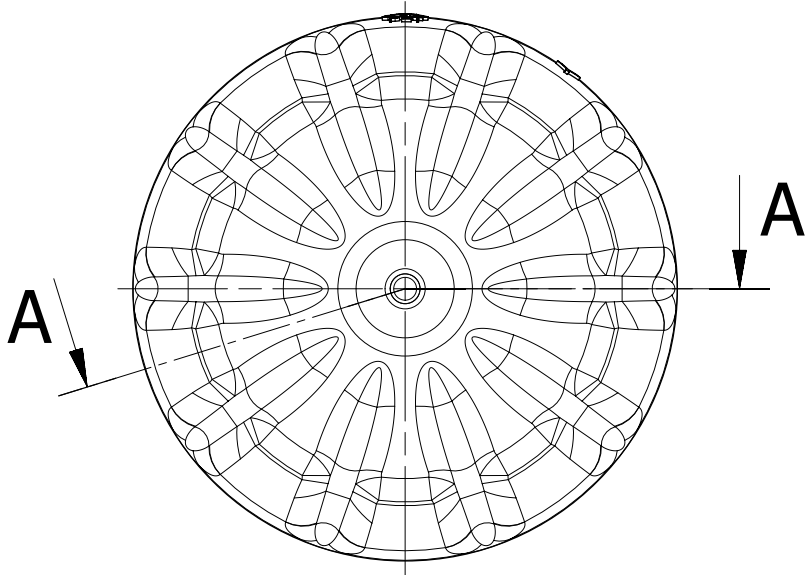


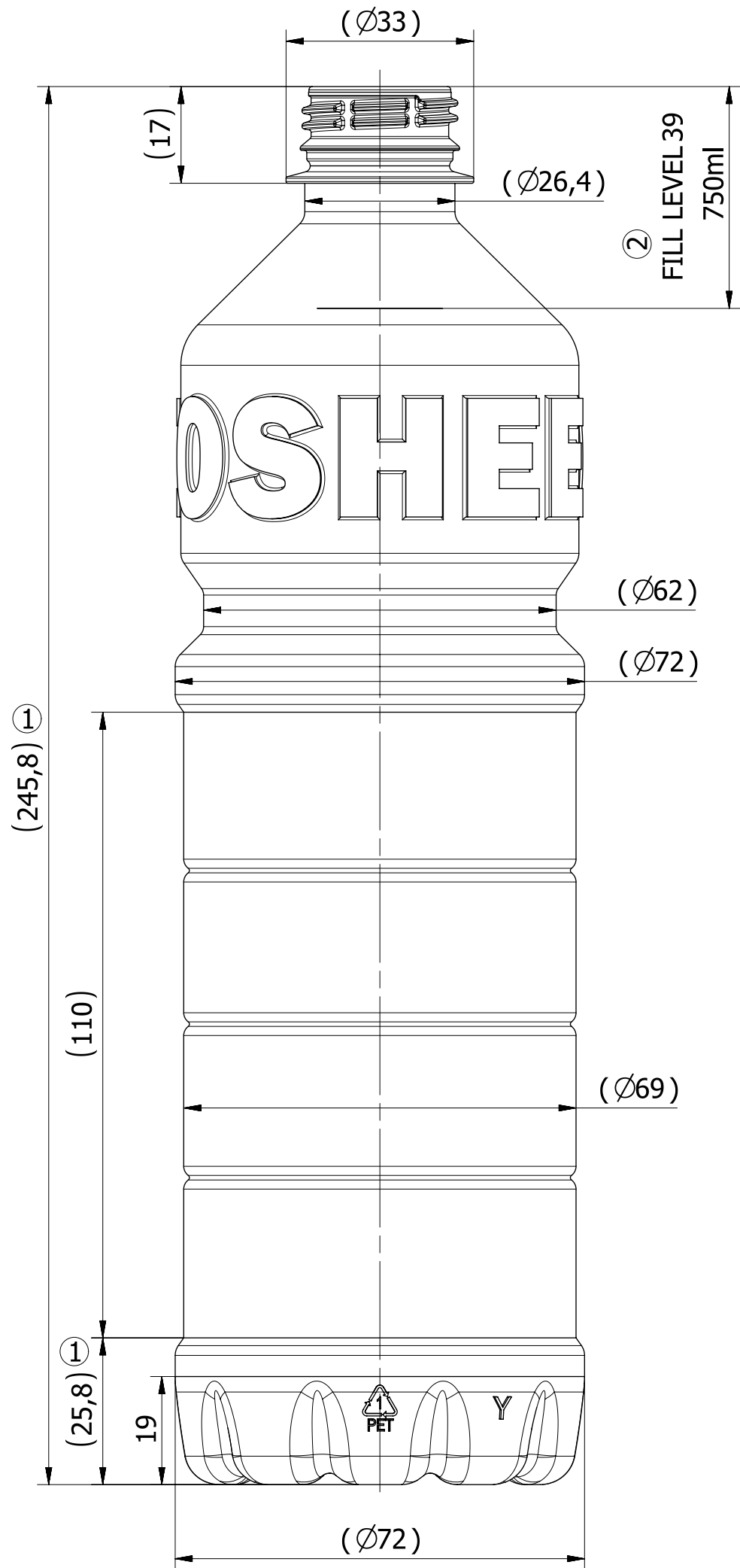
Y-cavity number

				Pojemnosc butelki: 1500ml	Nazwa: B811150_1_3_4		
02	zmiana z 50 na 49	29.06.2010	A.M.	Pojemnosc calej butelki: 1533ml	01 39g (PCO) Waga wyrobu:	PET Material:	1:1 Skala
01	zmiana z 36 na 39	29.06.2010	A.M.	 80-125 Gdansk, ul. Kartuska 267	29.06.2010 Data	b811150 Filename	A3 Format
Nr	Zmiana	Data	Podpis		A. Miączyński Rysował	Podpis	1/1 Arkusz

