



# **WINEMAKERS' FEDERATION OF AUSTRALIA**

# **WINE PACKAGING GUIDELINE**

Guidelines for the Use of Wine Packaging

**WINEMAKERS' FEDERATION OF AUSTRALIA**  
INCORPORATED

---

National Wine Centre, Botanic Road, Adelaide SA 5000 (PO Box 2414, Kent Town SA 5071) Telephone: 08 8133 4300, Facsimile: 08 8133 4366  
Email: [wfa@wfa.org.au](mailto:wfa@wfa.org.au)  
**ABN 38 359 406 467**

**WINEMAKERS' FEDERATION OF AUSTRALIA**  
**INCORPORATED**

---

National Wine Centre, Botanic Road, Adelaide SA 5000 (PO Box 2414, Kent Town SA 5071) Telephone: 08 8133 4300, Facsimile: 08 8133 4366  
Email: [wfa@wfa.org.au](mailto:wfa@wfa.org.au)  
**ABN 38 359 406 467**

**Wine Packaging Guidelines:**

The following guidelines have been prepared by the Winemakers' Federation of Australia (WFA) Packaging Committee. The guidelines are intended to provide a basic level of understanding of fundamental wine packaging issues for small to medium wineries and new entrants to the industry and are best used as a guide to the discussions that wineries should be having regarding specifications required for dry goods between packaging suppliers, wineries/brand owners and wine packagers.

The expert advice provided by members of the WFA Packaging Committee in the preparation of this document is gratefully acknowledged. These guidelines are supplemented by 'The Code of Good Manufacturing Practice for the Australian Grape and Wine Industry' prepared by the Australian Wine Research Institute (AWRI) and available to download from the AWRI website: [www.awri.com.au](http://www.awri.com.au) and the Wine Packagers of Australia (WPA) Specifications.

**WFA Packaging Committee:**

The Packaging Committee was established by the WFA to enable the development of a unified position for the wine industry in regard to packaging related issues. By maintaining a forum for direct discussion amongst industry stakeholders, the Packaging Committee is positioned to respond to political, technological, environmental, regulatory and market driven changes in wine, wine product and brandy packaging.

**Further Information:**

For further information contact the Executive Officer of the WFA Packaging Committee by phone on (08) 8133 4300 or email via [wfa@wfa.org.au](mailto:wfa@wfa.org.au)

**Disclaimer:**

The Winemakers' Federation of Australia Incorporated (WFA) has used all reasonable care and skill in preparing these guidelines, but does not warrant, expressly or impliedly, the accuracy or completeness of the information contained in this publication. Except to the extent that the WFA is prevented by law from limiting its liability for such loss, the WFA will not be liable for any loss suffered by any person using (either directly or indirectly) or relying (wholly or partially) on this publication, whether that loss arises from the WFA's negligence or otherwise. Any person using this publication should independently verify the accuracy, currency, suitability and completeness of the information before relying on it.

The information in this publication is correct as of 30th April 2015 and is subject to change without notice. The WFA reserves the right, in its sole discretion and without any obligation, to make improvements to, or correct any errors or omissions in any portion of these guidelines. The WFA is not responsible for ensuring that you receive any further updates of this publication.

© Copyright 2015

The Winemakers' Federation of Australia

National Wine Centre, Botanic Road, Adelaide SA 5000

PO Box 2414, Kent Town SA 5071

ABN 38 359 406 467

© Copyright: Reprint and quotation of the information published herein is permitted on the condition that full credit be given to the Winemakers' Federation of Australia.

## **Wine Packaging Guidelines: Index**

### **1. WINE SUPPLY & FILLING**

- Dissolved (DO) Oxygen in bulk wine
- Total Package Oxygen (TPO)
- Dissolved Carbon Dioxide
- Dissolved Nitrogen
- Filtration
- Fill Heights
- Fill Volume
- Sanitation

### **2. WINE BOTTLE CLOSURES**

#### **Natural Cork, Technical Cork, Sparkling Wine Cork,**

#### **Synthetic Closure**

- Visual Grade
- Critical Defects
- Non Critical Defects
- Closure Treatment
- Closure Taint

- Flavour Scalping
- Closure Moisture
- Embodied Oxygen and Oxygen Transmission Rate (OTR)
- Storage
- Usage

#### **Roll-On Tamper Evident Closures**

- Dimension
- Material & Thickness
- Liner
- Oxygen Transmission Rate (OTR)
- Decoration
- Knurling & Bridges
- Storage & Transportation
- Usage

#### **Crown Seal**

- Dimension
- Material and thickness
- Liner
- Decoration

- Varnish
- Storage and Transportation
- Usage
- Performance
- Alternative Closures

- Storage & Palletisation
- Usage

**Decorative Capsules: PVC / PET / Spinnable**

**Poly laminate, Metal, Poly laminate Sparkling Wine Hoods**

- Dimension
- (Top Disc) Air Holes
- Tear Tabs
- Material Thickness
- Decoration
- Spacing of Caps on Stick
- Appearance
- Seam
- Bottle Application
- Length Per Stick
- Packing
- Identification Label

### **Sparkling Wine Muselet**

- Dimension
- Body Wire
- Belt Wire
- Disk Steel
- Spacing of Muselet on Stick
- Appearance
- Bottle Application
- Length of Stick
- Packing
- Identification Label
- Storage & Palletisation
- Usage

### **3. LABELS**

- Size
- Colour
- Label Integrity
- Print Registration
- Adhesive

- Paper Grain
- Embossing
- Screen Printing
- Neck Labels/Strips
- Storage & Conditioning
- Release Liner
- Scuff Resistance
- Paper Selection
- Packaging of Labels
- Roll Direction

### **4. CARTONS**

- Carrying Capacity
- Corrugated Glue Bond Strength
- Dimension/Size
- Board Material - Flute Grade to be Specified
- Crush
- Cartons Containing Glass Bottles
- Print Quality

- Pre-print/Gloss Cartons
- Presentation/Integrity
- Quantity/Palletisation/Delivery
- Supplier Identification
- Storage Conditions
- Quality Levels
- Specifications for general purpose corrugated fibreboard boxes and blanks

#### **5. BAG-IN-BOX / SOFTPACK**

- Oxygen Transmission - Tap
- Oxygen Transmission - Cask Film Material
- Flex-Cracking
- Box-Pouch Compatibility
- Wine Preservatives
- Dissolved Gases
- Best Before Dates

#### **6. GENERAL PRODUCT SPECIFICATIONS**

- General
- Bottle Shape & Style
- Carton Shape
- Carton Orientation (Upright/Laydown)
- Pallet Configuration
- Slip Sheet
- Carton Identification (Stencil/Sticker)
- Divider
- Top Pads
- Carton Strength
- Barcode Requirements
- Mandatories / Sparkling Warnings / Display
- Capsule
- Neck Tags / Accessories

#### **7. GLASS BOTTLES**

- Dimensions
- Finish
- Capacity



- Exterior Surface Coating
- Label Panel
- Bottle Colour
- Glass Contaminants
- Lot Marking
- Handling & Storage
- Packing
- Critical Defects
- Major Defects
- Minor Defects
- Glass Glossary/Terminology

## **8. PET CONTAINERS**

- Dimensions
- Finish
- Capacity
- Exterior Surface Coating
- Label Panel
- PET Colour
- Fragments

- PET Supplier Container Defects
- Storage of Containers (pre & post fill)
- Handling & Storage
- Packing (prefilled)
- Traceability
- Product Identification & Traceability (post)
- Warehousing Finished Product
- Stock Rotation
- PET Type
- Filling & Capping Machine Set Up

