired by external conditions and/or the increase of volumes of the content, which have to be considered in handling, transporting and stocking the products. Customer must ensure that free head space is enough to compensate liquid expansion according to the handling and storage of his bottled product (container, temperature, etc).				
Section 2: Components' list				
4	Closure components	Raw material		Color / Characteristics
	Overcap	PE-HD		As per Customer request
	Skirt	PP		As per Customer request
	Pourer	PS		Transparent
	Valve	PP		Uncoloured
	Washer	PE-LD		Uncoloured
All closure's raw materials intended to come into contact with the bottled product are suitable to be used with foodstuffs.				
These materials are compliant with applicable regulation of Production country in force at this document's date. Compliance with the rule applicable in the destination country have to be certified by the production plant according to the interested rules.				
All production processes follow proper GMP to ensure quality and cleaning of our finished product and the relevant management system has been developed and third party certified according to ISO 22000 Standard (or equivalent) and according to ISO 9001 Standard.				

5.2

Section 3: Personalisation



Notes:

Artwork reference:

- a) This drawing doesn't represent the final shape of the cap (Refer to the section 1)
- b) Back-ground colour deviation: See artwork
- c) Admissible radial out of centre for the graphic on the top - See artwork

5.8

Section 4: Capping Systems

Values indicated below are Guala Closures' guidelines. The Customer might adjust capping machine settings to produce a satisfactory application. Different parameters are applicable if they don't compromise the functionality of the closures.

Closures must be handled in the best possible condition, minimizing any drop height and avoiding tumbling and rolling.

Capping Head top load	115 ± 10% kg	
Pressure block	Diameter	Drawing reference No. QC 523-A
	Profile	
Thread rollers	Radius	
	Lateral pressure	
Thuck-under rollers	Radius	
	Step	
	Lateral pressure	
Screw on application	Torque to apply	

Section 5: Packing

8	Packing & Shipment		Boxes	Octabin
		External dimensions of box or octabin (cm)		
		Number of pieces per box or octabin		
		Gross weight of box or octabin (kg)		
		Packed pallet dimension (cm)		
		Number of of box or octabin per packed pallet		
		Gross weight of packed pallet (kg)		
9	Storage conditions	<p>Any damage due to the transport must be reported on the transport documents otherwise the claim cannot be accepted. To avoid permanent deformations, it's forbidden to put more than one pallet/octabin on top of another.</p> <p>The pallets have to be stored in places free of contaminants, with relative humidity max 75% and temperature range from 4°C to 30°C; it is recommended to ensure that temperature of the closures prior to application is between 18°C and 30°C.</p> <p>It's recommended the application of FIFO criteria. After 90 days from the delivery date, if no negative feedback is received, the batch is considered accepted by the Customer.</p> <p>Although our closures are not subject to a shelf life, we strongly recommend our Customers to use the closures within 12 months from the delivery date. This recommendation is compulsory in case of lined closures (EPE, PVDC, Tin-Saran, woodpulp, etc.).</p>		

