



RUBA Thermoplast AG

your top cap supplier &
professional toolmaker



RUBA Quality Levels



All RUBA screw caps are inside injected and therefore especially suited to a finishing procedure.

To achieve the optimal efficiency and quality of the caps, it should be paid a lot of attention to many factors throughout the whole production process. Depending on the type of finishing and the customer's quality requirements, additional services are offered and can be ordered as well.



To minimize slight damage of RUBA caps caused by transportation, we offer our customers the possibility of packing smaller packages (smaller content in shipping cartons) upon request.

The percentage of rejects in the finishing process is 1 - 20% depending on the type of finishing and depends mainly on the desired quality of the customer.

An overview of the relevant surcharges can be found here:

| Type of finishing | Embossing | Full embossing | Metallization | Coating |
|-------------------|-----------|----------------|---------------|---------|
| Reject rate | 2 to 4 % | 5 to 8% | 10 to 20% | 5 to 8% |

| Quality level | Description | Explanation/ Rekommandation | Recommended order quantity for finishing | Guide price €/1'000 |
|-----------------------------|--|---|--|------------------------|
| QL_00 Standard | - standard quality and quality checks in accordance with directives | Standard production without any special additional work process Suitable for white and light-shaded caps | N/A | N/A |
| QL_01 Clean room filling | <ul style="list-style-type: none">- assessment and advice- special training of employees- cooling time adjustment (if necessary)- increased control- increased hygienic demands- covering of cartons with tape- closing of PE bags using the cable tie- protecting the pallets using foil hoods- documentation per order incl. photo per carton- using of plastic pallets (if required) | Special filling process Minimum share of dust particles Suitable for pharmaceutical products and dark finished caps | N/A | 4.00 |



| Quality level | Description | Explanation/recommendation | Recommended order quantity for finishing | Guide price €/1'000 |
|------------------------------------|---|--|--|------------------------|
| QL_02 Finishing & Pearl colours | <ul style="list-style-type: none"> - competent advice and clarifying regarding the quality requirements of customer - special training of employees - increased control - cooling time adjustment, extension of the cooling line, reduction of drop height (if necessary) - creation of a range board (if necessary, costs €250.00) - increased hygienic demands - protecting the pallets using foil hoods | <p>Suitable for all cosmetic closures, which are finished or refined</p> <p>Suitable for black and all dark colours Suitable for pearl colours/pearl masterbatches</p> | 108 to 120% | 0.50 to 3.50 |
| QL_03 Handling robot | <ul style="list-style-type: none"> - includes the complete QL_02 Finishing - robotical removal of the caps | The caps are delivered loose in the box Scratches are minimized Suitable for high-quality cosmetic products, as well as for black and all dark colours | 103 to 105% | 4.00 to 10.00 |
| QL_04 Layers | <ul style="list-style-type: none"> - includes the complete QL_02 Finishing - manual sorting/selection of caps based on range board - special packaging of parts incl. 100% control | The caps are delivered layered Suitable for very high quality and luxurious cosmetic products | 100 to 102% | 40.00 to 80.00 |
| QL_PCR | <ul style="list-style-type: none"> - special process, settings, production optimizations - dirt inclusions, other optical defects due to raw material and colour difference per batch possible - no sorting, quality control according to specifications QL_00 | Competent advice, clarification of suitable materials. Previous sampling necessary (€500.-) incl. documentation and report | N/A | Factor 1.5 – 3.0 |



If the ordered caps will be finished/decorated (metallized, embossed etc.), we would ask the buyer to mention this intention on his order. At least one additional service should be ordered as the standard quality QL_00 is not recommended for further processing.

We do not accept any liability for our subcontractors. Our liability is limited to the amount/quantity of the concerned order.

The delivery time for the finishing takes usually several weeks, because of various production steps, which are necessary by finishing. This should be considered when ordering.

We would like to inform you about the different kinds of decoration as well as to introduce some suppliers:

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We are always at your disposal for further information about the possibilities for refining our screw caps