A



B

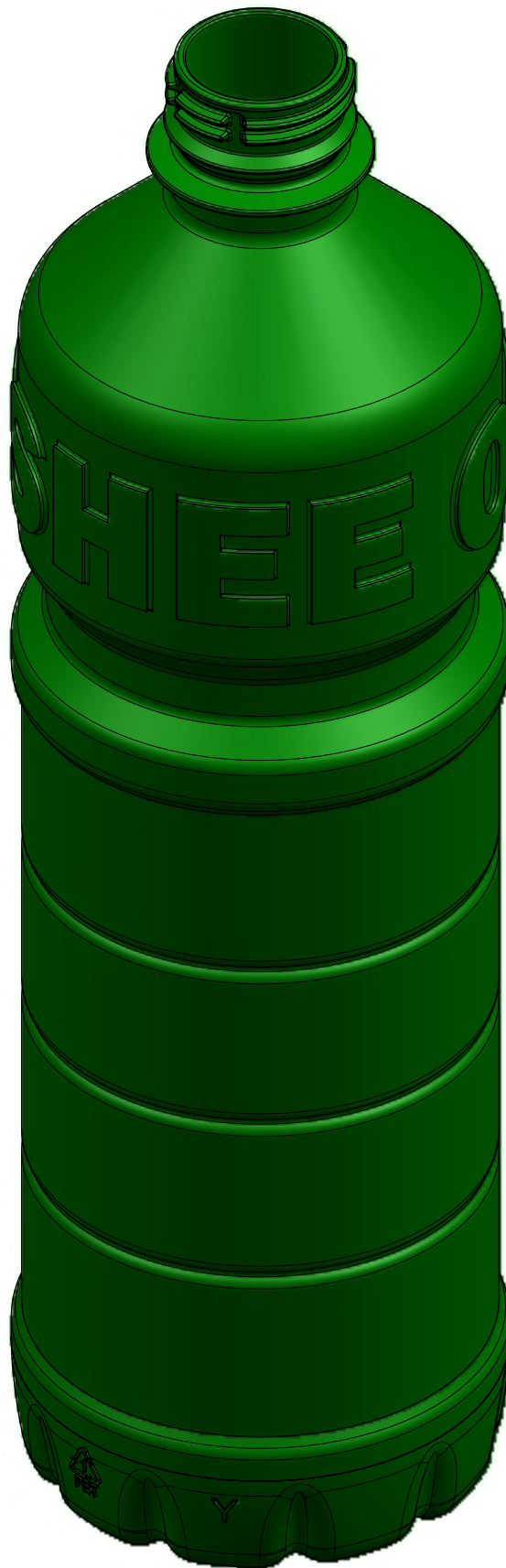
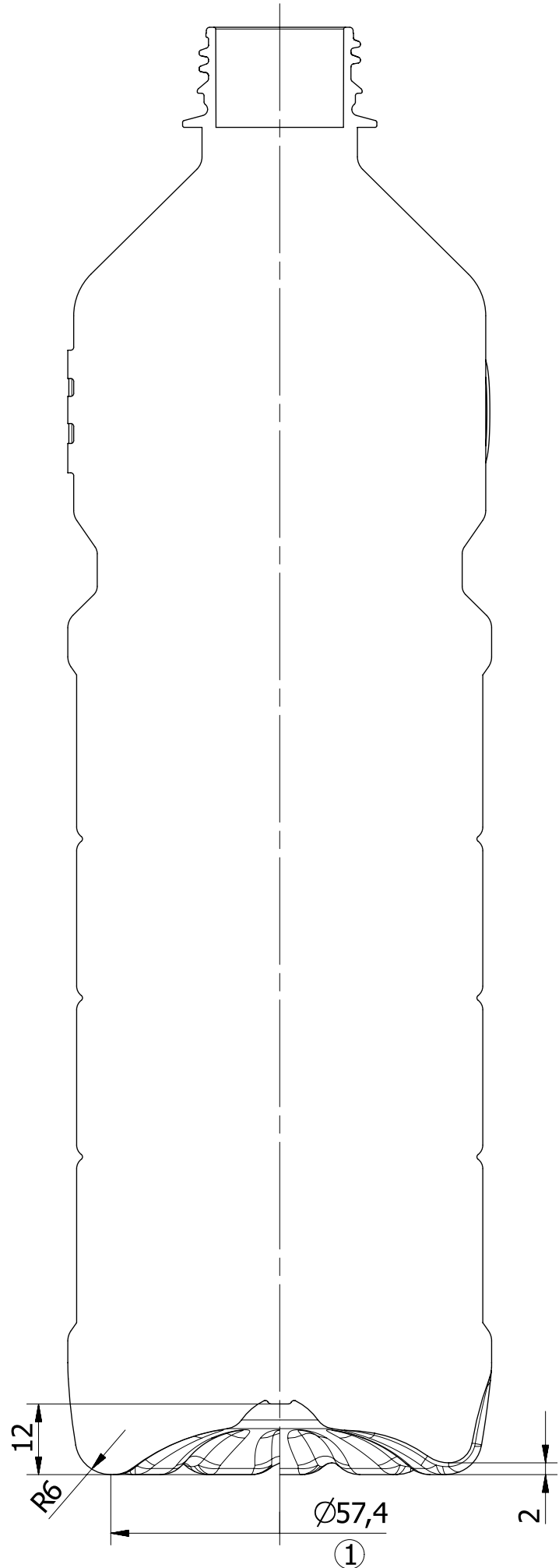


C

D

E

A-A



STANDARD NOTES FOR PET BOTTLE

- ALL DIMENSIONS IN MILIMETERS.
- FULL SCALE UNLESS NOTED.
- FOR BOTTLES 72 HOURS AFTER MANUFACTURED THE FOLLOWING TOLERANCES APPLY:

NOMINAL CAPACITY:	HEIGHT	DIAMETER
0 to 500ml	± 0,65	± 0,55
501 to 1490ml	± 0,85	± 0,70
1491 to 3000ml	± 1,20	± 0,85
3001 to 5000ml	± 1,80	± 1,80
- FOR AS DELIVERED BOTTLES. THE FOLLOWING TOLERANCES APPLY (EXCEPT WHERE NOTED):

