



GUIDELINES FOR PVC HEAT SHRINK CAPSULES

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	29 th August 2014

THIS IS A SPECIFICATION FOR CIRCULATION TO CUSTOMERS AND SUPPLIERS OF DRY GOODS. PLEASE MAKE SURE THE APPROPRIATE PEOPLE IN YOUR COMPANY ARE GIVEN A COPY OF THIS DOCUMENT.

PURPOSE

1. To inform customers, manufacturers and suppliers of Ozpak's Specifications for heat shrink capsules to ensure that supplied heat shrink capsules are capable of being mechanically applied on Ozpak's bottling lines.

GUIDANCE

2. Ozpak's experienced staff are available to answer any queries regarding the contents of this Specification and can assist with design concepts and organise trials of caps to ensure satisfactory results prior to bottling.
3. PVC capsules are made from a material that shrinks as it molds 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 bottle.
4. All queries regarding the requirements of this Specification should be directed through Ozpak's Customer & Planning Manager.

RESPONSIBILITY

5. Where the customer supplies their own capsules, Ozpak must assess and, if necessary, trial the capsules prior to bottling to confirm that Ozpak can achieve a mechanical application on its bottling lines.

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 Ozpak.

REQUIREMENTS

6. 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
7. Acceptable tolerance levels and specifications for PVC heat shrink capsules are contained in the following table:

Criteria	Description	Specification
Dimension	Length	45-70 mm (± 1 mm)
	Top Diameter	29 – 34 mm (± 0.5 mm)
	Taper	In accordance with length and bottle used (± 0.5 mm)
	Ovality	1.0 mm maximum
Top Disc Air Holes	Size	1.0 mm – 1.5 mm with all excess material removed
	Number of holes	4 required for automated dispensing
	Distance from centre	5 mm approximately
Tear Tabs	Performance	Per product specification
	Width	PVC 4.5 mm (± 0.5 mm)
	Protruding section	PVC 3.5 mm (± 1.0 mm) length
Material	Thickness	PVC as specified (± 0.1 mm)
Decoration	Artwork	As specified in artwork with agreed supplier (high/low colour ranges)
Print	Artwork	Shall not differ from supplied artwork
	Printing	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 – 11 mm
Length per stick		Less than 600 mm
Appearance		Not damaged / crushed / scuffed
		Not stuck together
		Not flattened
Traceability		The manufacturer/supplier is required to maintain records to identify all delivery batches and production dates. In the event of any quality issue that may occur, these records are to be available upon request.
Storage		Capsules are particularly fragile. Storage in suitable cartons is critical to their stability and performance. Downward pressure caused from incorrect storage could result in damage, preventing automatic dispensing on the bottling line.

INSPECTION AND TESTING

- The manufacturer/supplier must maintain a plan of inspection and testing of the product at all stages of production. Parameters and processes must be set up to ensure checks are carried out with sampling and inspection at critical control points.

PACKAGING AND DELIVERY

- Detailed information on the packing and delivery of dry goods is contained in Ozpak's Specification for the Documentation, Packaging and Delivery of Customer Supplied Dry Goods.

AUSTRALIAN PACKAGING COVENANT

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

REFERENCES

Winemakers Federation of Australia – Wine Packaging Guidelines November 2010

www.wfa.com.au

AS1199.0 – 2003 Sampling procedures and tables for inspection and attributes



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