

Technical Specifications

Closure: **31,5x44 Inbore**

Customer:

Bottled product: **Alcoholic product (no application wine)**

Customer Product Code:

Guala Product Code:

§ Ref. (*)	Enclosure A.1 - Section 1: Characteristics							
	Dimensions			Units	Ref. values		Guala Drawing	
5.1	Total height above the perforation			mm	18,0 ± 0,2		27.PR.01	
5.1	Diameter of the top closure (not included ovalization)			mm	31,6 ± 0,2		27.PR.01	
5.1	Height of closure			mm	43,9 ± 0,2		27.PR.01	
5.1	Type of neck-finish	External: UNI 9574 - GME 30.06 - GF 314 - UNE EN 15543						
		In bore: Not applicable						
	Functionality			Units	Ref. values / Notes			
5.4	Empty head space of the bottle (compulsory)			cm³	3%			
5.7	Resistance to static force on the head			Kg	Not applicable			
5.5	Opening torque (laboratory conditions with dry glass)			N m (lb in)	6 - 25 lb in			
	Slip torque (disengagement of liner from the glass sealing face)							
	Break torque (break of bridges)							
	Note: 95% of the measured values has to be within the indicate range. None mesurement shall be out of the range: 4,8<Torque<30lb in							
	Pressure retention	bar	Not Applicable	Tª Max.	°C	Not applicable	Pasteurization	NON
5.6	Tamper Evident behaviour			-	Breakage of the bridges			
	Enclosure A.1 - Section 2: Components' list							
4	Closure components		Raw material		Colour / Characteristics			
	Aluminium Shell		Aluminium (Alloy 8011)		Colour:		see Section 3	
					Tensile Strenght:		130 ÷ 170 (Nm)	
					Thickness:		0,23 ± 0,01 mm	
	Liner		Inbores D3/PP31,5/GB or D3/PP31,5/NB		Colour:		N/A	
					Barrier film:		N/A	
Internal laquer		Organosol or Polyester laquer - BPANIA						

(*)

reference to the relevant paragraph of the document "General Supply Specifications" of the closure

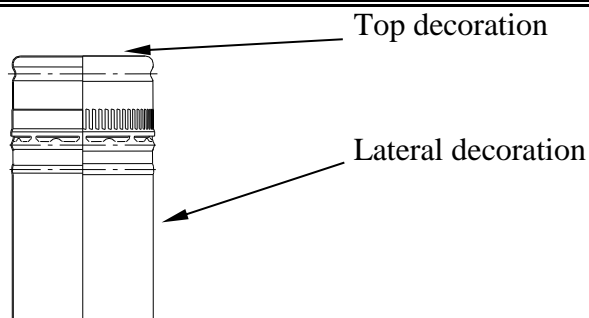
(*) : reference to the relevant paragraph of the document "General Supply Specifications" of the closure

Technical Specifications

Enclosure A.1 - Section 3: Personalisation

5.2

Aluminium colour, type of decoration and artwork



Note:

- 1) This drawing doesn't represent the final shape of the cap (Refer to the section 1)
- 2) Back-ground colour deviation: $\Delta E < 5$
- 3) Admissible radial out of centre for the graphic on the top: less than 1 mm

5.8

Enclosure A.1 - Section 4: Capping Systems

Here indicated values are Guala Closures' recommendations that must be verified and confirmed by the Client. The Client should adjust capping m/c settings to produce a satisfactory application whilst avoiding leakage.

Vertical Head load		130 ÷ 150 Kg
Pressure block	Diameter / profile	31,80mm / 6° or 12°
	Reform depth	Not Aplicable
Thread rollers	Radius	0,80 mm
	Step	Not Aplicable
	Lateral pressure	8 ÷ 12 Kg
Thuck-under rollers	Radius	0,90 mm
	Step	1,35mm (maximum 1,50mm)
	Lateral pressure	8 ÷ 12 Kg

8

Enclosure A.1 - Section 5: Packing and Shipment

Packing & Shipment	Box	External dimensions	590x340x330 mm
		Number of pieces	1300
	Pallet	Pallet dimension	120x100 or 120x80 cm
		Number of cartons	6 x 4

Storage conditions

To avoid permanent deformations,our recomendation is not to put more than one pallet on top of another.
The pallets have to be stored in places free of contaminats, with relative humidity max 75% and temperature range from 4°C to 30°C.
It's racommended the application of FIFO Criteria
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

NOTE: this document is an extract of the General Supply Specifications which describes general characteristics, trial procedures and supply conditions relevant to the closure.

Guala Closures ensures the quality and food safety of the supplies through a Company Quality System developed and certified in accordance to ISO9001 and FSSC 22000 standard.

After 90 days from the delivery date, if no negative information are back, the batch is considered accepted by the Customer.

Prepared by: I.Resino Position: Quality Manager Date: 23rd April 2018

Customer's acknowledgement (signature): _____ Date: _____