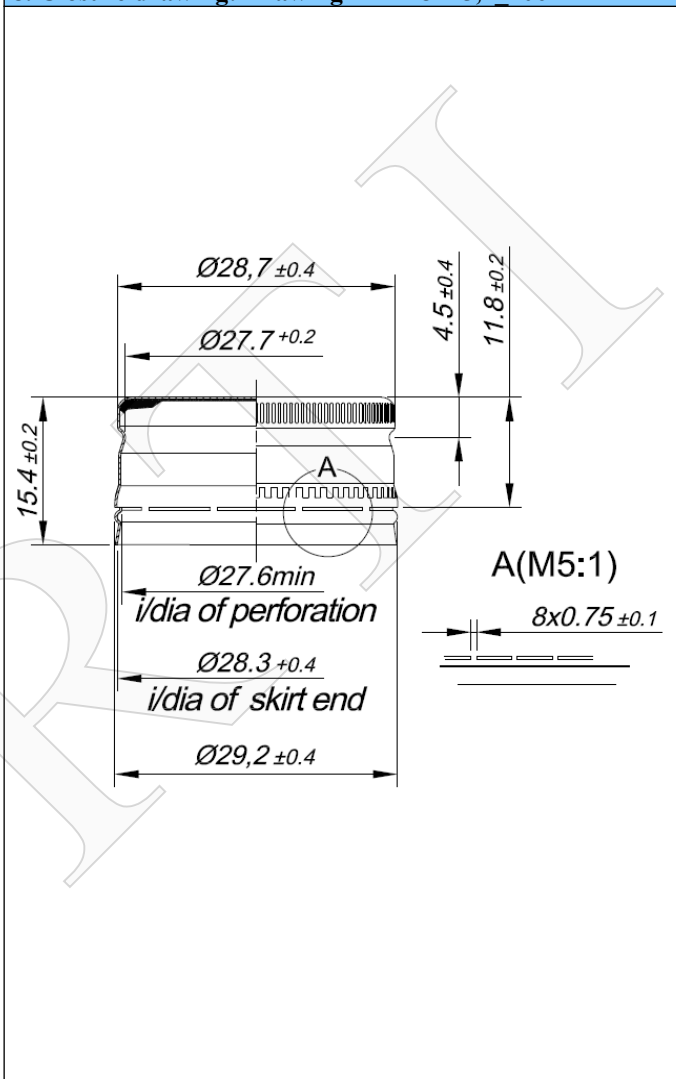


Product:	
<b>1. Shell material:</b>	
Al composition	EN AW-3105
Al condition	H16
Tensile strength R <sub>m</sub> , MPa	150-190
Elongation A50, %	≥ 3
Anisotropy, % max	≤ 2
Material thickness, mm	0,20±0,01
Note: Mechanical properties after a simulated solving treatment	
<b>2. Lacquers and inks</b>	
Internal lacquer type	Mod. vinyl
External lacquer type	Polyester/Mod. polyester
External inks type	Alkyd
<b>3. Liner – pvc sealing compound</b>	
Internal pressure	0,6 MPa
Max. mom. internal pressure	0,8 MPa
Filling goods: carbonated and non-carbonated soft drinks, fruit juices, mineral water. <u>Not suitable for ozonated water.</u>	
Pasteurization: approx. 20 min at 85°C	
Hot filling: approx. 95°C with cooling	
Sterilization: approx. 20 min at 121°C	
<b>4. Recommended application details (Glass) – for PET bottles adjust according to the bottle manufacturing specification:</b>	
Head pressure force, N	1900-2300
Thread roller pressure force, N	100-120
Undertuck roller pressure force, N	90-110
Note: These values are starting ones and can be varied according to the results to be achieved	
<b>5. Capping try dimension:</b>	
Depth of draw plunger, mm	2,60
Drawing diameter, mm	26,0
Pre-centering diameter, mm	28,4 <sup>+0,1</sup>
<b>6. Relevant bottle neck finishes:</b>	
<b>Type of bottle finish:</b>	<b>Rollers radius, mm</b>
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: MCA 2 CE.T.I.E. GME 32.00 and 28 bassa UNI 7564:1988 neck finishes are recommended for noncarbonated products	
<b>7. Opening torques (dry neck finish):</b>	
The torque needed to start the closure rotation (slip torque), Nm	0,70-1,80
Note: It is possible immediately after application the slip torque to be higher than the values indicated in this specification sheet. The specified values are reached one week after application.	
The torque needed to break the tamper evident band (break torque), Nm	0,70-1,30
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.	
<b>10. Storage and usage</b>	

**Pilfer-proof HSC 28×15,4**  
**8. Closure drawing: Drawing ID – 28×15,4 106**



Number of flutes/knurls	45±2
Weight, g	1,35±0,04

<b>9. Packaging specification:</b>	
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 <sup>+6</sup>
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.

