

Closure/Tapón: 8190 NR

Id.: STF-8190 NR

Date/Fecha: 27/3/2012

Page/Página: 1-2

Technical Specifications / Especificaciones Técnicas

Closure/Tapón: 8190 NR BANDA ANCHA

Customer/Cliente:

Product/Producto:

Customer Product Code /
Código del producto del Cliente

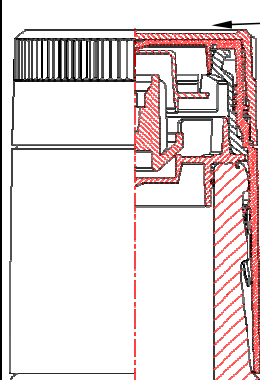
GUALA Product Code /
Código del producto GUALA

| Enclosure/ Anexo A.1 - Section/ Sección 1: Characteristics/ Características | | | | |
|--|---|-------------------|---|-------------------------------|
| § Ref.(*) | Dimensions/Dimensiones | Units Unidades | Ref. Values Valores de Ref. | Guala Drawing Dibujo Guala |
| 5.1 | Max. Ø internal (not include ovalization) Máx. Ø interno (sin ovalización) | mm | 37.40 ± 0.5 | DC-188 |
| 5.1 | Max. Ø external top (not include ovalization) Máx. Ø externo de la cabeza (sin ovalización) | mm | 38.80± 0.5 | DC-188 |
| 5.1 | Max. Height of the closure Altura del tapón | mm | 58.90 ± 0.8 | DC-188 |
| 5.1 | Bore Diameter Diámetro interior de la botella | mm | 25.0 ± 0.3 | E-292 |
| 5.1 | Type of neck finish Tipo de corona | -- | 1040 | E-292 |
| Functionalitý (The torque & application details are guidelines only. The customer should adjust capping machine to produce a satisfactory application whilst avoiding product damage) Funcionalidad (Detalles de torque y aplicación son guías. El cliente debe ajustar la máquina de taponado para obtener una aplicación satisfactoria evitando el goteo del producto) | | Unit Unidades | Ref. Values / Notes Valores de Ref. / Notas | |
| 5.4 | Empty head space of the bottle (compulsory) Cámara de Vacío de la botella (obligatorio) | cm³ | 3% | |
| 5.8 | Capping Head Force Carga de Taponado en la Cabeza | - | See section / Ver sección 4 | |
| 5.7 | Resistance to static force on the head Resistencia a fuerza estática en la cabeza | kg | 60 | |
| 5.5 | Opening Torque (referred to dry glass bottles) Máx. Torque de Apertura (referido a Botellas secas) | Lbs / in | 8 - 36 | |
| (*) 5% of the values could be above within a max of 20% of 30 lb/in. After 24 hours of capping the opening torque could be low as 10%. (*) 5% de los valores pueden estar arriba en un máximo de 20% de 36 lb/in. Después de 24 hrs de taponado el torque puede disminuir en 10%. | | | | |
| 5.6 | Tamper Evident Behaviour Comportamiento del Tamper Evident | - | Breakage of the Bridges Ruptura de los puentes/cintillo | |
| 5.3 | Pouring Rate (with hidroalcoholic solution ,1 litre) Tiempo de Vertido (con solución hidroalcohólica, 1 litro) | s / l | 70 ± 10 | |
| Enclosure/ Anexo A.1 - Section/ Sección 2: Components List/ Lista de Componentes | | | | |
| 4 | Closure Components | Raw Materials | Colour /Characteristics | Color |
| 5.2 | Componentes del Tapón | Materias Primas | / Características | |
| 1 | Overcap / Sobretapa | HDPE | According with the customer requirements De acuerdo a los requerimientos del cliente | |
| 2 | Tube / Tapatubo | PP Copolímero | According with the customer requirements De acuerdo a los requerimientos del cliente | |
| 3 | Pourer / Vertedero | PS | Colorless / Incoloro | |
| 4 | Valve / Válvula | PP Homopolímero | Colorless / Incoloro | |
| 5 | Washer / Empaque | LDPE | Colorless / Incoloro | |
| 6 | | | | |
| 7 | | | | |
| 8 | | | | |
| 9 | | | | |
| Aluminum Shell - Casquillo Aluminio; Liner - Linner; Overcap - Sobretapa; Cap - Tapa; Undercap - Bajotapa; Pourer - Vertedero; Valves - Válvulas; Balls - Canicas; Washer - Empaque; Skirt - Tubo; Tube - Tapatubo | | | | |
| Note: If the products are exposed to low temperatures during the transports, handling & storage, it is necessary to allow them to rest to the temperature of the area, before using them in the line of the one bottled, this to have the plastic temperature to not less than +18°C. Nota: Si los productos se exponen a bajas temperaturas durante los transportes, manejo y almacenamiento, es necesario dejarlos reposar a la temperatura del área, antes de usarlos en la línea de embotellado, esto para tener la temperatura plástica a no menos de +18°C. | | | | |
| (*): reference to the relevant paragraph of the general document "Supply Technical Specifications" of the closure (*): referencias de los párrafos correspondientes del documento general "Especificación Técnica de Suministro" del tapón | | | | |

