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This is a compliance document for circulation to customers, manufacturers and suppliers. Please make sure the appropriate people in your company are given a copy of this document.

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Purpose

The purpose of this specification is to ensure that supplied natural cork, agglomerate and technical corks, cork stoppers, sparkling corks and synthetic cork style closures are capable of being applied on Vinpac's automated bottling lines.

Guidance

Our experienced staff members are available to answer any queries regarding the content of this specification. They can also assist with design concepts and organise trials of corks to ensure satisfactory results prior to bottling.

All queries regarding the requirements of this specification should be directed through the customer's Account Manager.

Responsibility

Customers must ensure that corks provided to Vinpac are manufactured with reference to the information contained in this Specification.

⚠ The cork diameter must suit the neck of the wine bottle to be used and cork length must allow for legal wine fill volume and Vinpac recommended vacuity (see 'CI-001 – Vinpac Customer Communication - 49mm Cork Use' for further information).

We recommend that customers check and approve their cork artwork/or branded cork samples at their supplier's premises or receive samples for approval prior to delivery to Vinpac.

Requirements

Technical drawings and application specifications must be supplied in a legible size PDF format to the customer's Account Manager. Cork closure measurements with tolerances must be noted on the technical drawings.

Natural corks, agglomerate and technical corks, cork stoppers, sparkling corks and synthetic cork style closures must be free from harmful microbial growth and residues that would affect the colour, odour, taste, or related characteristics of the bottle content.

Vinpac does not recommend the use of colmated cork.

Corks and closures must comply with 'SU-012 – Food Safety Declarations for Food Contact Dry Goods'. This includes, but is not limited to:

- Surface coatings or treatments
- Inks used for printing
- Products used for agglomeration and disc adhesion

Criteria and Tolerances

Criteria	Tolerances
Extraction	Still Wine Corks - The quality and coverage of the surface coating for natural and technical still wine corks must allow extraction with independent extraction force values between 180 and 400N (Newton) with a recommended average between 200 and 350N.
	Sparkling Wine Corks - The extraction with independent extraction force values must be between 180 and 350N with a rotation between 90 degrees and 900 degrees.
Surface Coating	Adhesion of the surface coating to the cork shall be sufficient to prevent coating material flaking from the cork during bottling. No oily residue shall be present on the wine after using the treated closure. It should also ensure total impermeability with no signs of capillaries either along or through the cork. Any coating must perform adequately at temperatures between -10°C and 70°C.
Contamination	To reduce the risk of contamination, no open or incorrectly sealed bags, dirty bags (inside) or punctured bags are accepted.
Use By Date	All Cork shall have the use by date clearly marked on each bag and carton outer. Vinpac does not recommend using out of date cork without testing and retreatment by the cork supplier.

Batch Numbers	As cork is a wine contact dry good, all bags supplied must have a batch number (or means of identifying specifically treated lots) on each bag and the carton outer. This must be noted in English.
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Packing and Delivery

Detailed information on the packing and delivery of dry goods is contained in SU-009 – Vinpac Specification - Dry Good Packaging and Delivery Requirements.

Recycled Material and Packaging

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

References

Winemakers Federation of Australia – Wine Packaging Guidelines November 2010
www.wfa.com.au