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### 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

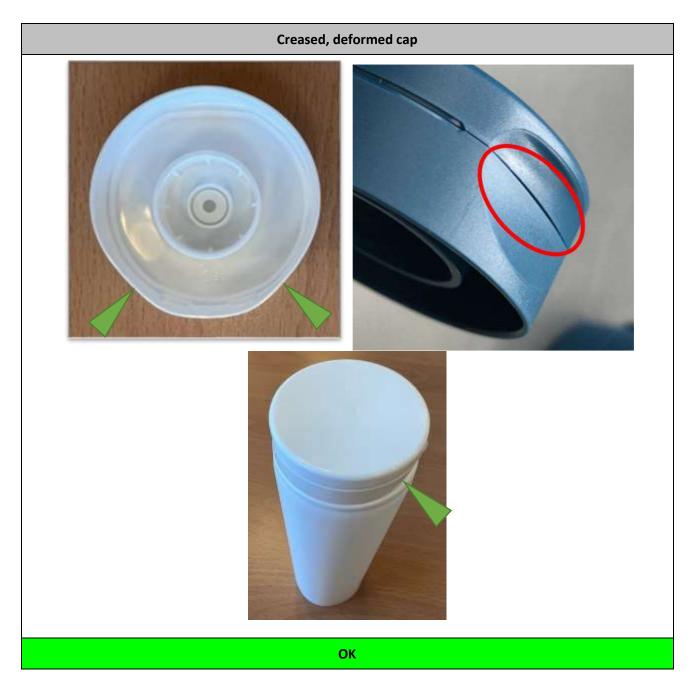
In cases where PE flip-top or screw caps are used, due to the characteristics of the material in these types of caps, some aspects and characteristics must be assessed.

The pictures of the defects are for guidance only.



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### 4.1. NG 112: appearance test





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#### Sink marks

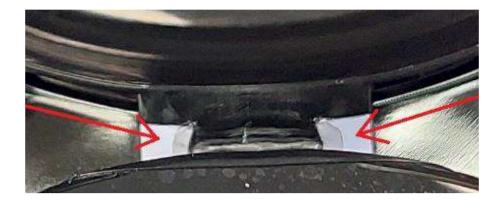






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#### **Flashes**



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#### **Bursts / Gases / Air bubbles**





OK

#### **Tube - cap separation**





\* To be confirmed and/or defined with defect range board if requested by the customer

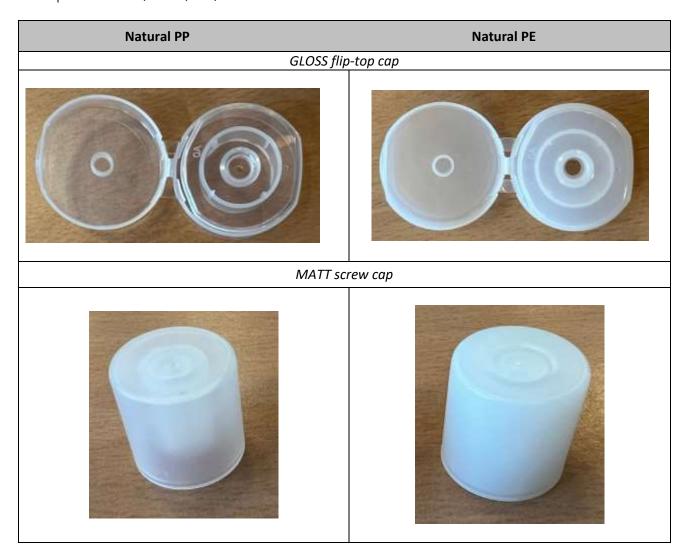
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#### 4.2. Colour - Transparency

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.



### 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.



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### 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 1992
Reviewed	Product Res Technology Jimenez Eduardo	SIGNATURE THE
Approved	Technology Group Director Valpuesta Juan Ignacio	SIGNATUE

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