Technical Specifications / Especificaciones Técnicas

Enclosure /Anexo A.1 - Section/Sección 3: Personalization/Decorado

5.2 Colours/Colores, Type of Decoration/Tipo de decoración, Artwork/Artes



Top Decoration / Grabado Superior

According with the customer requirements
De acuerdo a los requerimientos del cliente

Side Decoration / Decoración lateral:

Colour / Color

According with the customer requirements
De acuerdo a los requerimientos del cliente

5.8 Enclosure /Anexo A.1 - Section/Sección 4: Feeding & Capping /Alimentación y Taponado

| | | | |
|--|---|--|---|
| Feeding System Sistema de Alimentación | Centrifugal Bowl Alimentador centrífugo | pcs/hr pzs/h: | Ref.. |
| | Pick-up Head Acceleration Aceleración del cabezal | pcs/hr pzs/h: | Ref.. |
| | Star with pick and place Comienzo de toma y posiciona | pcs/hr pzs/h: | Ref.: DC-51 |
| Capping System Sistema de Taponado | Capping Head Cabezal de Taponado | pcs/hr pzs/h: | Ref.: DC-52B |
| | Capping Load Carga Cabezal de Taponado | Head Pressure Carga en la cabeza: 80 Kg \pm 10 % | |
| | 2 thread rollers 2 carretillas cuerda | Radius: Radio: N/A | Side Pressure: Presión Lateral: N/A |
| | 2 skirt rollers 2 carretillas cuerpo | Radius: Radio: N/A | Side Pressure: Presión Lateral: N/A |

8 Enclosure /Anexo A.1 - Section/Sección 5: Packing & Shipment /Empaque y Envío

| | | | |
|--|--|--|-----------------------|
| Packing & Shipment Empaque y Envío | Cardboard Box Caja de Cartón | External Dimensions: Dimensiones externas: | 59.8 X 39.4 X 33.4 cm |
| | | Quantity of pieces: Número de Piezas: | 600 |
| | | Gross Weight: Peso bruto: | ~ 13.10 Kg |
| | Pallet | Pallet Dimension: Dimensión del Pallet: | 100 X 120 cm |
| | | Boxes' Quantity: Número de Cajas: | 25 |
| | | Gross Weight: Peso Bruto: | ~ 347.5 Kg |

Note: This document is an extract of the Technical Specification of Supply that describes the general characteristics, test procedures and pertinent supply conditions to the closures. Guala Closures ensures the quantity of the quality of the supplies through a Company Quality System developed and certified in accordance to the norm ISO9001:2008. After 90 days of the delivery date, if no negative information is received, the lot is considered accepted by the customer.

