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Washing Kegs

Standard Operating Procedure

Operator procedure for washing and sanitising returnable TUW kegs and lids on the standard Rhima RP3 wash + sanitise machine pair.

Prepared for	TUW partner dairies
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Procedure

Step	Instruction
1	<p>Prepare kegs. Check kegs to ensure insides do not contain leftover milk. If they do, give them a high-pressure pre-rinse and use a scrubbing brush to remove any residue.</p> <p>Do not place kegs in the washer if they still contain milk — this will soil the tank water and undermine wash quality.</p>
2	<p>Prepare lids. Prepare a bucket of hot, soapy water and soak lids prior to wash. Use a scrubbing brush to remove any milk solids if required.</p> <p>Do not place lids in the washer if they still have dried milk on them.</p>
3	<p>Prepare drying station for kegs. Use a bucket of hot soapy water to wash down the keg drying station and lid drying bench.</p>
4	<p>Prepare drying station for lids. Wash and sanitise 4x crates through the washers and place these on the lid drying bench.</p>
5	<p>Load WASH machine with 4x lids and 4x kegs and close the door to start the wash cycle.</p>
6	<p>When the screen reaches 100%, the cycle will be finished. Once complete, empty remaining water from the bottom of the kegs and move 4x kegs and 4x lids into the SANITISE machine. Close the door to start the sanitise cycle.</p>
7	<p>When the screen reaches 100%, the cycle will be finished. Once complete, visually inspect the inside of each keg for milk residue or any other kind of particulate. If any is found, the keg will need to be washed again.</p>
8	<p>Remove kegs from the Sanitise machine and stack upside down on top of one another.</p> <p>When handling the kegs, hold them by the sides only — do not touch the insides, as this can cause contamination.</p>
9	<p>Visually inspect the inside of each lid for milk residue or any other kind of particulate. If any is found, the lid will need to be washed again.</p>
10	<p>Remove lids from the Sanitise machine and stack facing down on the clean crates in the lid drying station.</p>
11	<p>Once the kegs have dried upside down for 15 minutes, seal them with the lid and stack them on a pallet.</p> <p>If the keg is not given adequate time to dry and cool down, the lids will be difficult to fit.</p>

Step	Instruction
12	<p>Scan kegs as Clean using The Udder Way app. Refer to the guide on the side of the Keg Washing machine to set up.</p> <p>Why this matters: every wash event is recorded against the keg serial number. The scan is TUW's traceability layer — if a quality issue is raised by a downstream customer, the affected wash batch can be identified and contained immediately.</p>
13	<p>Maximum wash capacity per tank: 120 kegs.</p> <p>Once you have washed 120 kegs, the water tanks of both machines need to be drained and refilled. Failure to do so can result in soiled wash water and soiled kegs.</p>

Notes

- This SOP covers the wash & sanitise cycle only. Start-up, cleaning & closing, and preventative maintenance are documented in the companion SOPs.
- Pre-rinse is performed manually before kegs enter the washer — high-pressure water and a scrubbing brush. The wash machine itself is not used for pre-rinse.
- TUW kegs and lids are the only components. There are no valves, taps or moving parts on the keg itself — the wash pathway is keg body + lid only.
- Wash chemistry: Typhoon detergent (alkaline, non-caustic) at 1.5 g/L. Sanitisation chemistry: Oxysan (peroxyacid) at 0.75 g/L. See HACCP plan and SDS sheets for full chemistry detail.
- **ATP swab limit:** 10 RLU is the upper limit requiring reprocessing. **TUW recommended operating target: under 3 RLU**, especially where washing and filling occur at separate sites — the extra transport and handling between wash and fill warrants a tighter margin.