



NOMACORC®

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 info@nomacorc.com or calling us in the United States at 919-460-2200 or in Europe at (32) 87-63-88-20.

Storage of Nomacorc Closures

- All Nomacorc closures will arrive packaged in a sealed, polyethylene bag containing 1000 units.
- 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 and clean area, preferably between the temperatures of 5°C (41°F) and 30°C (86°F). Avoid any contact with liquids or natural corks, and keep out of direct sunlight.
- Each bag of closures should be opened immediately prior to placement into the corking machine to ensure they are clean of contaminants and do not absorb any sensory elements of the environment.
- Once bottling has begun and closures are removed from the bags, any unused Nomacorc closures upon completion of the process should be discarded to maintain hygienic conditions.
- For the storage of extra bags of closures, we recommend a maximum of one year.

The Bottles used with Nomacorcs

- Only quality bottles conforming to the CETIE or GPI standards on cork mouth finishes should be used with Nomacorc closures.
 - 18.0mm-19.0mm, measured at 3mm in from the top of the bottle
 - 18.5mm-20.0mm, measured at 15mm in from the top of the bottle
 - 19.0mm-20.5mm, measured at 30mm in from the top of the bottle
 - 19.0mm-21.0mm, measured at 45mm in from the top of the bottle

- Bottles from different lots should be uniform to ensure a successful filling run.
- The bottle mouth and neck should be thoroughly cleaned and dry.
- Re-used bottles (from a bottle recycling source or other provider) can pose a challenge for all corks, including Nomacorcs, due to the high degree of variability. As the re-used bottles will come from different manufacturers and different glass molds, the variation in bottle height and bottleneck dimensions can cause issues during bottling. Please ensure the bottles are thoroughly cleaned and dried prior to use, and pay close attention to bottle fill levels and headspace pressures.

The Set-Up of Corking Equipment used with Nomacorcs

- Any standard, well-maintained corking machined may be used with Nomacorcs, and special settings other than those used with natural bark corks are not typically required.
- Nomacorcs perform best on four-jaw feeding systems used with a vacuum.
- The condition of the corking jaws should be inspected prior to and during use.
- Heated clamps may 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 15.5mm and 16.5mm. Please refer to your equipment manufacturer to identify your default factory settings for the compression diameters. Current factory default settings on newer GAI and Bertolaso machines are 16mm.
- Manual corking machines may be used with Nomacorcs, however, extreme care must be used and Nomacorc recommends testing to ensure the jaws do not damage the closures.

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 cutting (which could indicate future leakage).
- The compression speed of the closure should be slow while the speed of the closure insertion into the bottle should be fast.
- Nomacorc recommends a maximum insertion of 1.0mm below the top of the bottle.

Ullage Pressure and Nomacorcs

- When closing bottles under vacuum, the pump should be set to -0.5bar (-6.75psi). For the ideal seal, 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).
- Please be aware that the vacuum pump gauges may not accurately reflect the actual ullage pressure, therefore, manual measurements through the closure into the headspace should be made with a pressure gauge attached to a thin needle.

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 Nomacorc closures should be inserted into the bottles under similar room temperatures (close to 20°C (68°F)). It is recommended that the closures themselves be brought up close to this temperature prior to use.
- Choose a Nomacorc length (36, 37, 38, 42, 43, 44 or 47mm) that, according to the fill height, will allow a minimum ullage (headspace) of 17mm at a wine temperature of 20°C (68°F) for a 750mL glass wine bottle.
- For a 1.5L wine bottle, the ullage or headspace height should be 27-30mm at a 20°C wine fill temperature.
- During the insertion process, Nomacorc closures typically elongate an average of 2mm when inserted into the bottle.