

**RJRI****QC Warning and Control Limits for Filter Rod Production****Spot Checks**

Parameter	Unit	Test Frequency	Maximum Sample Size	Maximum Limits Warning	Maximum Limits Control
Draft Resistance	mmWG	20 min.	20 rods	$\pm 15$	$\pm 25$
Circumference	mm	20 min.	20 rods	$\pm 0.10$	$\pm 0.15$
Total Rod Weight	mg	20 min.	20 rods	$\pm 25$	$\pm 35$

(Tests conducted by Filter Rod Maker Operator)

**RJRI****QC Warning and Control Limits for Cigarette Production****Spot Checks**

Parameter	Unit	Test Frequency	Maximum Sample Size	Maximum Warning	Limits Control
Circumference	mm	20 min.	20 cigs.	$\pm 0.10$	$\pm 0.15$
Total Weight at as found moisture	mg	20 min.	20 cigs.	$\pm 20$	$\pm 30$
Total Cig. Draft (HO)	mmWG	20 min.	20 cigs.	$\pm 10$	$\pm 15$
Total Cig. Draft (HC)	mmWG	20 min.	20 cigs.	$\pm 10$	$\pm 15$
Filter Dilution					
0 – 10%	%	20 min.	20 cigs.	$\pm 2$	$\pm 4$
11 – 20%	%	20 min.	20 cigs.	$\pm 3$	$\pm 5$
21 – 40%	%	20 min.	20 cigs.	$\pm 4$	$\pm 6$
over 40%	%	20 min.	20 cigs.	$\pm 5$	$\pm 7$

(Tests conducted by Cigarette Maker Operator)

Attachment 5c

**RJRI****QC Warning and Control Limits for Miscellaneous QC Tests**Cigarettes

Parameter	Unit	Test Frequency	Maximum Sample Size	Maximum Warning	Limits Control
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Moisture	%	2 / shift	100 g	$\pm 0.7$	$\pm 1.0$
Thickness (Borgwaldt)	0.1mm	2 / shift	2 x 10 cigs.	$\pm 2.5$	$\pm 3.0$
Target moisture					
Yield	%	1 / shift	4 x 2 cigs./pack	$\pm 15\%$	$\pm 20\%$
Yield (Maker application)	%	1 / shift	4 x 2 cigs./pack	$\pm 10\%$	$\pm 15\%$
Seal Leak (% poor – no. WG or lower)	%	1 / shift	1 x 10 packs	15	30
Free Ends	mg/cm <sup>2</sup>	2 / shift	2 – 4 packs (no. of cig./pack)	$\leq 14.5$	$\leq 18.0$