## **9. PACKAGING USAGE & SAFETY**

- General
- Product Identification
- Packaging Usage

## 1. Wine Supply & Filling

Critical Issue	Description	Recommendation/Observation
Dissolved Oxygen, (DO), in bulk wine	Can have a detrimental effect on product quality.	Sparge as required to reduce the DO to at least 0.5 ppm in tank.
Total Package Oxygen, (TPO.) in bottle.	This includes the DO in the wine and oxygen that has been trapped in the ullage space at closing.	<p>Should be kept as low as possible. Excess oxygen can result in premature aging resulting in the darkening of product and the modification of flavours (flavour loss and the development of undesirable flavours) leading to reduced shelf life. TPO levels should be measured during packaging to ensure that O<sub>2</sub> pick-up is controlled to a minimum.</p> <p>Total package oxygen at bottling can be measured in a number of ways including the following:</p> <ul style="list-style-type: none"> <li>• Oxyluminescence technologies such as the NomaSense, <a href="http://www.nomacor.com/wine-oxygen-analyzers.php">http://www.nomacor.com/wine-oxygen-analyzers.php</a>. The;</li> <li>• Using technologies to measure dissolved oxygen such as the Orbisphere along with appropriate bottle shaking protocols and calculations to account for the residual oxygen in the headspace.</li> </ul>
Dissolved Carbon Dioxide	The level of dissolved carbon dioxide will determine the level of "spritz".	If levels are too high this can cause filling problems due to fobbing. The closure and bottle must be appropriate for the dissolved carbon dioxide level. Dissolved carbon dioxide should be measured before and after filling. CO <sub>2</sub> is not usually used at the filler while filling red wine.
Dissolved Nitrogen	Used as an inert blanket during processing as a protection against oxidation.	Whilst only sparingly soluble at low product temperatures, dissolved nitrogen can cause excessive frothing during filling.

<b>Wine Supply &amp; Filling continued...</b>		
<b>Critical Issue</b>	<b>Description</b>	<b>Recommendation/Observation</b>
Filtration	Filtration can reduce or remove particulate matter and microbial contamination.	Integrity testing of absolute filters should be undertaken before and after filling. Testing of product filterability index should be determined to maximise filter life. <b>It is recommended that 0.45 micron membrane filtration should be used for wines containing fermentable sugars.</b> Filtration conditioning is essential. Manufacturers recommendations are required to ensure the correct filtration is used
Fill Heights	The fill height has to be at a level that allows enough ullage space for expansion of the wine at increased temperatures.	For standard Cetic cork finish bottles the ullage space should be greater than 12mm @ 20deg C. The use of a vacuum corker is strongly recommended. With standard BVS finish bottles the ullage space should be greater than 30mm. Bottle supplier recommendations should be used.
Fill Volume	The volume in the bottle must conform to the labelled volume under the National Trade Measurement Legislation which can be either the Minimum Fill System or the Average Quantity System.	Fill volumes must be measured using statistically reproducible systems. For information on National Trade Measurement Legislation contact the National Measurement Institute – <a href="http://www.measurement.gov.au">www.measurement.gov.au</a>
Sanitation	Clean sterile equipment is a prerequisite to the proper packaging of wine.	High levels of spoilage yeasts and bacteria will develop if the wine supply lines, filtration and filler are not comprehensively cleaned to manufacturer's recommendations. Machines and supply systems should be sanitised before bottling.

## 2. Wine Bottle Closures

### Natural Cork, Technical Cork, Sparkling Wine Cork, Synthetic Closures

		Recommendation/Observation			
Critical Issue	Description	Natural Cork	Technical Cork	Sparkling Wine Cork	Synthetic Closure
Visual Grade	The visual grade is assessed by correlating the number of defects or natural blemishes on the closure to a pre-set grade with the supplier.	Price and visual grade are directly related. Lower visual grades increase the risk of cork failure. A tolerance of +/- 5% can be set for each level of cork within the respective grade.	Price and visual grade are directly related. Lower visual grades can increase the risk of cork failure. A tolerance of +/- 5% can be set for each level of cork within the respective grade.	Price and visual grade are directly related. Lower visual grades can increase the risk of cork failure. A tolerance of +/- 5% can be set for each level of cork within the respective grade.	Not Applicable.
Critical Defects	These are defects that will potentially cause the closure to fail.	Zero is the target.	Zero is the target.	Zero is the target.	Zero is the target.
Non Critical Defects	These are defects that although visible are unlikely to cause the closure to fail.	Non critical defect levels increase as the visual grade decreases.	Non critical defect levels increase as the visual grade decreases.	Non critical defect levels increase as the visual grade decreases.	

Wine Bottle Closures continued...		Recommendation/Observation			
Critical Issue	Description	Natural Cork	Technical Cork	Sparkling Wine Cork	Synthetic Closure
Closure Treatment	Closures are usually treated with a coating to help insertion, extraction and wine travel reduction.	Cork extraction forces should be in the range of 25-40KG/F after 24 hours at room temperature (20°C) for red wine and at fridge temperature (5°C) for white wine. Wine travel up the side of the cork should not occur. Based on the treatment used the best before date should be 6 months from the production date.	Cork extraction forces should be in the range of 25-40KG/F after 24 hours at room temperature (20°C) for red wine and at fridge temperature (5°C) for white wine.	Removal of sparkling wine corks relies upon a twisting torque motion in the range of 2.2nm to 2.8nm. The treatment and insertion depth will affect the ease of extraction. Insertion depths should be monitored during the production run.	Cork extraction forces should be in the range of 25-40KG/F after 24 hours at room temperature (20°C) for red wine and at fridge temperature (5°C) for white wine. Wine travel up the side of the cork should not exist.
Closure Taint	All closure batches can cause some type of flavour modification. This ranges from the addition of highly flavoured wood related compounds to highly aromatic tainting compounds such as TCA, glue related flavours and plastic contaminants.	Cork batches should contain a minimal level of taint affected corks, as evaluated through an agreed sensory method.	Cork batches should contain a minimal level of taint affected corks, as evaluated through an agreed sensory method.	Cork batches should contain a minimal level of taint affected corks, as evaluated through an agreed sensory method.	No flavour modification should occur.
Flavour Scalping	Closures have the ability to mask or absorb the fruit flavours of the wine.	No masking or absorbing should occur.	No masking or absorbing should occur.	No masking or absorbing should occur.	No masking or absorbing should occur at bottling but can occur over time.
Closure Moisture	The moisture level of closures is critical to their stability and performance.	Treated corks should have a moisture level of 6-8%.	Treated corks should have a moisture level of 4-8%.	Treated corks should have a moisture level of 4-8%.	Not Applicable.

