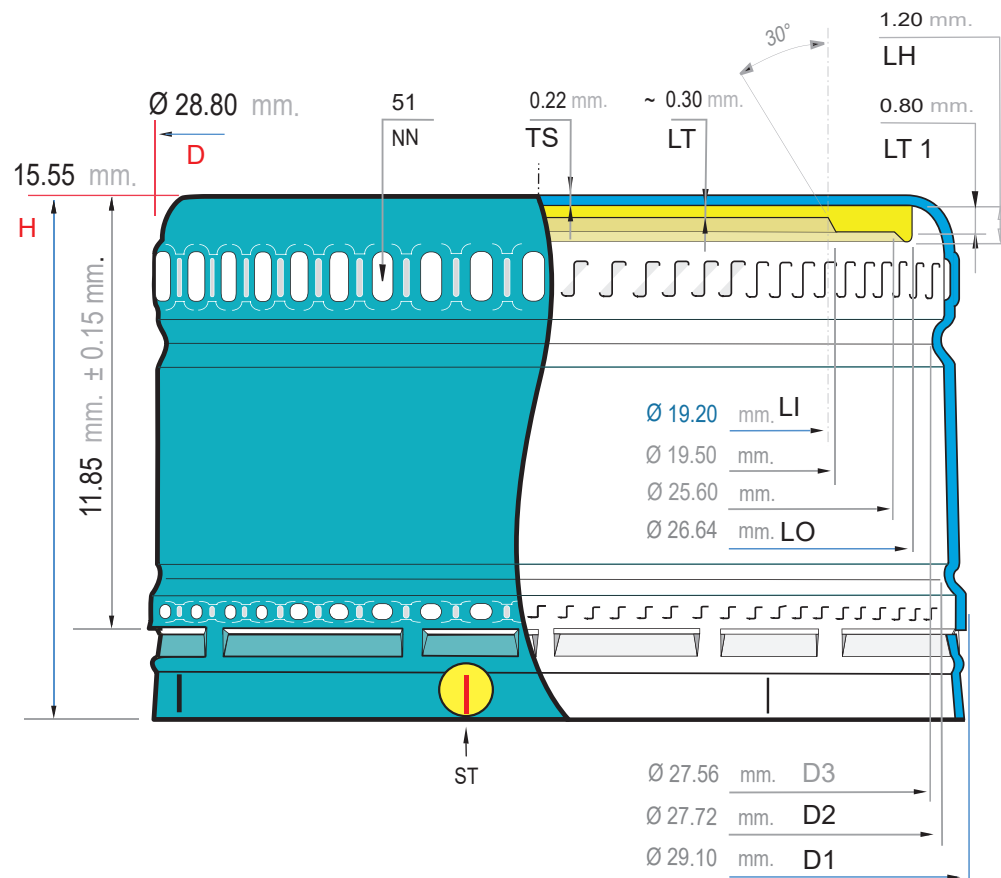


ALU Cap (R.O.P.P. / Roll On Pilfer Proof) Specification & Liner Profile

28.80 x 15.55 mm. Alu Cap R.O.P.P.



Auditor



Certificate



Certificate

Item	Feature	Specification	Tolerance
-	Shell Material Type & Temper.	Alloy 3105 - H 14	-
-	Caps Partial Weight.	1.210 g.	± 0.015 g.
TS	Thickness of Sheet.	0.220 mm.	± 0.005 mm.
H	Shell Height.	15.55 mm.	± 0.15 mm.
D	Shell Diameter Ø.	28.80 mm.	± 0.10 mm.
D1	Overall Diameter Ø.	29.10 mm.	± 0.15 mm.
D2	Inside (Brim) Diameter Ø.	27.72 mm.	± 0.05 mm.
NN	Number of Knurling.	51.	-
ST	Score Type (Security Seal) Slit.	5 Score. or No Score.	5S or NS.
-	Liner Type.	PVC Free.	-
LT	Liner Disc Thickness.	0.30 mm.	-
LT1	Liner Disc Thickness.	0.80 mm.	-
LH	Liner Sealing Ring Height.	1.20 mm.	-
LI	Liner Sealing Inside diameter Ø.	19.20 mm.	-
LO	Liner Sealing Outside diameter Ø.	26.64 mm.	-
-	Liner Weight.	0.275 g.	± 0.10 g.
-	Liner Profile Code.	928 Modify to 941.	-

