



## GUIDELINES FOR FILL VOLUME & VACUITY

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| 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 | 12 <sup>th</sup> August 2014 |

THIS SPECIFICATION SHOULD BE MADE AVAILABLE TO YOUR PRODUCTION STAFF & MANUFACTURERS AND SUPPLIERS OF GLASS IN REGARD TO FILL VOLUME & VACUITY.

### A. PURPOSE

This specification is an assurance to our customers that Food Safety and Quality at Ozpak is constantly monitored using worldwide tools of Hazard Analysis in conjunction with various other safety/quality programs conducted at our site. In line with the requirements imposed by this standard we are required to carry out testing to ensure product is safe and legal

### B. GUIDANCE

Ozpak's experienced staff are available to answer any queries regarding the contents of this specification.

### C. RESPONSIBILITY

Customers should ensure that they complete Appendix A in relation to Fill Volume / Average Fill and forward it to Ozpak's Customer Service Manager.

Weights and measures law in Australia and the European Union, states that packages must contain, on average, the fill volume stated on the label. These laws also state that no package is to have a fill volume lower than the label specified amount. While Ozpak and the W.P.A. are confident that there are no issues with non-standard or inadequate packages there is a potential for there to be a problem with average contents being slightly underweight due to the regulation of internal size of glass bottles available in Australia. Ozpak and the W.P.A.'s research has shown that bottle weights for given glass types from the glass manufacturer can vary by as much as 35grams which translates to approximately 35ml. During the bottle filling process, the vacuity and thus, fill volume is achieved through bottle fill height. Variation in size and thickness of glass in bottles therefore has a direct impact on average fill volume, which is a legal requirement in Australia and the EU.

Testing that Ozpak and the W.P.A. have conducted has revealed that on occasion, with certain combinations of glass, screw caps, crown seals and cork length/thickness, there can be a resultant legal non-conformity in average fill, if the optimum vacuity is to be achieved. Further Ozpak and the WPA have also determined that in order for the industry accepted minimum vacuity for screw cap bottles to be achieved, average fill volume can also be compromised. Investigation of records have revealed that based on average fill weight checks, there can be approximately 0.2% average under-filling on affected 750mL bottles and 0.15% average under-filling on affected 1500mL bottles (combined screw cap and corked data).

These circumstances are common in the wine industry. In fact, Tyson Stelzer, author of *Taming the Screw* (Wine Press 2005), concedes that bottle manufacturers need to provide a greater range of bottles capable of achieving fill heights. It is obvious, therefore, that this is a problem for the whole wine industry. Further to the best of the W.P.A. and Ozpak's knowledge "average contents" has never been an issue.

In the opinion of Ozpak and the W.P.A. achieving the correct vacuity is an essential packaging quality parameter. This is because there are significant quality risks which result from compromising vacuity, including leaking bottles, damage to outer packaging and an increased risk of wine oxidation due to perforation of bottle seals.

In line with the W.P.A. and Ozpak's obligations as described above and in relation to product legality, W.P.A. are requesting that before bottling services are to commence, you contact your Customer Service Manager in relation to your intention to fill bottles in order to meet Average Fill legal requirements, or to preserve the important Vacuity of filled bottles. Where possible, Ozpak will continue to endeavour to achieve both industry best practice in terms of vacuity, at the same time as achieving average fill requirements. However Ozpak and the W.P.A. strongly recommend that Vacuity should always be the parameter upheld. Ozpak and the W.P.A. would like to note that due to the variation in bottle weights of glass, it is impractical for Ozpak to conduct testing on package samples in advance of packaging runs to determine their capability to meet both Average Fill and Vacuity Requirements.



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**APPENDIX A**

**Fill Volume / Vacuity Disclaimer**

I, .....[name], am a representative of .....[company] and I wish to provide Ozpak with the following direction in relation to fill volume and vacuity, where it is evident that both parameters cannot be achieved simultaneously during packaging runs.

Option 1 – After reading the attached letter, I wish to instruct Ozpak to fill bottles in accordance with Industry Recommended Vacuity at the expense of Fill Volume, only where it is impossible to achieve Fill Volume and Vacuity at the same time.

Signature .....

Date.....

OR

Option 2 – After reading the attached letter, I wish to instruct Ozpak to fill bottles in accordance with Trade Weight and Measures Legislation at the expense of Industry Recommended Vacuity, only where it is impossible to achieve Fill Volume and Vacuity at the same time.

Signature .....

Date.....



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