Wine Bottle Closures continued...		Recommendation/Observation			
Critical Issue	Description	Natural Cork	Technical Cork	Sparkling Wine Cork	Synthetic Closure
Embodied oxygen and oxygen transmission rate, (OTR)	<p>Oxygen reacts with wine setting up a driving force for diffusion from both within the closure matrix and from the air outside of a bottle.</p> <p>The rate oxygen diffuses through a closure into wine is called the oxygen transmission rate and it can have a substantial impact on the wine style experienced by the consumer.</p> <p>Low OTR values can lead to the development of reductive characters, high OTR values can lead to shortened shelf life</p> <p>Typically measured using ASTM F 1307 or ASTM F1927</p>	Typically variable OTR value with an average of 0.0005 cc/closure/day in air	Typically OTR value of 0.0005 cc/closure/day in air		Typically OTR value with of 0.002 cc/closure/day in air

<b>Wine Bottle Closures continued...</b>		<b>Recommendation/Observation</b>			
<b>Critical Issue</b>	<b>Description</b>	<b>Natural Cork</b>	<b>Technical Cork</b>	<b>Sparkling Wine Cork</b>	<b>Synthetic Closure</b>
Storage	Storage of closures is critical to the stability and performance. Closures readily absorb and desorb moisture. Closures readily absorb volatile compounds from the environment.	Corks must be stored in a clean dry and cool environment. Refer to supplier for temperature and humidity recommendations. They must not be stored with other chemicals /cleaning agents/paints etc. Corks should be transported and stored separate from all timber products to prevent contamination.	Corks must be stored in a clean dry and cool environment. Refer to supplier for temperature and humidity recommendations. They must not be stored with other chemicals /cleaning agents/paints etc. Corks should be transported and stored separate from all timber products to prevent contamination.	Corks must be stored in a clean dry and cool environment. Refer to supplier for temperature and humidity recommendations They must not be stored with other chemicals /cleaning agents/paints etc. Corks should be transported and stored separate from all timber products to prevent contamination.	Closures must be stored in a clean dry and cool environment. Refer to supplier for temperature and humidity recommendations They must not be stored with other chemicals /cleaning agents/paints etc.

Wine Bottle Closures continued...		Recommendation/Observation			
Critical Issue	Description	Natural Cork	Technical Cork	Sparkling Wine Cork	Synthetic Closure
Usage	Maintenance and set-up of corking machinery is critical to closure performance.	<p>Corker jaws must be clean and free from chips/cracks or abrasions.</p> <p>Only food grade lubricants can be used.</p> <p>Compression diameter is critical and the cork should only be compressed to 16mm.</p> <p>Vacuum corking equipment should be used to maintain a vacuum of 0 to -35kPa under the closure.</p> <p>Headspace (vacuity) should be maintained at a minimum of 12mm (for a 750mL bottle), from the bottom of the closure to the wine surface, when the wine is at 20 degrees, to reduce the likelihood of corks pushing out due to increases in storage temperature.</p>	<p>Corker jaws must be clean and free from chips/cracks or abrasions.</p> <p>Only food grade lubricants can be used.</p> <p>Compression diameter is critical and the cork should only be compressed to 16mm.</p> <p>Vacuum corking equipment should be used to maintain a vacuum of 0 to -35kPa under the closure.</p> <p>Headspace (vacuity) should be maintained at a minimum of 12mm (for a 750mL bottle), from the bottom of the closure to the wine surface, when the wine is at 20 degrees, to reduce the likelihood of corks pushing out due to increases in storage temperature.</p>	<p>Corker jaws must be clean and free from chips/cracks or abrasions.</p> <p>Only food grade lubricants can be used.</p> <p>The recommended Insertion is 23mm +/- 1mm after muselet application.</p>	<p>Corker jaws must be clean and free from chips/cracks or abrasions.</p> <p>Only food grade lubricants can be used.</p> <p>Compression diameter is critical and the closure should only be compressed to 16mm.</p> <p>Vacuum corking equipment should be used to maintain a vacuum of 0 to -10kPa under the closure.</p> <p>Headspace (vacuity) should be maintained at a minimum of 12mm (for a 750mL bottle), from the bottom of the closure to the wine surface, when the wine is at 20 degrees, to reduce the likelihood of closures pushing out due to increases in storage temperature.</p>



<b>Roll-On Tamper Evident (ROTE) Closures</b>		
<b>Critical Issue</b>	<b>Description</b>	<b>Recommendation/Observation</b>
Dimension	Length: Diameter: Ovality: Compatibility:	As specified (+/- 0.25mm) As specified (+/- 0.05mm) Tolerance (+/- 0.4mm) Check compatibility with bottle type.
Material & Thickness	Aluminium Alloy 8011 Thickness Hardness	Discuss with supplier As specified (+/- 0.01mm) Different specifications for hardness exist - essential to discuss with supplier as will impact on application
Oxygen transmission rate, (OTR)	Oxygen reacts with wine setting up a driving force for diffusion from the air outside of a bottle. The rate oxygen diffuses through a closure into wine is called the oxygen transmission rate and it can have a substantial impact on the wine style experienced by the consumer. Low OTR values can lead to the development of reductive characters, high OTR values can lead to shortened shelf life Typically measured using ASTM F 1307 or ASTM F1927	The OTR value is determined by the liner used
Liner	Different liners available from different suppliers	Essential to discuss wadding specifications with supplier/s as different liners provide different sealing capability which has an effect on shelf life. Defects or scratches on the wadding will result in oxidation and/or leakage.
Decoration	As specified by Artwork.  Scuff resistance.	As per agreed colour tolerances with suppliers (high/low colour ranges). Scuff testing specification to be discussed with supplier.
Knurling & Bridges	These are areas where defects can occur in the manufacturing process such as broken bridges or poorly defined knurlings.	Regular inspection should occur to ensure that these defects do not occur.

<b>Roll-On Tamper Evident (ROTE) Closures</b>		
<b>Critical Issue</b>	<b>Description</b>	<b>Recommendation/Observation</b>
Storage & Transportation	Storage of ROTE capsules is critical to the stability & performance. ROTE capsules handled & stored incorrectly can be damaged and not dispense and apply correctly. The wadding material can absorb external flavour contaminants and the storage should reflect this possibility.	ROTE closures must be stored in a clean dry cool environment. Capsules must not be stored with other goods or goods stored on top which can damage the capsules. Ensure palletised cartons are placed onto pallets with no overhang.
Usage	Maintenance and set-up of ROTE capping heads is critical to capsule performance.	Refer to capping machine & cap manufacturer manuals for capping head set up. Critical points to be covered are head pressure, redraw and thread/tuck Specifications of bottle finish, capsule and capping machinery must be compatible.
<b>Crown Seal</b>		
<b>Critical Issue</b>	<b>Description</b>	<b>Recommendation/Observation</b>
Dimension	Height: Diameter External: Diameter Internal: Flange Angle: Dome radius: Compatibility:	As specified (+/- 0.35mm) As specified (+/- 0.55mm) As specified(+/- 0.25mm) 10 degrees – 20 degrees 140mm to 200mm Check compatibility with bottle type.
Material & Thickness	Tin Plate Stainless Steel Type AESI -430	As specified (+/- 0.03mm) As specified ( “ 0.01mm)
Liner	High oxygen barrier wadding is recommended for long term sealing of wine.	Discuss liner requirements with supplier/s to ensure that specifications meet requirements

<b>Crown Seal continued...</b>		
<b>Critical Issue</b>	<b>Description</b>	<b>Recommendation/Observation</b>
Oxygen transmission rate, (OTR)	<p>Oxygen reacts with wine setting up a driving force for diffusion from the air outside of a bottle.</p> <p>The rate oxygen diffuses through a closure into wine is called the oxygen transmission rate and it can have a substantial impact on the wine style experienced by the consumer.</p> <p>Low OTR values can lead to the development of reductive characters, high OTR values can lead to shortened shelf life</p> <p>Typically measured using ASTM F 1307 or ASTM F1927</p>	The OTR value is determined by the liner used
<p>Decoration</p> <p>Varnish</p>	<p>As specified by Artwork.</p> <p>Food grade, varnishes used to meet standards</p>	As per agreed colour tolerances with suppliers (high/low colour ranges). Specify varnishes used are resistant to alcohol water & abrasion.
Storage & Transportation	Proper storage conditions for crown is critical to the stability & performance. Crown seals handled & stored incorrectly can be damaged and not dispense and apply correctly. The wadding material can absorb external flavour contaminants and the storage should reflect this possibility.	
Usage	Maintenance and set-up of Crown capping heads is critical to capsule performance.	Refer to capping machine & cap manufacturer manuals for capping head set up.

