



# Twin Top<sup>®</sup> Closures

*Portocork*

Introduced in the mid 1990s,  
**Twin Top<sup>®</sup>** is among the most successful  
technical corks ever developed.



Based on Champagne cork technology, Twin Top<sup>®</sup> has a granulated body and high-quality discs at each end. These stoppers retain all the benefits of a natural cork closure with added protection from our exclusive process "ROSA" (extraction of 2, 4, 6 TCA by steam distillation). These stoppers are recommended for wines having a shelf life of less than 5 years in the bottle. Twin Tops retain all the beneficial properties of Natural cork stoppers, satisfy the highest demands of winemakers, and can be used on the same bottling line as traditionally-punched natural cork stoppers.

## PRODUCTION FLOWCHART



## SPECIFICATIONS

PHYSICAL MECHANICAL TESTS	SPECIFICATIONS
Length (l)	$l \pm 1.0$ mm
Diameter (d)	$d \pm 0.4$ mm
Ovality	$\leq 0.3$ mm
Moisture	4% – 9%
Specific Weight	$290 \pm 40$ Kg/m <sup>3</sup>
Extraction Force	$30 \pm 10$ daN

PHYSICAL CHEMICAL TESTS	SPECIFICATIONS
Peroxide Content	$\leq 0.1$ mg/cork
Dust Content	$\leq 3$ 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 high CO<sub>2</sub> may require a cork with a greater diameter than normal.
- 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 CO<sub>2</sub> 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.

### Available Dimensions

- 44 x 23.5 mm
- 39 x 23.5 mm
- 39 x 26 mm
- 39 x 27.5 mm