

**VinPerfect Inc.**

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## Specifications for the VinPerfect Closure System

<b>1. Product Description</b>	30x60 BVS Roll On Pilfer Proof Closure
<b>2. Application</b>	<p>Intended for wine bottle closures, non-carbonated beverages with and without alcohol.</p> <ul style="list-style-type: none"> <li>• Cold filling from +5 °C until +30 °C (41...86°F)</li> <li>• Minimum shelf life of 30 years with the VinPerfect “Medium” Liner if bottled at 30 PPM FSO<sub>2</sub> and minimal at-bottling oxygen pickup</li> </ul>
<b>3. Mechanical Properties</b> 3.1 Dimension and Tolerances  3.2 Weight 3.3 Standard Value for Torque (dry neck finish)  3.4 Recommendations for Capping Machine Setting   3.6 Internal Pressure Rating	<ul style="list-style-type: none"> <li>• Closure dimension: 30x60 mm</li> <li>• For use on neck finish according to CE.T.I.E. GME 30.13-02/07 Type 30H 5.6 ±0.6 g</li> <li>• Head load: 350-450 lbs</li> <li>• Thread rollers: 20-24 lbs</li> <li>• Pilfer rollers: 18-22 lbs</li> <li>• Tuck Under Groove Depth 1.5 - 2 mm</li> <li>• Open torque after sealing: 15 - 25 in-lbs (Small increase possible after 3 days)</li> <li>• Over-torque: 2 in-lbs higher than respective open torque</li> <li>• Reform block diameter: 27.6 mm</li> <li>• Reform depth: 1.2 – 1.6 mm</li> <li>• Thread roller nose radius: 0.75 - 0.90 mm</li> <li>• Tuck under roller nose radius: 0.75 - 0.90 mm</li> <li>• Angle of tuck under roller: 15°-20° or 90°</li> <li>• Suitable for sealing bottles with internal pressure &lt; 4 bar (&lt;58 PSI)</li> </ul>
<b>4. Application Instructions</b>	<p>Roll-on closures are partially formed during the application process; therefore we cannot guarantee every parameter. Above-mentioned ranges are laboratory confirmed values shortly after sealing and should be used as recommended values only. We do not take responsibility for application defects, since we cannot verify our standard settings are followed during bottling. The values depend on machine properties, settings and supplier recommendations/instructions, glass bottles, as wells as print and lacquer structure. Therefore it is crucial for the bottler to perform test runs to check open torques and leak tightness before every bottling, particularly prior to bottling of initial deliveries.</p> <p><b>NOTE:</b> <i>VinPerfect Liners use a higher quality, high-density foam that is harder to compress than other liners. This may require you to change (lower) the height of your tuck-under and thread rollers so that they make contact with the bottle at the appropriate location. Please check during setup.</i></p>

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	<ul style="list-style-type: none"> <li>• Closure, beverage and ambient temperature: +5 to +30°C (41 to 86°F)</li> <li>• Upright storage of sealed bottle at least 10 minutes</li> <li>• Storage temperature after sealing +5 to +35°C (41 to 95°F)</li> <li>• Filling level: <i>ratio headspace/ fill volume</i> should be 2% at 20°C (68°F), in case of temperature deviation to be corrected respectively, e.g. lower filling level at lower beverage temperature</li> <li>• Use of new glass material recommended for optimal operation</li> <li>• Neck finish must be free of cracks and damages (e.g. burrs and “orange peel” texture etc.), which prevent correctly sealing</li> <li>• Concentric application of the cap to the bottle is absolutely necessary</li> <li>• Appropriate rolled on thread is crucial for optimal function</li> <li>• Thermal and chemical treatments in connection with screw caps must be checked sufficiently and need to be approved before processing explicit.</li> <li>• Capped bottles should not be allowed to clash together or have the closure dented in any way. Failure to do these points results in refusing any guaranty claims.</li> </ul>
<b>5. Screwcap Storage</b>	<ul style="list-style-type: none"> <li>• Odorless, dry and UV- protected in closed cardboard boxes at constant storage temperature: +5 to +35°C (41 to 95°F);</li> <li>• Recommended storage temperature 48 hours before processing: 20 +/- 5°C (68 +/- 9°F)</li> </ul>
<b>6. Durability</b>	<ul style="list-style-type: none"> <li>• 10 years from closure manufacturing date.</li> <li>• After 10 years, bottles should be kept inverted to maintain liner pressure.</li> </ul>
<b>7. Materials</b> 7.1. Liner (VPL-30)	<ul style="list-style-type: none"> <li>• Four layer laminated liner containing listed materials in the subsequent order: a high-density pharmaceutical grade elastomer, PET, an aluminum deposition, PET. The last layer of PET provides food-grade contact surface.</li> <li>• Thickness approx. 23 mm</li> <li>• The sealing material used is conforming to the FDA US Code of Federal Regulations (CFR 21, § 177.1210c).</li> </ul>

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<p>7.2. Varnishes and Printing Inks</p> <p>7.3. Inside Lacquer (Adhesive Lacquer/Organosol) and Outside Lacquer</p> <p>7.4. Printing Inks</p> <p>7.5 Aluminum</p>	<ul style="list-style-type: none"> <li>• Thermally hardened (200° C) polyester-phenol resin combination</li> <li>• Visual overlaps are possible on side printed closures with certain print structures</li> <li>• Organosols, slightly golden-colored with slip additives or polyester resin combination in organic solvents</li> <li>• Wet offset printing ink based on alkyd, without heavy metals</li> <li>• UV- varnishes possible at side printed closures</li> <li>• The inside lacquer used meets the requirements of § 175.300 of US FDA Regulations.</li> <li>• Made of aluminum sheets according to EN 541 and DIN EN 573-3</li> </ul>
<p><b>8. Product Identification and Traceability</b></p>	<p>All products are labeled including following items: liner type, screw cap type (e.g. 30x60), color, graphic used, quantity per carton, production lot number, order number, count of boxes per order.</p> <p>These items must be quoted in any kind of customer inquiries to guarantee the traceability.</p>
<p><b>9. Packaging</b></p>	<p>Closures are packaged loosely in cardboard boxes with transparent plastic bags. When packaged on pallets, they are stacked up to 5 layers of 5 boxes per layer, with 1000 pieces per box, or a full pallet of 25,000 units. The cardboard is a single-wall 44 ECT (Minimum Edge Crush Test at 44 lbs per square inch) that delivers a 275 lbs burst test rating (275 lbs per square inch required to rupture or burst the side of the cardboard box).</p>
<p><b>10. Product Number</b></p>	<p><b>L-05SBLK-M</b>(as an example)</p> <ul style="list-style-type: none"> <li>- L = Denotes Type of Cap (Laser, Embossed, Undecorated, Printed)</li> <li>- 05 = VinPerfect Reference to Producer of Screwcap</li> <li>- SBLK = VinPerfect reference to color (will differ based on color choice)</li> <li>- M = Reference to oxygen transmission specification (M, M+, L, SNX, SNT)</li> </ul>
<p><b>11. Quantity</b></p>	<p>The box content is checked electronically and is packed within positive tolerance. Each box contains 1004 units and all boxes are kept on a box-per-box liner process, so every 1004 caps is lined and kept separate from each other.</p>
<p><b>12. Conformity</b></p>	<ul style="list-style-type: none"> <li>• Our closures conform to the respective requirements outlined above.</li> <li>• We reserve the right to modify specifications for the purpose of technical progress and inform our costumers about respective changes regarding processing our closures. The latest issue of specification is valid only (see date below).</li> </ul>