



Mobile Bottling Specifications and Requirements

Scope

These Specifications and Requirements are for mobile wine bottling services from Newark Bottling Inc. They are applicable only when accompanied by a signed “Wine Bottling Service Agreement” (contract) between “Newark Bottling Inc.” (NBI) and the “Winery”.

NBI Provides...

Bottling System Capabilities

- Rated for nominal 3000 bottles per hour
- Symmetrical round bottle
- Tooling for bottles 50 – 102mm (2 – 4”) diameter x 355mm (14”) high

Mobile Bottling Trailer

- 50-foot drop deck enclosed trailer hauled by separate truck
- Climate controlled (heating and cooling)
- 208-volt 3-phase power distribution system
- Fully fitted with all the equipment necessary for mobile bottling

Air Compressor & Nitrogen Generator

- 15 horsepower rotary screw variable speed air compressor with refrigerant air dryer
- 4.5 cfm @99.95% pure nitrogen generator with desiccant air dryer

Wine Transfer Equipment

- Portable Criveller variable speed lobe pump with nitrogen purge connections
- 25’ Bacco wine hose with 1.5” Tri-Clover connections

Wine Filtering Equipment

- Single element 2-stage (code 7) filter housing to accommodate 4-inch x 30-inch filter elements (preliminary and final)
- Available for purchase: Pall preliminary (1.0 micron) and final (0.45 micron) filter elements
- Pall Compact Touch filter integrity tester
- Filter bubble tester

Water Purification Equipment

- Dual grade 25/1-micron sediment filter
- Activated charcoal filter
- Ultraviolet disinfection system

Additional Sanitization & Quality Control Equipment

- 17 KW steam generator for filler sanitizing
- Hygiena SystemSURE portable ATP surface bacteria tester/analyser



Bottling Equipment

- Fimer Monoblock bottler
- 16-head rotary inverting bottle rinser (choice of compressed air or purified water)
- Prefill bottle deaerator and nitrogen filler
- 16-head gravity/low vacuum filler with fill level control
- Vacuum corker (natural, synthetic or agglomerate corks) with pre-cork nitrogen sparger
- Screw capper (standard or Stelvin Lux caps) with nitrogen fill to bottle neck and cap

Capsuling Equipment

- Omar, Robino & Galandrino capsuler
- Automatic capsule feed and dispensing
- Bottle neck blow-off
- Adjustable for a broad range of capsule sizes
- Capable of rolling aluminum capsules or heat shrinking PVC capsules

Labeling Equipment

- Eticap rotary labeler
- Pressure sensitive self-adhesive labels
- Up to 3 labels per bottle – front, back, neck (single label per spool)
- Spool maximum outside diameter: 280mm (11")
- Spool holding plate outside diameter: 300mm (11.75")
- Spool core inside diameter: 76mm (3")
- Spool wind: No. 4 (left side off, outside peel)
- Label spacing on Liner: 2.5 – 3.0mm (0.098 – 0.118")
- Front label max dimensions: 135mm long x 200mm high (5.375 x 7.875")
- Back label max dimensions: 135mm long x 200mm high (5.375 x 7.875")
- Neck label max dimensions: 135mm long x 100mm high (5.375 x 3.875")

Case Taper & Case Label Printer

- On-board case taper (top only) and case label printer (print, peel & present, LCBO spec compliant)

NBI Staff

Two NBI qualified technicians will operate the mobile bottling equipment and work with winery staff to:

- Provide a safe and respectful work environment for all bottling personnel
- Ensure all bottling specifications provided by the winery are met (temperature compensate fill level)
- Arrive on-site with equipment configured as per the samples previously provided by the winery
- Sanitize the wine circuit with steam prior to commencing bottling
- Regularly monitor fill level, closures and packaging materials to ensure overall quality
- Follow NBI standard operating procedures to ensure all wetted parts of the bottler remain bacteria-free during bottling
- Minimize wine losses that occur at the start and end of each bottling run
- Wash and flush the wine circuit in the bottler at the end of each bottling run
- Withhold hourly samples of each wine bottled for quality assurance purposes and record date and time on each sample



Winery Provides...