Nota: Este documento es un extracto de la Especificación Técnica de Suministro que describe las características generales, procedimientos de prueba y condiciones de suministro pertinentes de la tapa. Guala Closures asegura la calidad de los suministros a través del Sistema de Calidad de la compañía desarrollado y certificado de acuerdo con la norma ISO 9001:2008. Después de 90 días de la fecha de entrega, si ninguna información negativa es recibida, el lote se considera aceptado por el cliente.

Prepared by:

Preparada por: Rafael Ramírez

Reviewed by:

Revisado por: Leopoldo Florido

Date:

Fecha: 27/03/2012

Customer Acknowledgement (signature):

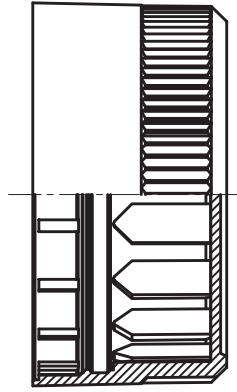
Aprobación y recibido del Cliente (firma):

Date:

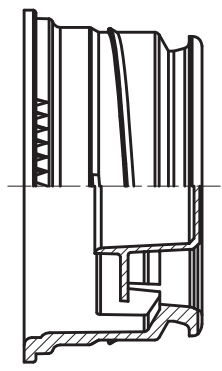
Fecha:

ANEXO 2

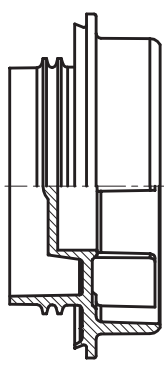
1 OVERCAP
SOBRETAPA 8101



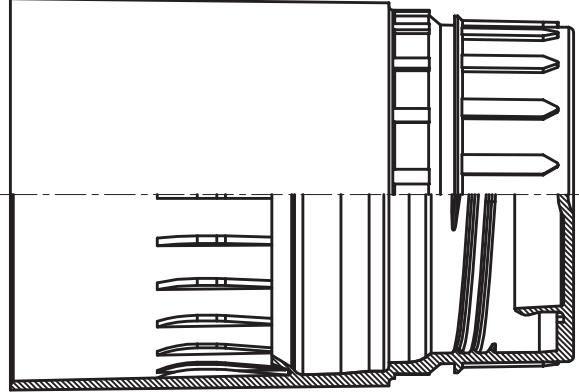
3 POURER
VERTEDERO 8142



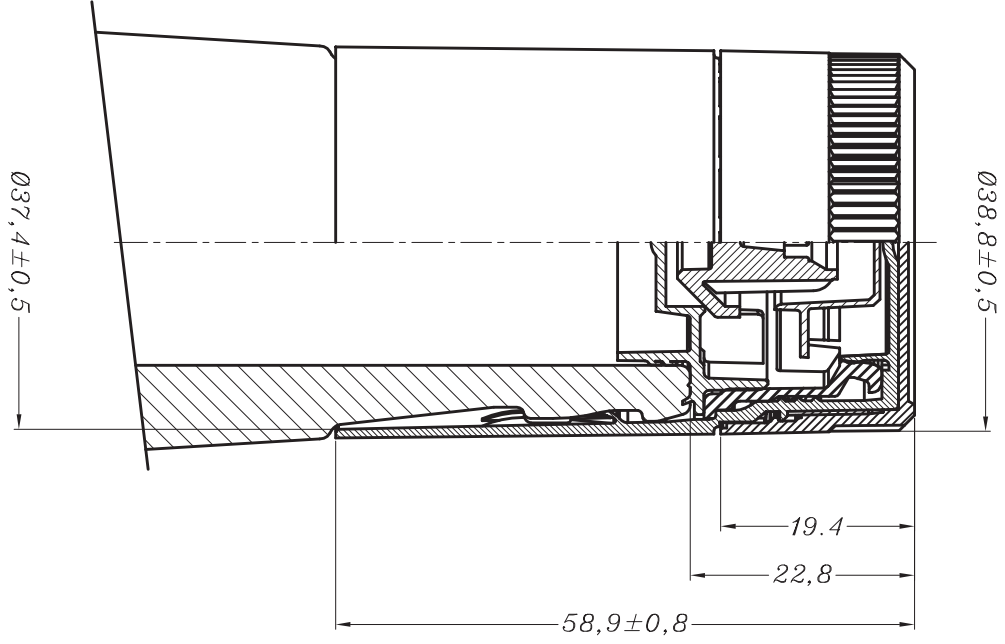
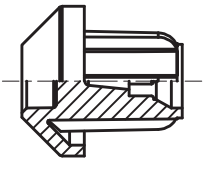
4 WASHER
EMPAQUE 8103