Standard test data:

-	Pressure Test No Leakage at.	110 up to 150 psi.	-
-	Opening Torque Test.	4 up to 12 lps.	-
- ALU Caps ROPP. Use For Glass Bottle Neck Finish Type: MCA-1 & MCA-2 or Other			

Drawing by
ACM

Checked by
Ali.S.A

Updated by
Ali sayed

Approved by
Engr. M. AL-Amoudi

Date Year 1985

Update
4 / 4 / 2024



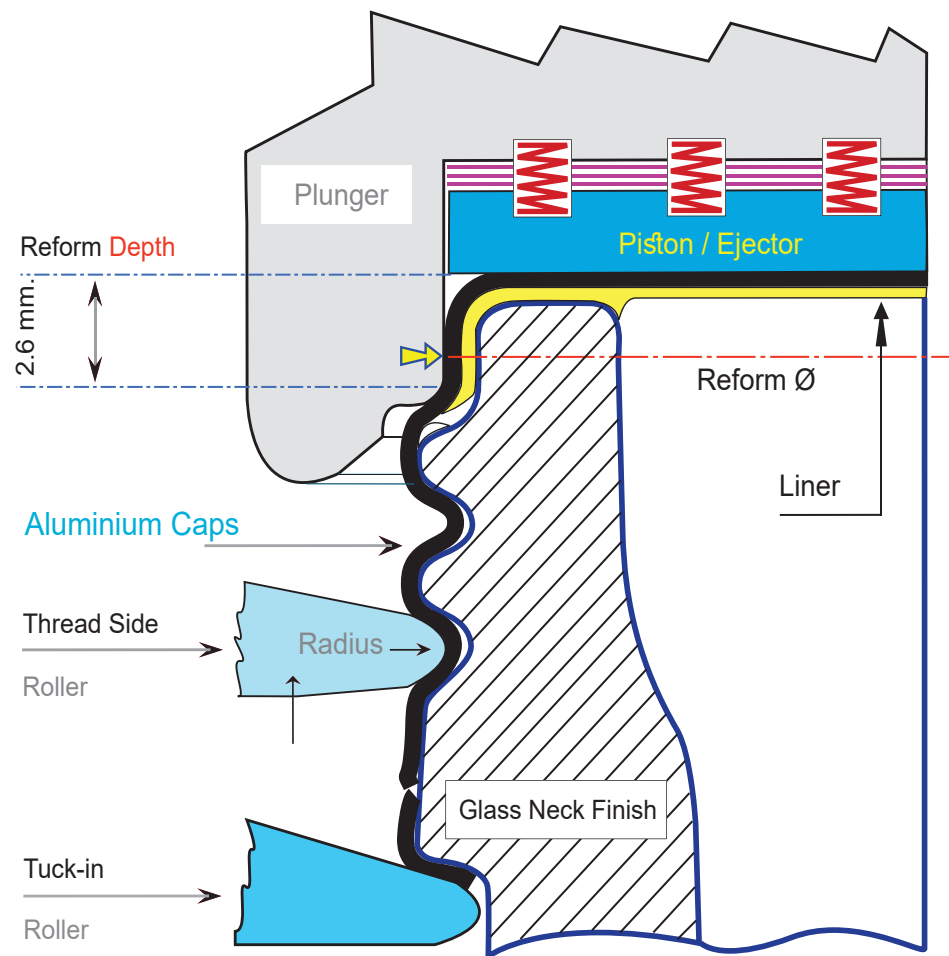
شركة الممودي لصناعة السدادات
AL-AMOUDI CLOSURES MFG. CO.

