

Dolium

One-Way PET Kegs

Manual Filling Instructions



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1 - General precautions

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- Thoroughly read the **Handling and Safety Instructions**.
§ 4.1 **MUST DO's** and **DO NOT's**
- For information on storage of empty or filled Dolium kegs or on palletizing see the **Keg Hygienic Filling Guidelines**
- **AVOID** any contact with alkaline cleaning agents and detergents.
- Ensure the working area for the kegs is pH neutral.
- **DO NOT** steam kegs.

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STORAGE
0°C < T° < 35°C
(32°F) (95°F)



2A - Prepare Dolium[®] Kegs

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Spray with PerAceticAcid Preferred method

STEP	ACTION
1	Rinse-off the spear head with cold, potable water.
2	Pour out the remaining rinse water.
3	Disinfect the spear heads by spraying with peraceticacid (minimum concentration 100 ppm PAA)
4	Allow a contact time of 3 to 5 minutes for sufficient disinfection action



2B - Prepare Dolium® Kegs

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Spray with Alcohol 80% alternative method

STEP	ACTION
1	Rinse-off the spear head with cold, potable water.
2	Pour out the remaining rinse water.
3	Disinfect the spear heads by spraying sufficient alcohol
4	Allow a contact time of 10 to 15 minutes for sufficient disinfection activity, prior to full evaporation of the alcohol



3 - Kit parts : Manual filling equipment

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1 - Keg connector 2 - Pressure gauge 3 – Plastic tubing 3/8”



Remove all
non-return
valves

Types: S – D – A – G

Ø +/- 50 mm
1 bar = 14,7 psi

L = 2 meter



3 – Prepare the filling equipment

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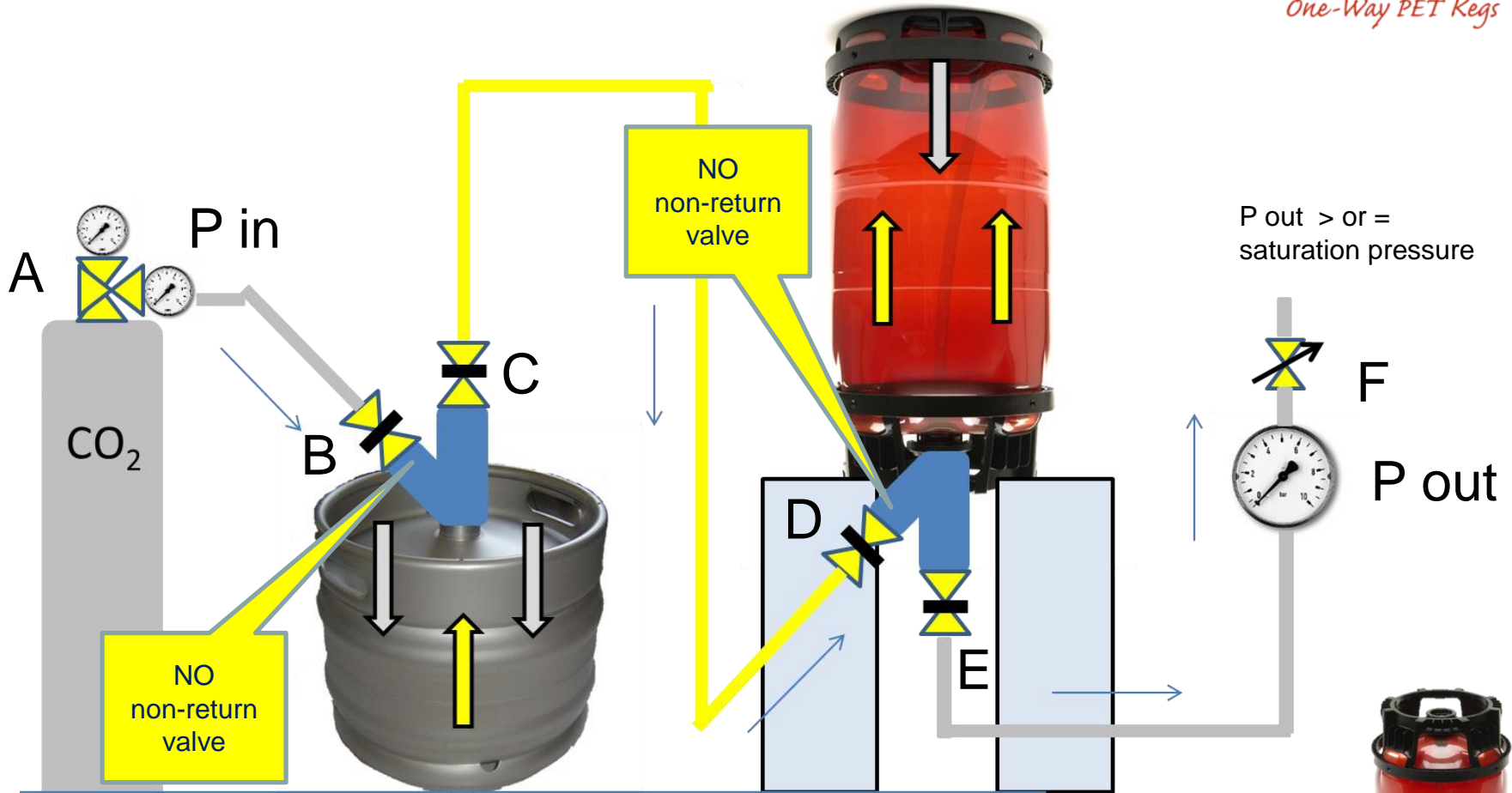
STEP	ACTION
1	When a CIP cleaning of a part of the filling line can be used: See Dolium Automatic Filling Guidelines for additional information
2	Take the kit "Manual filling equipment" out of the disinfection bath
3	Rinse out with water. Verify that the rinse water is of a potable quality and free of any beer harmful micro-organism.
4	Immerse the kit for 15 minutes in the PAA solution