<b>Crown Seal continued...</b>		
<b>Critical Issue</b>	<b>Description</b>	<b>Recommendation/Observation</b>
Performance	Pressure resistance: Recommend secure seal testing of product using an approved test pressure vessel at start up & at regular intervals during bottling. Test application using no/go gauge at regular intervals during bottling.	Refer to supplier specifications as to pass/fail dimensions and secure seal requirements. A Go/no go gauge should identify 3 crimping diameters – the ideal, min & max tolerance for passing.

**Alternative Closures**  
Increased number of alternative closures available – manufacturing and application specifications are very specific. Comprehensive investigation to be undertaken with supplier

Decorative Capsules		Recommendation/Observation		
Critical Issue	Description	PVC / PET / Spinnable Poly laminate	Metal	Poly laminate Sparkling Wine Hoods
Dimension	Length: Top Diameter: Taper: Ovality: Orientation Mark:	Per product specification (+/- 1mm) Per product specification (+/- 0.5mm) 1.0 - 1.2 degrees 1.0mm max Not Applicable.	Per product specification (+/- 1mm) Per product specification (+/- 0.5mm) 1.0 - 1.2 degrees 1.0mm max Not Applicable.	Per product specification (+/- 1mm) Per product specification (+/- 0.5mm) 4.5 degrees 2.0mm max Per product specification.
(Top Disc) Air Holes	Size: Number of holes: Distance from centre:	1.0mm - 1.5mm Per product specification. 5mm approx	1.0mm - 1.5mm Per product specification. 5mm approx	1.0mm - 1.5mm Per product specification. Not Applicable.
Tear Tabs	Performance:  Width: Protruding Section:	Per product specification.  PVC 4.5mm +/- 0.5mm PVC 3.5mm +/- 1.0mm (length)	Not Applicable.	Tears cleanly along the edges of the tear tab strip. 4.5mm +/- 0.5mm 3.5mm +/- 1.0mm (length)
Material Thickness		PVC: As specified (+/- 0.01mm) Foil: As specified (0.04mm thick)	As specified (+/- 0.01mm)	Body: As specified (+/- 0.01mm) Foil: As specified (+/- 0.1mm)
Decoration	As specified by Artwork.	As per agreed colour tolerances with suppliers (high/low colour ranges).	As per agreed colour tolerances with suppliers (high/low colour ranges).	As per agreed colour tolerances with suppliers (high/low colour ranges).
Spacing of Caps on Stick		8 - 11mm	8 - 11mm	9 - 11mm
Appearance		Not damaged/crushed. Not stuck together.	Not damaged/crushed. Not stuck together.	Not damaged/crushed. Not stuck together.
Seam		Good adhesion. No excessive glue.	Not Applicable.	Good adhesion. No excessive glue.
Bottle Application		No tearing/splitting. No puckering/blistering/ripping. No scuffing. No upturned edges.	No tearing/splitting. No puckering/blistering/ripping. No scuffing. No upturned edges.	No tearing/splitting. No puckering/blistering/ripping. No upturned edges. No glue failure. No seam opening up.
Length Per Stick		Less than 600mm	Less than 600mm	Less than 600mm

Decorative Capsules continued...		Recommendation/Observation		
Critical Issue	Description	PVC / PET / Spinnable Poly laminate	Metal	Poly laminate Sparkling Wine Hoods
Packing		Sticks packed horizontally.	Sticks packed horizontally	Sticks packed horizontally.
Identification Label		Product description. Quantity of capsules per carton. Product code. Job number. Carton number.	Product description. Quantity of capsules per carton. Product code. Job number. Carton number.	Product description. Quantity of capsules per carton. Product code. Job number. Carton number.
Storage & Palletisation	Storage of capsules is critical to the stability and performance. Capsules handled and stored incorrectly can be damaged and not dispense automatically on line.	PVC must be stored in clean dry and cool environment. The capsules must not be stored with other goods or goods stacked on top which can damage the capsule. Ensure palletised cartons are placed onto pallets with no overhang.	Metal must be stored in clean dry and cool environment. The capsules must not be stored with other goods or goods stacked on top which can damage the capsule. Ensure palletised cartons are placed onto pallets with no overhang.	Capsules must be stored in clean dry and cool environment. The capsules must not be stored with other goods or goods stacked on top which can damage the capsule. Ensure palletised cartons are placed onto pallets with no overhang.
Usage	Maintenance and set-up of closure dispenser and heat unit (PVC) / spinning unit and rollers (Metal) / pleater and smoother (Poly) is critical to capsules performance.	The correct heat setting is critical to the capsules performance. Capsules are not to split or separate either during application or during the shelf life of the product.	Correct rollers and tension is critical to the capsules performance.	Pleaters and smoothers settings must be set to the correct pressure at start up to ensure no blistering occurs.

<b>Sparkling Wine Muselet</b>		
<b>Critical Issue</b>	<b>Description</b>	<b>Recommendation/Observation</b>
Dimension	Top Diameter: Height:	Per product specification (+/- 0.5mm) Per product specification (+/- 0.6mm)
Body Wire	Specification:  Galvanisation: Purity Level: Mechanical Strength:	Galvanised/Lacquered Wire Diameter: Free Belt: 0.95mm +/- 0.03mm Fixed Leg: 1.00mm +/- 0.03mm Secure galvanised coating of at least 30gms/sqm 99.995 Minimal tensile strength: 19kgf Minimal torsion for wire 210mm long: 44 rotations with a 4mm diameter ring.
Belt Wire	Specification: Galvanisation: Purity Level: Mechanical Strength:	As per supplier specifications. First fusion zinc (French Standard: NF A 91.131) 99.995 Minimal elongation: 18% Minimal tensile strength: 28% Minimal torsion for wire 210mm long: 44 rotations with a 4mm diameter ring.
Disk Steel	Tin Plated Steel:  Coloured Steel:	Thickness: 220µm +/- 30µm Minimal tin coating: E = 2.8µm/2.8 µm (coated both sides)  Thickness: 210µm - 230µm Colour coating: 1. Pre treatment varnish 2. Ink 3. Over coating varnish Colour coating made on: 1. Electrolytic tin plated steel 2. Chromium tin plated steel
Spacing of Muselet on Stick		Spacing pitch 5mm +/- 0.5mm
Appearance		Packed to prevent damage and not damaged. Crushed and not stuck together.
Bottle Application		The bottling head twisting nose correctly set will apply and un-apply the muselet to a standard bottle for 2 full cycles, with a failure rate less than 5 per cent.
Length Per Stick		Less than 600mm

<b>Sparkling Wine Muselet continued...</b>		
<b>Critical Issue</b>	<b>Description</b>	<b>Recommendation/Observation</b>
Packing		Sticks packed horizontally.
Identification Label		Product description. Quantity of capsules per carton. Product code. Job number. Carton number.
Storage & Palletisation	Storage of muselet is critical to the stability and performance. Muselets handled and stored incorrectly can be damaged and not dispense automatically.	Muselets must be stored in a clean dry environment. Goods must not be stacked on top which can damage the muselet. Ensure palletised muselet are placed onto pallets with no overhang.
Usage	Maintenance and set up of muselet dispensers and applicators is critical to muselet performance.	Very light coating of food-grade oil to be applied to muselet during muselet manufacture, to assist running in muselet dispensers. Important to rinse off muselet after application to bottle, as acidic wine content will dull the wire zinc finish.



