

Prepared By: Vinpac International's Quality Assurance Team

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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 screw cap closures (including but not limited to Stelvin, Lux, WAK and Savin) 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 screw caps 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 screw cap closures provided to Vinpac are manufactured with reference to the information contained in this specification.

The screw cap closure must be manufactured to the specification of the particular bottle finish dimensions they are intended to fit. Information on bottle finishes can be sourced through your Account Manager.

Customer supplied closures must be approved by Vinpac prior to bottling to confirm they can achieve a mechanical application on our automated lines.

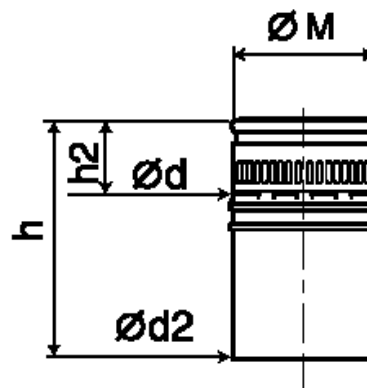
Requirements

Technical drawings and application specifications must be supplied in PDF format to the customer's Account Manager at least 6 weeks before the scheduled bottling date.

Corks and closures must comply with 'SU-012 – Vinpac Specification – Food Safety Declarations for Food Contact Dry Goods'.

Acceptable tolerance levels and requirements for decoration of screw cap closures are contained in the following table:

Size	Diameter (ØM)	1 st Inside Diameter (Ød)	2 nd Inside Diameter (Ød2)	h2	h
22 X 30	22.7	21.65	22.10	12.6	29.8
25 X 43	25.6	24.7	25.10	12.5	42.8
28 X 44	28.4	27.5	27.85	16.0	43.9
30 X 50	29.7	28.7	29.15	18.0	49.9
30 X 55	29.7	28.7	29.15	18.0	54.9
30 X 60	29.7	28.7	29.15	18.0	59.9
31.5 X 60	31.4	30.5	30.95	18.0	59.9



Criteria and Tolerances

Criteria	Description	Tolerances
Dimension	Length	+/- 0.3
	Diameter (ØM)	+/- 0.3
	1 st (Ød) and 2 nd (Ød2) inside Diameter	As specified in table 1
	Ovality	+/- 0.4
Material & Thickness	Aluminium alloy 8011 H24	Thickness 0.23mm +/- 0.01.
Liner	Liner condition	No holes, scratches, doubles, missing or incomplete liners.
	Liner material	Material which is in contact with the wine must conform/ comply to the Australian, EU & FDA regulations for food contact materials.
Paint	Internal	Epoxy-phenolic lacquer, suitable for contact with alcoholic liquids and must conform/ comply to the Australian, EU & FDA regulations for food contact materials.
	External	Polyester or vinyl base coating - Polyester inks.
Print	Artwork	Shall not differ from supplied artwork.
	Print	Clear, no smudging & shall not rub off/scuff.
	Registration	+/- 0.5mm.
Colour	Darker/lighter	+/- 5% darker/lighter.
Appearance		Not damaged/crushed.
Packaging	Outer packaging type	High density polyethylene bags then into a cardboard shipper, suitable for contact with dry foodstuffs & taped closed.
Application	Vertical load, roller pressures	Supplier application specification must be supplied.
Pressure retention	Bubble point test	Supplier must state if product is suitable for sparkling product and must provide test parameters.

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, where goods shall be made using recyclable or recycled materials, packed using recyclable materials and all packaging materials minimised.

References

Winemakers Federation of Australia – Wine Packaging Guidelines November 2010

www.wfa.com.au