

**O Z P A K***Bottled in Australia, Packaged for the World***SPECIFICATIONS FOR DECORATIVE METAL CAPSULES**

Prepared by Ozpak Pty Ltd	Date of Issue
Based on Guidelines prepared by W.P.A. members: Barossa Bottling Services, Best Bottlers, Hunter Bottling Co., McLaren Vale Bottlers, Ozpak, Portavin, Prowine, Torresan Estate & Vinpac	1 st September 2014

THIS IS A SPECIFICATION FOR CIRCULATION TO CUSTOMERS AND SUPPLIERS OF DRY GOODS. PLEASE MAKE SURE THE APPROPRIATE PEOPLE IN YOUR COMPANY ARE GIVEN A COPY OF THIS DOCUMENT.

This Specification will be updated as required.

PURPOSE

- To inform customers, capsule designers, manufacturers and suppliers of Ozpak's Specifications for Decorative Metal Capsules.
- The requirements contained in this Specification are given to ensure that decorative metal capsules are capable of being applied on Ozpak's bottling lines.

GUIDANCE

- Ozpak's experienced staff are available to answer any queries regarding the contents of this Specification, and can assist with design concepts and organise trials of capsules to ensure satisfactory results prior to bottling.
- Capsules cannot be orientated to bottle.
- All queries regarding the requirements of this Guideline should be directed through Ozpak's Customer Service Manager.

RESPONSIBILITY

- Customers must ensure that decorative metal capsules provided are manufactured with reference to the information contained in this Specification.
- All capsules must conform to the Winemakers Federation of Australia Wine Packaging Guidelines unless otherwise specified in this document.
- Technical drawings and application specifications must be supplied in PDF format.

REQUIREMENTS

- The decorative metal capsule must:
- Be manufactured to the specification of the particular bottle finish they are intended to fit.
- Must not split or separate during or following application to the bottle.
- Acceptable tolerance levels and requirements for decorative metal capsules are contained in the following table:

Criteria	Description	Tolerances
Dimension	Length	45 - 70mm (± 1 mm tolerance)
	Top Diameter	29-34 (± 0.5 mm)
	Taper	in accordance with length and bottle (± 0.5 mm)
	Ovality	1.0mm max
Top Disc Air Holes	Size	1.0mm - 1.5mm with all excess material removed
	Number of holes	4 required for automated dispensing
	Distance from centre	5mm approx
Material	Thickness	As manufacturer has specified ± 0.1 mm
	Alloy type	Needs excellent spinning capability
Print	Artwork	Shall not differ from supplied artwork
	Print	Clear, no smudging & shall not rub off/scuff.
	Registration	0.5mm \pm
Colour	Darker/lighter	5% \pm darker lighter
		Must have high scuff resistance
Spacing of Caps on Stick		8 - 11mm with well defined separation rings
Length Per Stick		Less than 600mm

Appearance		Not damaged/crushed/scuffed
		Not stuck together
		Not flattened
Application		Capsules are not to split or separate during or following application to the bottle
Length Per Stick		Less than 600mm
Packing		Sticks packed horizontally into recessed trays with end caps in a suitable carton to avoid crush damage, sealed to prevent ingress of foreign material and in clean packaging that is made of contamination resistant recyclable material.
Storage		Capsules are particularly fragile. Storage in suitable cartons is critical to their stability and performance. Downward pressure caused from incorrect storage could result in damage, preventing automatic dispensing on the bottling line.

PACKAGING AND DELIVERY

Detailed information on the packing and delivery of dry goods is contained in Ozpak's Specification for the Documentation, Packaging and Delivery of Customer Supplied Dry Goods Delivery.

AUSTRALIAN PACKAGING COVENANT

As part of Australia's sustainability objectives, we request that where practical dry goods are made using recyclable materials and are packed using recycled materials.

GOOD MANUFACTURING PRACTICE (GMP) AND FOOD SAFETY

The manufacturer/supplier shall maintain pest control within their production facility. ISO and HACCP systems must be in place.

INSPECTION AND TESTING

The manufacturer/supplier must maintain a plan of inspection and testing of the product at all stages of production. Parameters and processes must be set up to ensure checks are carried out with sampling and inspection at critical control points.

REFERENCES

Winemakers Federation of Australia – Wine Packaging Guidelines November 2012

www.wfa.com.au

[Australian Packaging Covenant www.packagingcovenant.org.au](http://www.packagingcovenant.org.au)



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