### 3. Labels

		Recommendation/Observation	
Critical Issue	Description	Wet Gum	Pressure Sensitive
Size	<p>It is recommended that the maximum label dimension be restricted in height by 5mm at the top and bottom of the label panel to avoid puckering at the label extremities due to inconsistencies in application (especially for bottles with small label panels such as premium sparkling and burgundy bottles).</p> <p>Label edges must be perfectly cut in accordance with Artwork specifications and free from burrs.</p> <p><u>Wet Gum</u>: Maximum tolerance for any label size on all directions shall be +/- 0.25mm. Maximum variance between smallest and largest label shall be 0.5mm.</p> <p><u>Pressure Sensitive</u>: Size variation is not applicable.</p> <p>Distance between labels on a web shall be in accordance with labeller's manufacturer's specification or recommendation for the labelling machine.</p> <p>Large labels are more susceptible to bubbling/creasing especially when applied to irregular/uneven bottles. Generally the larger the label the greater the risk. Large labels on uncoated paper increases the risk further.</p>	<p>Particular attention to die cut, rule cut, and guillotine cut labels.</p> <p>Attention should be taken to ensure variances do not occur too frequently in a bundle or batch.</p>	<p>Once a die or rule has been made there will be no size variation from that tool.</p> <p>Trials should be conducted under production conditions to confirm that the large label can be applied adequately to achieve the desired aesthetics.</p>
Colour	<p>Labels shall lie between approved colour tolerances. Foil edges to be clean without chipping or feathering.</p>	<p>Colour specifications should be established from first print run and be agreed between printer and print purchaser.</p>	<p>Colour specifications should be established from first print run and be agreed between printer and print purchaser.</p>

Labels continued...		Recommendation/Observation	
Critical Issue	Description	Wet Gum	Pressure Sensitive
Label Integrity	Images shall be as per label Artwork approval. Text and legal requirements shall be as per Artwork approval.	Refer to specific National and International Regulations. Refer to AWBC <a href="#">publications</a> . www.wineaustralia.com	Refer to specific National and International Regulations. Refer to AWBC <a href="#">publications</a> . www.wineaustralia.com
Print Registration	Print registration movement shall not cause image distortion, colour shift or visual misalignment.		
Adhesive	Adhesive shall not bleed from the interface between the stock and the backing medium. Select Adhesive for requirements.		Adhesive should be selected based on requirements for aggression, repositionability, moisture resistance and specialized applications etc. eg, clarity when using clear plastic stocks requiring window effects.
Paper Grain	Grain is to be horizontal with the application orientation on the container.	ie grain should lay lengthways around the curve of the container and cause the label to curl top to bottom when wet.	
Embossing	Embossing is to be evident, in correct position and in accordance with the Artwork. Grain emboss will reduce the surface area contact of adhesive to bottle. A grain free border around the labels helps to maximise adhesive contact from the label edges to the glass, reducing the possibility of label edge lift. Grained labels should be test applied to ensure edge lift does not occur and adhesion is sufficient.	Reference should be made to the colour specification for customer approval.	Reference should be made to the colour specification for customer approval. Emboss should not be so deep that damage to the liner occurs. A 3mm emboss/grain free border is recommended for maximising adhesive contact at the label edges for best adhesion
Screen printing	Large areas of screen “varnish grain” create surface tension. Screen Grain labels should be test applied to ensure adhesion is sufficient and edge lift does not occur.		

Labels continued...		Recommendation/Observation	
Critical Issue	Description	Wet Gum	Pressure Sensitive
Neck Labels/Strips	Uncoated paper should be avoided as lifting/pinging can occur. Permanent adhesive should be used for all necks. Non-Varnish (Reverse Glue Flap) to be provided for overlap of wrap around necks.		Permanent adhesive should be used. Non-Varnish (Reverse Glue Flap) to be provided for overlap of wrap around necks.
Storage & Conditioning	Labels are to be delivered supported, bound and shrink wrapped. Store in a stable environment.	All care to be taken to avoid extremes of humidity variation to allow labels to stabilize moisture content thus avoiding bending and movement of the stock. Labels should be delivered at least 24 hours before use and stored in similar conditions to the applicator environment to ensure they are stabilized to the same temperature conditions.	All care to be taken to avoid extremes of humidity variation to allow labels to stabilize moisture content thus avoiding bending and movement of the stock. Labels should be delivered at least 24 hours before use and stored in similar conditions to the applicator environment to ensure they are stabilized to the same temperature conditions. Remove from sealed packs only as required to load applicator.
Release Liner	Release Liner must remain uniform in colour for total production run.  Labels shall not pre-release from the Release Liner Release Liner shall not break during the application process.  Different material is available. Please consider the environmental impact as only some Release liners are recyclable.		This shall not occur during storage or in the application process.

Labels continued...		Recommendation/Observation	
Critical Issue	Description	Wet Gum	Pressure Sensitive
Scuff Resistance	Labels should be resistant to label damage during transit.	Labels should be fit for purpose and not scuff during application, packaging, storage or transit. Refer to label printer for test details and requirement for trialling if required and request particular attention when divider-less shippers are used.	Labels should be fit for purpose and not scuff during application, packaging, storage or transit. Refer to label printer for test details and requirement for trialling if required and request particular attention when divider-less shippers are used.
Paper Selection	Stock to be compatible with labelling machines, adhesives and application speed.  Moisture integrity should be considered when selecting paper stock	Trials should be conducted under production conditions to confirm compatibility of unproven stocks to the conditions of each bottling line. Where labels are required to be submitted to high humidity and wet conditions, trials should be conducted on printed and varnished stock to ensure they meet expectations under these adverse conditions.	Trials should be conducted under production conditions to confirm compatibility of unproven stocks to the conditions of each bottling line. Where labels are required to be submitted to high humidity and wet conditions, trials should be conducted on printed and varnished stock to ensure they meet expectations under these adverse conditions.
Packaging of Labels	The packaging of labels should be discussed with your label supplier. Different methods of packaging are available. Bulk bins, individual packaged or shrink wrapped rolls are the most common forms of packaging. Each of these types of packaging may have an impact on your storage, WHS or environmental systems.	Ensure that labels are packed in bundles	

<b>Labels continued...</b>		<b>Recommendation/Observation</b>	
<b>Critical Issue</b>	<b>Description</b>	<b>Wet Gum</b>	<b>Pressure Sensitive</b>
Roll direction	The roll direction should be selected as per your labelling machine suppliers specification		Select and specify the correct roll direction applicable to your labelling machine.

## 4. Cartons

### Corrugated and Pre-Print Fibreboard Cartons

Critical Issue	Description	Recommendation/Observation
Carrying Capacity	Performance: For any box to provide satisfactory service in the field depends upon many factors. It is necessary to match the function of the carton to the nature of the contents, and the relevant distribution system (handling processes).	For decision (6 pack versus 12 pack) please consider the following points <ul style="list-style-type: none"> <li>• Customer specifications</li> <li>• OH&amp;S considerations</li> <li>• Packing efficiencies</li> <li>• Palletising efficiency</li> <li>• Product damage during transport</li> <li>• Cost of the packaging</li> </ul> Further Reference: AS 2400 (1986)
Carton type	Different carton types are available for use <ul style="list-style-type: none"> <li>• RSC Carton</li> <li>• Laydown cartons               <ul style="list-style-type: none"> <li>• Different configurations</li> <li>• 2 x 3</li> <li>• 1 x 6</li> <li>• 2 x 6 etc.</li> </ul> </li> <li>• Wrap around carton</li> </ul>	For decision (Carton Type) please consider the following points <ul style="list-style-type: none"> <li>• Customer specifications</li> <li>• OH&amp;S considerations</li> <li>• Pack stability</li> <li>• Packing ability and efficiencies</li> <li>• Palletising efficiency</li> <li>• Product damage during transport</li> <li>• Cost of the packaging</li> <li>• Type of insert /dividers</li> </ul> Supplier/client negotiation - fitness for purpose.