Trailer Access

A minimum space of 100 feet by 12 feet (on a firm and stable gravel base or better) with 14 feet overhead clearance (trees, wires, etc.) to maneuver, set up and bottle. In most cases NBI will survey the site prior to bottling for trailer access and utilities.

Electrical Power Supply

A dedicated 100 amp 208-volt 3-phase service, or a 35KW 3-phase generator. Power should be located within 50 feet of the rear of the bottling trailer. A winery-supplied receptacle (Hubbell No. HBL5100R9W or HBL5100C9W) should be installed and properly wired prior to bottling. NBI technicians will not connect directly into electrical panels. If there is not a compatible receptacle, the winery must supply a qualified individual (licensed electrician) to install and remove NBI's supplied pigtail to and from the winery's electrical panel/generator.

Water and Sewer

- A reliable supply of potable water at a minimum of 50 psi and 10 gpm used to sanitize, rinse, wash and flush. Dirty water can cause filters to plug and fail.
- A means to collect and dispose of the trailer discharge (water).

Pre-Bottling Data and Samples (two weeks prior to bottling)

- Sample glass (12 bottles) with manufacturer drawing/specifications
- Sample corks or screw Caps (36 pieces) with manufacturer drawing/specifications
- Sample bottle labels (1 spool)
- Sample bottle with label(s) applied and established fill point – NBI is not responsible for establishing the legal fill point
 - Note: to achieve proper cork vacuum, a 12mm space is required below the cork
- Case label data (content and format) or sample

Wine and Filters

- Wines must be pre-filtered as needed to be “bottle-ready” upon arrival of NBI
In-line filtration, blending or additives is not permissible while bottling
Improperly filtered wine can plug filters, cause fill height issues or slow down the bottling speed
- Final bottling filters can be purchased from NBI or the winery may choose to provide their own
Filters offered by NBI are Pall 1.0-micron preliminary and 0.45-micron final
- Wines must be at least 15°C to assure proper fill and prevent condensation (to avoid label problems)

Pump, Hose and Fittings

- Any adapters or additional hoses as necessary to connect to NBI's equipment
- Work with NBI staff to sanitize the pump and hoses 30 minutes prior to the start of bottling



Winery Staff

Quality Control Representative

One representative responsible for bottling quality including, but not limited to:

- Verify proper sanitation of filters and filling equipment, and the integrity testing of filter elements
- Approve, monitor and make all decisions regarding: wine quality and characteristics; fill height; cork insertion; screw cap closure; label placement; case label and overall package quality
- Be available at all times during bottling
- Before and during bottling, ensure all winery staff monitor overall package appearance and promptly communicating any problems to the NBI crew

Material Handling

Provide experienced personnel for all material handling that can perform physically demanding work.

Minimum requirements are as follows:

- Load glass one person
- Packers two people
- Case label one person
- Palletizing one or two people
- Forklift operator one person

Packaging Materials and Supplies

Glass, closures, capsules, bottle labels and cases must be on site prior to bottling, be clean and meet all specifications. NBI does not guarantee that winery supplied materials will work on the bottling line unless they were tested and approved by NBI two weeks prior to the bottling date. Use of recycled glass is not permissible due to the inconsistencies encountered from various manufacturers' molds.

- Note: On bottling day glass must be climatized to match the wine temperature to prevent labelling problems

Changes

Bottle, closure, capsule, label and wine changes can take 30 to 90 minutes, depending upon the number of tooling parts that need to be changed or adjusted. Notify NBI prior to the bottling date for these changes.

Hourly Rates

NBI bottling fees are based on the nominal production rate of 3000 bottles per hour unless agreed upon prior to bottling. NBI may impose an hourly rate for downtime due to winery-related problems. This includes packaging materials not being provided on time, improper wine filtration, shortage of labor, or any other reason regarding winery operations, as they affect the bottling process.

Bottling Start Time

Unless otherwise agreed upon bottling should begin at 8:00 am. The NBI crew needs winery access and materials by 6:00 am for sterilization and set-up.

Payment

Full payment is due upon completion of job and submission of invoice, unless otherwise agreed upon in advance.