TITLE: ALU Cap R.O.P.P - Specification & Liner Profile

Project	Review /Refc.	Code / Ref. No.	Drawing No.
ALU Caps R.O.P.P.	SACMI & CE.T.I.E	PMV 10007.023 EC 1-	DS-A.1001.02

for more details please contact us at our e-mail: acm@al-amoudi.net

Technical support for Capping & Reformed Plunger Alu Caps Roll On P.P. on Glass Neck Finish



Auditor



Certificate



Certificate

Feature	Specification	Tolerance
Caps Type : 5 Score & NO Score	5S. & NS.	
Caps Width x Haeight	w 28.80 x h 15.55	± 0.15 mm.
Liner Type	PVC FREE	

Plunger & Roller Radius Size :

Bottle Neck Finish Type .	MCA-2	
Reform Ø .	26.0 mm.	
Reform Depth. For (MCA-2).	2.6 mm.	
Thread Side Roller Radius. For (MCA-2).	0.7 R.	± 0.03 R.
Tuck-in Roller Radius.	0.8 R to 0.9 R.	

Capping Head Load Pressure Setting :

Top Pressure .	200 kg.	1960 to 2300 N.
Side Roller Pressure .	12 to 13 kg.	117 to 127 N.
Tuck-in Roller Pressure .	14 to 16 kg.	137 to 150 N.

Pressure Test after Quality Confirmation Capping :

No Leakage & Blow Off .	110 to 150 psi
-------------------------	----------------

Torque Test :

Opening Torque after sealing.	4 to 8 lbs.
Opening Torque after 48 hours .	6 to 14 lbs.

DRAWING BY
ACM

CHECKED BY
Ali.S.A

UPDATED BY
Ali sayed

APPROVED BY
Eng. M. AL-Amoudi

DATE
Year 1985

UPDATE
7 / 7 / 2024



شركة المومدي لصناعة السدادات
AL-AMOUDI CLOSURES MFG. CO.

TITLE : ALU Cap - Technical data for Capping process..

PROJECT

ALU Caps

Ref.

ALCOA - USA
CE.T.I.E.

CODE REF. NO.

200855
SACMI

DRAWING NO.

DS-A.1002.03

for more details please contact us at our e-mail : acm@al-amoudi.net

ALU Caps Type (R.O.P.P) Roll On Pilfer Proof - Seal of application



Auditor



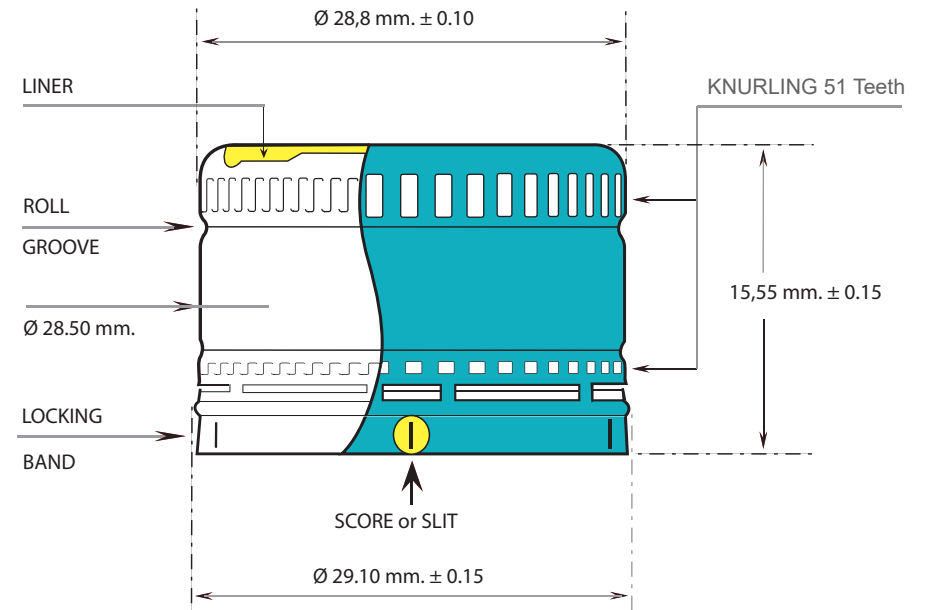
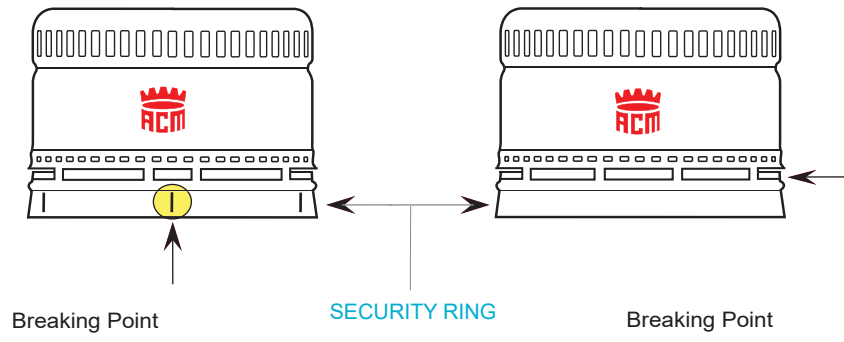
Certificate