Cartons continued...		
Critical Issue	Description	Recommendation/Observation
Size	Panel Sizes: Slotting Position:  Under/Oversize Slotting:  Height: Other:	Panel size of +/- 1mm with no more than 3mm accumulated. Slotting position +/- 3mm from the centre of crease and clean cut slots.  Under/Oversize slotting +/- 2mm unless specified (the aim is 3mm past the score line).  Height +/- 2mm Centre of slot to line up (same plane).  Minimal evidence of torn edges of board as a result of blunt cutter blades.
Corrugated Glue Bond Strength	Corrugated glue bond strength is measured by the liner adhesion test.	Reference: AS 1301.430s Note: Where A, B, C R or I flute are used, the liner adhesion shall not be less than 0.5 kN/m of flute.
Board Material - Flute Grade to be Specified.	Cartons shall be constructed from A, B, C, R or I flute single wall, double wall or triple wall corrugated fibreboard.  <b>LCBO requirements</b> Shipping container material must be recyclable.	As per negotiated specification between supplier and client. Thickness: 2.4mm - 4.2mm Paperweight to be negotiated between supplier/client to performance.  <b>LCBO requirements</b>  Full details of requirements are available at LCBO Product Packaging Standards – <a href="http://www.LCBOtrade.com">www.LCBOtrade.com</a> .

<b>Cartons continued...</b>		
<b>Critical Issue</b>	<b>Description</b>	<b>Recommendation/Observation</b>
Crush		To be specified between supplier/client. Overall non print area 0.2mm Printed area 0.3mm Pull straps, folding belts 0.25mm ( pending on board combination and art work requirements )
Cartons Containing Glass Bottles	<p><b>LCBO Requirements</b> Single wall cartons (A or C flute) must have burst strength capacity of <math>\geq 175</math> psi as tested by the Mullen Burst Strength Test or 32 ECT</p> <p>Double wall cartons (B or C flute) must have burst strength capacity of <math>\geq 175</math> psi as tested by the Mullen Burst Strength Test.</p>	<p>Refer to LCBO Product Packaging Standards at <a href="http://www.LCBOtrade.com">www.LCBOtrade.com</a> for complete requirements. Approved board grades are Z107A from Amcor Fibre Packaging and 625WK-B(2) from Visyboard, for cartons up to 22 kg.</p> <p>Refer to LCBO Product Packaging Standards at <a href="http://www.LCBOtrade.com">www.LCBOtrade.com</a> for complete requirements.</p>
Print Quality	<p>Colour (cartons shall be between colour tolerances):</p> <p>Register (colours and print):</p> <p>Appearance/Neatness (imperfections shall be eliminated ie Smear/Offset/Spattering/Imperfections)</p> <p>Stereo Placement/Alignment:</p>	<p>Colour: specifications should be established, and agreed between supplier and client using PMS standards. Registration: specifications for register +/- 2mm for each colour and +/- 3mm registration print to each carton. Appearance: specifications should be established between supplier and client. Stereo Alignment: specifications should be established between supplier and client (printing should be squared to the carton panel(s) within +/- 6mm).</p>
Pre-print/Gloss Cartons	<p>Top and Bottom long flaps:</p> <p>Gloss Varnish:</p>	<p>A minimum gap of 4mm +/- 2mm. Specifications to be set by supplier / client; however no gloss prints to occur on internal flaps (glue sealing surfaces).</p>
Presentation/Integrity	<p>Text and Images shall be as per approved artwork, inclusive of legal requirements.</p>	<p>Text and images should be established and agreed between supplier and client Refer to Domestic and International regulations (FSANZ).</p>
Quantity/Palletisation/Delivery		<p>To be agreed between supplier and purchaser, inclusive of shrink or stretch wrap - to reduce moisture changes or possible contamination/damage during storage and distribution.</p>



<b>Cartons continued...</b>		
<b>Critical Issue</b>	<b>Description</b>	<b>Recommendation/Observation</b>
Supplier Identification	Supplier /Pallet Identification	Each carton should have supplier identification and production details.
Storage Conditions	Critical to the aesthetics and performance of the carton.	All cartons must be stored in a clean and dry environment. Store in temperatures above 5 degrees and Below 35 degrees. Excessive dry/wet conditions should be avoided – air humidity affects the material and the usability of the carton. Further reference: Australian Standards.
Quality Levels	AQL Standards	Such specific level can be set to standard AQL levels of Non-conformance. These will need to be agreed between supplier and client.
Specifications for general purpose corrugated fibreboard boxes and blanks	Definitions/Descriptions and Terminology	Reference: AS 3537-2006 No warped/boxed cartons for automated packaging No excess glue to glue lap causing cartons to stick together No fishtailing, no more than 3mm variation between top and bottom of glue lap Washboarding is unacceptable Cartons to be presented the same way, in bundles for automated packaging or mechanical use  ( All above, levels to be agreed to between purchaser and supplier )

## 5. Bag-in-Box / Softpack

<b>Plastic or Metallised Plastic Wine Packs with Dispensing Tap</b>		
<b>Critical Issue</b>	<b>Description</b>	<b>Recommendation/Observation</b>
Oxygen Transmission - Tap	The tap is a large window for oxygen transmission.	Quoted oxygen transmission measurements should be done using ASTM F1307 and are generally measured in cc O <sub>2</sub> /Package/Day @ 25°Celsius
Flow Rate – Tap	Operation of tap should be simple to use with a good flow rate.	It should be expected that a standard drink can be dispensed in less than 5 seconds.
Handling & Storage	Consideration needs to be given to the handling and storage of bags prior to production as excessive heat can cause the taps to deform and degrade the bag material	Recommendation that all bags are transported and stored out of direct sunlight or radiant sources of heat & in a dust free area.
Oxygen Transmission - Cask Film Material	Unlike glass, plastic films allow oxygen to permeate through their structure. The oxygen transmission rate is quoted as cc oxygen/square meter /24hrs. As films are flexed their oxygen transmission rate increases.	When comparing film structures always use measurements of pre-flexed films. Measurements should be done using the ASTM D3985-81.

<b>Plastic or Metallised Plastic Wine Packs with Dispensing Tap continued..</b>		
<b>Critical Issue</b>	<b>Description</b>	<b>Recommendation/Observation</b>
Flex-Cracking	Plastic films can "crack" due to flexing during the packing and transport of softpacks. This cracking increases the oxygen transmission rate of the film and in extreme cases can lead to leakage.	During packing, the pouches need to be handled with care to minimise shocks and excessive flexing.
Box-Pouch Compatibility	The size and dimensions of the cardboard cask box and the pouch are interdependent and will affect the performance of the whole package. Flex-cracking and pack deformation can be improved by optimising the compatibility of the sizes.	Your pouch supplier should provide you with the optimum size combination for you to consider. Design of box should be such that the bag is not exposed to sharp edges of board form die cutting during loading and transport
Wine Preservatives	Due to the oxygen permeability of the pack particular attention needs to be paid to preservative levels at filling to maximise the shelf-life of the pack.	
Dissolved Gases – Carbon Dioxide and Oxygen	Wine contains dissolved carbon dioxide in various quantities. If the level is high at filling the gas can come out of solution during transport and storage causing the bag to balloon (and in extreme cases burst). Dissolved Oxygen can be detrimental to the quality of the product.	Typical dissolved carbon dioxide levels at bottling are less than 0.7grams per litre. Carbon Dioxide should be measured prior and after filling. Dissolved Oxygen should be as low as possible to extend the shelf life of the product.
Best Before Dates	Softpacks are required by law to carry "Best Before" dates, as does any product which has a shelf life of less than two years.	Product trials ought to be conducted to determine appropriate best before dates as wine life may be effect by wine chemistry, preservative levels, sanitation, exposure to heat and transport.
Bag Strength	A function of the cask film material	Determined by performing sustained and burst pressure testing. A 'drop' test may be used as an indicator of strength.

