



**R.J. Reynolds Tobacco Company**  
Research and Development Department

438201

Division Cigarette Technology

NOTEBOOK TITLE: MTP

(Refers to the Notebook as a whole, "subject" on the inside pages refers to the contents of each page.)

Name C.D. McGee  
(Please Print)

Date Issued 2-15-90

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Continued from Page No. \_\_\_\_\_ Continued in Page No. \_\_\_\_\_

Employee's Signature C.D. McGee



R.J. Reynolds Tobacco Company

Project No. MTP

Subject

Test Malt A from Malt Products  
as a Sweetener in Barley CasingDate 3-1-90

438201

Wt. in GRAMS

Barley  
CasingBlend

K-22

1,150 gms

Sucrose

A  
35B  
—C  
35

C-1

9.66 ✓

9.66 ✓

9.66

B-3

25 ✓

25 ✓

25

B-9

25 ✓

25 ✓

25

E-1 (Light)

20 ✓

20 ✓

20

Malt A

25 ✓

60 ✓

25

~~W-1~~ W-1

400

400

400

C\* Double  
Casing

C-30

1385

Sucrose

7.0

C-1

1.93

B-3

5.0

B-9

5.0

E-1

4.0

Malt A

5.0

Powdered ~~Almond~~ ~~Root~~ ~~Root~~ ~~Root~~  
Lovage Root

0.35

C-138

550

5,000

Processes

1. Steam K-22
2. Apply hot casing (160°F)
3. Dry to 10-11% Moisture
4. Add W-1 to adjust to 15%.

\* C Double Casing -- Same casing as Barley  
C casing but at 20% the level, and containing  
the Powdered Lovage Root Powder

Note: See NBP 438207 for #20/C Barley Analyticals

SIGNATURE AND DATE

C.D.M. Exler 3-2-90

READ AND UNDERSTOOD (Signature and Date)



R.J. Reynolds Tobacco Company

Project No. MTP

Subject

Date 3-8-90MTP  
Dakota Blend with modified G-7-10

438202

202 A - Dakota Control

202 B - Same as A but with 2% Sucrose, 0.3 Cocoa, and 0.2 Licorice added to the G-7-10 before blending.

Burley Casing - K-22 - 3500 grams

B-4	118 gms
B-2	39.33 gms
C-1	19.67 "
F-1	19.67 "
W-1	374 "

5 Kg. Lot of Dakota

	A	B
Cased K-22	890g.	890g.
C-30	1615g.	1615g.
TB	865g.	865g.
G-7-10	965g.	—
G-7-10 <del>modified</del> <del>modified</del>	—	965g plus addition (See Below)

Sucrose	19.3g. (2%)
F-1	2.90g. (0.3%)
C-1	1.93g. (0.2%)
W-1	100g.

- Cut and add G-13-23 at 10% Total
- Topdress with S-18.3 at 4.41g./Kg.

SIGNATURE AND DATE

C.D. McEhee 3-9-90

READ AND UNDERSTOOD (Signature and Date)



R.J. Reynolds Tobacco Company

Subject

Test Licorice Extract  
from MacAndrews & Forbes

Project No. \_\_\_\_\_

Date \_\_\_\_\_

438203

Bland

Casing

K-22

GRAMS

1150 gms

Sucrose	35
Licorice Ext. 3xP147	5.0
B-3	30
B-9	15
B-4	30
W-1	400

C-30

For Cutting

1,385 gms

B-9 25

TB

B-3 25

775 gms

W-1 75

G-7-10

1,140 gms

C-13

550 gms

yield 5,000 gms

This test was  
not made cpm

SIGNATURE AND DATE

READ AND UNDERSTOOD (Signature and Date)



R.J. Reynolds Tobacco Company

Subject

Test IFF Blend/Casing Formulation

Project No.

MTP

Date

3-26-90

438204

Ammonified

BlendK Casing

	A	B	C	D	E		A	B	C	D	E
K-22	1525	1150	1150	1150	1150	F-1	26.4	✓	-	-	-
C-30	925	1385	1385	1385	1385	C-1	37.7	✓	9.66	✓	9.66
TB	900	775	775	775	775	E-1	3.77	20.0	✓	20.0	✓
G-7-10	350	1140	1140	570	570	B-3	37.7	✓	30	✓	30
G-7-4	850	-	570	570	570	B-9	19	✓	15	✓	15
C-13	450	550	550	550	550	Sucrose	56.25	✓	25	✓	25
						B-2	-	-	-	-	20
						B-4	-	70	✓	70	✓
						W-1	400	✓	400	✓	400

Bph before Ammonified - 5.42

" After " - 7.18

TB/Sheet/F.C.

