



Line 4 Specifications & Check List

- Line #4 is a 48 foot dock height trailer hauled by trucking contractors. *This line requires approximately 80 feet in length and 50 feet in width to maneuver.* We also need a clear path of 12 feet wide by 14 feet tall allowing that no trees, bushes, or other obstacles obstruct or rub up against our equipment causing damage.
- TIOB crew must have access to the facility, power, water, and bottling materials, 2 hours prior to the scheduled start time. Unless otherwise agreed upon, bottling will begin at 8:00 am and end at 4:30 pm which includes a ½ hr. lunch break.
- Bottling area should be level and within 100 feet of water, power, and wine.
- Winery must supply a dedicated 3-phase circuit for one of the following: 230v with either 60 or 100 amps, or: 480v with either 30 or 60 amps, or: a generator with a minimum of 35kw. A Hubbell type receptacle should be installed and properly wired prior to bottling. If a Hubbell type receptacle or Service Disconnect isn't provided, The CUSTOMER or their Electrician will wire directly into a dedicated circuit breaker within their Electrical Panel.
- High pressure Nitrogen tanks are required to be supplied by the winery. Daily output is subject to many factors depending on climate and winery usage and one can expect the below outputs.
 - Dwyer on wheels rated @ 350lbs, 5500 cu. Ft. averages from 1500 to 2500 cases
 - Dwyer w/out wheels rated @ 250lbs, 3600 Cu. Ft. averages from 1000 to 1300 cases
 - Cylinder/Canister rated @ 255 Cu. Ft. averages from 100 to 300 cases
- TIOB bottling lines require clean, filtered, potable water supplied with a minimum of 30 PSI and 10 GPM. Dirty water used during sanitation can cause filters to plug and fail!
- Wines must be at least 58 degrees Fahrenheit to assure proper fill and to minimize condensation.
- TIOB uses 30 inch code 7 filters. We carry 0.50µ Pre and 0.45µ Final Filters along with a 70µ stainless steel screen (bug-catcher). The winery can supply its own filters or purchase our proprietary filters. If other filters are required, please call your TIOB contact to make arrangements at least two weeks prior to bottling.
- Line #4 use a Waukesha 30 wine pump and can provide 100 feet of 1 ½ inch hose with tri-clover fittings. The winery must provide any adapters necessary to connect to our pump and hoses. The winery is solely responsible for sanitizing the pump and hoses 30 minutes prior to the start of bottling.
- The Winery is to designate one person responsible for decisions regarding bottling, quality control and bottling approvals, who shall be available at all times during bottling. The packers provided by Winery are responsible for monitoring overall package appearance and communicating any problems to the TIOB crew.
- The winery is to provide experienced personnel which are able to perform physically demanding work while paying attention to details concerning quality. Two people to dump glass, three people for packing cases, one person to apply case labels and/or date stamp, one person rotating with dumpers to stack cases, and one person to operate the forklift.
- Line #4 uses an Impresstik vacuum labeler and can apply front and back labels using one or two rolls. #3 (off-right) unwind, 3" core, with a maximum of 11" OSD on either a PK44 or 1.5 poly liners with a tolerance of + or – 2mm in all directions. ***Tapered glass must have tapered labels on separate rolls.***
- Recommended Minimum label height of 0.50" and Maximum label height of 5.50". Label packages should not exceed 70% of label panel width due to glass tolerances and label heights should be at least 5mm less than the specified label panel height. Packages outside these tolerances should be tested prior to bottling.
- Glass Specs: Empty glass should be packed neck down for dumping. Most 375ml bottles up to 1.5L with a minimum height of 160mm and a maximum height of 360mm and a minimum diameter of 55mm and maximum diameter 108 ± 2mm. Any glass outside these parameters should be sent to TIOB two weeks prior to bottling for testing.
- Line #4 has a BelCor 150 top case sealer that uses clear packaging tape.