
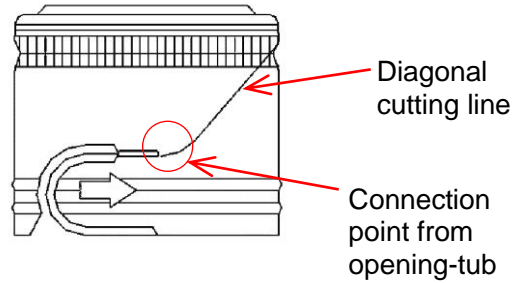


Recommended Quality Control for Capping of KT+KS Sake Closures

We suggest the below method for quality control on a routine basis.

Test	Numeric control			Visual control	
	Crimping height	Crimping depth (dia.)	Rotation torque of KT	Diagonal cutting line	Connection point from opening-tub
Good or NG	9.5±0.3mm Vernier caliper	28.4±0.2mm Vernier caliper	40~120N·cm Torque gauge	Wide opening is NG	Rupture is NG
Note	>Too low: may make damage to connection point from opening-tub, causes unusual opening. >Too high: may cause opening of diagonal cutting line. Also make damage to the bottle neck.	>Too big (i.e. loose): may cause easy KT rotation which makes difficult to open KT. >Too small (i.e. hard): cause damage to diagonal cutting line, and a risk of unusual opening.	>This is not affected to sealing itself. This may not controlled on a routine basis. >If lower than 40N·cm, KT may turn easily so that difficult to open. >If higher than 150N·cm, a risk of damage to the bottle neck.	>Too big opening may cause injury while the bottle neck held by hand. >Shallow opening usually is acceptable.	>Crimping height and dia. may not adjusted properly. >It is not unfavorable from the point of pilfer-proof.
explanation drawings	 <p>9.5±0.3mm Difficult to measure precisely, so use reference</p> <p>28.4±0.2mm average of 2 points i.e. bottle neck parting line and PL +90°.</p>			 <p>Diagonal cutting line</p> <p>Connection point from opening-tub</p>	

>The recommended figures are for our KT+KS subject to our recommended capping tool. Sake caps made by other companies may have different control range.
 >The measurement results are different between just after filling/capping and some hours later.
 >Sake-bottle neck finish (KT+KS finish) is used not only 1.8 liter bottle but also many of 720ml/300ml bottles recently. We recommend to make your own control method by actual used bottles and capping machine.

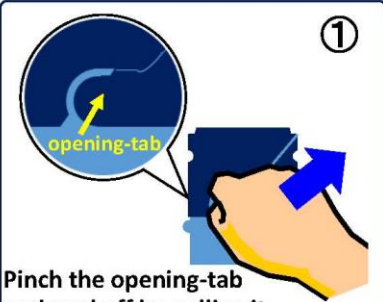
(end of paper / hy) original 2012.7.12 translated 2016.6.28/tk

For your reference

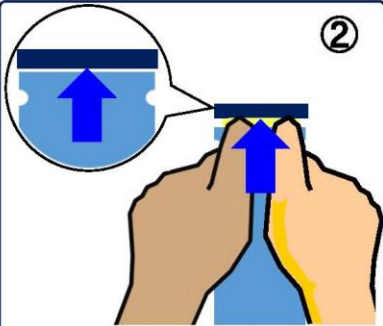
Opening tub must be peeled upward, at least horizontally. Can't open properly if pull downward.

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To open Traditional SAKE cap



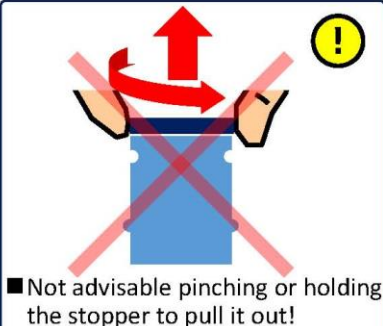
① Pinch the opening-tab and peel off by pulling it transversally upward.
(Upward is easier than Horizontally.)