4A – Dolium[®] Keg upside down preferred method faster fill

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SOURCE: keg or tank

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4 – Dolium® Keg

Manual Filling process

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STEP	ACTION
1	All valves must be closed (A,B,C,D,E and F)
2	Identify the temperature (°C) and carbonation (CO ₂ gr/l) of the beer
3	Determine the saturation pressure . See Handling and Safety Instructions, p. 6 §4,7
4	Set the pressure " P in " to this saturation pressure + 1 bar by regulation of valve A
5	Vent the tube to B with CO ₂ by pushing down the handle of the "SOURCE" connector
6	Pre-pressurize all DOLIUM kegs to the saturation pressure + 1 bar This action avoids foam building at start of the filling step 10
7	Remove the air from the spear of the beer storage keg or tank and connect.
8	Remove the air from tube C - D with beer by opening valve C and D and by pushing down the handle of the DOLIUM keg connector
9	Connect the DOLIUM keg connector to the spear of the DOLIUM keg. Only a small volume of beer might flow into the DOLIUM keg.
10	Open valve E and regulate the beer flow at valve F Keep pressure at P out ≥ saturation pressure
11	Almost full, slow down by closing the CO ₂ exit valve F
12	Disconnect the DOLIUM keg connector by lifting the handle
13	Immerse the DOLIUM keg connector into a PAA solution for an intermediate disinfection rinse to prevent cross-contamination between 2 keg fillings.
14	DO NOT lay down the DOLIUM keg connector on the (ground) surface
15	Fill the next DOLIUM keg by starting at step 9



4 – Dolium® Keg

Fill level

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Fill beer level
Up to the middle
of the feet (4A)
or of the shoulder (4B)



5 - Clean keg after filling

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STEP	ACTION
1	Rinse-off remaining beer residues with sterile, potable water.
2	Pour out the residual liquid.
3	Spray disinfect the spearheads
4	Cap the spear
5	Put on Dolium neck carton over keg neck



6 - Palletize filled kegs



STEP	ACTION
1	Use clean pallets.
2	Check the allowed maximum load for the pallets used.
3	Do NOT use pallets that are visually contaminated.
4	Do NOT use pallets with nails sticking out of the surface.
5	Strap the filled kegs at each level.
6	Wrap the palletised kegs with a white plastic film as it is a better protection against sunlight
7	Place cardboard top



7 - Store filling equipment

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STEP	ACTION
1	At the end of the filling of the Dolium kegs depressurise the kit
2	Clean and rinse out until all beer residues are removed, then drain the kit
3	Immerse the kit completely into the disinfection bath for hygienic storage
4	Respect the chemical dosing and renewal frequency of the QAC based disinfectant solution.



8 - Contact

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AXA  **GLASS**

www.dolium.eu

info@dolium.eu

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