CasingPART A B thru E

Filling Capacity

HFCs

100 ✓

A=453, 454

B-3

10

25

B=422, 423

B-9

10

25

C=443, 454

W-1

100

150

D=465, 466

E=469, 438, 477

Burley Processing Steps

1. Case-Burley at 160°F

2. Apply steam after drying, 175°F, 35% moisture

3. Dry Burley to 3-5% moisture 1st stage - 250°F

(Blue m DRYER)

RANGE 160 - max. 215°F

APPROX. 1 HR.

2nd " - 250°F

4. Re-order to 15-16% with heavy steam

Cigarettes Made on 4-2-90

SIGNATURE AND DATE

C.D. Mc... 3-26-90

READ AND UNDERSTOOD (Signature and Date)



R.J. Reynolds Tobacco Company

Project No. MTPSubject Analytical Results  
#199Date 3-29-90438205

Based on Dry wt. (Corrected to 100%)

[Total Blend]

Tobacco Analysis	Found	Am't	Found	Found	Found	Found
Percentage Basis	199A	Applied	199B	199C	199D	199E
Moisture	12.00		12.91	12.61	13.38	12.81
Nicotine	2.34		2.18	1.95	2.24	2.16
Reducing Sugar	10.0		9.42	8.00	9.12	9.52
Total Sugar	12.30		11.60	10.06	11.54	11.82
Ann. Spec.	0.25		0.25	0.25	0.265	0.24
pH	5.40		5.43	5.41	5.39	5.36
Cocoa	0.057 (-)		0.15 (0.19)	0.18 (0.19)	0.00 (-)	0.00 (-)
Licorice	0.15 (0.19)		0.057 (-)	0.137 (0.19)	0.14 (0.19)	0.19 (0.2)
Phosphorus	0.30		0.30	0.31	0.31	0.31

Burley

Cased & Dried	199A	199B	199C	199D	199E
Moisture	12.61	14.64	12.07	13.75	12.27
Nicotine	3.26	2.90	3.04	3.09	4.24
Red. Sugar	2.06	2.69	1.93	2.32	1.60
Total Sugar	5.15	6.56	4.66	6.03	4.33
Ann. Spec.	0.55	0.45	0.43	0.46	0.48
pH	5.78	5.83	5.81	5.93	5.78
Cocoa	-	1.04	0.99	-	-
Licorice	0.54	-	0.58	0.67	0.59
Phosphorus	0.24	0.29	0.26	0.27	0.296

SIGNATURE AND DATE

C.D. Moore 3-30-90

READ AND UNDERSTOOD (Signature and Date)



R.J. Reynolds Tobacco Company

Project No. MTPSubject Analyticals  
Test #195Date 3-30-90

438206

Based on Dry Wt. (Corrected to 100%)Tobacco Analysis

<u>Percentage Basis</u>	<u>195A</u>	<u>195B</u>	<u>195C</u>	<u>195D</u>
Moisture	13.65	13.83	13.70	13.46
Nicotine	2.60	2.50	2.55	2.55
Reducing Sugar	11.35	10.68	11.82	11.32
Total Sugar	13.09	12.65	12.17	12.83
Ann. (Spec.)	0.23	0.255	0.24	0.265
pH	5.36	5.39	5.34	5.39
Cocoa	0.046	0.046	0.058	—
Licorice	0.185	0.21	0.16	0.17
Phosphorus	0.31	0.31	0.31	0.32

Cigarette Smoke

Puffs/Cigt.	8.5	9.0	9.2
TPM mg/Cigt.	20.0	19.4	19.7
Nic. "	1.20	1.21	1.25
Water "	3.5	3.0	3.2
Tar "	15.3	15.1	15.2
TPM/Puff	2.34	2.17	2.16
Nic/ "	.141	.135	.137
Tar/ "	1.79	1.69	1.67
no CO	4.35	4.05	3.83
MA CO	12.97	12.71	12.25
MB CO	14.6	14.2	13.8
CO Puff/Cigt.	8.5	9.0	9.2

SIGNATURE AND DATE

C.D. McFarlane 3-30-90

READ AND UNDERSTOOD (Signature and Date)