2 TUBE
TAPATUBO 8195



5 VALVE
VALVULA 5104



Ø37,4±0,5

| | | | |
|---|--------------|------------------------|--|
| MATERIALE | GRUPPO | DIBUJOS COMERCIALES | DATA |
| RITIRO | | | DATE |
| SHRINKAGE | | | SCALE |
| DUREZZA | MODELLO CH. | TAPON 8190 BANDA ANCHA | 2:1 |
| HARDNESS | CLOSURE MOD. | | |
| QUANTITA | PARTICOLARE | DETALLE DE COMPONENTES | |
| TREATMENT | | | |
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| | | | Tolleranze generali salvo altre indicazioni General tolerance unless noted |
| | | DC-188 | ISO 17° 13 |
| | | ARCH. | angolo angulo ±20° |
| | | DISCEN. R. Ramirez | |

| | | | | |
|----------------------|---|------------|------------|--------------------|
| SEGUNDA | Se estandarizan los puntos de medición con los modelos de tapones Guala | 08-03-2011 | 29-03-2012 | R. Ramirez |
| PRIMERA MODIFICACION | Pasar a formato Guala | 12/10/2005 | 18/05/2011 | R. Ramirez |
| MODIFICA MODIFIED | DETTAGLIO DETAIL | ERA WAS | DATA DATE | DISEGNATORE DRAWER |

* A DISCREZIONE DELLA VETTERIA
* TO THE CHOICE OF THE GLASS MANUFACTURER

Ø36.7±0.3
Ø36.4±0.3
Ø35.8±0.3
Ø34.6±0.3
Ø34.2±0.4
Ø25±0.3

GIUNZIONE COLLARINO
TOP RING SEAM

1.5 MAX

TRATTO ESENTE DA OGNI
SCABROSITA' AI FINI
DELLA TENUTA
SECTION HIGHLIGHTED IN
DARK TO BE PERFECTLY
SMOOTH FREE FROM
DEFORMATION AND
CYLINDRICAL TO
ENSURE PERFECT
SEAL

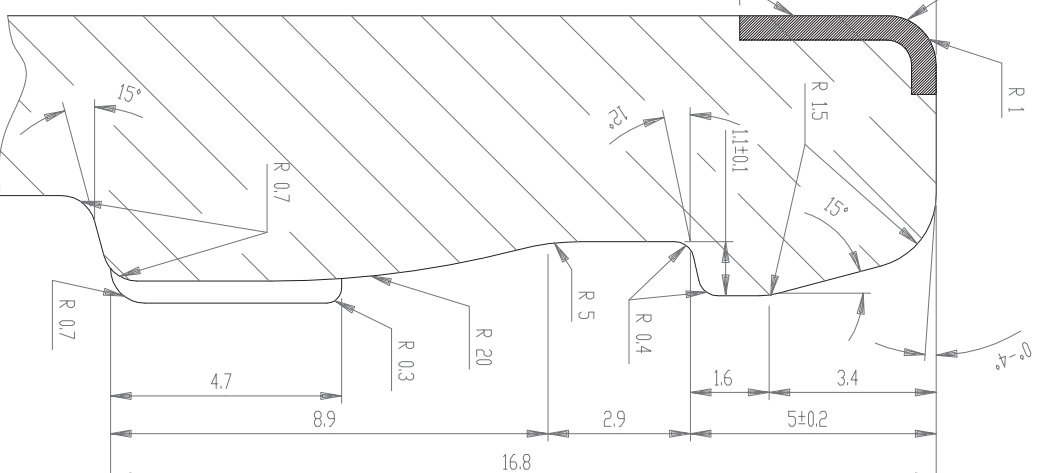
N°8 TACCHE ANTIROTAZIONE
8 ANTIROTATION LUGS