NOMINAL CAPACITY	HEIGHT	DIAMETER
0 to 500ml	+0,60 -1,25	+0,50-0,65
501 to 1490ml	+0,75 -1,60	+0,60 -0,85
1491 to 3000ml	+1,20 -1,50	+0,75 -1,00
- FOR AS DELIVERED BOTTLES. THE FOLLOWING CAPACITY TOLERANCES APPLY (EXCEPT WHERE NOTED):

NOMINAL CAPACITY	INDIVIDUAL	AVERAGE
0 to 1000ml	± 1,25% of nominal	± 0,75% of nominal
> 1000	± 1,00% of nominal	± 1,50% of nominal

- UWAGI:
- Pierwotny model wykonany na podstawie bloku formującego.
 - Butelka dostarczona jako wzór dla kształtu denka ma inne wymiary, w tym 247mm wysokości całkowitej.

MEASUREMENT POINT				PREFORM 1	PREFORM 2		
FILL POINT CAPACITY		nominal	(ml)	750			
FILL POINT CAPACITY		calc	(ml)	750			
BRIMFULL CAPACITY		calc	(ml)	781 ②			
PREFORM WEIGHT			(g)	20,5			
2	Wyliczenie pojemności nalewu i pojemności całkowitej butelki			25.09.2024	A. Witek		
1	Zmiana wymiarów			25.09.2024	A. Witek		
No	Modification			Date	Signature		
Diameter		Label length	Surface area	Neck	Base volume		
72 mm		216,77 mm		PCO1881			
				Gravity center			
Drawn by:		Signature:	Date:	Description:			
A. Witek			10.08.2024				
Approved:		Signature:	Date:				
				Number			
		b910075_7					
UL. KARTUSKA 267 80-125 GDAŃSK POLSKA		TEL: (+48 58) 302 34 32 FAX: (+48 58) 302 96 93 office@lonza.com.pl www.lonza.com.pl		Material	Scale:	Sheet size:	
				PET 1.335 g/cm3		1:1	A2
				ISO 128			
THIS DRAWING IS THE PROPERTY OF THE LONZAPET SP. Z O.O. COMPANY AND IS NOT TO BE USED OR REPRODUCED WITHOUT WRITTEN PERMISSION							

A

B

C

D

E

ZAŁĄCZNIK 8.4

Top View:

- Diameter: $\varnothing 29,50 \pm 0,30$
- Diameter: $\varnothing 25,90 \pm 0,20$
- Diameter: $\varnothing 22,50 \pm 0,15$
- Height: $15,70 \pm 0,30$
- Lug Thickness: $0,9 \pm 0,1$
- Total Diameter: $\varnothing 31,15 \pm 0,30$

Sectional Views:

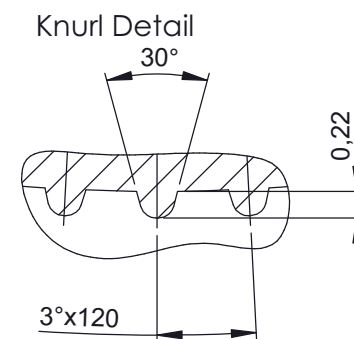
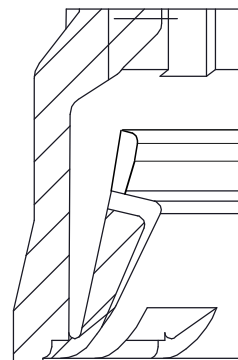
- A-A
- C-C

Detail C:

Knurl Detail:

- Angle: 3°
- Length: 120
- Depth: $0,22$

Skala (Scale): 2:1	Nazwa rysunku (Title): Nakrętka jednoczęściowa PCO1881 z pierścieniem zabezpieczającym A1881 CSD1KT One piece HDPE cap PCO1881 A1881 CSD1KT	Nr rysunku (DWG No.): M-1077
Firma: mika	na podstawie rysunku SACMI UCM00198492 original SACMI drawing no. UCM00198492	Data: 20.02.2024



2:1

Nakrętka jednoczęściowa PCO1881 z pierścieniem zabezpieczającym A1881 CSD1KT

Firma:

