



Decorative Metal Capsules Guideline

WPA_07

Prepared By: Wine Packagers of Australia

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This WPA Guideline contains information for the manufacture and supply of decorative metal capsules to third party contract packagers.

Where bottling customers are supplying their own decorative metal capsule, they should contact their contract packager to discuss whether this Guideline is sufficient for them or whether they have their own Specifications.

1. Guidance

All queries regarding this information should be discussed with the bottling customer's contract packager.

A contract packager may request trials prior to bottling to confirm a capsule's ability for mechanical application on their automated lines.

2. Responsibility

Customers must ensure that decorative metal capsules provided to their contract packager are manufactured with reference to the information contained in this Guideline.

All capsules must conform to the Winemakers Federation of Australia Wine Packaging Guidelines unless otherwise specified in this document.

3. Requirements

Technical drawings and application specifications must be supplied in PDF format to the contract packager approximately 28 days before the scheduled bottling date. At least 50 samples will be required for trial on their automated bottling lines.

4. Criteria and Tolerances

Criteria	Description	Tolerances
Dimension	Length	45 - 70mm (± 1 mm tolerance)
	Top Diameter	29-34 (± 0.5 mm)
	Taper	in accordance with length and bottle (± 0.5 mm)
	Ovality	1.0mm max



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Criteria	Description	Tolerances
Top Disc Air Holes	Size	1.0mm - 1.5mm with all excess material removed
	Number of holes	4 required for automated dispensing
	Distance from centre	5mm approx
Material	Thickness	As manufacturer has specified ± 0.1 mm
Print	Artwork	Shall not differ from supplied artwork
	Print	Clear, no smudging & shall not rub off/scuff.
	Registration	0.5mm \pm
Colour	Darker/lighter	5% \pm darker lighter
		Must have high scuff resistance
Spacing of Caps on Stick		8 - 11mm with well-defined separation rings
Length Per Stick		Less than 600mm
Appearance		Not damaged/crushed/scuffed
		Not stuck together
		Not flattened
Application		Capsules are not to split or separate during or following application to the bottle.
Length Per Stick		Less than 600mm
Packing		Sticks packed horizontally into recessed trays with end caps in a suitable carton to avoid crush damage, sealed to prevent ingress of foreign material and in clean packaging that is made of contamination resistant recyclable material.
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.

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.

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6. Recycled Material and Packaging

Each contract packager has their own sustainability objectives. Where practical, dry goods are be 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