R.J. Reynolds Tobacco Company

Project No. MTP

Subject

AnalyticalDate 3-30-90201 C -- Bunkley Portion438207

	<u>Percentage</u>	<u>Before Double Casing</u>
	<u>201 C</u>	<u>Bunkley, Cased &amp; Dried, Re-Ordered</u>
Moisture	16.98	
Nicotine	3.37	
Rel. Sugar	1.69	
Total Sugar	2.53	
Ann. (Spec.)	0.61	
pH	5.79	
Cocoa	—	
Licorice	0.83	
Phosphorus	0.33	

SIGNATURE AND DATE

READ AND UNDERSTOOD (Signature and Date)

C.R.M. 3-30-90





R.J. Reynolds Tobacco Company

Project No. MTP

Subject

Analytical DATA

Date

3-30-90

#187

438208

Based on Dry Wt. (Corrected to 100%)

Tobacco Analysis

Percentage

	<u>187A</u>	<u>187B</u>	<u>187C</u>	<u>187D</u>	<u>188A</u>	<u>188B</u>	<u>188C</u>
<del>Moisture</del>							
Moisture	13.30	12.32	13.19	11.83	12.34	12.69	12.59
Nicotine	2.38	2.28	2.32	2.31	2.30	2.20	2.09
Red Sugar	12.00	11.18	10.48	10.55	10.83	11.22	10.98
Total Sugar	12.69	12.20	11.29	11.23	12.56	11.91	12.13
Ann. Spec.	.25	.27	.28	.25	.265	.25	.27
pH	5.34	5.34	5.34	5.34	5.38	5.38	5.40
Cocoa	.058	.09	.069	.068	.046	0.046	.057
Licorice	.38	.15	.14	.17	.41	.38	.41
phosphorus	.30	.32	.32	.29	.31	.32	.33

<u>Cigarette Smoke Analysis</u>	<u>187A</u>	<u>187B</u>	<u>187C</u>	<u>187D</u>	<u>188A</u>	<u>188B</u>	<u>188C</u>
Puffs/cigt.	10.1	8.6	9.0	9.0	9.9	9.6	9.5
TPM mg./cigt.	19.9	19.4	19.9	19.9	20.9	20.3	20.2
Nic "	1.29	1.20	1.24	1.24	1.28	1.26	1.22
Water "	2.9	3.2	3.2	3.2	3.4	3.2	3.2
Tar "	15.7	15.0	15.5	15.4	16.3	15.8	15.7
TPM/Puff	1.98	2.25	2.23	2.20	2.11	2.11	2.13
Nic./ "	0.128	0.139	0.139	0.139	0.130	0.131	0.129
Tar / "	1.56	1.74	1.73	1.71	1.64	1.64	1.66
% Co.	3.42	4.11	3.93	3.84	3.73	3.61	3.68
ml. Co	12.02	12.41	12.31	12.21	12.95	12.17	12.19
MG Co	13.5	14.0	13.9	13.7	14.6	13.7	13.7
Co Puff/cigt.	10.1	8.6	9.0	9.0	9.9	9.6	9.5

51208 6312

SIGNATURE AND DATE

READ AND UNDERSTOOD (Signature and Date)

C.D. M... 3-30-90



R.J. Reynolds Tobacco Company

Project No. MTPSubject Duplicate CARL Richter Formulation  
Without FLAVOR Ingredients (Part A)Date 4-2-90Part B = Target C = Same as A but with ALL G-7-10

438209

Blend	C			K-22 Casing	
	A	B		A	B
K-22	915 ✓	690 ✓	ALL G-7-10 G-7-4 G-7-10 G-7-4 C-13 3,000	F-1	6.41 X
C-30	555 ✓	831 ✓		C-1	7.32 X 5.80 ✓
TB	540 ✓	465 ✓		Sucrose	54.90 X
G-7-10	210 ✓	342 ✓		E-1	3.20 X 12.0 ✓
G-7-4	510 ✓	342 ✓		B-3	9.15 X 18.0 ✓
C-13	270	330	SAME but with ALL G-7-10 G-7-4 G-7-10 G-7-4 C-13 3,000	B-9	7.78 X 9.0 ✓
	3,000	3,000		B-2	— 12.0 ✓
				B-4	— 42.0 ✓
				W-1	240 X 240
				W-1	240 X 240

Finish K Casing

A-K-22

B-Casing for Cutting

B-3

9.15 ✓

30

B-9

7.78 ✓

30

W-1

50 ✓

75

Virginia &amp; Oriental Casing A &amp; C

B-3

21.90 ✓

B-9

18.62 ✓

HFCs

32.85 ✓

W-1

Burling Casing Procedure

1.) K-22 moisture at 15%

2.) Case at 160°F

3.) Use High Pressure steam at 175° and 35% moist

4.) Dry to 8% moisture 1st stage 290 air temp

255°F iso temp and 270

LAB DRYER 3rd = 250

5.) Re-order to 15% moisture

6.) Add Finish Casing (B-3/B-9)

VA/Or Casing Procedure

1) Moisture 16%

2) Steam

3) Add B-3 &amp; B-9 &amp; HFCs

4.)

