

Prepared By: Vinpac International's Quality Assurance Team

Date of Issue: 14 March 2014

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.

Contents

1. Purpose
2. Guidance
3. Responsibility
4. Requirements
5. Criteria and Tolerances
6. Packing and Delivery
7. Recycled Material and Packaging
8. References

Purpose

The purpose of this specification is to ensure that supplied PVC Heat Shrink Capsules are capable of being applied on our 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 capsules to ensure satisfactory results prior to bottling.

PVC capsules are made from a material that shrinks as it moulds itself over the bottle closure during the automated application process. This can cause wrinkling around the top of the bottle. Cork punch depths can vary slightly across the bottling run and, where the cork insertion depth is slightly below the edge of the bottle top, wrinkling will be more pronounced. This finish is unavoidable but does not affect the performance of the capsules. Capsules cannot be orientated to bottles.

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

Responsibility

Where the customer supplies their own capsules, Vinpac must assess and, if necessary, trial the capsules prior to bottling. Sample capsules should be supplied at least 6 weeks before the scheduled bottling date to confirm we can achieve a mechanical application on our automated lines.

Requirements

All capsules must conform to the Winemakers Federation of Australia Wine Packaging Guidelines unless otherwise specified in this document.

Customers should check and approve their capsules (colour and artwork) at the manufacturer/supplier's premises or receive samples for approval prior to delivery to Vinpac.

PVC Heat shrink capsules 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.

Criteria and Tolerances

Criteria	Description	Tolerance
Dimension	Length	45-70 mm (\pm 1mm).
	Top Diameter	29 – 34 mm (\pm 0.5mm).
	Taper	In accordance with length and bottle used (\pm 0.5mm).
	Ovality	1.0mm maximum.
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 approximately.
Material	Thickness	PVC as specified (\pm 0.1mm).
Decoration	Artwork	As specified in artwork with agreed supplier (high/low colour ranges).
Print	Artwork	Shall not differ from supplied artwork.
	Print	Clear, no smudging must have high scuff resistance.
	Registration	0.5 mm \pm must have high scuff resistance.
Seam		Good adhesion and coverage right to the edge.
		No excessive glue.
Packing		Sticks packed lengthwise/parallel in a suitable carton to avoid crush damage, sealed to prevent the ingress of foreign material and in clean packaging materials which are made of contamination resistant recyclable material.

Spacing of caps on stick		8 – 11mm.
Length per stick		Less than 600mm.
Appearance		Not damaged / crushed / scuffed.
		Not stuck together.
		Not flattened.

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 and recyclable materials.

References

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