



Screw Cap Closures Guideline

WPA_10

Prepared by: Wine Packagers of Australia

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This WPA Guideline contains information for the manufacture of screw cap closures, and information on their supply to third party contract packagers.

Where bottling customers are supplying their own screw cap closures, 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.

2. Responsibility

Customers must ensure screw cap closures provided to their contract packager are manufactured with reference to the information contained in this Guideline.

The screw cap closure must be manufactured to the specification of the particular bottle finish dimensions they are intended to fit. Information on bottle finishes can be sourced through your contract packager.

3. Requirements

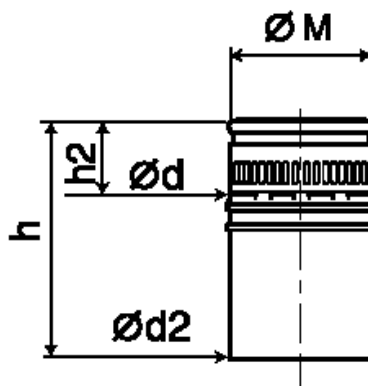
Technical drawings and application specifications must be supplied in PDF format to your contract packager at least 6 weeks before the scheduled bottling date.

Corks and closures must comply with WPA_012 Food Safety Declarations for Food Contact Dry Goods.

Acceptable tolerance levels and requirements for decoration of screw cap closures are contained in the following table:

Size	Diameter (ØM)	1 st Inside Diameter (Ød)	2 nd Inside Diameter (Ød2)	h2	h
22 X 30	22.7	21.65	22.10	12.6	29.8
25 X 43	25.6	24.7	25.10	12.5	42.8
28 X 44	28.4	27.5	27.85	16.0	43.9
30 X 50	29.7	28.7	29.15	18.0	49.9
30 X 55	29.7	28.7	29.15	18.0	54.9
30 X 60	29.7	28.7	29.15	18.0	59.9
31.5 X 60	31.4	30.5	30.95	18.0	59.9

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4. Criteria and Tolerances

Criteria	Description	Tolerances
Dimension	Length	+/- 0.3
	Diameter (ØM)	+/- 0.3
	1 st (Ød) and 2 nd (Ød2) inside Diameter	As specified in table 1
	Ovality	+/- 0.4
Material & Thickness	Aluminium alloy 8011 H24	Thickness 0.23mm +/- 0.01.
Liner	Liner condition	No holes, scratches, doubles, missing or incomplete liners.
	Liner material	Material which is in contact with the wine must conform/ comply to the Australian, EU & FDA regulations for food contact materials.
Paint	Internal	Epoxy-phenolic lacquer, suitable for contact with alcoholic liquids and must conform/ comply to the Australian, EU & FDA regulations for food contact materials.
	External	Polyester or vinyl base coating - Polyester inks.
Print	Artwork	Shall not differ from supplied artwork.

	Print	Clear, no smudging & shall not rub off/scuff.
	Registration	+/- 0.5mm.
Colour	Darker/lighter	+/- 5% darker/lighter.
Appearance		Not damaged/crushed.
Packaging	Outer packaging type	High density polyethylene bags then into a cardboard shipper, suitable for contact with dry foodstuffs & taped closed.
Application	Vertical load, roller pressures	Supplier application specification must be supplied.
Pressure retention	Bubble point test	Supplier must state if product is suitable for sparkling product and must provide test parameters.

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.

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.

6. References

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