

REFPET Plant Technical Requirements

Purpose To list technical requirements bottlers must meet for approval to refill REFPET with the company’s product.

Scope Apply this document to each bottling location that fills carbonated beverages in REFPET bottles.

As a bottler, what requirements must I follow? Generally, you must establish programs, staff and train, operate according to company standards, and keep proper records.

Establish programs, procedures, equipment, and testing

1. Have approved programs for Consumer Response and Incident Management.
2. Have written standard operating procedures (SOPs) for all plant processing and packaging equipment. SOPs must cover start-up, shut-down, sanitation, preventive maintenance, and quality-control testing.
3. Get all mandatory equipment and bottle-inspection systems in place and operating before the first filling, including approved equipment for pre-wash inspections. (See [document TBD](#) in this manual for a list of required equipment.)



CAUTION: Before the first filling on a line, do a 25-loop, line-trial test to evaluate bottle wear and send results to the division technical manager for approval.

Staff and train for REFPET processing

1. Get REFPET training from suppliers and division people for all key plant employees before the first filling.

2. Employ a professional QC manager for your plant who has the correct degree and training for this key job. Make sure he or she has the authority to stop production and put a product on hold until the problem with a quality requirement or standard is resolved.
3. Have a fully staffed QC department for all REFPET production shifts.
4. Have a qualified engineer or equally trained professional maintain and operate the pre-wash inspection detectors.

Operate according to company standards

1. Agree in writing to operate REFPET plants so they meet all REFPET requirements in this manual and in [policy documents](#).
2. Use only approved proprietary bottles, **not** industry bottles or your own products.
3. Use only approved line lubricants, washer additives, and label glues.
4. Use [date coding](#) that identifies your plant, date and time of production, and the line on which every REFPET bottle is filled.



NOTE: If you have a single-line plant, just identify the production facility and the filling date and time.

Keep proper records

1. Keep records of all REFPET training.
2. Establish REFPET log books for record keeping, and keep all records for at least two years. See [document TBD](#) for a list of required records.