<b>Plastic or Metallised Plastic Wine Packs with Dispensing Tap continued..</b>		
<b>Critical Issue</b>	<b>Description</b>	<b>Recommendation/Observation</b>
General	Customers will require a full product specification.	
Bottle Shape & Style	This will indicate if the production line has the capabilities to run it down the line. Glass label panel will dictate the label sizes and shapes appropriate for bottle. Neck finish will dictate the closure that can be applied, namely screwcap, cork length and diameter, capsule; PVC, PET, tin diameter and length . Size and shape of the carton needed.	Obtain bottle drawings that include required (critical) dimensions.
Carton Shape/size	Will depend on the quantity of bottles required for packaging i.e. gift box, 6 pack, 12 pack, cluster pack, divider Bottle shape and size.	Customer specific market requirement. Length by width by height and weight will be required by customers.
Carton Orientation (Upright/Laydown)	Closure used on bottle has an important impact on bottle orientation required for storage and transport.	Carton orientation may be required by customers and be customer or brand specific.
Pallet Configuration	Carton stacking and palletisation is determined by the type of bottle and the carton used. Pallet configuration will be required by customer specification.	Refer Correx palletising chart.
Slip Sheet	Required for some customers to aid depalletisation.	Size and thickness of slip sheet will be determined by pallet size, pallet configuration and carton weight.

Carton Identification (Stencil/Sticker)	Is a mandatory requirement, artwork will need to include specific mandatory details or an un-printed area for ink jet application or stickers.	Customer specific requirements. Warehouse handling requirement. Legal and mandatory requirements for different markets
--	--	--

<b>General Product Specifications</b>		
<b>Critical Issue</b>	<b>Description</b>	<b>Recommendation/Observation</b>
Divider	<p>Used as an aid for carton stabilisation and to help minimise label damage – optional</p> <p><b>LCBO requirements</b> Dividers must provide adequate protection against damage or breakage and must prevent direct bottle to bottle contact.</p> <p>Dividers must be secure when carton is inverted.</p>	<p>Recommended for all sparkling products, cartons that are designed for lay down or inverted bottles, multi-packs ie 24x single serve bottles, brandy. Refer to the Export Market Grid USA and Canadian requirements. <a href="http://www.wineaustralia.com">www.wineaustralia.com</a> and <a href="http://www.LCBOtrade.com">www.LCBOtrade.com</a></p> <p>Dividers must not be less than full shoulder height of the bottles. Refer to LCBO Product Packaging Standards at <a href="http://www.LCBOtrade.com">www.LCBOtrade.com</a> for complete requirements.</p> <p>Requirement can be achieved by at least 1 piece of the corrugated/solid fibreboard extending to the full height of the carton or by adhesive bonding the divider to the inner surface of the carton (i.e. OTOR style divider). Refer to LCBO Product Packaging Standards at <a href="http://www.LCBOtrade.com">www.LCBOtrade.com</a> for complete requirements.</p>
Top Pads	<p><b>LCBO requirements</b> A top pad is a corrugated or solid fibreboard sheet used for extra protection or for separating tiers or layers of articles within a carton.</p>	<p>All wines packaged in an inverted bottle position require a top pad inserted between the tops of the bottles and the 2 inner flaps of the shipping container, or the 2 inner flaps and 2 outer flaps of the carton must meet in the centre. Refer to LCBO Product Packaging Standards at <a href="http://www.LCBOtrade.com">www.LCBOtrade.com</a> for complete requirements.</p>
Carton Strength	A function of the corrugated flute and liner used.	<p>Determined by carton weight and orientation. Customer requirement. Product security ie sparkling cartons are generally stronger.</p>
Barcode Requirements	A standardised approach to numbering and bar coding trade items.	Refer to GS1 Australia User Manual - Numbering and Bar coding - <a href="http://www.gs1au.org/index.asp">www.gs1au.org/index.asp</a>

<b>General Product Specifications continued...</b>		
<b>Critical Issue</b>	<b>Description</b>	<b>Recommendation/Observation</b>
Mandatories / Sparkling Warnings / Display	Carton artwork to consider bottle orientation symbol, Stanley knife warning, carton display cuts. Using 6 pack cartons as a retail unit.	Product specific.  If a customer requires a 13 digit barcode on a pack, ensure relevant labelling mandatory requirements for retail packages are met. Refer to AWBC Wine Label Law for these requirements. <a href="http://www.wineaustralia.com">www.wineaustralia.com</a>
Mandatories	Using six & 12 pack cartons as a retail unit	If a customer requires a 13 digit barcode on a pack, must ensure relevant labelling mandatory requirements for retail packages are met. Refer to AWBC label law for these requirements. <a href="http://www.wineaustralia.com">www.wineaustralia.com</a>
Capsule	Composition of capsule is determined by product design or customer requirement (some require capsules to be PET for recycle).	Capsule composition will be determined by customer specifications.
Neck Tags / Accessories	A promotional item that can be applied to individual bottles. Number applied per carton is limited to line capabilities.	Promotional requirement.

## 7. Glass Bottles

Critical Issue	Description	Recommendation/Observation
Dimensions	The specific measurements of a bottle either by physical measurement and / or from the suppliers approved drawings	Glass bottle dimensions shall be as per approved drawings (commonly known as “ware specs”) provided by their suppliers.
Finish	The specific glass finish affects type, style and size of closure usage. The most common finishes available for the Australian domestic and export markets are “cork mouth”, “BVS”, and Crown/Sparkling.	The finish of each bottle shall be as per approved manufacturer drawings & shall perform with the appropriate/specified closure. The sealing surface/s on all bottles must be smooth & undistorted and within the specified tolerances.
Capacity	Bottle capacities do vary from that nominated/specified (i.e. 750ml) due to manufacturing variances, however actual capacity must be within the specified/acceptable tolerances.	Any measurement of bottle capacity must be in accordance with either the minimum fill system or the average quantity system For more information on trade measurement legislation, contact National Measurement Institute – <a href="http://www.measurement.gov.au">www.measurement.gov.au</a>
Exterior Surface Coating	Bottles are coated to inhibit scuffing during transport.	Minimal scuffing should exist. Excess surface coating can lead to poor label adhesion.
Label Panel	Sink & Bulge	Maximum 0.1mm per 25mm length of label panel to a maximum of 0.5mm
Bottle Colour	Bottle colour does vary during manufacturing within a specified range (refer supplier specifications and tolerances).	Bottle colour must be within the specified supplier range unless notified by the supplier, and agreed to use.
Glass Contaminants	The manufacture, handling and transport of glass bottles can contribute to the inclusion of physical contaminants glass fragments in containers.	Bottles supplied that contain contaminants such as glass fragments are classified as critical defects. ## (This reinforces the importance of bottle rinsing prior to use and monitoring the condition of pallets on arrival. )
Lot Marking	Glass pallets should be labelled with manufacturing time and batch-lot numbers and plant reference code/s	During usage, pallet numbers and production dates should be recorded to assist with traceability.



