

Product: **ALPLA HL-28**

Shell Material (Aluminium part)

Al Composition	EN AW-3105
Al Condition	TZ 13
Tensile strength Rm MPa	150 - 190
Elongation. A50, % min	≥ 3
Anisotropy, % max	≤ 2
Material Thickness, mm	0.20 ± 0,01

Lacquers and inks (aluminium part)

Internal lacquer type	Mod. Epoxy
External lacquer type	Mod. Polyester / Epoxyester
External ink type	Alkyd

Plastic Part

Plastic ring	High Density Polyethylene (HDPE)
--------------	---

Liner

Granulen HL sealing compound for sensitive mineral waters, CSD, wine, beer, lemonade and fruit juices.

Internal pressure:	0.6 Mpa
Max. mom. internal pressure:	0.8 Mpa

Recommended application details (Glass) - for PET bottles adjust according to the bottle manufacturers specification:

Head pressure force, N:	1900 - 2100*
Thread roller pressure force, N:	90 - 110

Note: These values are starting values and can be varied acc. to the results to be achieved
* For carbonated drinks the value must be at the upper limit.

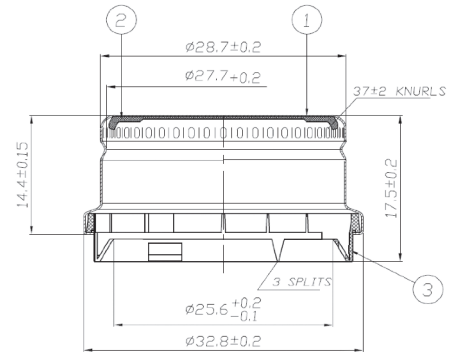
Capping tray dimensions

Dept of draw plunger, mm:	2.50
Drawing diameter, mm:	26.0

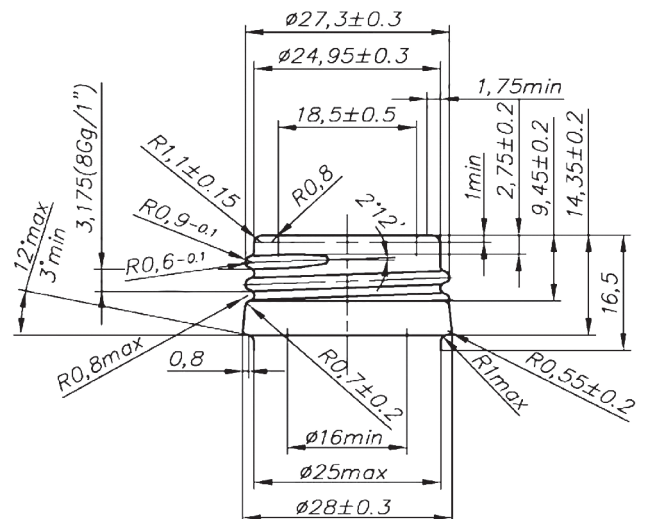
Opening torques (dry neck finish)

Opening torques, Nm:	0,35 - 1,70
----------------------	--------------------

Closure Drawing



Relevant Bottle Neck Drawing DIN 6094-8G



Food Contact Approval

All materials intended to come into contact with food are in conformity with the European Community directives, the relevant national regulations and the relevant FDA requirements. All products comply with Commission directive 94/62/EC concerning heavy metals.

All resins and additives used for inside lacquer production comply with the following Regulations:

- Commission directive 10/2011 relating to plastic materials and articles intended to come into contact with foodstuffs.
- FDA regulation; CFR 21, chapter 175.300 Resinous and polymeric coatings

User has to verify the closures suitability with the specific bottled product and to guarantee the absence of chemical and organoleptic alterations.

Packaging specification

Quantity, pcs.	4 600 pcs	Pallet type – Euro pallet	Dimension 1200 x 800 x*
Box Dimension (internal), mm	590 x 385 x 350 mm		* Height of the pallet may vary with customers' requirements
Cardboard Type	Corrugated five layer cardboard	Outside packing	Stretch wrapped
Polyethylene Sack	Polyethylene –non-toxic, antistatic <100 ppm Pb, Cd, HgCr⁺⁶	Pallet identification	Labelling
Adhesive Strip (Scotch)	50 mm		
Product Identification	Labelling		

Notes: Closures shall be stored in a well-ventilated place avoiding direct sunlight and strong odour for the period of 1 year.
Pallets shall not be stacked.