



P.E.T. Containers Guideline

WPA_20

Prepared By: Wine Packagers of Australia

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This WPA Guideline contains information for the manufacture and supply of P.E.T. containers to third party contract packagers.

Where bottling customers are supplying their own P.E.T. containers, 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 directed to your contract packager.

2. Responsibility

Customers must ensure that P.E.T. containers provided to contract packagers are manufactured with reference to the information contained in this Guideline.

Customer supplied P.E.T. containers must be assessed and, where necessary, trialed prior to bottling. Sample P.E.T. containers shall be supplied at least 6 weeks before the scheduled bottling date to confirm your contract packager can achieve a mechanical application on their automated bottling lines.

The customer must advise their contract packager of the “Best Before” date for the product. This information will be applied to your product either by inkjet, laser etch or label during bottling. Customers should check with their contract packager to confirm whether they can also ink jet this information on to the shipper when packaged.

3. Requirements

P.E.T. Containers must comply with current existing regulations and legislation as per WPA_12 Food Safety Declaration for Food Contact Dry Goods.

Manufacturer’s approved technical drawings showing bottle dimensions and tolerances together with application specifications to be supplied in legible PDF format at least eight weeks in advance of the customer’s scheduled bottling date. These drawings must include:

- Bottle height
- Neck diameter
- Bottle finish dimensions (i.e. Bore/thread detail)

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- Fill point
- Fill volume
- Brimful volume
- Bottle diameter
- Weight
- Embossing details if present

4. Criteria and Tolerances

Criteria	Tolerance
Application requirements - 750mL capping head vertical load pressure	Supplied to withstand downward vertical load pressure of 90 - 100kg.
Application requirements - 187mL capping head vertical load pressure	Supplied to withstand downward vertical load pressure of 80 – 120kg.
Bottle neck finishes	To comply with the CETIE standards.
Brimful capacity and fill point tolerances	<p>Must be as specified on the approved technical drawings. The manufacturer/supplier shall maintain records of the average capacity over the manufacturing run. Manufacturer/supplier must ensure containers supplied can maintain Australian average fill requirements.</p> <p>⚠️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.</p>
Exterior surface coating	To be treated with approved materials. These coatings are to cover the exterior of the bottle and show no visible signs of application or discoloration No treatment is to be inside the bottle.
	Must resist scuffing and or abrasion during processing, handling and distribution.
	Shall allow for full label adhesion using self-adhesive labels
	Materials or application levels shall not be changed without prior notification to your contract packager..
Bottle Colour	As agreed to between supplier and customer.
Bottle Stipple	Required on base of containers to aid bottle conveying and handling on contract packagers' automated bottling lines.
Critical defects – Foreign Matter	Containers supplied that are found to contain any foreign matter will be classified as critically defective and will not be

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	accepted.
Critical defects – Imperfections	Any mismatching of either the thread or finish of supplied containers that result in over-press.
	Imperfections that will cause closure seal failure or wine to leak.
	Defects that affect the appearance and stability of the containers.
Bottle Identification	Individual containers must be marked on the base with bottle ID, mould number, supplier Code and Manufacturers logo.

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, are packed using recyclable materials and all packaging materials minimised..

7. References

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

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