

Prepared By: Wine Packagers of Australia

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This WPA Guideline contains information for the manufacture and supply of muselets and strip wires to third party contract packagers.

Where bottling customers are supplying their own muselets and strip wires, this Guideline could be given to the supplier, but we encourage they contact their contract packager to discuss whether this Guideline is sufficient for them or whether they have their own Specification.

1. Guidance

All queries regarding this information should be directed to your contract packager.

2. Responsibility

Bottling customers must ensure that muselets and strip wires provided to contract packagers are manufactured with reference to the information contained in this document and be capable of mechanical application on automated bottling lines.

3. Requirements

Technical drawings and application specifications must be supplied in PDF format to the contract packager within at least six weeks before the scheduled bottling date. At least 50 samples will be required for trial by contract packagers on their automated bottling lines.

4. Criteria and Tolerances

Criteria	Description	Tolerances
Dimensions	Length	Per product specification (+/- 0.8mm).
	Top Diameter	Per product specification (+/- 0.5mm).
	Height	Per product specification (+/- 0.6mm).
Body Wire	Specification	Galvanised/lacquered wire diameter 0.95mm (+/- 0.03mm).
	Galvanisation	First fusion zinc (French Standard NFA91.131).
	Purity level	99.995%
	Mechanical strength	Minimal elongation: 16% Minimal tensile strength: 28% Minimal torsion for wire: 210mm long: 44 rotations with a 4mm diameter ring

Strip Wire	Specification	As per supplier specification.
	Galvanisation	First fusion zinc (French Standard NFA91.131).
	Purity level	99.995
	Mechanical strength	Minimal elongation: 18% Minimal tensile strength: 28% Minimal torsion for wire: 210mm long: 44 rotations with a 4mm diameter ring
Disc Steel	Tin Plated Steel	Thickness: 20 µm – 22 µm (+/- 0.2µm).
		Minimal tin coating: E = 5.6 µm.
		Thickness of tin: 5.6 µm on both faces.
	Coloured Steel	Thickness: 21 µm - 23 µm (+/- 0.2 µm).
Coloured Coating	Electrolytic tin plated steel and Chromium tin plated steel: <ul style="list-style-type: none"> 1. Pretreatment varnish 2. Ink 3. Over coating varnish 	
Packaging and appearance		Sticks packed horizontally. No sign of damage, not crushed and not stuck together.
Spacing of muselet		Spaced evenly on stick to dispense automatically.
Length per stick		Less than 600mm.
Bottle application		No breaking of wire when loop twisted.

5. Packing and Delivery

Detailed information on the packing and delivery of dry goods is contained in WPA_09 Dry Good Packaging and Delivery Requirements.

6. Recycled Material and Packaging

Each contract packager has their own sustainability objectives. Where practical dry goods are made using recyclable or recycled materials, packed using recyclable materials and all packaging materials minimised.

7. References

Winemakers Federation of Australia – Wine Packaging Guidelines November 2012
www.wfa.com.au



Muselets and Strip Wires Guideline

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