Certificate

1 - Alu Caps Type : 5 Score

2 - Alu Caps Type : NO Score



NOTE :

- 1 - **5 score** means during cap opening the security ring will be out with cap.
- 2 - **No score** means during cap opening the security ring will be left on the bottle neck.
- 5S means (5 Score or Slit) NS means (No Score or slit) .

for more details please contact us at our e-mail : acm@al-amoudi.net

DRAWING BY
ACM

CHECKED BY
Ali.S.A

UPDATED BY
Ali sayed

APPROVED BY
Engr.M.AL-AMOUDI

DATE
Year 1985

UPDATE
4 / 1 / 2023



شركة المودي لصناعة السدادات
AL-AMOUDI CLOSURES MFG. CO.

TITLE : ALU Caps Type (5 Score & No Score).

PROJECT	REV.	SHEET NO.	CODE REF. NO.	DRAWING NO.
Alu Caps R.O.P.P			157 51 007 SACMI	DS-A.1003.02



Technical Data Sheet - ALU Caps

Product Name: **ALuminum Caps** **ROPP**. Roll On Pilfer Proof.

Specification

Use for:

- Use at Beverage factory sealing glass bottle Neck Finish type: (MCA-1 / MCA-2 & All MCA-.. Code).
- Alu caps It Used to seal the bottle Neck Finish to Protect the Internal Soft Drinks, Beer, Water, Juices

A - **Material :**

- **Shall** Material Type: Special Aluminum Alloy / Aluminum Sheet - Code - Alloy- 3105 - H.
- **Liner** Material Type: PVC Free. - Germany
- Overprint Varnish Type: Acrylic. - AkzoNobel. - UK.
- Adhesive Lacquer Type: Epoxy Phenolic. - AkzoNobel. - UK.
- Size Coat Type: Polyester. - AkzoNobel. - UK.
- Printed Ink Type: Alkyed Ink. - AkzoNobel. - UK.
- Caps Color According to Customer Flavor.

B - **Dimensions:**

- Overall Diameter Ø : 28.80 mm. ± 0.10 mm.
- Overall Height: 15.55 mm. ± 0.15 mm.
- Number of Knurling: 51

C - **Information:**

- Reform Crimp Diameter Ø : 26.00 mm.
- Capping head Top Load: 200 kg.
- Side Roller Pressure. 12 to 14 kg.
- Tuck-In Roller Pressure. 14 to 16 kg.
- Opening Torque: 4 : 12 lbs.
- Pressure Test: 110 to 150 Psi.

D - **Storage :**

- The products should be used before 12 Months from production date (Best Before Date: **BBD**).
- Storage at Temp. 25 °C, Avoid storage of boxes in direct sunlight. / Protect from excessive humidity.

