

# Nomacorc Closures Bottling Guidelines

Following these simple guidelines, successful bottling with Nomacorc closures should be achieved provided there is adherence to all other recommendations on bottling conditions from the glass suppliers and equipment manufacturers. Adaptations to fit specific needs are the responsibility of the bottler; however, Nomacorc representatives are available for additional guidance and troubleshooting by emailing us at [info@nomacorc.com](mailto:info@nomacorc.com) or calling us in the United States at +1 (919)460-2200 or in Europe at (+32) 87-63-88-20.

## Storage of Nomacorc Closures

- If these closures are to be stored on site for a period of time prior to use, please ensure they are kept in a cool, dry, odor-free and ventilated room, preferably between the temperatures of 10°C (50°F) and 30°C (86°F). Avoid any contact with chemicals, pesticides, fungicides, chlorine-based sanitary products and treated wooden structures (most especially those treated with halophenols).
- Each bag of closures should be opened directly before bottling.
- Open bags should be used immediately and completely.
- For the storage of extra bags of closures, we recommend a maximum of 12 months after production date.

## The Bottles used with Nomacorcs

- Nomacorc products are designed to work best with bottles according to the CETIE or GPI standards.
- Bottles from different lots should be uniform to ensure a successful filling run.
- The bottle mouth and neck should be thoroughly cleaned and dry.
- Recycled bottles are not recommended with Nomacorc closures.

## The Set-Up of Corking Equipment used with Nomacorcs

- Any standard, well-maintained corking machine may be used with Nomacorcs. Special settings are not typically required.
- Nomacorcs perform best on four-jaw corking head.
- The condition of the corking jaws should be inspected prior to and during use. Look for a good fitting joint at the edges, without "parrot mouth", and the absence of nicks on the edges of the jaws and the absence of grooves in the ellipse of the jaws.
- Heated clamps should not be used with Nomacorc closures.
- Centering of the cork plunger, the closure and the bottle neck is critical to ensure proper seals and prevent any damage to the corking equipment or closures.
- To maintain optimum mechanical and aesthetic performance, the recommended compression diameter settings on the corking jaws for Nomacorc closures are between 15,5 mm and 16,0 mm. Please refer to your equipment manufacturer to identify your default factory settings for the compression diameters. In certain low temperature conditions, it may be helpful to adjust the compression diameter up to 16,5 mm.
- Manual corking machines may be used with Nomacorc closures. However, extreme care must be used and Nomacorc recommends testing to ensure the jaws do not damage the closures. Please contact Nomacorc for more information.

## The Bottling Process used with Nomacorcs

- To monitor the jaws during the run, remove several bottles from the conveyor after the run has begun and check for any lipping, creasing or cuts.
- Nomacorc recommends a maximum insertion of 1.0mm below the top of the bottle.

### **Ullage Pressure and Nomatics**

- When closing bottles under vacuum, monitor the pressure in the ullage (headspace) approximately ten minutes after bottling to ensure it is between -0.3bar (-4.35psi) and +0.3bar (+4.35psi).
- Manual measurements through the closure into the headspace should be made with a pressure gauge attached to a thin needle (afrometer).

### **Filling Height and Temperature**

- Fill levels should comply with the bottle manufacturer's designated fill height and wine temperature, which is usually indicated at the bottom of the bottle. This is often either 55mm, 63mm, or 70mm as filled at 20°C (68°F) measured from the very top rim of the bottle.
- Recommended fill heights provided by the bottle suppliers always refer to a wine temperature of 20°C (68°F). Therefore, if the wine is to be filled at temperatures other than 20°C (68°F), fill height adjustments must be made to account for eventual expansion of the wine.
- The Nomatic closures should be inserted into the bottles under similar room temperatures (close to 20°C (68°F)).
- Choose a Nomatic length that, according to the fill height, will allow a minimum ullage (headspace) of 15mm at a wine temperature of 20°C (68°F) for a 750mL glass wine bottle. The expansion curves show the approximate temperature to which the wine will contact the stopper and will apply a hydraulic pressure. In all cases, this pressure will result in movement of the closure and/or leakage.
- During the insertion process, Nomatic closures typically elongate an average of 2mm after inserted into the bottle.
- For other capacity than 0,75 litre, please refer to the bottle manufacturer's information.