

Prepared By: Wine Packagers of Australia

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This WPA Guideline contains information for the manufacture and supply of glass bottles to third party contract packagers.

Bottling customers 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 that glass bottles provided to contract packagers are manufactured with reference to the information contained in this Guideline and conform to the Winemakers Federation of Australia Wine Packaging Guidelines.

⚠ Customer supplied glass must be assessed by your contract packager prior to bottling. Sample glass should be supplied at least 6 weeks before the scheduled bottling date to ensure they can achieve mechanical application on their automated lines. This includes bottles with orientation lug/cleft for label placement.

⚠ Supplied glass must be new; contract packagers will not fill second hand or washed glass.

3. Requirements

Glass must comply with current existing regulations and legislation referred in the WPA_12_Food Safety Declaration for Food Contact Dry Goods.

Manufacturer's approved technical drawings showing bottle dimensions and tolerances together with application specifications shall be supplied in legible PDF format several months in advance of the scheduled bottling date. These drawings must include:

| Specification | Criteria |
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| Bottle height | Bottles supplied must conform to their stated dimensions and tolerances. |
| Bottle diameter | Bottles supplied must conform to their stated dimensions and tolerances. Maximum ovality objective is 75% of the body diameter tolerance range. |
| Neck diameter | Bottles supplied must conform to their stated dimensions and tolerances. |
| Bottle finish dimensions (i.e. bore / thread detail) | Bottle neck finishes are to have a maximum tuck under angle of 12° as endorsed by the Winemakers Federation of Australia (WFA). |
| Fill point | Cork mouth E mark or fill level must allow sufficient vacuity for your supplied cork length and comply with EU regulations or Australian equivalent. |
| Fill volume | Fill point tolerances must be as specified on the approved technical drawings. |

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| | 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. ⚠ The legal standard fill level is the level that would be expected in the bottle used, i.e. 187mL, 200mL, 375mL, 500mL, 750mL, 1L, 1.5L, 3L and 6L. Contract packagers must meet this requirement when filling. |
| Brimful volume | Brimful capacity and fill point tolerances must be as specified on the approved technical drawings. |
| Weight | Bottles supplied must conform to their stated dimensions and tolerances. |
| Pressure rating | Bottles supplied must conform to their stated dimensions and tolerances. |
| Orientation cleft details if present | Bottles supplied must conform to their stated dimensions and tolerances. |
| Embossing details if present | Bottles supplied must conform to their stated dimensions and tolerances. |
| Label Panel Dimensions | Bottles supplied must conform to their stated dimensions and tolerances. |

Bottles shall not deviate from the perpendicular for more than 1% of the bottle height when rotated 180 degrees.

The exterior surface coating of wine bottles is to be treated with approved coating materials. The bottle surface must:

- Resist scuffing and/or abrasion during processing, handling and distribution.
- Allow for full label adhesion to the glass using pressure sensitive labels.
- Cover the exterior of the bottle only with no treatment inside the bottle or on the finish of the bottle.
- Have no significant sign of application (i.e. severe discoloration or “drips”).
- In line with agreed industry standards. 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.

The manufacturer or supplier will maintain pest control and glass breakage control measures within their production facility.

4. Criteria and Tolerances

| Criteria | Tolerances |
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| Unacceptable critical defects – defects resulting in health risks | Any defects found that could be hazardous to a consumer will result in the glass being rejected. Any contaminants i.e. glass fragments, mould, dust, insects, etc present in supplied bottles or their packaging will not be accepted as these are classified as critical defects. |

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| | Any mismatching of either the BVS thread or finish that results in overpress or any imperfections that will cause glass to fracture or break are deemed critical and unacceptable. |
| Unacceptable Major Defects – defects resulting in container failure | Any defects found that can result in container failure, glass loss, leaking product or will 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 will be rejected e.g. excessive sink and bulge in the label panel. |

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

C.E.T.I.E. International Technical Centre for Bottling and Packaging www.cetie.org

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

Australian Government National Measurement Institute: www.measurement.gov.au