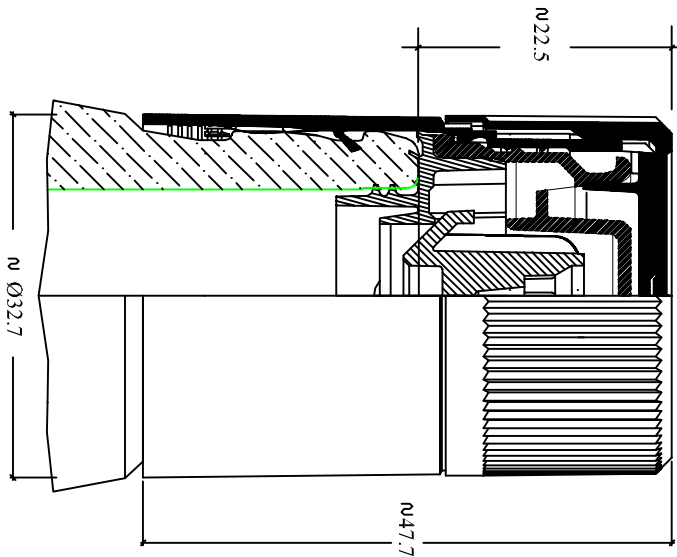
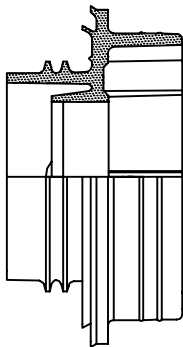
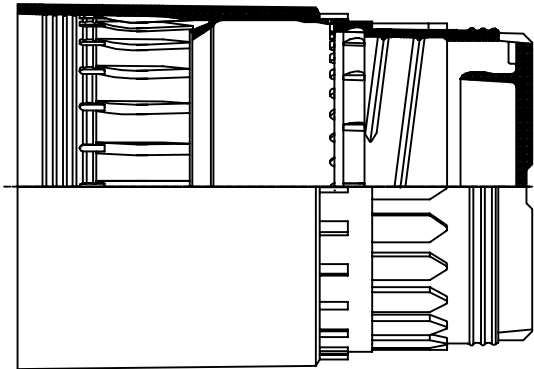
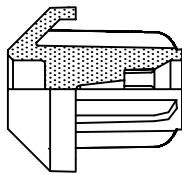
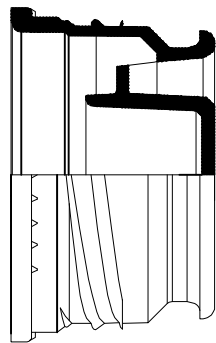
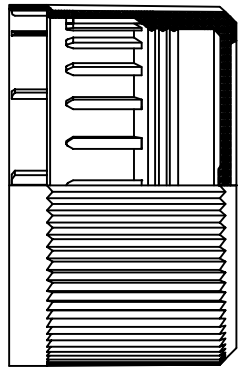
Prepared by: D.Gaona Position: Quality Department Date: 26/03/2019

Sent to: _____ By: _____ Date: _____

Customer approval signature: _____ Date: _____

If any comment isn't received within 10 working days from the receipt of this document, it will be considered fully agreed by customer.

⁽¹⁾ : This document (Technical Specifications) is an extract of the General Supply Specifications for Closures which describes expected use, main characteristics, trial procedures and supply conditions of our closures. Guala Closures reserves the right to modify the information here reported.

