



Natural Cork Closures

Portocork

Natural cork cylindrical stoppers are obtained by punching the highest quality raw cork.



The Portocork Difference

The stoppers are rectified to obtain the exact desired length, and then qualities are selected by state-of-the-art optical cameras. Then, the most important step: every single bale of cork is tested for TCA using GC/MS technology. This uncompromising use of technology minimizes the possibility of cross-contamination prior to washing, which is the key to Portocork's success. Following the washing process which incorporates hydrogen peroxide, the stoppers are dried with sterilized air, and then manually sorted. Before shipment, an additional GC/MS test is performed on 20% of all bales. This rigorous process, second to none in the cork industry, is one of the many reasons Portocork is the leading supplier of natural cork stoppers to the U.S. wine market.

PRODUCTION FLOWCHART

1 · CONVEX BOILING

2 · CORK BARK SORTING

3 · CUTTING *and* PUNCHING

4 · MECHANICAL FINISHING

5 · ELECTRONIC SORTING

6 · TCA CONTROL *by* GC/MS

7 · WASHING *and* DRYING

8 · SORTING

9 · TCA CONTROL *by* GC/MS

10 · BRANDING

11 · TREATMENT

12 · PACKAGING *and* DISPATCH

SPECIFICATIONS

PHYSICAL MECHANICAL TESTS	SPECIFICATIONS
Length (l)	$l \pm 1.0 \text{ mm}$
Diameter (d)	$d \pm 0.5 \text{ mm}$
Ovalisation	$\leq 0.7 \text{ mm}$
Moisture	5% – 7.5%
Extraction Force	$30 \pm 10 \text{ daN}$

PHYSICAL CHEMICAL TESTS	SPECIFICATIONS
Peroxide Content	$\leq 0.1 \text{ mg/cork}$
Surface Treatment Content (1)	$t \pm 4 \text{ mg/cork}$
Dust Content	$\leq 3 \text{ mg/cork}$

MICROBIOLOGICAL TEST	SPECIFICATIONS
N° of UFC/cork	Bacteria < 2 Yeast < 2 Mould < 5

TCA TEST USING GC/MS	SPECIFICATIONS
	< 1.5 PPT

VISUAL TEST	SPECIFICATIONS
Visual Grade (2)	Reference Deviation > -5%

CHECKLIST FOR WINERIES

Selection and Storage of Corks

- Portocork can calculate the required cork diameter from the volume of the neck of your bottle.
- A wine with a high CO₂ may require a cork with a greater diameter than normal. Corks that are longer than normal may aid in long-term cellaring for some wine bottle types.
- Corks should be ordered for immediate or quick use.
- Store in a well-ventilated room with controlled temperature between 15°C and 20°C and 50% to 70% humidity.

Inserting the Cork

- Ensure that the cork is slowly compressed to a diameter of no less than 15 mm.
- The cork should be inserted as quickly as possible.
- For standard bottlenecks, the cork should be inserted to 1 mm below the top of the neck.
- Minimize moisture on the interior of the bottleneck.
- Headspace at 20°C should be at least 15 mm.
- Vacuum bottling or CO₂ flushing will reduce internal pressures.

Storage and Transportation of Wine

- After bottling, keep wine upright for a minimum of 5 – 10 minutes.
- Ideal bottle storage conditions are 15–20°C at 50%–70% humidity.
- Keep the wine cellar clean and free of pests.
- Bottles should always be kept in an upright position.

Maintaining Equipment

- Maintain the corker jaws free of nicks and signs of wear.
- Ensure proper alignment of plunger and location ring.
- Ensure corking machine operates smoothly, especially during compression.
- Clean all cork-handling surfaces regularly with chlorine-free products.

Food Standards & Norms

All Portocork products are manufactured in accordance with FDA, Portuguese and European regulations for materials and articles that come into contact with food.

