
	Technical specifications - Caps made of PE	Code	E.00.00100
		Version	02
		Page	1 from 10

Index	
1. OBJECTIVE	2
2. SCOPE	2
3. DEFINITIONS - ABBREVIATIONS	2
4. PE CAPS	2
4.1. NG 112: APPEARANCE TEST	3
4.2. COLOUR - TRANSPARENCY	9
5. INFLUENCE OF PE MATERIAL IN CAPS	9
6. ENVIRONMENTAL, HEALTH AND SAFETY, CSR AND OTHERS	10
7. ASSOCIATED DOCUMENTS	10
8. APPROVALS AND CHANGES	10

	Technical specifications - Caps made of PE	Code	E.00.00100
		Version	02
		Page	2 from 10

1. Objective

Define and quantify the risk points and acceptable quality limits associated with caps (thread and flip-top caps) in Polyethylene material.

2. Scope

PE caps assembled on extruded and/or laminated tubes.

3. Definitions - abbreviations

GIS Glossary X.00.00000.

4. PE caps

In cases where PE flip-top or screw caps are used, due to the characteristics of the material in these types of caps, some aspects and characteristics must be assessed.

The pictures of the defects are for guidance only.

4.1. NG 112: appearance test

Creased, deformed cap**OK**

Outside / inside Injection point**OK**


Scratches, marks

*** Continues on next page**

**OK**





Sink marks**OK****Flashes****OK**

Bursts / Gases / Air bubbles**OK****Tube - cap separation***** To be confirmed and/or defined with defect range board if requested by the customer****OK**

	Technical specifications - Caps made of PE	Code	E.00.00100
		Version	02
		Page	9 from 10


4.2. Colour - Transparency

The natural colour of the PE is whiter (less transparent) than many commonly used PPs, so the level of transparency may not be the same.

Natural PP	Natural PE
<i>GLOSS flip-top cap</i>	
	
<i>MATT screw cap</i>	
	

5. Influence of PE material in caps

Most of the extruded tubes are made of PE and if the cap were also made of PE, the whole assembly would be considered "mono-material". In this way we improve its recyclability at the end of its life.

	Technical specifications - Caps made of PE	Code	E.00.00100
		Version	02
		Page	10 from 10

6. Environmental, Health and Safety, CSR and others

Food contact:

Currently approved materials have different certifications for food contact compliance.

If PE PCR materials are used, the customer must assess in particular the suitability of the use of these raw materials with regard to the regulatory point of view.

Regulatory information on PCR materials may be provided upon signature of a confidentiality agreement.

7. Associated documents

Denomination	Document code
GIS Glossary	X.00.00000
Technical Specifications - Extruded plastic tubes and plastic caps	E.00.00000
Technical Specifications - Laminated tubes and plastic caps	E.00.00001

8. Approvals and changes

Owner	Quality Environment and PRL Res. - Technology Ezkurra Jorge	SIGNATURE 
Reviewed	Product Res. - Technology Jimenez Eduardo	SIGNATURE 
Approved	Technology Group Director Valpuesta Juan Ignacio	SIGNATURE 

Summary Modification	Update redaction of paragraph 4.2. Colour - Transparency
Supersedes	V01