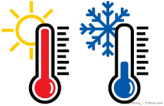


Processing Instructions G-Cap® Screw Caps (BVS)



1	Storage in general 	Odorless, dry, UV-protected when stored in a sealed carton at temperatures ranging from +5° to +35° C. Keep in this condition 48 hours before processing at temperatures between +15° to +25° C.
2	Closures In general	Roll-on closures, are deformable sealing cylinders. Due to their nature, it is not possible to specify each parameter for processing with pinpoint accuracy. Only ranges of parameters can be provided. Therefore, it is necessary for the user to conduct short test runs before each filling, particularly with initial deliveries, to determine the appropriate opening torque and ensure the seal's tightness. These test runs allow the user to assess the performance and suitability of the roll-on closures for the specific application. They help ensure that the closures meet the desired standards of opening force and sealing effectiveness. Regular testing is recommended to maintain consistent quality and performance throughout the production process.
3	Bottles 	Use only new glass bottles that comply with the standards (DIN EN 16293 / CE.T.I.E GME 30.13) Before use, it is important to inspect the bottle neck for any damages or defects. Check for cracks, the degree of mouth finish, and the presence of an orange peel-like texture. These inspections ensure that the bottle neck is in good condition and will provide a proper seal with the closure. Using bottles with undamaged and properly finished necks is crucial for maintaining the integrity of the product and ensuring a secure and effective closure.
4	Bottling: before and after 	The recommended ambient temperature for the closure and the filling material is between +5° C and +30° C. It is important to maintain this temperature range to ensure proper sealing and integrity. To determine the appropriate fill level, refer to the bottle manufacturer's data sheet. The fill level may be indicated at the rim or the bottom of the bottle. For example, at 20° C, the fill level should be adjusted accordingly. Before sealing, verify that the closure head meets the supplier's specifications as stated in their data sheet. Ensure that the sealing gasket or disc is correctly inserted. After sealing, perform visual and mechanical inspections to ensure quality. Check the sealing depth, thread, and crimping for proper alignment and absence of any visual damage. The closure should be centered, with a slight ease of opening and a light indentation on the mouth of the bottle. Repeat these inspections every 30 minutes. After sealing, allow the bottles to stand upright for at least 10 minutes. This resting period helps ensure proper sealing and allows any pressure inside the bottle to stabilize.
5	Storage 	Filling material: +5°C bis +35°C Closures: Re-seal partially opened packages tightly.