

**GUIDELINE**

# Processing of Pano BLUESEAL<sup>®</sup> caps

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Pano Verschluss GmbH  
Gasstraße 29 · 25524 Itzehoe · Germany  
Tel. +49 48 21-7706-0

## CAP TEMPERATURE DURING SEALING

The thermoplastic elastomers (TPE) can be slightly firmer at room temperature than the compounds which contain PVC. For this reason the caps with compound K\* (W) have to be preheated up to 60 to 80°C before capping in order to get the same capping result as with caps with PVC compound.

For the capping with closures E (C) and T (M) a preheating may also be considered but it must be in context with the filling temperature of your products and depends also on the way how the products are closed (f.ex. with a cold-vacuum machine or with a steam-vacuum machine).



## MEASUREMENTS AFTER SEALING

### 1. MEASURING MOULD LINE - LUG DISTANCE\*

6 GLASSES PER HOUR

### 2. MEASURING SEALING SAFETY\*

6 GLASSES PER HOUR



## MEASUREMENTS AFTER POST-TREATMENT

### 1. MEASURING MOULD LINE - LUG DISTANCE\*

REGULARLY ON 6 GLASSES

### 2. MEASURING SEALING SAFETY\*

REGULARLY ON 6 GLASSES

### 3. CHECKING COMPOUND IMPRESSION

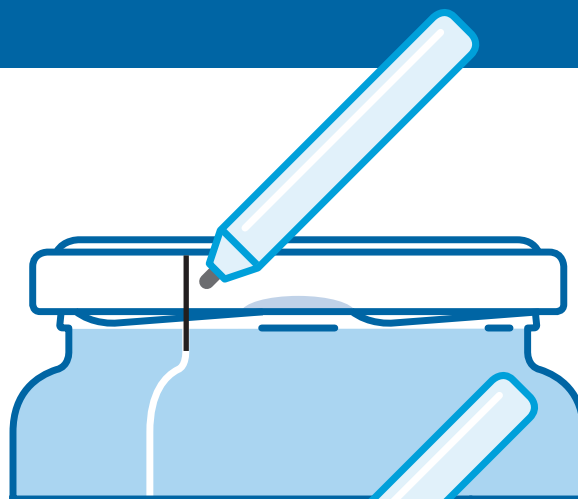
REGULARLY ON 6 GLASSES



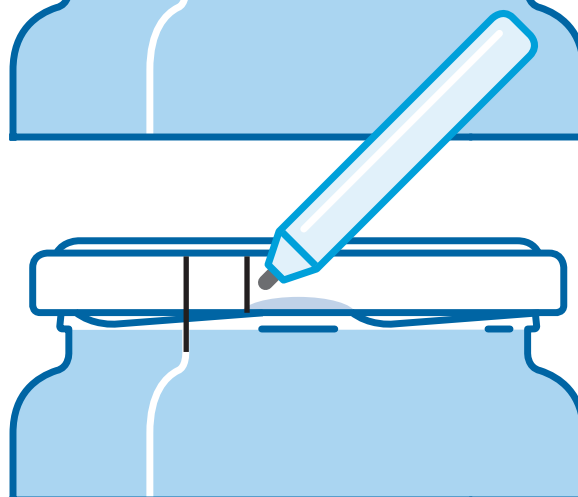
\*Not applicable for cap RUP/RUB 38. Please refer to the notes at the end of the instructions.

## MEASURING SEAM - LUG DISTANCE

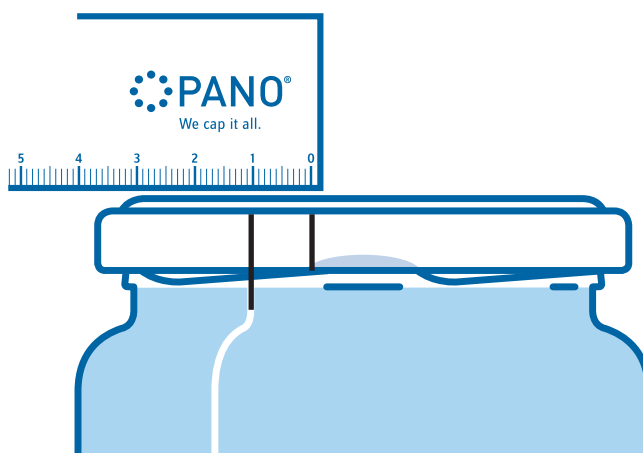
**1.**  
MARK THE POSITION  
OF THE SEAM OF THE  
GLASS AT THE CAP EDGE  
USING A FELT-TIP PEN.



**2.**  
MAKE A SECOND MARK  
AT THE LEFT EDGE  
OF THE LUG.



**3.**  
MEASURE THE DISTANCE  
BETWEEN THE  
TWO MARKINGS.



The measured value must correspond to the value specified for your cap:

### DURING PASTEURISATION / WITHOUT POST-TREATMENT

DOB/DTO, TWS/TSB 63, 66, 70, 77, 82: 7-13 mm

DOB/DTO, TWS/TSB 48, 53, 58: 9-13 mm

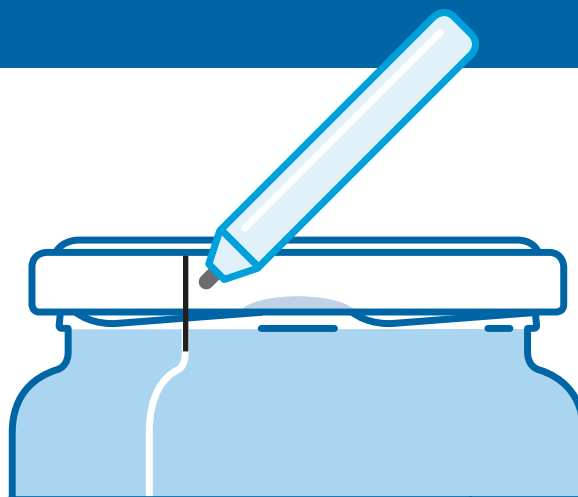
### DURING STERILISATION

DOB/DTO, TWS/TSB 63, 66, 70, 77, 82: 5-9 mm

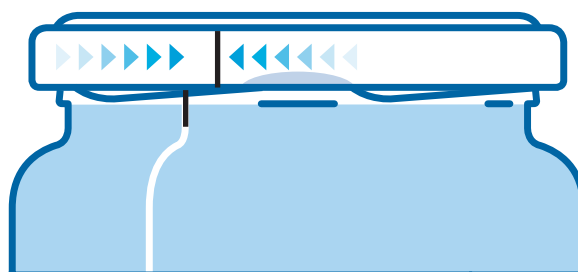
DOB/DTO, TWS/TSB 48, 53, 58: 7-11 mm

## MEASURING CAP SAFETY

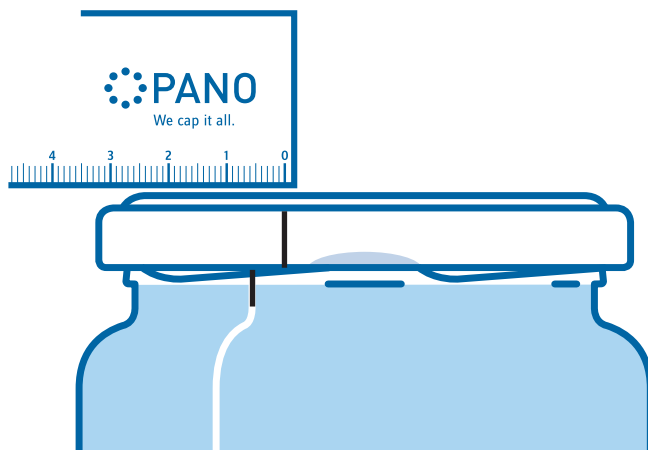
**1.**  
MARK THE POSITION OF THE SEAM OF THE GLASS AND AT THE CAP EDGE USING A FELT-TIP PEN.



**2.**  
OPEN THE CAP AND THEN APPLY IT AGAIN FINGER TIGHT.



**3.**  
MEASURE THE DISTANCE BETWEEN THE TWO SCALE LINES OF THE MARKING.



The measured value must correspond to the specified value:

### DURING PASTEURISATION / WITHOUT POST-TREATMENT

After the sealing: 3-7 mm

After the post treatment: 1-6 mm

### DURING STERILISATION

After the sealing: 5-8 mm

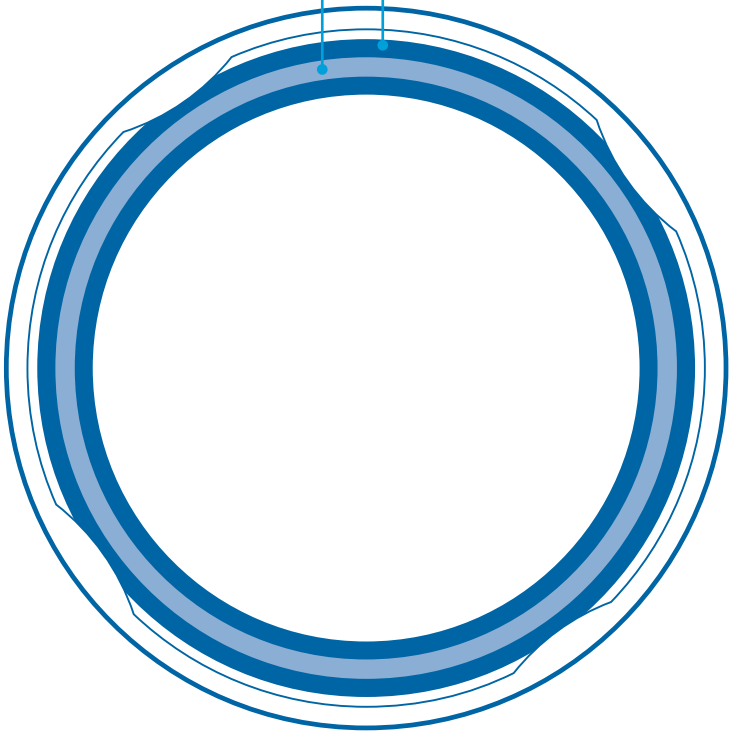
After the post treatment: 1-6 mm

# CHECKING COMPOUND IMPRESSION

COMPOUND

COMPOUND IMPRESSION

**The compound impression:** While sealing, the cap is pressed onto the rim of the glass opening so tightly that a depression is formed in the compound - the impression of the glass rim. This impression is called the compound impression



### How do I check the compound impression?

Checking is done through visual inspection of the underside of the cap. Here it should be noted:

- 1.** THE COMPOUND IMPRESSION MUST BE VISIBLE AS A DISTINCT DEPRESSION.
- 2.** THE IMPRESSION MUST HAVE THE SAME DEPTH ALL AROUND.
- 3.** THE COMPOUND MUST NOT BE DAMAGED. NO IMPRESSION UP TO THE METAL!

### CAP RUP/RUB 38

The measurement of mould line - lug distance and sealing safety is not applicable. Regularly carry out the following visual inspections on 6 glasses.

**AFTER THE SEALING:**

1. Check whether the lug is engaged at the end of the thread.

**AFTER THE POST TREATMENT:**

1. Check whether the lug is engaged at the end of the thread.
2. Check the compound impression.