Also : A. Blend Tobaccos and steam at 140-150°F at moisture

B. Dry cut tobaccos to 13.5%

Filling Capacity - - A = 455, 451

B = 464, 478

C = 455, 454

SIGNATURE AND DATE

READ AND UNDERSTOOD (Signature and Date)



Subject

Test Cased Barley at  
High Heat Treatments -Date 3-12-90

438210

Three barley (K-22) casings are to be made  
and use high <sup>dry</sup> heat in 3 stages, i.e. 290°, 270°, 250°F, at  
the processing area (Lelann Smith). The casings are:  
(K-22 - - 20 lbs.)

Casings - grams

	A	B	C
Sucrose	276 + ✓	544.3 ✓	High Fructose Corn Syrup 42% → 382 X
C-1	76.2 ✓	72.6 X	76.2 X
E-1	157.78 X ✓	31.73 X	157.78 X
B-3	236.66 X ✓	90.72 X	197.21 X
B-9	128.30 X ✓	77.14 X	197.21 X
42-283 ← B-4	236.66 X ✓	—	—
W-1	<del>2700</del> 2700	2380 ✓	<del>2700</del> 2700
F-1	—	63.55 X	—

A = #199 D Repeat (23% K-22)

B = #209 C Repeat (30% K-22)

C = #188 C Repeat (Ammon. K-22 at 23%)

Adjust pH to 7.  
with Amm. Hydrox.

pH of C before Ammoniation = 5.32 5.36  
" " C After " = 7.06

- Sample A+B were cased at 160°F and then steam added to raise moisture approx. 32%
- Sample C was ammoniated with no heat for casing - steam to 32%.
- All parts taken to processing for drying in Sargent dryer

Conditions: A =

	Drying Time	Cooling Time	Reorder Time	Drying Start Time	Drying End Time
210A	3:00 3:04 down	4.0	4.0	10:29	10:38

SIGNATURE AND DATE

READ AND UNDERSTOOD (Signature and Date)

Date 3-13-90

438211

A repeat of #210 A & 210 B was made and taken to processing for drying. The repeat drying temp. for the two blends was:

	DRY Moist Drying temp. (1st Pass)	COOL Moist Drying
210 A Repeat	10.3	11.8
210 B Repeat	7.2	6.6

The Conditions were:

Time:  $5\frac{1}{2}$  minutes  
 Temp: 290°F, 270°F, 250°F  
           1st PASS, 2nd, 3rd

The new designation for the repeats will be

210 A Repeat -- will become 210 A1  
 210 B " " " 210 B1

Note: The 210 A1 could possibly have used F-1 instead of C-1, but will be tested anyway. A repeat using C-1 will become 210 A2.

Repeat Drying Conditions  
 of B&C



R.J. Reynolds Tobacco Company

Subject

Test R-7-10 in Dakota Blend  
 TPD-398 Box 10

Project No. DakotaDate 4-24-90

438212

Burley Casing

K-22	B-4	40.46
1200 grams	B-2	13.49
	C-1	6.74
	F-1	6.74
	W-1	12.8

5 Kg. Lot (Dakota)FOR Cutting

Cased K-22	890 gms	B-3	85g.
C-30	1615 "	B-9	85g.
TB	865 "	W-1	55
<del>R-7-10</del> R-7-10	965 "		
(TPD-398)			
Box 10			
mid test			

- Add 10% of G-13-23 for the total blend.
- Apply 4.4% grams of 5-183/Kg. of cut filler

SIGNATURE AND DATE

C.D. M. 4-25-90

READ AND UNDERSTOOD (Signature and Date)

Subject Incorporate Burley Dried at 170° D  
into Blends

Date 4-25-90

438213

Like 199D	Like 199D	Like 209C	Like 188C	Like 209C
<u>213A</u>	<u>213B</u>	<u>213C</u>	<u>213D</u>	<u>213E</u>

