

TS-16-01.2012	 TECHNICAL SPECIFICATION METAL CLOSURES TWIST OFF 82mm	
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Version: 06		

Twist-Off (TO) belong to the group of metal vacuum closures, which form a hermetical seal on a suitable jar container immediately after the capping process.

1. DEFINITION

This specification is applied to metal lug closures type TO designed to close standard glass jars diameter 82mm, with PVC inner sealing ring (plastisol) to provide vacuum. There are 6 lugs formed into a closure curl. Vacuum provided by inner PVC ring, which creates sealing during the thermal process.

Temperature Resistance: pasteurization (max 105° C/60 minutes), sterilization (121° C/60min, optional 131° C/60 min). Information- on box label.

Profiles:

- RTS (Regular Twist off with step- shape of the groove)
- RSB (Regular Twist off with a vacuum click button)

2. TECHNICAL DATA

2.1. Metal specification:

• Standard EN 10202:2011 –Cold reduced tin-mill products. Electrolytic tinplate and electrolytic chromium/chromium oxide coated steel.
• Thickness: 0,16-0,17 mm; Temper/Annealing: TH 580-620; DR (double reduced); Tin coating upside/downside (gr/m ²) standard 2.8/2.8;
• Closures comply with legislation CEE directive 94/ 62/ CE - in relation to heavy metal contents.

2.2. Chemical composition of tinplate (in %), for TH 620, (tolerance 1% is acceptable) - Table 1:

C	Si	Mn	Ni	Cr	P	S	Al	Cu	Fe
Max 0.08	Max 0.03	Max 0.35	Max 0.08	Max 0.08	Max 0.02	Max 0.02	Max 0.08	Max 0.08	The rest to 100%

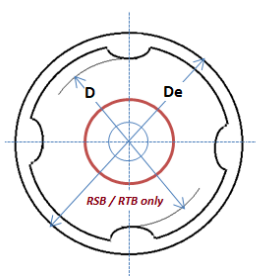
2.3. Coating/Varnishing by Commission Regulation (EC) No. 1895/2005 for restriction of usage of certain epoxy derivatives in materials and articles intended to come into contact with food (Fig.1).

- **External protection (Top):** Size coat (polyester): Gold, Clear, colored enamels in combination with Polyester transparent overprint varnishing, for stable, flexible and resistible external protection, compatible with conventional and UV inks;
- **Internal protection (Reverse):** System of anticorrosion primer size and adhesive varnish (organozol, BPA NI); food grade;

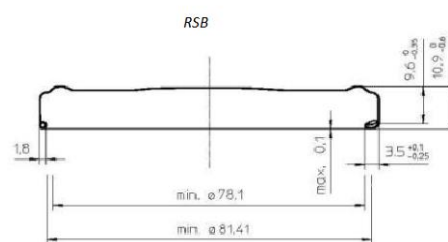
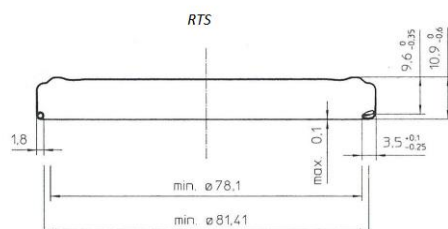
2.4. Sealing ring: PVC compound (plastisol) by EU Regulation No 10/2011- for plastic materials intended to come into contact with food (fig.2).

3. SHAPE, SIZE, TECHNICAL DATA, PACKING

Fig. 3



Cap diam (mm)	mm					Average weight (g/cap)	Lugs	Cap Composition(%)			Packing					
	H (finished cap height)	D (internal diameter between lugs)	De (external diam)	Lw Lug (width)	Lug (height)				Metal	Coating	PVC gasket	Pcs /box	Boxes /pall	Box size	Gross kg /box	Pall size EURO
Φ82 <i>(RTS/RSB)</i>	10.30- 10.90	78.10- 78.60	85.14 +0.05	3.20- 3.65	9.30- 9.70	12.5 +0.5	6	88	2	10	700	36	40x40x 40	11	80/120/ 260	410



4. STORAGE CONDITION: T=+5 / +35° C, relative humidity below 80%, 36 months from production date;
5. DECLARATION OF CONFORMITY: TO 82 closures meet Regulation (EC) No. 1935/2004 of European Parliament and Council for materials and articles intended to come into contact with food. Closures are made by technology for manufacturing of food products packaging. All materials applied in production are EU origin.