



KITA SANGYO

“HEIWA Crimper Head” and “Hand Capper model K”, manual capping of Sake KT+KS closures User’s guide

「平和 1.8L 王冠用ヘッド」と「手押し打栓機・モデル K」の操作説明



Important notice

- Use the hand capper on a durable and flat table, which is strong enough to withstand the heavy weight and operation movement.
- Falling down of the capping head / hand capper may cause injury. Fixing the capper base to the table by screws is recommended.
- Use grove and safety glass to prevent injury in case of glass break.

重要なお注意

- 据え付けは確実に！機械重量に十分耐えられる丈夫で平らな机に、水平になるように据え付け、転倒防止の処置をしてください。
- 据え付けに不備があると、落下・転倒・異常振動などが発生し人身事故につながります。手押し打栓機の底板は机に固定することを推奨します。
- 破びんのリスクに備えて、保護メガネ・保護手袋を着用することを推奨します。

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Set up "crimper head" and "hand capper" セットアップ



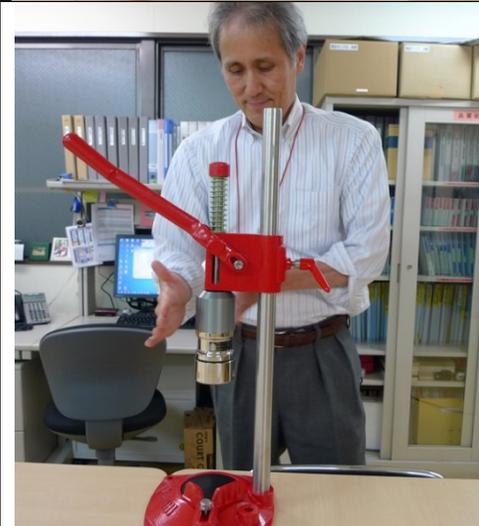
1. Place the hand capper on a table.

手押し打栓機を作業のしやすい机に固定します。



2. Insert the crimping head into the thread of capper.

打栓ヘッドを、手押し打栓機のネジ部分に差込みます。



3. Screw-in until the tread end and firmly fixed.

止まるまで回転させます。打栓ヘッドをしっかりと固定してください。



4. Ready to do capping KT+KS closures.

取付け完了。王冠の打栓が出来る状態になりました。

Issyobin (Sake 1.8 liter bottle) capping 一升びんの打栓

		
<p>The height of crimping head should be adjusted “even” or “2-5mm lower” to the bottle height.</p> <p>打栓ヘッド下端の高さが、びん高さと同じ、または 2~5mm 低くなるように高さを調整します。</p>	<p>Very important: The center of the bottle and the crimping head must be in line. Please check the centering position by actual bottle, and,, 重要！ びんの中心線と打栓ヘッドの中心線が一致してはいけません。実物のびんで位置を合わせて、、、</p>	<p>,,, adjust the side supporter to make the correct center and fix it.</p> <p>、、、びん固定金具(Y字型金具)をその位置に合わせて、固定します。</p>



Apply the KT+KS cap to the bottle. Push-in the cap vertically and firmly until the end.

びんに、KT+KS(冠頭+替栓)を手で最後まで押込みます。垂直に力をかけてください。



Place the bottle on the capper plate. Please remind, centering of crimping head and bottle.

びんを打栓機に置きます。びんと打栓ヘッドの中心線が出ていることに留意してください。



Press the handle underneath completely. Capping completed. Check the KT is firmly cramped, and does not turn easily.

ハンドルを真っ直ぐ最後まで下ろします。打栓完了です。KTが十分クランプ(びん凹部に沿って変形)されているか、また簡単に回らないことを確認してください。

QC of capping, please refer → http://www.kitasangyo.com/e-Academy/capping/KT+KS_capping_E.pdf

Kita Sangyo Co., Ltd. QA & Environment Div.

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					

>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.

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

E / 4-frame

To open Traditional SAKE cap

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

Not advisable pinching or holding

E / 2-frame

To open Traditional SAKE cap

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

Not advisable pinching or holding

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

REFERENCE
※参考資料・きた桑葉

	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	Pinch the opening-tab and peel off by pulling it transversally upward. (Upward is easier than horizontally.) opening-tab Do not pull downward! Be careful with the cutting edge of the peeled capsule!	「取口」を起こしてつまみ、「斜め上」方向に引く。 (「長横」より「斜め上」が開きやすい) 「取口」 「斜め下」に引くのは× アルミの切断面に注意！	Pincer la languette et décoller tirant transversalement vers le haut. Languette d'ouverture Ne pas tirer vers le bas! Prenez garde avec la fine pointe de la capsule!	Alzare la linguetta e tirarla obliquamente verso l'alto. (E' facile aprire seguendo l'incisione della linguetta tirando verso l'alto e non orizzontalmente.) Linguetta d'apertura. Non tirare obliquamente verso il basso! Stare attenti con la punta di troncatura, è tagliente!	Den Griff leicht anheben und den Deckel nach oben abziehen. (nach oben ist einfacher als nach vorne) Griff Den Griff nicht nach unten ziehen. Vorsicht vor den scharfen Kanten des abgezogenen Deckels!
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!	親指で押し上げると開けやすい。 「つまむ」「握る」は開けにくい！ 回しても開きません！	Pousser le bouchon vers le haut d'un mouvement de pouce 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!	Spingere in alto usando due alluci. Funziona male se lo tiri o aggrappi! Non si apre la bottiglia di Sake, se giri il tappo!	Den Verschluss mit beiden Daumen von der Unterseite nach oben druecken. Den Verschluss nicht unter seitlichem Druck nach oben ziehen. Sakeflaschen koennen nicht durch Drehen des Verschlusses geoeffnet werden.

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日本語版の KT+KS キャッピングの品質管理 → http://www.kitasangyo.com/e-Academy/capping/KT+KS_capping_J.pdf

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