Note : Moor information use ACM product Data Sheet Document. acm@Al-amoudi.net./acm.amoudi@gmail.com

Prepared by:
Food Safety Time

Approved by :
Plant Manager



Product Description - ALU Cap

Product's Full Description

ALU Cap :-

A - Alu Caps **R.O.P.P** - Roll On Pilfer Proof. It uses for Capping glass **Neck Finish**. Type (**MCA- 1 & MCA-**

B - It is made from Aluminum sheet code - **Alloy- 3105 - H** - With coated (**Adhesive Lacquer, Size Coat, Ink, Varnish. And PVC Free Liner**).

C - **How to Produce.**

Printing Procedure :

First run on the Plain **ALU Sheet** at coating line for the lacquering of the first side.

- 1 - The back side of the sheets coated with **Adhesive lacquer** for the liner sticking.
- 2 - The front side is coated with **Size coat** to make the printed ink becomes stronger sticking.
- 3 - Back again to front side for Printing **Logo** it depend upon how many color of logo to be printed (**e.g. Red , Blue , white ,orange ,Green act.**).
- 4 - After that is the applying of overprint **Varnish** for final process and to be transfer to production line for punching.

Production Procedure :

- 1 - Operator to prepare the press machine (**PTV 019**) ready for punching Alu Sheet.
- 2 - Re-check the printed sheets one by one before feeding if there is no lacquered sheets or logo ink defect
- 3 - Adjusting the press machine (**PTV 019**) for logo centering before punching.
- 4 - After that we make ready for start punching the Alu Sheet.
- 5 - Start production and store to 4 bins for Alu-cap stock

Lining Procedure :

The machine has 3 codes **ATV , BTA, and PMV 100**.

- 1 - **ATV** : The badly drawn cap of **PTV 019** machine will carefully sorted out by assign operator.
- 2 - **BTA** : The cap passes through this to forming a knurling.
- 3 - **PMV100** the cap will passed to the frequency inverter for heating lacquer to be sticking with the liner PVC Free and go to the forming punch to form it.
- 4 - Machine has automatic inspection. (Liner cut or missing by vacuum, and Alu Caps shall shape defect).
- 5 - There is assign operator to be watched the cap defect and for carton packing.
- 6 - Packing, Carton print tag includes customer name tag Flavor, batch #, Production date, and Box numbe

Storage :

- The products should be used before 12 Months from Alu Boxes production date (Best Before Date: **BBD**).
- Storage at Temp. 25 °C, Avoid storage of Alu Caps boxes in direct sunlight. / Protect from excessive humidity.

Note : Moor information use ACM product Data Sheet Document. acm@Al-amoudi.net./ acm.amoudi@gmail.com

Prepared by:
Food Safety Time

Approved by :
Plant Manager



Packaging Specification - ALU Caps - R.O.P.P.

General Description

Product Type : **28 mm. Aluminum Caps** (ALU CAPS - R.O.P.P.)

Property	Value	Remarks
Material	Aluminum Alloy (3105) Temper H 14.	
Weight , g	1.50 g.	
Tamper Indicating	No	
Liner Forming Process	Die cut	
Diameter. Mm	28 mm.	
Shell Molding Process	ALOY	
Vendor	Closures	
Finish Type	Alu Cap	
Closure type	Alu Caps - R.O.P.P.(5 Score & No Score)	
Market	KSA & Middle East	
Approved Usage- closure	CSD	
Liner	Yes	

Materials

Property	Value	Remarks
Shell Material Type	Aluminum Alloy (3105) .	
Shell Hardness	H 14	
Shell Base Color	Silver	
Internal coating	Modified Vinyl	
External coating Base coat	Polyester	
Print color	As request	
Varnish Type	Acrylic	
Ink Type	Diaflex Conventional	
Liner Type	PVC FREE	
Liner Color	White	
Liner Supplier	ACTEGA -DS GMBH- Germany.	