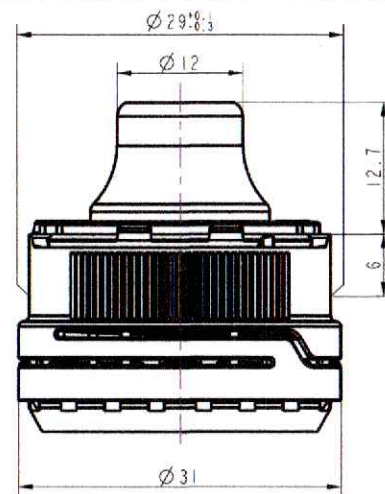
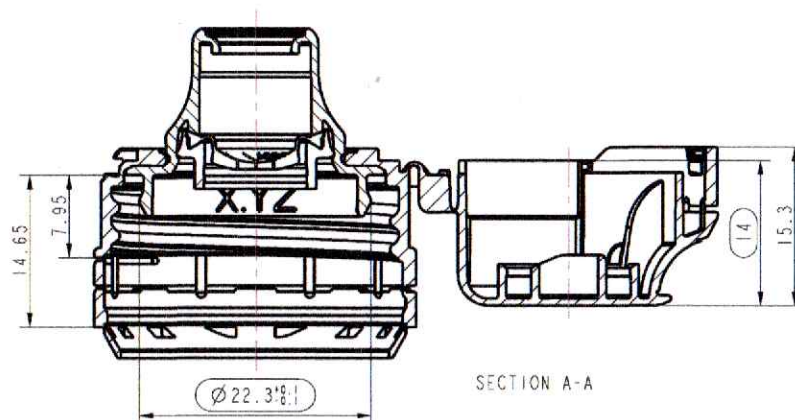
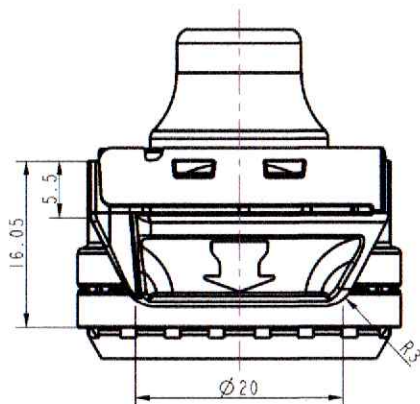


M-1077

Data:

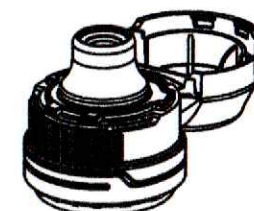
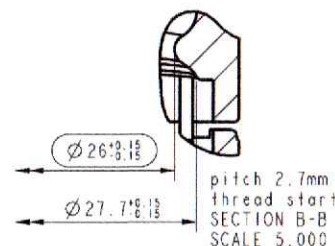
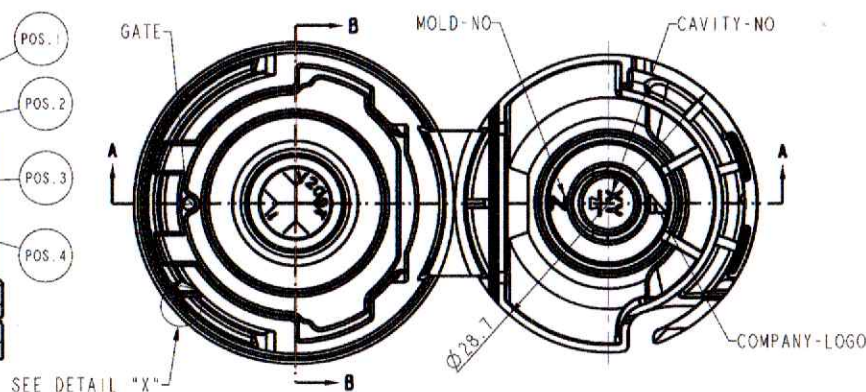
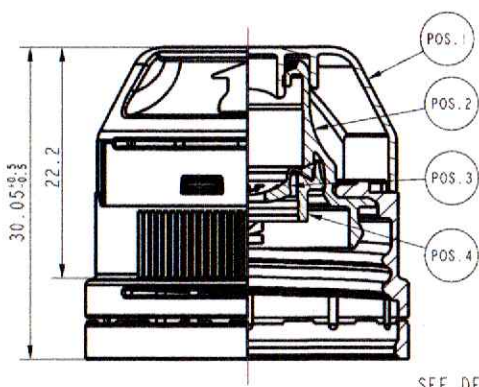
20.02.2024

