



## SPECIFICATIONS FOR GLASS BOTTLES

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 <sup>th</sup> 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 to ensure that customer supplied glass bottles are capable of being filled mechanically 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 bottles to ensure satisfactory results prior to bottling.
3. All queries regarding the requirements of this Specification should be directed through Ozpak's Customer Service Manager.

### RESPONSIBILITY

4. Customers must ensure that glass bottles provided are manufactured with reference to the information contained in this Specification and conform to the Winemakers Federation of Australia Wine Packaging Guidelines.
5. Customer supplied glass must be assessed and, where necessary, trialed by Ozpak prior to bottling. Sample glass should be supplied at least 6 weeks before the scheduled bottling date to ensure Ozpak can achieve un-troubled mechanical application on its bottling lines.
6. For decorated or screen printed bottles please refer to Ozpak's Specification for Decorated Bottles.
7. Supplied glass must be new as Ozpak will not fill second hand or washed glass.

## REQUIREMENTS

8. Glass must comply with current existing regulations and legislation (that is European and FDA – Food and Drug Administration) for products in contact with food. A copy of the current European and FDA declaration must be supplied to Ozpak by the manufacturer/supplier of glass.
9. Manufacturer's approved technical drawings showing bottle dimensions and tolerances together with application specifications to be supplied in legible PDF format several months in advance of your scheduled bottling date. These drawings must include:

Specification	Criteria
Bottle height	Bottles supplied must conform to their stated dimensions and tolerances.
Bottle diameter	<p>Bottles supplied must conform to their stated dimensions and tolerances</p> <p>Maximum ovality objective is <math>\pm(0.5+0.12.d)</math> of the body diameter tolerance range.</p>
Neck diameter	Bottles supplied must conform to their stated dimensions and tolerances
Bottle finish dimensions (ie bore / thread detail)	Bottle neck finishes are to comply with the current CETIE standard of 12° tuckunder angle as endorsed by the Winemakers Federation of Australia (WFA). (Please note the WFA are in discussion with CETIE to retain this Australian Standard and not move to a proposed a 15° tuckunder angle as is currently being proposed)
Fill point	<p>Brimful capacity and fill point tolerances must be as specified on the approved technical drawings. The manufacturer/supplier shall maintain records of the average capacity over the manufacturing run.</p> <p>Manufacturers/supplier must ensure bottles supplied can maintain Australian average fill requirements.</p> <p>Cork mouth E mark or fill level must allow sufficient vacuity for your supplied cork length and comply with EU regulations or Australian equivalent. <b>Note:</b> More information on vacuity levels can be found in Ozpak's Specification on Fill Volume and Vacuity</p>
Fill volume	Brimful capacity and fill point tolerances must be as specified on the approved technical drawings. The manufacturer/supplier shall maintain

	<p>records of the average capacity over the manufacturing run. Manufacturers/supplier must ensure bottles supplied can maintain Australian average fill requirements.</p> <p>The legal standard fill level is the level that would be expected in the bottle used, ie 187ml, 200ml, 375ml, 500ml, 750ml, 1L, 1.5L, 3L and 6L.</p>
Brimful volume	<p>Brimful capacity and fill point tolerances must be as specified on the approved technical drawings. The manufacturer/supplier shall maintain records of the average capacity over the manufacturing run. Manufacturers/supplier must ensure bottles supplied can maintain Australian average fill requirements.</p>
Weight	<p>Weight of bottles supplied may vary to ensure that all other stated dimensions and capacities are maintained within their stated tolerances. Nominal weight must be stated on the specification provided</p>
Pressure rating	<p>Bottles supplied must conform to their stated dimensions and tolerances</p>
Orientation cleft details if present	<p>Bottles supplied must conform to their stated dimensions and tolerances</p>
Embossing details if present	<p>Bottles supplied must conform to their stated dimensions and tolerances</p>
Label Panel Dimensions	<p>Bottles supplied must conform to their stated dimensions and tolerances</p>

10. For any given bottle over a 100mm in height, it has a tolerance specification of 1.3%h.

11. The exterior surface coating of wine bottles is to be treated with approved coating materials.

The bottle surface must:

- a. resist scuffing and/or abrasion during processing, handling and distribution
- b. allow for full label adhesion to the glass using pressure sensitive labels
- c. cover the exterior of the bottle only with no treatment to be present inside the bottle neck or the bottle proper.
- d. have no significant sign of application (ie severe discoloration or “drips”). Individual bottles to be batch coded with the date and time of manufacture. Preference is for laser batch coding on the side panel no higher than 15mm from the base of the bottle

and in a legible print for traceability, as well as all bottles to show manufacturer's trademark, individual mould number and cavity numbers.

12. The manufacturer or supplier will maintain pest control and glass breakage control measures within their production facility.
13. If required, Ozpak reserves the right to inspect using AS1199-0.2003 sampling plan for 100% inspection. If defects are found at the stated reject level the whole batch will be isolated and rejected back to customer.

Criteria	Tolerances
Unacceptable critical defects – defects resulting in health risks	<p>Any defects found that could be hazardous to a consumer will result in the glass being rejected</p> <p>Any contaminates ie glass fragments, mould, dust, insects ,etc present in supplied bottles or their packaging will not be accepted as these are classified as critical defects</p> <p>Any mismatching of either the BVS thread or finish that results in over press or any imperfections that will cause glass to fracture or break are deemed critical and unacceptable.</p>
Unacceptable Major Defects – defects resulting in container failure	Any defects found with an AQL > 0.65% that can result in container failure, gas loss, wine to leak or cause disruption to bottling will be rejected
Minor defects – defects resulting in container function not being compromised but possible aesthetic issue	Any defects that noticeably affect appearance of labels or the glass surface could affect stability of the glass and will be rejected e.g. poor sink and bulge in the label panel.

## ALERTS



All bottles must be filled to the legal requirement. For example a 750ml bottle must be capable of being filled to at least 750ml on our automated bottling lines taking in to consideration cork length and other factors (for more information on fill requirements refer to the Ozpak Specifications on such)



Customer supplied glass must be assessed and approved prior to bottling on your contract packer's bottling lines.

## PACKING 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.

## REFERENCES

C.E.T.I.E. International Technical Centre for Bottling and Packaging [www.cetie.org](http://www.cetie.org)

Winemakers Federation of Australia – Wine Packaging Guidelines November 2010  
[www.wfa.com.au](http://www.wfa.com.au)

Australian Packaging Covenant [www.packagingcovenant.org.au](http://www.packagingcovenant.org.au)

Australian Standard: 1199.0-2003 Sampling procedures and tables for inspection and attributes

Australian Government National Measurement Institute: [www.measurement.gov.au](http://www.measurement.gov.au)



Ozpak Pty Ltd  
ABN 57 091 370 446  
201 Odwyer Road  
Nagambie VIC 3608  
P.O. Box 133  
Nagambie VIC 3608  
Telephone + 61 (0) 3 5736 2800  
[administration@ozpak.com.au](mailto:administration@ozpak.com.au)