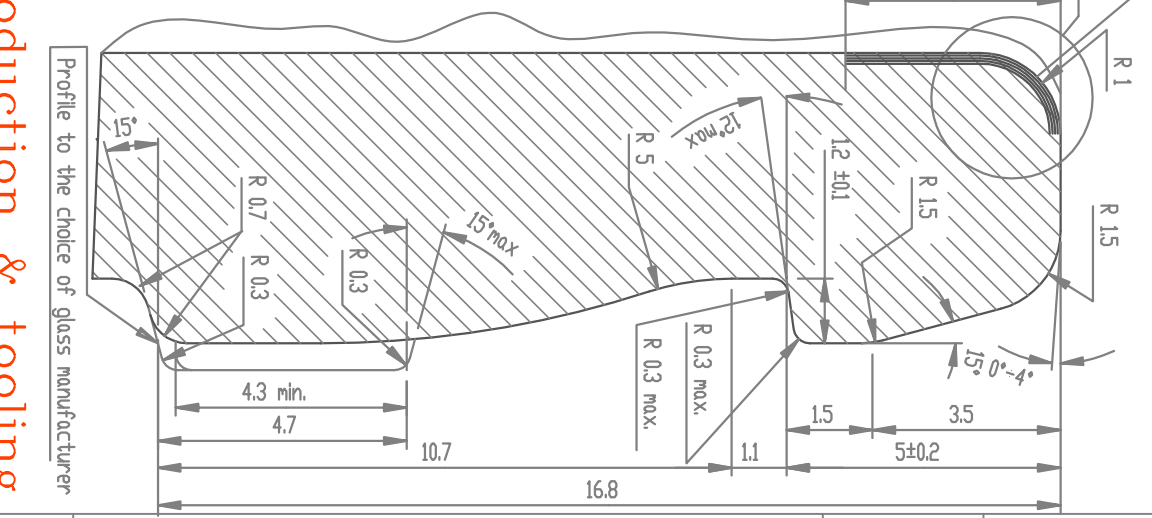
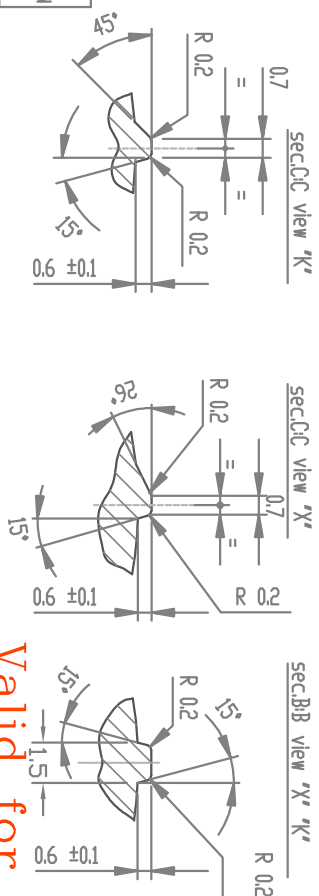
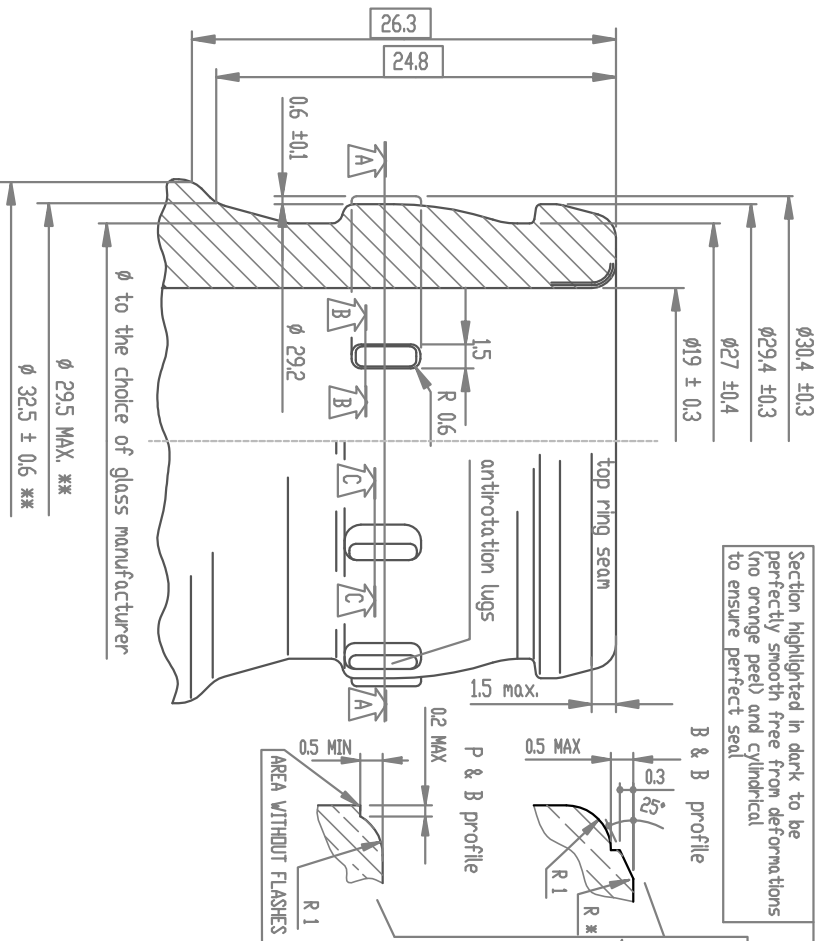
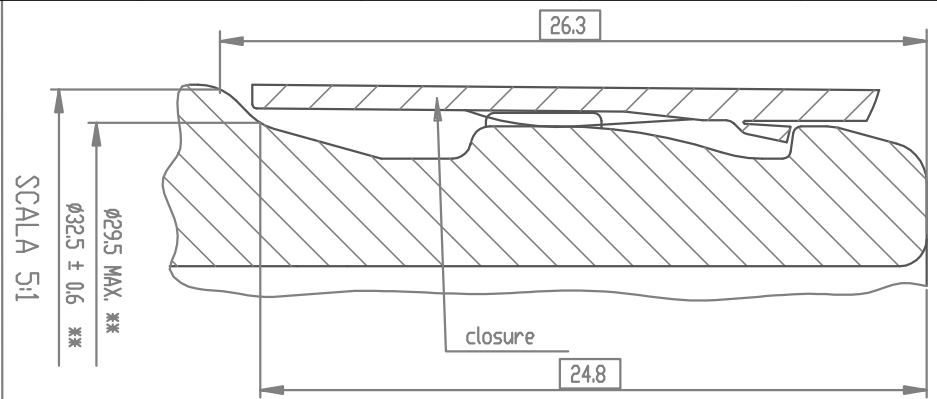