ZAŁĄCZNIK NR 8.5



ARTICLE	ASSEMBLED POSITIONS	ASSEMBLED COMPONENTS
FRE-330500	1	CLOSURE
FRE-330500.A01	1, 2.1, 3, 4	CLOSURE, SPOUT, VALVE, RETAINER
FRE-330500.A02	1, 2.1	CLOSURE, SPOUT
FRE-330500.A03	1, 2.2, 3, 4	CLOSURE, SPOUT, VALVE, RETAINER
FRE-330500.A04	1, 2.2	CLOSURE, SPOUT

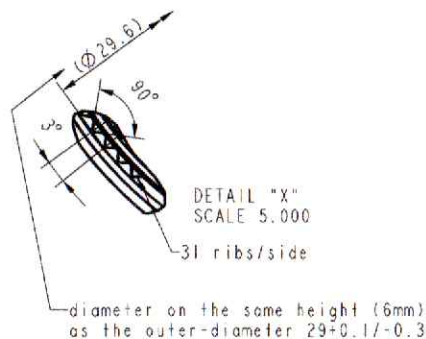
POS.	PART	PART-NO	WEIGHT
1	CLOSURE	FRE-330500	3.3gr
2.1	SPOUT	FRE-294600	1.1gr
2.2	SPOUT	FRE-290500	1.1gr
3	VALVE	TPE-500	0.1gr
4	RETAINER	FRE-350000	0.2gr



SCALE 1:000

ADDITIONAL TESTING CHARACTERISTICS	VALUE/ITEM
OPENING FORCE	5N-20N
TIGHTNESS BY 3 BAR	TEST
PANO-BAND/TE-FEATURE	FUNCTION

SEE DETAIL "X"



DYREKTOR ZAKŁADU

mgr inż. Mirosław Sułeca

If a recommended bottle finish is shown, the measurements shown are based upon our current knowledge. It is the responsibility of the receiver of the information contained in these drawings to test for fit and function of the total package.

						In Progress	
REVISION		REVISION DATE		REVISION BY		DRAWING STATUS	
CALCULATED PART WEIGHT: - gr.		DRAWING CLASS:					
MATERIAL: PP/PE/TPE/PP		DRAWING TYPE: SNAP TOP					
GENERAL TOLERANCE		TITLE: "Light Original" 28mm PC01881 EVO					
INCHES		OUTER SURFACE:		DESIGN ENGINEER: A.D.			
< 1.18 ± 0.008		HIGH GLOSSY		DATE: 09.08.22			
< 1.18 < 4.70 ± 0.010		INNER SURFACE:		APPROVED BY: V.N.			
< 4.70 < 13.70 ± 0.020		TECHNICAL POLISHED		APPROVAL DATE: 28.06.23			
METRIC		UNDIMENSIONED DRAFT:		SCALE: 2 : 1		UNITS: MILLIMETERS	
< 30 ± 0.2		Q'30' PER SIDE		SHEET 1 of 1			
< 120 ± 0.3							
< 450 ± 0.5							
ANGULAR ±0°15' FOR DIM > 1"							
CONFIRM CURRENT REVISION PRIOR TO USE		FILE NAME: FRE-330500C		DRAWING FORMAT: A3			
CONFIDENTIAL POSSESSION OF THIS DRAWING IS AN ACKNOWLEDGEMENT THAT IT AND ITS CONTENTS ARE THE EXCLUSIVE PROPERTY OF APTAR. THE ARTICLE SHOWN ON THIS DRAWING OR THE DRAWING MAY NOT BE REPRODUCED IN ANY FORM WHATSOEVER WITHOUT WRITTEN PERMISSION FROM APTAR.		Aptar					
		DRAWING NUMBER: FRE-330500C					
		CUSTOMER DRAWING					