(ALL G-7-10)

ased K-22 (210A-1)	1279 ✓	—	—	—
" " (210A-2)	—	1279 ✓	—	—
" " (210B)	—	—	1665 ✓	1665 ✓
" " (210C)	—	—	1260 ✓	1260 ✓

C-30	1385 ✓	1385 ✓	925 ✓	1385 ✓	925 ✓
TB	775 ✓	775 ✓	900 ✓	775 ✓	900 ✓
G-7-10	1140 ✓	1140 ✓	350 ✓	1140 ✓	1200 ✓
C-13	550	550 ✓	450	550	450
G-7-4	—	—	850 ✓	—	—

<u>For Cutting</u>	<u>For Cutting</u>	<u>For Cutting</u>	<u>Burley</u>	<u>Burley</u>
B-3	25 ✓	25 ✓	15.28 ✓	15.28
B-9	25 ✓	25 ✓	13.0 ✓	13.0
W-1	—	—	60 ml ✓	—

<u>Total Casing</u>	None	None	None	Yes	None
---------------------	------	------	------	-----	------

HFCs	<div style="border: 1px solid black; border-radius: 50%; width: 100px; height: 100px; display: flex; align-items: center; justify-content: center; margin: 0 auto;"> <span style="font-size: 2em; font-weight: bold;">F</span> </div> <p>Same as E except add Light casing to C-30 + TB</p> <p>B-3 36.57 ✓ B-9 31.10 ✓ HFCs 54.86 W-1</p> <p>1. Steam then add casing (cold).</p>	HFCs	80 ✓
C-1		C-1	10 ✓
B-3		B-3	28 ✓
B-9		B-9	25 ✓
E-1		E-1	8 ✓

SIGNATURE AND DATE

READ AND UNDERSTOOD (Signature and Date)

Subject

Test. Water-Soluble Flavorants  
in MTP Burley Casing

Project No.

MTP

Date

5-10-90

438214

BlandBurley Casing

K-22

1150

HFCS (55%)

C-1

B-3

B-9

E-1 (Light)

B-4

Choc. Syrup (Vng.)

Coriander Powder

Vanilla Exp. 3-7d

w/ (Moth &amp; Murphy)

Cocoa abs. (P. Robert)

A

B

C

D

35✓

35✓

35✓

35

10✓

10✓

10✓

10✓

30✓

30✓

30✓

30✓

15✓

15✓

15✓

15✓

20✓

20✓

20✓

20✓

30✓

30✓

30✓

30✓

2.70✓

10.7✓

4.0✓

—

1.0✓

1.0✓

0.5✓

—

—

—

7.70✓

—

350✓

350

350

350

—

—

—

1.5✓

C-30

1385

TB 975

Processing

Q-7-10 940

C-13 550

1. Add hot (160°F) casing to K-22
2. Dry in drum (duct heat) to 10-11%.
3. Re-Order (by straining) to 15% moisture
4. Add C-30, TB, and Q-7-10, steam slightly and add →

B-3 25 gms } For  
B-9 25 gms } Cutting  
H-1 50 gms }

5. Cut at 25 CPI, dry to 13% and add C-13

SIGNATURE AND DATE

C.D. M... 5-11-90

READ AND UNDERSTOOD (Signature and Date)



R.J. Reynolds Tobacco Company

Subject

ANALYTICAL RESULTS  
#210 (Cased & Dried Burleys)Project No. MTPDate 5-14-90

438215

Based on Dry wt. (Corrected to 100%)  
Cased and Dried at PT & D

Percentage	210A-1	210A-2	210B	210C
Moisture	10.76	11.67	10.81	11.52
Nicotine	<del>2.13</del> 3.13	2.98	3.21	3.15
Reducing Sugar	2.13	2.04	1.35	2.94
Total Sugar	6.38	7.13	7.62	4.63
Ann. Spec.	0.34	0.32	0.49	0.37
pH	5.64	5.55	5.57	5.60
Cocoa	0.89	—	0.75	—
Licorice	—	1.00	0.91	0.89
Phosphorus	0.26	0.25	0.27	0.27

SIGNATURE AND DATE

READ AND UNDERSTOOD (Signature and Date)





Subject

Test HFC S(55)

Reaction FLAVOR (HARVEY YOUNG)

Project No.

