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FINISHED PRODUCT SPECIFICATIONS	Date: 11-05-13	
MICROTECH STOPPER	VERSION: 1	

Innovation and technological advances in the manufacture of technical stoppers have allowed us to create PE MICROTECH stoppers, made from microgranulate cork taken entirely from our natural cork stopper manufacturing process. Parramon Exportap is the only company to remove the outer bark from the punched cork strips before trituring them to produce microgranulate. Removing the bark before the trituration process eliminates the possibility of any problems appearing that might affect the sensorial neutrality.

Both the density and the granulometry are checked to ensure perfect suitability. Parramon Exportap offers this type of technical stopper for wines with a certain level of product turnover, as they guarantee a perfect closure and provide the following qualities:

- They are recyclable, biodegradable and are produced from natural raw material.
- They offer good elasticity and compression/expansion, which means a tight closure.
- They offer perfect airtightness for liquids and gas.
- They have a homogeneous physical structure
- They offer very competitive value for money.

DESCRIPTION:

MicroTech cork stoppers for still and sparkling wines, which are bevelled, washed, treated, marked and packaged, are made of punched cork strips from which the back has been removed. All the raw material is sourced from our natural stopper manufacturing plant and the planks are 100% Spanish natural cork.

MEASUREMENTS		
POSSIBLE LENGTHS	POSSIBLE DIAMETERS	POSSIBLE QUALITIES
40 mm	24 mm	MicroTech
44 mm	26 mm	
47 mm		
48 mm	30.5 mm	MicroTech for champagne/cava

1-QUALITY STANDARDS FOR STOPPERS MANUFACTURED BY PARRAMON EXPORTAP, S. L.

CHARACTERISTICS	LOWER LIMIT	UPPER LIMIT	UNITS
Constitutional moisture	3	7	% humidity
Length	-0.5	+05	mm
Diameter	-03	-03	mm
Ovalisation	0	050	mm
Seasoning time of cork (raw material)	12	-	months as from harvesting
Density	250	330	kg/m ³
Extraction force	20	40	daN
Diameter recovery:			% RSD
Instantaneous		90	
After 5 minutes		95	
After 1 hour		97	
Residual powder		<= 1	mg/ stopper

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Extractable TCA:		<1.5	
2,4,6-trichloroanisole		< 1	Ng/1
Residual peroxide		<0.2	mg/ stopper
Breaking stress under torsion	9	14	daN/cm ²
Airtightness		> 2	Bar
Microbiological characteristics:			
Fungi and yeast	0	10	CFU/stopper
Bacteria	0	30	CFU/stopper

The cork's seasoning time is controlled using a FIFO warehouse system.

Of the above characteristics, the report which is produced for each shipment includes the following parameters: humidity, diameter, length, ovalisation and mean density. The samples taken for this analysis are: for shipments of 0 to 5,000 stoppers, a test sample of 5 stoppers; for 5,000 to 50,000 stoppers, a test sample of 10 stoppers; for 50,000 to 200,000 stoppers, a test sample of 25 stoppers; and for 200,000 to 400,000, a test sample of 50 stoppers.

The microbiological characteristics, maximum powder content and capillarity are tested in batches by sending samples to an external laboratory in a sterile clinical analysis container. This report is available for any customers who wish to read it.

1.2 MARKING

The stoppers may be branded or marked using ink or laser.

1.3 SURFACE TREATMENT

The surfaces of all our stoppers are treated with a combination of paraffin and silicone. Parramon Exportap does not advise hot bottling.

2-SANITARY RECORDS

All the products involved in the stopper manufacturing and treatment processes comply with Spanish legislation on food contact materials as well as EU and FDA directives.

3-PACKAGING

Parramon Exportap, S. L. packages its stoppers in plastic or aluminium bags containing SO₂ in a proportion not exceeding 2g of SO₂ per bag (measured under normal conditions). The bags are vacuum sealed and labelled. These bags are then placed into cardboard boxes which are also sealed and labelled.

The number of stoppers per bag and box depends on the specific order placed by the customer, but does not exceed 1,000 standard stoppers per bag or 5,000 stoppers per box.

Other types of packaging can be arranged at the customer's request.

4-BOTTLING RECOMMENDATIONS

-The air chamber, with wine at 20 °C, should be equal to or greater than 10 mm.

-The stoppers should be free of dust before bottling.

-The stoppers should be inserted as quickly as possible.

- The stoppers should be compressed slowly, with a diameter of no less than 15.5 mm.



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- The bottle's internal pressure should not exceed 0.9 bar.
- Once the product has been bottled, the bottles should be kept upright for at least 10 minutes.

5-LABELLING

All the boxes are labelled with at least the following information: the name Parramon Exportap, S. L, our order number, the customer's reference number, the total number of stoppers in the order, the batch number, the size of the stoppers, the quality of the stoppers, the number of stoppers per box, the box number out of the total number of boxes and the method used to mark the stoppers.

6-DOCUMENTATION SENT WITH EACH BATCH

-A delivery slip with the following details: Parramon Exportap, S. L.'s details, the customer's details, our order number and the customer's order number or reference, the date the stoppers left the premises of PE, the number of stoppers, their description (evaluation only if requested by the customer), the batch number, the net and gross weight and the name of the shipment company responsible for the delivery.

-A final quality control report for the customer, with the following details: Parramon Exportap, S. L.'s details, the customer's details, the total number of stoppers, the description of the stoppers, the batch number, the customer's reference, the control date, the humidity control, the length, the maximum diameter, the minimum diameter, the mean diameter, the ovalisation, the density, the visual quality control, the marking, the surface treatment, the type of packaging and the person responsible for the control. More parameters and laboratory analyses may be added according to the specifications of each customer. Other analyses will only be performed at the customer's request.

Drafted by: Estrella Bravo Checked and approved by: F. Parramon

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