② Push up the stopper with thumbs.



Do not pull downward!
Be careful with the cutting edge of the peeled capsule!



Not advisable pinching or holding the stopper to pull it out!
SAKE bottles cannot be opened by turning the stopper!

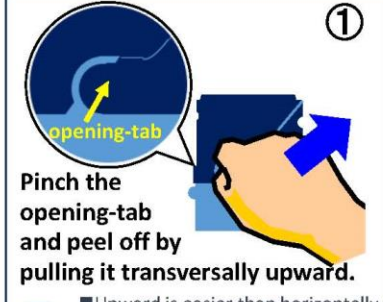
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! ! ! NG ご注意

改訂版 rev.2
「真横禁止」→
「真横より斜め上
を推奨」に変更
2014.09.16


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To open Traditional SAKE cap



① Pinch the opening-tab and peel off by pulling it transversally upward.

- Upward is easier than horizontally.
- Do not pull downward!
- Be careful with the cutting edge of the peeled capsule!



② Push up the stopper with thumbs.

- Not advisable pinching or holding the stopper to pull it out.
- SAKE bottles cannot be opened by turning the stopper!

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「お酒のキャップ」(一升びんなどに使われる「冠頭・替栓」)の開け方 150201+160525

	英語 English	日本語 Japanese	フランス語 French	イタリア語 Italian	ドイツ語 German
1	<p>Pinch the opening-tab and peel off by pulling it transversally upward. (Upward is easier than Horizontally.)</p> <p>opening-tab</p> <p>Do not pull downward! Be careful with the cutting edge of the peeled capsule!</p>	<p>「取口」を起こしてつまみ、「斜め上」方向に引く。 (「真横」より「斜め上」が開きやすい)</p> <p>「取口」</p> <p>「斜め下」に引くのは× アルミの切断面に注意！</p>	<p>Pincer la languette et décoller tirant transversalement vers le haut. (Tirer vers le haut est plus facile que de tirer horizontalement)</p> <p>Languette d'ouverture</p> <p>Ne pas tirer vers le bas! Prenez garde avec la fine pointe de la capsule!</p>	<p>Alzare la linguetta e tirarla obliquamente verso l'alto. (E' facile aprire seguendo l'incisione della linguetta tirando verso l'alto e non orizzontalmente.)</p> <p>Linguetta d'apertura.</p> <p>Non tirare obliquamente verso il basso! Stare attenti con la punta di troncatura, è tagliente!</p>	<p>Den Griff leicht anheben und den Deckel nach oben abziehen. (nach oben ist einfacher als nach vorne)</p> <p>Griff</p> <p>Den Griff nicht nach unten ziehen. Vorsicht vor den scharfen Kanten des abgezogenen Deckels !</p>
2	<p>Push up the stopper with thumbs</p> <p>Not advisable pinching or holding the stopper to pull it out! SAKE bottles cannot be opened by turning the stopper!</p>	<p>親指で押し上げると開けやすい。</p> <p>「つまむ」「握る」は開けにくい！</p> <p>回しても開きません！</p>	<p>Pousser le bouchon vers le haut d'un mouvement de pouce</p> <p>Il est plus difficile d'ouvrir la bouteille en pinçant ou tenant le bouchon ! Ce ne sont pas des bouchons à vis. Les bouteilles de saké ne peuvent être ouvertes en tournant le bouchon!</p>	<p>Spingere in alto usando due alluci.</p> <p>Funziona male se lo tiri o aggrappi!</p> <p>Non si apre la bottiglia di Sake, se giri il tappo!</p>	<p>Den Verschluss mit beiden Daumen von der Unterseite nach oben druecken.</p> <p>Den Verschluss nicht unter seitlichen Druck nach oben ziehen. Sakeflaschen koennen nicht durch Drehen des Verschlusses geoeffnet werden.</p>