

PARRAMON EXPORTAP, S. L. FINISHED PRODUCT SPECIFICATIONS COLMATED NATURAL CORK STOPPER	EPA Code-05 Date: 11-05-13 VERSION: 6	Page 1/3
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DESCRIPTION: Natural cork stoppers for still wines, shaped, chamfered, colmated, sorted, washed, coated, treated, marked and packaged, made of planks of 100% Spanish natural cork.

MEASUREMENTS		
POSSIBLE LENGTHS	POSSIBLE DIAMETERS	POSSIBLE QUALITIES
39 mm	23 mm	COLM AA
44 mm	24 mm	COLM A
49 mm	26 mm	COLM AB
		COLM B

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

CHARACTERISTICS	SPECIFICATIONS
Constitutional moisture	4% - 8%
Length	± 1 mm
Diameter	± 0.40 mm
Ovalisation	0.50 mm
Microbiological characteristics: fungi yeast and bacteria	10 CFU/stopper 30 CFU/stopper
Seasoning time of cork at Parramon's facilities	minimum 12 months
Apparent density	135-210 kg/m ³
Maximum powder content	< 2 mg/stopper
Extraction force	20-40 daN
Capillarity	< = 2.5 mm
Diameter recovery:	
instantaneous	> = 88% of its diameter
5 minutes	> = 93% of its diameter
Extractable TCA: 2,4,6-trichloroanisole	<2 Ng/1



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

Of the above characteristics, the report which is produced for each batch includes the following parameters: humidity, diameter, length, ovalisation, density and extraction and insertion force. The samples taken for this analysis are: for batches 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 VISUAL CHARACTERISTICS

AQL (Acceptable Quality Level): C (critical defect): 0% of the control sample. S (secondary defect): 5% of the control sample.

CRITICAL DEFECTS: any defect that affects the appearance, shape or functioning of the stopper, making it unusable or possibly unsuitable for optimal use:

- Cracks
- Yellow stains
- Green cork
- Rotten cork



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- Insect galleries
- Exfoliation
- Misshapen stoppers
- Belly spots that exceed 50% of the stopper's length
- Cuts that exceed 50% of the stopper's length and/or diameter

SECONDARY DEFECTS: any non-critical defect that affects the stopper's appearance or use without stopping it from functioning properly:

- Belly spots that do not exceed 50% of the length
- Cuts that do not exceed 50% of the length
- Incorrect chamfer
- Oblique heads
- Cracks that do not exceed 50% of the length and/or diameter

The report that is produced for each batch includes AQL tests for C and S defects.

1.3 QUALITY

Any stoppers that are seen to have critical defects are removed and destroyed.

They should correspond to PE standards. A maximum of 5% of units with a quality lower than the reference values will be accepted.

The visual quality control is recorded and sent with each shipment.

1.4 MARKING

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

The ink used meets FDA standards.

1.5 SURFACE TREATMENT

The surfaces of all our stoppers are treated with a combination of paraffin and silicone, in accordance with FDA standards.

Parramon Exportap does not advise hot bottling.

2-SANITARY RECORDS

The sanitary records at Parramon Exportap, S. L. are kept up to date and 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.

Parramon Exportap undergoes three quality audits each year: an internal audit; a UNE-EN-ISO 9001:2008 quality audit; and an ISO 14001:2008 environmental and Syste Code audit.

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.

Once the stoppers reach the customer's premises, we recommend they be placed in a well-ventilated storage area under controlled temperature and humidity, with a temperature of between 15 °C and 25 °C and humidity of between 50% and 70%.

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.

PARRAMON EXPORTAP, S. L. Commercial Registry of Girona, Volume 909, Folio 95, Sheet GI-16859 - Tax ID Code No. ESB 17471079



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

-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 extraction force, 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

Version:	Date	Description of changes
0	29-11-10	New version
1	11-05-13	Controls added