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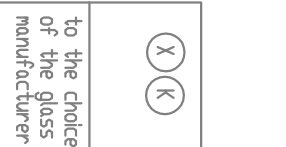
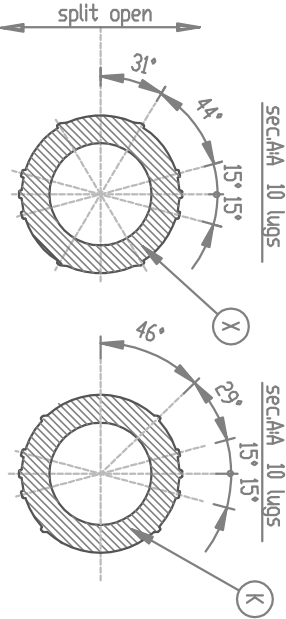
GUALA 1031 T.E. 47 NR

Rev.D



Revision Index	Detail of revision	Date	Drawn by
3	Insert new closures type Superdelux 47	04/04/2012	POSTCAD
2	Removed Alusnap 47 version	04/04/2012	MARECCO
1	INSERT NEW CLOSURES TYPE ALBA 47	28/10/2008	POSTCAD

Valid for production & tooling

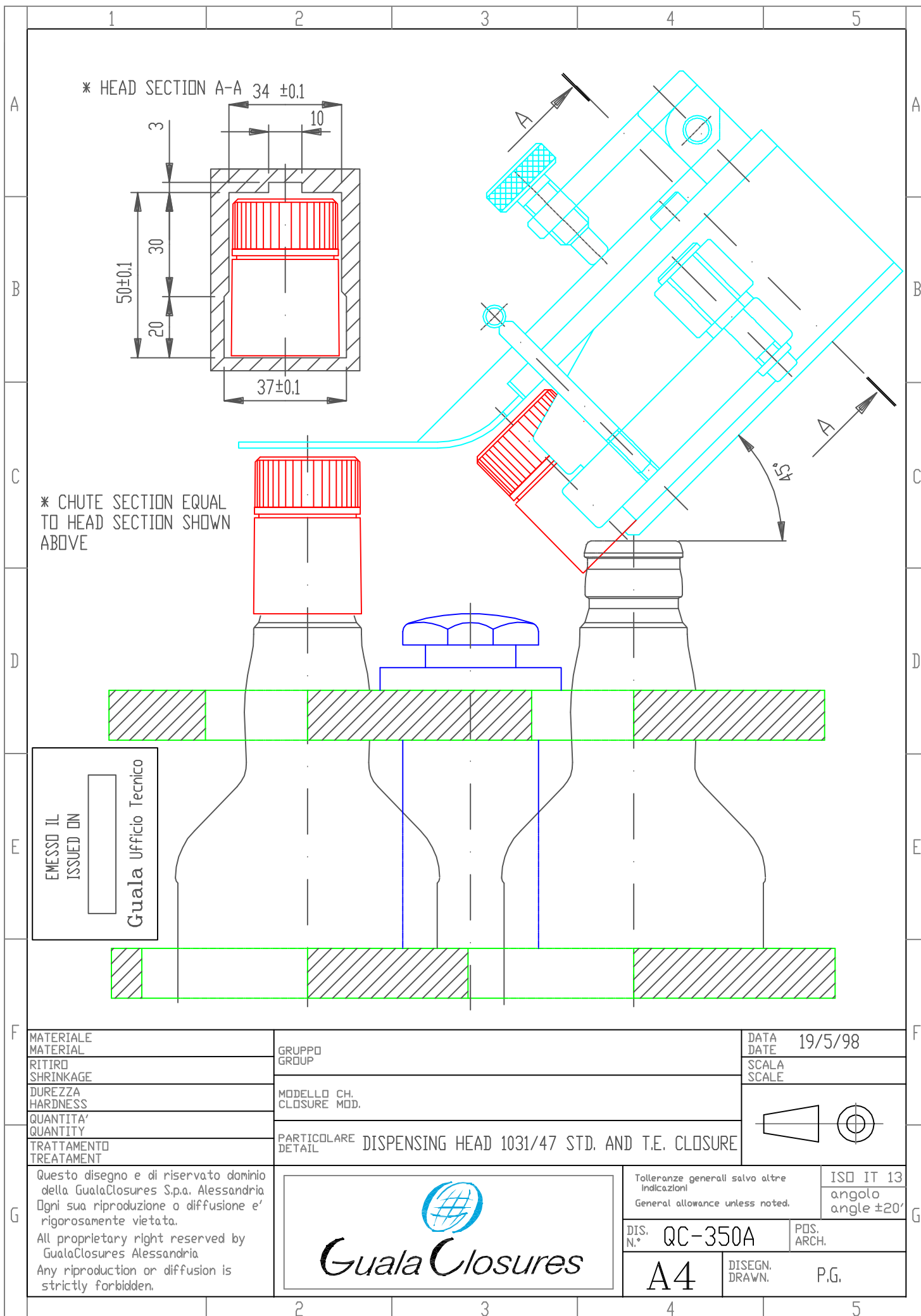


GROUP	DETAIL	DESCRIPTION
NECK FINISH	NECK FINISH	1031/47 STD and TE; 1331/47; 1332/47; ALBA/47 SUPERDELUX/47

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B						B														
C						C														
D						D														
E						E														
F	<div style="display: flex; justify-content: space-between; align-items: center;"> <div style="text-align: center;"> <p>115 KG. $\pm 10\%$</p> </div> <div style="border: 1px solid black; padding: 10px; text-align: center;"> <p>EMESSO IL ISSUED ON</p> <div style="border: 1px solid black; width: 150px; height: 20px; margin: 5px auto;"></div> <p>Guala Ufficio Tecnico</p> </div> </div>					F														
G	<table border="1" style="width: 100%;"> <tr> <td style="width: 30%;"> MATERIALE MATERIAL RITIRO SHRINKAGE DUREZZA HARDNESS QUANTITA' QUANTITY TRATTAMENTO TREATMENT </td> <td style="width: 40%;"> GRUPPO GROUP MODELLO CH. CLOSURE MOD. </td> <td style="width: 30%;"> DATA DATE SCALA SCALE </td> </tr> <tr> <td colspan="2"> <p>Questo