Dimensional Analysis

Property	Target	Min.	Max.	Test method
Shell external dimension	28.80 mm.	28.70 mm.	28.90 mm.	PEPSICO Global Guide
Shell Internal dimension	27.80mm.	27.65 mm.	27.95 mm.	"
Shell Height Dimension	15.55 mm.	15.40 mm.	15.70 mm.	"
Shell Weight	1.25 g.			"
Liner External Diameter	26.60 mm.			"
Liner Thickness	0.40 mm.			"
Liner Profile	928 / 941			"
Liner Weight	0.275 mg.	0.265 mg.	0.290 mg.	"
Liner Hardness, Shore A	83	78	88	"

Performance Requirements

Property	Target	Min.	Max.	Test method
Pressure Test (SST) .	150 psi.	125 psi.	150 psi.	125 : 150
Removal Torque. (Cold).for Twist Off	8 lps.	6 lps.	12 lps.	Global Guide

A

Pallet Configurations

Property	Target	Remark
Pallet Material	Wood	
Pallet Size	L -1.000 x W - 1,000 X H - 130 mm.	
No. of layers each pallet	5 - Layers	
No. of Boxes each Layer	4 - Boxes	
Total Boxes each Pallet	20 - boxes x 7, 000 pieces .	
Total Packaging Height	2,150 mm.	
Use for Packaging cover	Shrink film and Cardboard on top	
Use for Boxes closing	Masking Tape on Top & Bottom	

B

Property	Target	Remark
Pallet Material	Wood or Plastic	
Pallet Size	L -1.200 x W - 1.000X H - 130 mm.	
No. of layers each pallet	5 - Layers	
No. of Boxes each Layer	5 - Boxes	
Total Boxes each Pallet	25 - boxes x 7, 000 pcs .	
Total Packaging Height	2,150 mm.	
Use for Packaging cover	Shrink film and Cardboard on top & Bar code Ticket. at 2 side	
Use for Boxes closing	Staple on Top & Bottom W/ Masking Tape	

Reference Document

Drawing Type	Document Description
Alu Caps Specification Drawing	ALU Caps specification (R.O.P.P.). Code (DS-A.1001.02 , DS-A.1002.02, DS-A.1003.03, DS-A.1004.03) .
Packaging Specification	Packaging Specification Code (PD-PS.A.02) .
Packaging Pallet Drawing	Drawing of Load Packaging Pallet 20 & 25 boxes. Code (PD-BCPP.G.03 (PD-BCPW.G.03) .
Packaging Packer's note Drawing	Packer's note for carton Production Details. Code (PD.PN.A.02) .

