

Screwcap Application Settings

For BVS Standard EN16293

For 0.23mm Gauge 8011 ALLOY 30x60 SCREWCAPS

TORQUE VALUES FOR OPENING CLOSURES ON DRY GLASS BVS FINISH

Vcap External Diameter mm	Radius of Tuck Roller	Radius of Threading Roller	SLIP Torque Values in Lbs x inches	BREAK Torque Values in Lbs x inches
29.80	Min. 0.75mm Max. 0.90mm	0.75mm	9 – 25	8 – 20

*These are indicative values for closures applied on dry glass threads.

The amount of compression ('bite down') of the liner-seal on to the bottle rim's sealing surface, can contribute to the amount of force required to initially release /slide the applied closure (slip torque). The capping head pressure load should be in the vicinity of 150 to 180kg, with the pressure block shimmed to allow for 1.5 to 1.7mm redraw depth (top-shaping) of the cap.

The torque range for the initial release (slip torque) are to be expected between 9-20lbs x inches, however this value can be as high as 25lbs x inches, due to differences in cap, cap application or nuances of bottle specifications. The force required to break the closures' bridges can range from 8 – 20lbs x inches, but this will generally be between 12 to 18lbs x inches (this can be as high as 28lbs x inches, due to deviations in cap bridge widths or bottle specifications).

The principal contributor to the break torque force is the width variability of the caps' 8 bridges.

CAPPING HEAD ROLLER ARM PRESSURE SETTING GUIDE

Values are based on head in working position (on bottle)

Roller Arm for:	Vcap 2020		Stelvin* 2020		Guala* 2019
Threading	7.5 – 13kg	9 to 10 kg (expected)	7 – 14kg	11 to 11.5kg (expected)	9kg ±2kg
Seaming	6.5 – 12kg	8.0 to 8.5kg (expected)	7 – 14kg	9 to 9.5kg (expected)	7.5kg -2.5kg/+4.5kg

These are guiding values – only to be used as a start point 'setting' for operators. Particularly for the seaming roller arms, the side pressure amount depends on; the roller radius and the angle at which the roller arms are positioned to contact /profile the caps' alloy. Machine operators will need to adjust seaming (tuck) roller pressures to suit individual requirements.

* The above information is a guide and is subject to change. Contact your cap supplier to verify their latest recommended roller arm application pressures. Be willing to try other roller arm pressure settings best suited to achieve the highest performing results for the batch of bottles or caps in use.

Sealing — Phases of Vcap application on BVS mouth finishes

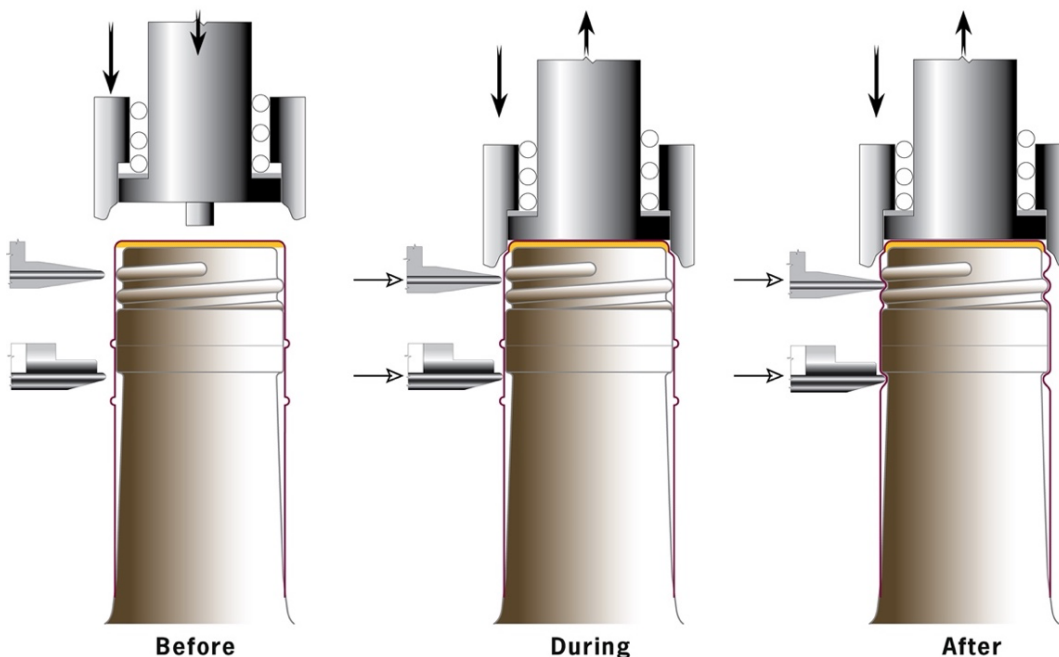


Illustration of BVS mouth finish with top shaping (re-draw)