Ø A DISCREZIONE VETTERIA
Ø TO THE CHOICE OF
GLASS MANUFACTURER

SPIGOLI ARROTONDATI
TO BE ROUNDED

PROFILO NON IDONEO
WRONG PROFILE

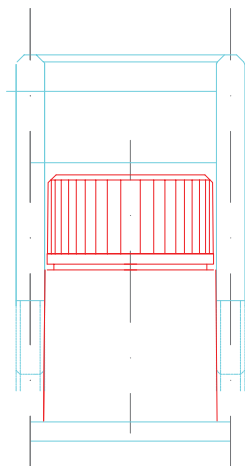
PROFILO IDONEO
SUITABLE PROFILE



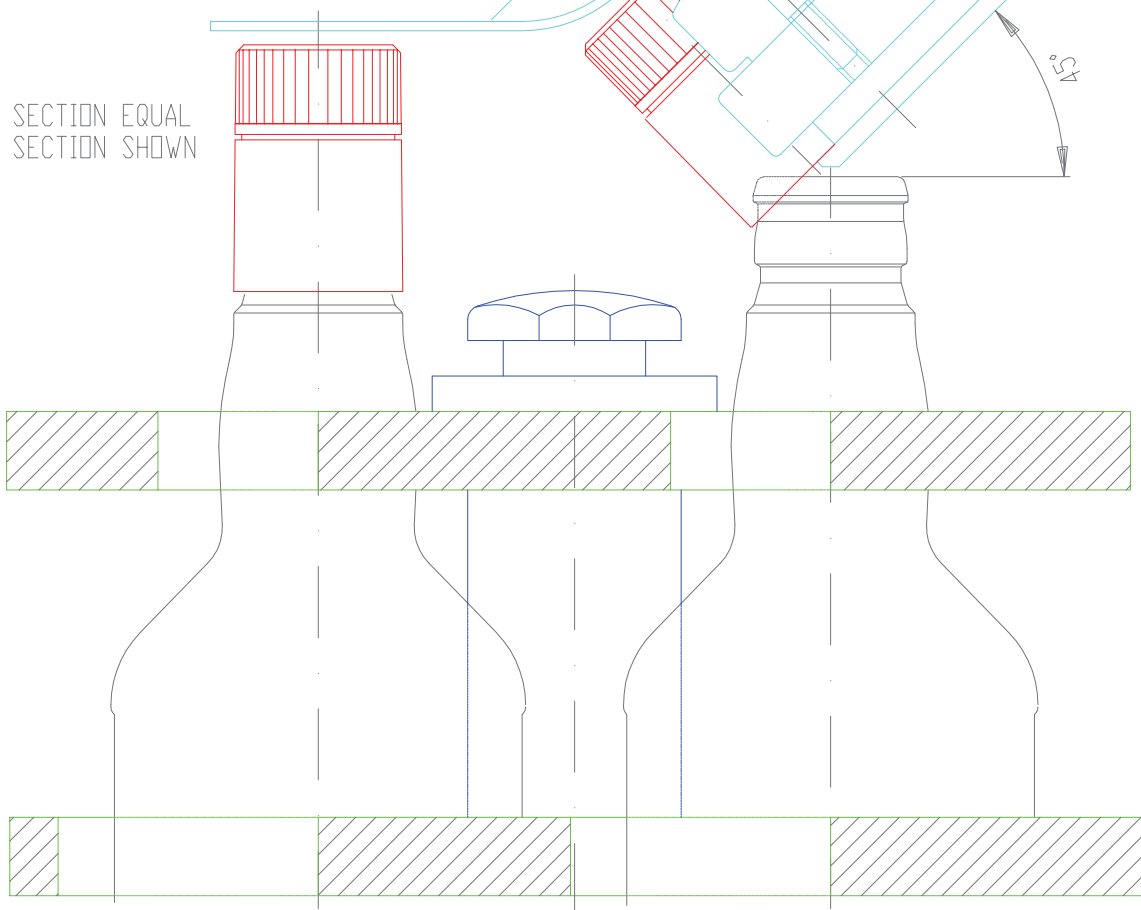
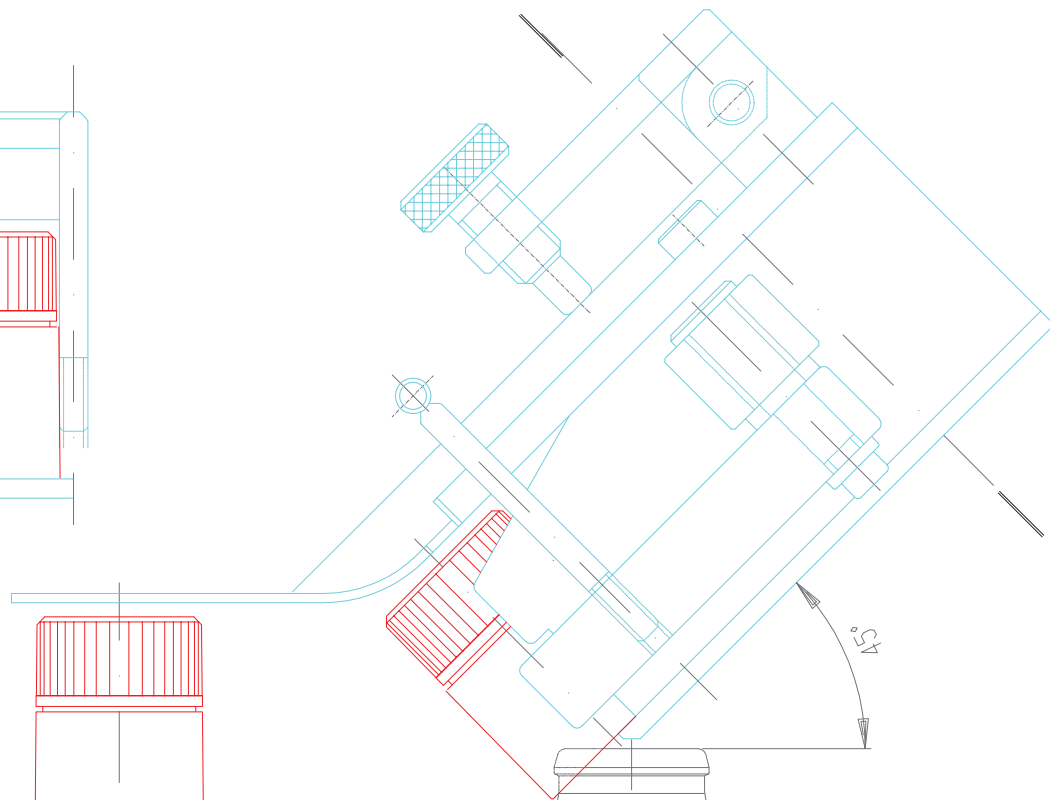
| | | |
|-----------|----------------------------|---|
| MATERIALE | GRUPPO | DATA |
| TRATTO | GRUPPO | DATE |
| SHRINKAGE | | SCALE 10:1 5:1 |
| DUREZZA | MODELLO CH. | |
| HARDNESS | CLOSURE MOD. | |
| QUANTITA' | 1040 closure | |
| QUANTITY | | |
| TREATMENT | PARTICOLARE | |
| | Imboccatura Neck finish | |
| | |  |

| | | |
|---|--|--|
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| Gualaclosures | | |
| A3 | | |
| DISCEN DRAWN | | |
| Baricchi | | |

Anexo 4



* CHUTE SECTION EQUAL TO HEAD SECTION SHOWN ABOVE



MATERIALE
MATERIAL

RITIRO
SHRINKAGE

DUREZZA
HARDNESS

QUANTITA'
QUANTITY

TRATTAMENTO
TREATMENT

GRUPPO
GROUP

DIBUJOS COMERCIALES

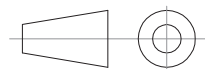
MODELLO CH.
CLOSURE MOD.