Prepared by :
Production ManagerApproved by :
Plant Manager



Al - Amoudi Closures Manufacturing Co.
Production Section

Ref. : ACM System

ISO 22000 - 2018

Code : PD-PPBC.G.04

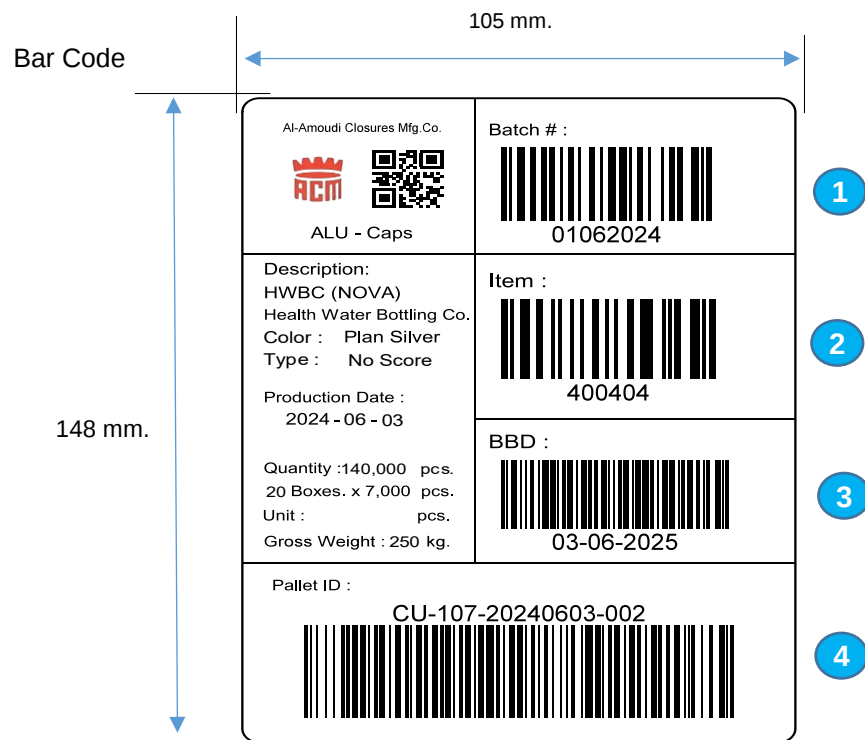
Issue date : 03-06-2024

Packaging Pallet & Bar Code - 20 Boxes . - ALU Caps

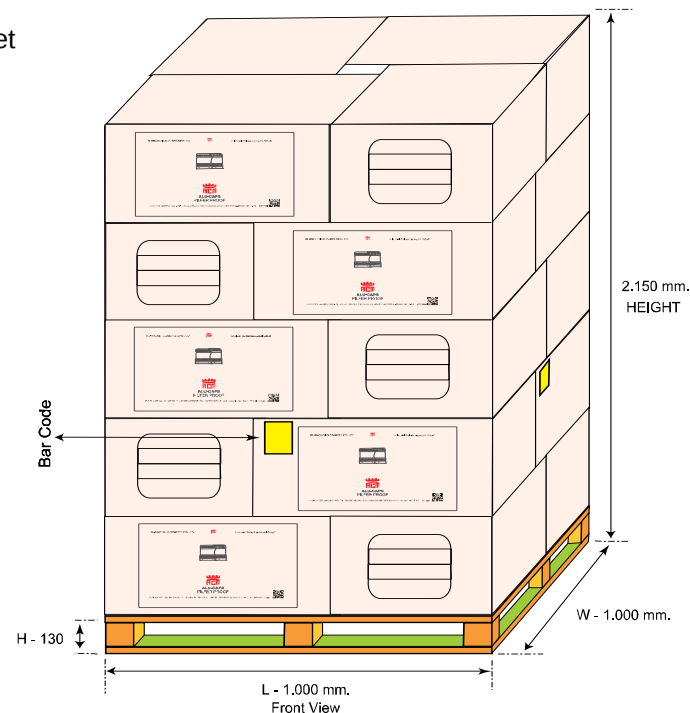
Prepared by : Production manager

Approved by : Plant manager

Issue #. : 4



Pallet



Packaging Details

1 -	Pallet type :	Wooden	A - Bar code type :	128
2 -	Pallet size :	W 1,000 X D 1,000 X H 150 mm.	B - Bar code size :	100 mm. X 90 mm.
3 -	No. of layers each pallet :	5 - Layers	C - Bar code position :	at (800 mm.max. Height) 2 pcs 1- in Center Front- Second in Center left side.
4 -	No. of boxes each layer :	4 - Boxes	D - Bar code contain :	1 - Batch #. / 2 - Item. / 3 - BBD.- Best Before Date. / 4 - Pallet ID.
5 -	Total boxes each pallet :	20 Boxes X 7,000 pcs.= 140,000 pcs.		
6 -	Total boxes net weight.	20 Box X 12 kg = 240 kg.		- The box is multi layers strong enough to support the load with internal plastic bag for crown protection .
7 -	Total pallet weight .	255 kg. max		- The box with rider (QR) at side also packer's note for carton production details. Code (PD.PN.A.02) .
8 -	Total packaging height :	2,150 mm.		- The Wooden pallet is strong enough to support the load for plant storage .
9 -	Use for packaging cover :	Shrink film & Cardboard on top		- Stretching shrink film wrapping is applied to the exterior of each pallet to help unitize the load and to safeguard
10 -	Use for boxes closing :	Packaging Tape on Top & Bottom		against the dust and the Spray water also with cardboard on top for dust protection .

for more details please contact us at our e-mail : acm@al-amoudi.net.

Attachment the packer note of boxes - Code : (PD-PN.A.02).