



## SPECIFICATIONS FOR THE MANUFACTURE AND DECORATION OF POLYLAMINATE SPARKLING HOODS

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	1 <sup>st</sup> September 2014

THIS IS A SPECIFICATION FOR CIRCULATION TO CUSTOMERS, MANUFACTURERS AND SUPPLIERS OF POLYLAMINATE SPARKLING HOODS. PLEASE MAKE SURE THE APPROPRIATE PEOPLE IN YOUR COMPANY ARE GIVEN A COPY OF THIS DOCUMENT.

This Specification will be updated regularly.

### PURPOSE

1. To inform customers, manufacturers and suppliers of Ozpak's Specifications to ensure that supplied poly laminate sparkling hoods are capable of being 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 hoods 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 poly laminate sparkling hoods provided to Ozpak are manufactured with reference to the information contained in this Specification.
5. Where the customer supplies their own Poly laminate Sparkling Hoods, Ozpak must assess and, if necessary, trial the hoods prior to bottling to confirm we can achieve a mechanical application on our bottling lines.

## REQUIREMENTS

6. Technical drawings and application specifications must be supplied in PDF format to Ozpak at least 6 weeks before the scheduled bottling date.

Criteria	Specification
Hood Length	Hoods must be a minimum length of 80mm and a maximum length of 122mm and manufactured to the specification of the particular bottle finish. Information on bottle finishes can be sourced through Ozpak's Customer Service Manager.
Hood Diameter	The diameter of the base of the hood dimension must be sized to be 1mm greater than the bottle neck at the contact point.
U.V. Orientation mark	The fluorescent orientation mark applied to the hood must be able to register on Ozpak's scanners. All other backgrounds must be below the "switching threshold" as described in Appendix B – UV Orientation. This will allow scope for adjustment on the bottling line.
U.V. Orientation mark dimensions	Orientation marks must be 4mm wide and 70mm long and 180 degrees from the centre print or scallop.
U.V. Orientation mark design	Orientation mark must be of a heat sealable optical brightener with an acrylic overprint varnish designed for surface printing to facilitate high speed conversion in the bottling line and reduce waste from misalignment of the capsules (see Appendix A).
U.V. Orientation mark positioning	Orientation mark must start at 50mm from top of the formed hood and extend 70mm to the base of the hood and must be compatible for use with Ozpak's scanners.
Spot orientation mark	Spot can be either black or white dependent on hood colour. The spot orientation mark applied to the hood must be able to register on Ozpak's s as described in Appendix B – Spot Orientation. This will allow scope for adjustment on the bottling line.
Spot orientation dimensions	Spot must be a minimum of 5mm wide and a minimum of 12mm high/length and 180 degrees from the centre print or scallop

Spot orientation mark design	Orientation mark must be of a heat sealable optical brightener with an acrylic overprint varnish designed for surface printing to facilitate high speed conversion in the bottling line and reduce waste from misalignment of the capsules
Spot orientation positioning	Spot must start at a minimum of 5mm from the base of the hood and clear of any other printing.
Hood Packaging, Storage and Delivery	<p>Each stick of hoods must be no longer than 580mm and spacing of hoods on stick must be 9-11mm.</p> <p>The hood sticks must be a packed layer on a suitable tray to avoid crush damage.</p> <p>To eliminate compaction during transportation and enable smooth and consistent application during bottling, hood sticks should be aligned to the forklift entry on pallets and placed across the direction of travel on transport.</p>

#### PACKING AND DELIVERY

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

#### AUSTRALIAN PACKAGING COVENANT

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

#### INSPECTION AND TESTING

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

**ALERTS**

Ozpak cannot be held responsible for incorrect orientation where hoods have not undergone trials prior to bottling.



Customers must accept the risk of using hoods manufactured outside of the requirements of this specification.

**REFERENCES**

Winemakers Federation of Australia – Wine Packaging Guidelines November 2010

[www.wfa.com.au](http://www.wfa.com.au)

Flint Group Technical data sheet Product: Heat sealable OB OPV Code: N41022

Datalogic TL80 Series Spot Orientation and Datalogic LDU Series UV Orientation

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



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