<b>Glass Bottles continued...</b>		
<b>Critical Issue</b>	<b>Description</b>	<b>Recommendation/Observation</b>
Handling & Storage	Storage is critical to the performance of bottles.	Ideally glass bottles should be stored under cover. Where possible, glass should be supplied to the bottling line at a consistent temperature <i>Note: the closer to the wine fill temperature the better.</i>
Packing	Pallets, divider board and wrapping can deteriorate over time. <i>Note: As there is a cost and return associated with this packing material care should be taken to avoid any damage.</i>	When using glass, particular attention should be paid to the dividers. Pallets and dividers must be free of foreign materials, pests and dust. <i>Note: Stacked dividers boards must be stored whilst awaiting collection.</i>
Critical Defects	Unacceptable. Defect that are likely to result in a health risk.	Defects include, but not limited to, are Bird swing, loose glass internal, external stuck glass, internal fused glass, overpressed finish, stuck plunger, sugary finish, open internal blister, carbon or any foreign objects, any other defects that could be hazardous to a consumer. Any object that is likely to result in glass/product contamination, failure of pressure bottles or that could be considered hazardous to a consumer <u>should not be used.</u>
Major Defects	Any functional defect that may cause the container to fail.	Defects include line over finish, split ring, chipped finish, offset finish, choked neck, body check or split, sloping finish, out of round or oval, split seams, crizzled finish, stones (stressed) split bottoms, split seams, air marks, any other defects that may result in container failure, disruption to bottling or closure application..
Minor Defects	Any defect that is generally aesthetic in nature, but does not affect the functionality of the container.	Defects include colour off standard, wave laps, wash board, brush marks, loading marks, knurling, excessive coating, slug necks, sunken ware, cold wave, take out check, hard blisters, any other defects that noticeably affect appearance and may affect stability. Any defect that does not impact on the function of the container but is a departure from acceptable standards and appearance.

## 8. PET Containers

Critical Issue	Description	Recommendation/Observation
Dimensions		PET bottle dimensions shall be as per approved drawings.
Finish		The finish of each bottle shall be as per approved drawings & shall perform with the specified closure. The sealing surface on all PET bottles must be smooth & undistorted.
Capacity		Brimful capacity & fill point tolerances shall be as specified on approved drawings. Suppliers must ensure PET bottles supplied can maintain Australian fill requirements. For more information on national trade measurement legislation contact National Measurement Institute. <a href="http://www.measurement.gov.au">www.measurement.gov.au</a>
Foreign Objects		PET bottles supplied that contain any foreign material should not be accepted.
PET Supplier Container defects	Any defects that is visual or has an affect on the performance or appearance of the container	Colour off standard, any defects that noticeably affect the appearance and may affect stability. Any defect that does not impact on the function of the container but is a departure from acceptable standards and appearance.

<b>PET Containers continued...</b>		
<b>Critical Issue</b>	<b>Description</b>	<b>Recommendation/Observation</b>
Storage and transport of empty bottles.	Keep away from heat sources.	<p>The effects of heat can range from minor distortion of the bottle panels to shrinking and gross deformation rendering the container unfit for use. Pallet wrap must ensure bottles are stable during shipment &amp; storage. The tension in the wrap should be firm but must not damage bottles.</p> <p>Transport conditions can cause scuffing on PET bottles and they should be routinely checked at delivery.</p> <p>Seek Suppliers recommendations for appropriate transport conditions. These must be followed to prevent damage to the bottle during transport</p>
	Products must be stored inside	<p>Never leave Products in direct sunlight. (even on a cool day)</p> <p>Store your Products in a cool dry location. The formation of condensation in the shrink-wrapping or in individual containers can occur if stored in a humid environment.</p> <p>Do not exceed the recommended pallet stack height.</p> <p>Seek Suppliers recommendations for appropriate storage conditions.</p>

<b>PET Containers continued...</b>		
<b>Critical Issue</b>	<b>Description</b>	<b>Recommendation/Observation</b>
	Manage stock rotation	<p>First in first out.</p> <p>Be aware that the shelf life of the package can start deteriorating from the manufacture of the bottle depending on the oxygen scavenger used.</p> <p>Suppliers will be able to supply information on shelf life.</p> <p>Pallet tickets should state no exposure to sunlight heat or moisture. This will alert forklift drivers to the proper handling process.</p> <p>..</p>
<b>On the packaging line.</b>		
		Ensure that pallets, layer pads and bottles are compatible with your packaging technology..
	Conveyer Scuffing	Care must be taken to ensure that PET bottles do not remain on a moving conveyer during extended production stops – Conveyors should be switched off or bottles removed from the line. Conveyors should preferably be non-Stainless to reduce possible PET damage.

<b>PET Containers continued...</b>		
<b>Critical Issue</b>	<b>Description</b>	<b>Recommendation/Observation</b>
Traceability		The supplier is required to maintain records to identify all delivery batches & production dates.
Product Identification & Traceability		A best before date is required.. . Reference Standard 1.2.5 Date Marking of Packaged Food.
Warehousing finished product		Refer to the Suppliers recommendations in relation to the maximum finished product pallet height.
Stock rotation		Ensure oldest stock is used first, (first in first out)
PET Type		PET containers are available with different O <sub>2</sub> scavengers and barriers these assist in extending the shelf life of the packaged product.  Consult with your PET supplier on the most appropriate options for your products.
Filling & Capping Machine Set up	Critical, correct filling & capping machine set.	Consult with bottle supplier as to the correct filling & capping machine set up.  Trial bottles on equipment to ensure equipment is capable of handling PET.  Ensure that the cap applicator can perform at the stated top pressure for the bottle. If a counter pressure filler is being used ensure that the pre-evacuation has been turned off otherwise the bottle will implode. Bottle flushing to expel air will then be required.

## 9. Packaging Usage & Safety

Critical Issue	Description	Recommendation/Observation
General	The primary purpose of these packaging guidelines is to offer guidance for what is considered industry best practice for those companies who procure and use packaging.	Reference should always be to supplier specifications for usage. <ul style="list-style-type: none"> <li>• Weights / Dimensions for both manual handling, storage and to suit any customer equipment</li> <li>• Palletisation configurations / method / stability</li> <li>• Protection from environmental factors during storage and transport</li> <li>• Supplied in a configuration that matches customers process capability</li> <li>• Objective should be to minimise waste within packaging</li> </ul>

<b>Packaging Usage &amp; Safety continued...</b>		
<b>Critical Issue</b>	<b>Description</b>	<b>Recommendation/Observation</b>
Product Identification	Identification labels should be mandatory for all packaging deliveries.	<p>Each pallet must show all of the following information:</p> <ul style="list-style-type: none"> <li>• Customers Item Number</li> <li>• Customers Order Number</li> <li>• Brief Component Description including brand</li> <li>• Number shippers on pallet</li> <li>• Number items per shipper and for pallet</li> <li>• Sequential case number or time of production</li> <li>• Production date</li> <li>• Suppliers name &amp; location</li> <li>• Customer specified barcode</li> </ul> <p>Each shipper must show all of the following information</p> <ul style="list-style-type: none"> <li>• Suppliers name &amp; location</li> <li>• Customers Item Number</li> <li>• Customers Order Number</li> <li>• Brief Component Description including brand</li> <li>• Number of items per case</li> <li>• Case Weight</li> <li>• Sequential case number or time of production</li> <li>• Production date</li> <li>• Customer specified barcode</li> </ul>
Packaging Usage	Documentation of the usage of packaging is an important process to comply with Australian and international product traceability requirements.	<p>Systems to record and maintain the usage of packaging should be incorporated in the company's packaging operating procedures.</p> <ul style="list-style-type: none"> <li>• Traceability to batches / productions / shifts</li> <li>• Match to supplier batches and production dates</li> </ul> <p>Storage methods &amp; duration with aim to operate within FIFO principles.</p>