SUPPLY TECHNICAL SPECIFICATIONS: VITOP TAPS AND GLANDS FOR ASEPTIC APPLICATIONS

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Contents:

1. *APPLICABLE PRODUCTS*

This document applies for taps, in all validated color versions, and for glands for aseptic applications.

Figure 1: Aseptic gland (left); Aseptic tap (right).

Composition:

Taps are made of five components.
Materials used to manufacture gland and the components of the taps are reported in the following table:

Component	Material	Lubricant	Masterbatch
Body	Polypropylene (PP)	NO	YES/NO
Capsule	Polypropylene (PP)	NO	YES
Piston	High Density Polyethylene (HDPE)	NO	YES
Valve	Elastomer	YES	NO
Foil	Aluminum	NO	NO
Gland	Linear Low Density Polyethylene (LLDPE)	YES	NO

2. *RESPONSIBILITY AND WARRANTY*

Performance of the taps and glands is under the responsibility of *Vitop,* but *Vitop* cannot be considered responsible for any improper use of its products by the buyer and/or the final consumer.

The period of delivery of the taps/glands by *Vitop* and their installation on the container by the manufacturer shall not exceed one year. Also, the period between delivery of the taps/glands by *Vitop* to the container manufacturer and their use by the final consumer must not exceed two and half years.

3. REFERENCE CERTIFICATION

Vitop guarantees the performance of its products through an appropriate Quality System and internal procedure certified by:

- UNI EN ISO 9001:2008
- UNI EN ISO 22000:2005

Moreover, the assembly area of the taps is kept very clean, meeting the norms of production of packaging materials intended to come into contact with food.

Food contact and others statements:
Vitop taps and glands, for aseptic applications, are suitable to come into contact with food.
Specific statements for food contact, as well as for REACH, heavy metals and the environment, are provided by *Vitop* on request.

4. PERFORMANCES AND TEST METHODS

4.1 Leak proof

Each tap must undergo and pass a tightness test at a pressure of 0.4 bars.

4.2 Oxygen permeability

The *Vitop* tap has a permeability rate of oxygen of approximately 0.1 cm^3 (24 hour period, 21% oxygen rate, 50% relative humidity).

5. PACKAGING AND STORAGE SPECIFICATION

Taps and glands are adequately packed and sent to the customer on pallets of 24 cardboard boxes (taps: 1000 units per box – glands: 1200 units per box) with protective adhesive tape (quality Seal).

5.1 Packaging identification

Each cardboard box is identified with a proper label and with an identification code that indicates:

- *Vitop's* address
- *Vitop*'s article code
- *Vitop*'s SAP code
- Quantity per box
- Production date
- Line number
- Box number
- Traceability code

In order to guarantee a correct traceability system, the identification code must be registered by bag manufacturers in their production records, and *Vitop's* code must correspond with their own code that identifies a specific batch of bags.

5.2 Storage specification

The temperature of the area where the taps/glands are stocked shall be room temperature (over 4°C and less than 30°C).
In order to prevent defects to the box/product no pallet can be put on another one.
Vitop also suggests to use FIFO for the stock management.

6. FILLING AND FITTING PROCESS

Filling centers are provided with containers with the taps partially inserted in the gland.
The taps may be placed in a preset position (the height being determined by the position of the *Vitop* gland's inner groove) and guided inside the gland according to the client's indications.
On inserting the tap inside the gland, the tap must be centralized to prevent any damage to either part. The taps must not be inserted into the glands if the temperature is below 10°C.
Vitop suggests to keep pallets in the production department at least 24 hours in advance to make sure that operations with *Vitop* taps and glands will be carried out at room temperature (20 ± 3°C).

The filling temperature, with this specific gland, must not exceed 45°C.
In case of hot filling, it is compulsory storing the recipients with the taps facing upwards to reduce to the maximum the pressure on the glands.

As the regulations and products mentioned in this statement change over time, Vitop advises its customers to ask for a new declaration periodically. This declaration cancels any previous version.