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# INOC

Natural sealed stoppers  
for still wines



## DATA SHEET

**PRODUCT:** Stopper for still wines (alcoholic drink with alcohol content of < 20% (v/v) and pH lower than 4.5) intended for human consumption over a period of from a few weeks to 36 months, kept in storage conditions where the temperature does not exceed 40°C.

**MATERIAL:** Stopper in natural cork, sealed by a supplementary process consisting of blocking the lenticels with cork powder and a binder.

**TYPE:** One-piece cylindrical stopper.

**VISUAL CATEGORY:** According to samples for approval validated with the customer and taking account of the evaluation of anomalies in natural (sealed) stoppers in the FFL of 01-03-2012.

**DIMENSIONS:** L 45.0 to 49.0 mm D 24.0 mm

### TRACEABILITY CODE:

Default  
a ss n ACi  
a: last figure in the year / ss: number of the week of the surface treatment / n: order number in the week (from 2 if necessary) / ACi: ACIn countermark

**MARKING:** Body marked with ink and vintage branded on ends.

**SURFACE TREATMENT:** Based on silicon and paraffin suitable for food contact.

**PACKAGING:** Airtight sealed bag containing SO<sub>2</sub> (2,0 ± 1,0 g of gaseous SO<sub>2</sub> / 1.000 stoppers per sealed pouch).

### PACKING:

Carton of 5.000 stoppers in bags of 1.000 for the 45 and 49.

Pallet 100 x 120 x 180.

Single trip pallet in heat treated wood  
or

Plastic single trip pallet (on request with supplementary cost to be borne by the customer).

**SHELF LIFE BEFORE CORKING IN ORIGINAL PACKAGING:** 6 months.

## TECHNICAL SPECIFICATIONS AND INSPECTION METHODS

Specifications	Method	Samples	Reference values
Humidity (%)	ISO 9727-3	20	6,0 ± 2,0
Length (mm)	ISO 9727-1	32	Nominal ± 0,7
Diameter (mm)	ISO 9727-1	32	24,0 ± 0,4
Ovalisation (mm)	ISO 9727-1	32	≤ 0,7
Capillarity (mm)	NF B 57-100	4 treated finished stoppers ready for use	≤ 1,0
Visual quality • Operational faults • Non-operational faults	ISO 16419	80	NQA (= acceptable quality level) faults table Reference value depends on the type of range: • Standard range • Entry-level range
Dust content (mg/stopper)	ISO 9727-7	4	≤ 1,5
Dimensional recovery after compression in %	ISO 9727-4	5	> 90 (minimum)
Residual peroxides (mg/stopper)	ISO 21128	1 x 4	≤ 0,1
Liquid tightness in bars (relative pressure)	ISO 9727-6	6	> 0,9 (minimum)
Extraction force (daN) - measured with an NF EN12726 bottle ring	ISO 9727-5	5	15 to 40 (for the 45) 15 to 45 (for the 49)
Releasable 2,4,6-TCA (ng/L)	ISO 20752	1 x 10 or 2 x 10 according to size of the batch	Up to 4° ≤ 2,5 5° and 6° ≤ 3,5

## STORAGE CONDITIONS AND RECOMMENDATIONS FOR USE

Stopper life after corking between 6 and 36 months, according to visual category provided the correct conditions are respected:

### • storage

Stoppers will be kept in their original packaging and respecting correct storage conditions:

- storage above ground level;
- clean, healthy, ventilated and odourless location;
- temperature of the storage location between 15 and 25°C and avoiding sudden changes in temperature;
- relative humidity between 40 and 65%;
- stoppers must be kept away from any chemical products, pesticides, fungicides, phytosanitary products, chlorine-based sanitary products and wood surfaces or materials which have been treated (in particular with halophenols). Storing the stoppers for 48 hours before bottling, at an average temperature of 20°C, allows the stoppers to be in optimal conditions for use.

The first stoppers purchased will be the first ones used (FIFO).

All bags opened will be used immediately and in their entirety.

### • corking

Stopper for still wine on bottles fitted with a CETIE finish (NF EN 12726).

In addition to the quality of the materials, the success of the corking operation also depends on the conditions in which this operation is carried out and in particular on the following aspects:

- the equipment being in good condition and correctly adjusted;
- training of the staff responsible for checking, adjusting and performing the operation;
- checks on the corking to be carried out without fail at the start of the corking operation and at regular intervals during the operation. The results of these tests must be documented and archived.
- rinsing and draining of the bottles before they are filled;
- correcting the wine level according to the temperature;
- compression diameter of the clamps between 15.5 +0.5/-0. Optimum 15.8 mm;
- diameter of the piston between of 14 ±0.5 mm;
- the stands must be flat and in a clean condition to ensure the bottle slides and is positioned correctly;
- the mouthpieces and adjustment cones must not have any scratches, chips or ovalisation;
- creating a vacuum when corking. The pressure in the headsapce of the bottles must be between -0.3 and 0 bar after 3 minutes of corking;
- wait for at least 3 minutes before laying down the bottle so that the stopper has time to exert sufficient pressure on the glass.

### • bottle transport

- Maintain a stable temperature in a healthy and odourless environment.

Source: CETIE Bottling Guides - Guide no. 1 - 2007 edition

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