



# PVC Heat Shrink Capsules Guideline

WPA\_15

**Prepared By:** Wine Packagers of Australia

**Date of Issue:** 14 March 2014

This WPA Guideline contains specifications for the manufacture and supply of PVC heat shrink capsules to third party contract packagers.

Where bottling customers are supplying their own PVC heat shrink capsules, they should contact their contract packager to discuss whether this Guideline is sufficient for them or whether they have their own Specifications.

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## 1. Guidance

PVC capsules are made from a material that shrinks as it molds itself over the bottle closure during the automated application process. This can cause wrinkling around the top of the bottle. Cork punch depths can vary slightly across the bottling run and, where the cork insertion depth is slightly below the edge of the bottle top, wrinkling will be more pronounced. This finish is unavoidable but does not affect the performance of the capsules. Capsules cannot be orientated to bottles.

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

## 2. Responsibility

Where the customer supplies their own capsules, we suggest bottling customers contact their contract packager to assess and, if necessary, trial the capsules prior to bottling. Sample capsules should be supplied at least 6 weeks before the scheduled bottling date to confirm that can achieve a mechanical application on their automated lines.

## 3. Requirements

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

Customers should check and approve their capsules (colour and artwork) at the manufacturer/supplier's premises or receive samples for approval prior to delivery to their contract packager.

PVC Heat shrink capsules must:

- Be manufactured to the specification of the particular bottle finish they are intended to fit.
- Must not split or separate during or following application to the bottle.



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## 4. Criteria and Tolerances

Criteria	Description	Tolerance
Dimension	Length	45-70 mm ( $\pm$ 1mm).
	Top Diameter	29 – 34 mm ( $\pm$ 0.5mm).
	Taper	In accordance with length and bottle used ( $\pm$ 0.5mm).
	Ovality	1.0mm maximum.
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 approximately.
Material	Thickness	PVC as specified ( $\pm$ 0.1mm).
Decoration	Artwork	As specified in artwork with agreed supplier (high/low colour ranges).
Print	Artwork	Shall not differ from supplied artwork.
	Print	Clear, no smudging must have high scuff resistance.
	Registration	0.5 mm $\pm$ must have high scuff resistance.
Seam		Good adhesion and coverage right to the edge.
		No excessive glue.
Packing		Sticks packed lengthwise/parallel in a suitable carton to avoid crush damage, sealed to prevent the ingress of foreign material and in clean packaging materials which are made of contamination resistant recyclable material.
Spacing of caps on stick		8 – 11mm.
Length per stick		Less than 600mm.
Appearance		Not damaged / crushed / scuffed.
		Not stuck together.
		Not flattened.

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