disegno e di riservato dominio della GualaClosures S.p.a. Alessandria. Ogni sua riproduzione o diffusione e' rigorosamente vietata. All proprietary right reserved by GualaClosures Alessandria Any riproduction or diffusion is strictly forbidden.</p> </td> <td> <p>ISO IT 13 angolo angle $\pm 20^\circ$</p> </td> </tr> <tr> <td colspan="2"> <div style="text-align: center;"> <p>GualaClosures</p> </div> </td> <td> <p>Tolleranze generali salvo altre indicazioni General allowance unless noted.</p> </td> </tr> <tr> <td colspan="2"> <p>DIS. N.° QC-523A</p> </td> <td> <p>POS. ARCH.</p> </td> </tr> <tr> <td colspan="2"> <p>A4</p> </td> <td> <p>DISEGN. DRAWN. P.G.</p> </td> </tr> </table>				MATERIALE MATERIAL RITIRO SHRINKAGE DUREZZA HARDNESS QUANTITA' QUANTITY TRATTAMENTO TREATMENT	GRUPPO GROUP MODELLO CH. CLOSURE MOD.	DATA DATE SCALA SCALE	<p>Questo disegno e di riservato dominio della GualaClosures S.p.a. Alessandria. Ogni sua riproduzione o diffusione e' rigorosamente vietata. All proprietary right reserved by GualaClosures Alessandria Any riproduction or diffusion is strictly forbidden.</p>		<p>ISO IT 13 angolo angle $\pm 20^\circ$</p>	<div style="text-align: center;"> <p>GualaClosures</p> </div>		<p>Tolleranze generali salvo altre indicazioni General allowance unless noted.</p>	<p>DIS. N.° QC-523A</p>		<p>POS. ARCH.</p>	<p>A4</p>		<p>DISEGN. DRAWN. P.G.</p>	G
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