PARTICOLARE
DETAIL

DISPENSING HEAD STD. AND T.E. CLOSURE

DATA
DATE 04-07-2007

SCALA
SCALE



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GualaClosures Group

Tolleranze generali salvo altre indicazioni
General allowance unless noted.

ISO IT 13

angolo
angle $\pm 20^\circ$

DIS.
N.° DC-51

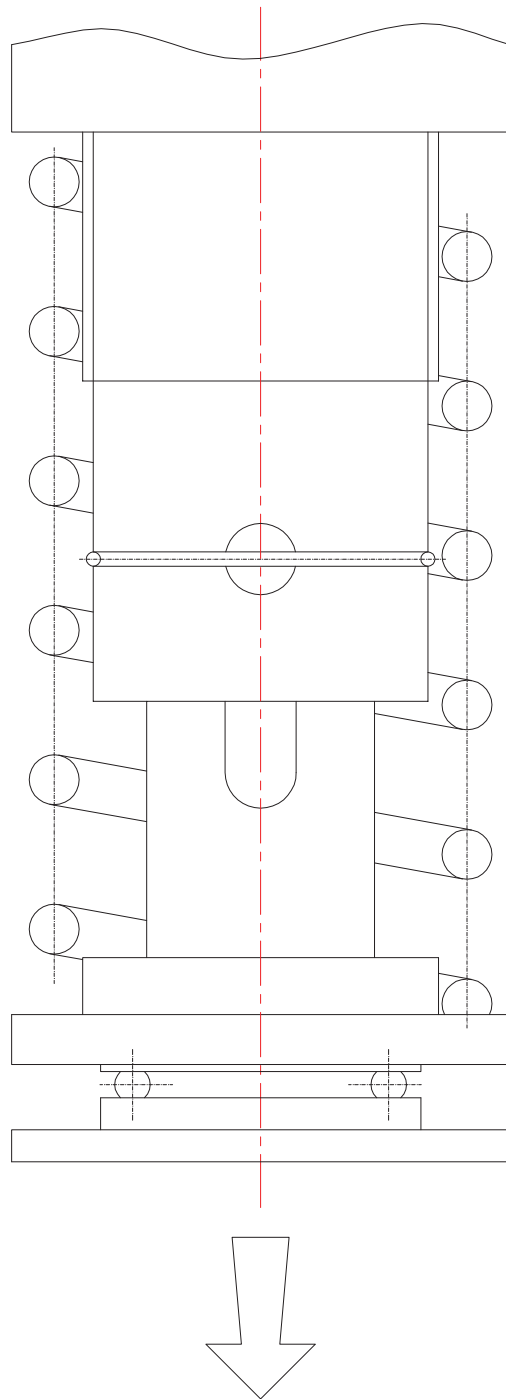
POS.
ARCH.

A4

DISEGN.
DRAWN.

R. Ramírez

Anexo 4



KG. 60±10%

| | | | | | |
|--|-----------------------------|--|---|-------------------|-----------------------------------|
| MATERIALE MATERIAL | GRUPPO GROUP | DIBUJOS COMERCIALES | DATA DATE | 29-03-2012 | |
| RITIRO SHRINKAGE | | | SCALA SCALE | | |
| DUREZZA HARDNESS | MODELLO CH. CLOSURE MOD. | |  | | |
| QUANTITA' QUANTITY | | | | | |
| TRATTAMENTO TREATMENT | PARTICOLARE DETAIL | INDICATIVE SKETCH FOR PRESSURE HEAD | | | |
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| | | | DIS. N.° | DC-52B | Ind. mod. N. Mod. |
| | | | A4 | DISEGN. DRAWN. | R. Ramirez |