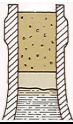


Processing Instructions

Natural Cork Stoppers

(Wine and Sparkling Wine)



1	Storage of cork stoppers in general 	Natural cork stoppers must be stored in separate rooms that are well-ventilated, odor-free and at a normal room temperature. We recommend processing the cork stoppers within 6 months of receiving them.
	Storage of cork stoppers before bottling	Natural cork stoppers should be stored at a temperature of 18/20°C for at least 24 hours prior to processing. This allows the cork stoppers to acclimate to the desired temperature and ensures better handling during processing.
2	Bottles 	Please use only bottles whose inner neck dimensions comply with the following standards: Wine bottles: DIN EN 12726 Sparkling wine bottles: DIN 6094-5
3	Cork jaws 	The cork jaws must be regularly inspected for damages before and during use. Damaged cork jaws cause creases and other mechanical damage to the cork, leading to leaks and an increased presence of cork dust. The diameter of the cork jaws must not be less than 16 mm when in the closed state.
4	Corking machine 	To prevent unwanted cork dust, the following parts of the corking machine should be carefully inspected before bottling: • Cork hopper: Check for sharp edges and mechanical damage on its moving parts • Cork feeding tube: Inspect for sharp edges and mechanical damage • Cork jaws (as mentioned in point 3) • Cork jaws heating element: Ensure it does not exceed a maximum temperature of 80° C • Centering tulip and cork plunger: Check for proper fit and precise centering • Bottle guide: Ensure it matches the shape of the bottle Optimal centering of the bottle under the cork jaws ensures a clean and straight placement the natural cork in the bottle neck. For sparkling wine corks, the corking depth should be 22 - 24 mm.
5	Filling level 	There should be a minimum clearance of 55 mm (with a cork length of 44 mm) above the fill level (measured from the top edge of the bottle neck) when the wine is a temperature of 20° C. If the wine is colder, the fill level should be adjusted lower, and if the wine is warmer, the fill level should be adjusted higher accordingly.
6	Internal pressure	The internal pressure of the bottles should be checked with every filling. This applies even when using a vacuum device to verify its functionality. The necessary bottle resting time after corking depends on the internal pressure of the bottles.
7	Laying down or upright positioning of the bottles 	To prevent pressure-related issues, it is ideal to allow the bottles to stand for 24 hours after corking. This resting period helps stabilize the internal pressure and minimize the risk of any undesired pressure build-up or leakage. However, if effective pressure-reducing measures such as CO² overpressure or vacuum devices are in place, a resting time of 5 minutes while stand is generally sufficient. Please note that standard agglomerated cork stoppers are only suitable for standing storage for a maximum of 12 months. It is important to follow these guidelines to ensure the quality and integrity of the sealed bottles during storage.
8	Storage and transport of the bottled wine	Major temperature fluctuations should be avoided during storage and transportation. Temperature variations can cause changes in the volume, leading to issues such as cork pushers and pressure-related leaks.