MTP

Date

5-

438216

216 A216 B216 C

Case R-22 (210B) 1474

1474

1474

C-30

1185

1185

1185

TB

775

775

775

Q-7-10

1140

1140

1140

C-13

550

550

550

C-30/TB Casing (Parts B & C)BC

HFC S(55)

55.86

111.72

B-3

33.18

33.18

B-9

28.22

28.22

- Steam @ C-30 AND TB, then  
Add cold casing
- Add Burley & Q-7-10

SIGNATURE AND DATE

READ AND UNDERSTOOD (Signature and Date)

Test MTP Casings

438217

Per 9,072 grams

Like 210B  
For 213E  
Similar to 210B  
but with HFCs and  
Cocoa Abs.Like 214D  
of 214D

	<u>A (g)</u>	<u>B</u>	<u>C</u>	<u>D</u>
Sucrose (s)	544.8	—	—	—
C-1	72.6	72.6	79	90.72
E-1	31.73	31.73	158	181
B-3	90.72	90.72	236	272 •
B-9	77.14	77.14	118	—
F-1	63.55	63.55	—	90.72
B-4	—	—	236	363 •
HFCs (ss)	—	544	276	408 •
Cocoa Absolute	—	30	59	30
B-8	—	—	—	181 •
W-1	—	—	—	—

## Drying Conditions at PTSD

	<u>Up Draft Drying</u>	<u>Down Draft Drying</u>	<u>Cooling</u>	<u>Re-Order</u>
217A	3.5	1.5	2.0	4.5
Moisture			12.5	

<u>Moistures</u>	<u>Before</u>	<u>After Re-Order</u>	<u>Before Re-Order</u>
217A		14.9	12.5
217B	31.2	12.8	11.8
217C	32.9		6.9

SIGNATURE AND DATE

READ AND UNDERSTOOD (Signature and Date)

51208 6321

Subject

Make MTP Prototypes with  
Heat Accelerated Cased Burleys  
P.T. & D

Project No.

MTP

Date

6-4-90

438218

(Repeat of  
of #214B)

	218A ✓	218B	218C	218D
Cased K-22 (217A)	1472 (27%)	— ✓	—	—
" " (218B)	—	1472 (27%)	— ✓	—
" " (217C)	—	—	1277 (23%)	— ✓
" K-4 (217D)	—	—	—	1539 (27%)

C-30	(1095) ✓	1095 ✓	1385 ✓	1475 ✓
------	----------	--------	--------	--------

TB	925 ✓	925 ✓	975 ✓	250 ✓
----	-------	-------	-------	-------

<del>RETEN</del> G-7-10	1200 ✓	1200 ✓	940 ✓	925 ✓
-------------------------	--------	--------	-------	-------

~~G-13 @ 1000 for A.B. & C~~

G-13	9% Total 450	9% Total 450	550	<del>550</del>
------	-----------------	-----------------	-----	----------------

G-13-23	—	—	—	500
---------	---	---	---	-----

<del>Burley</del> Portion: B-3	13.51	13.51	—	—
only B-9	11.50	11.50	—	—

For Cutting	—	—	B-3 <del>25</del> 25	25
			B-9 25	25

SIGNATURE AND DATE

READ AND UNDERSTOOD (Signature and Date)

51208 6322



Subject

Da Kata Blend for Harvey  
Test R-7-10

Date 6-4-90

438219

Casing for K-22Per Kg. of Strips

B-4	33.71	gms
B-2	11.24	"
C-1	5.62	"
F-1	5.62	"
W-1	107	"

5 Kg. LotFor Cutting

Cased K-22	890	B-3	81
C-30	1615	B-9	81
TB	865	W-1	50
G-7-10	965		

Add 10% G-13-23

Apply 4.41 gms/Kg. of Cut Filler of S-183

SIGNATURE AND DATE

READ AND UNDERSTOOD (Signature and Date)

51208 6323

Remake #218 for Texting vs  
Lab Dried Barley ~~vs~~ Heat Treatment at PT&D

6-21-90

438220

Kg. Blends	(214) (Repeat)				K Casing				
	A	B	C	D		A	B	C	D
K-22	1350✓	1350✓	1150✓	1100✓	Sucrose	81.4✓	—	—	—
K-4	—	—	—	250✓	HFC5 (55)	—	81✓	35✓	60.71✓
C-30	1075✓	1075✓	1385✓	1475✓	C-1	10.8✓	10.8✓	10✓	13.5✓
TB	925✓	925✓	975✓	750✓	E-1	4.72✓	4.72✓	20✓	27✓
G-7-10	1200	1200✓	940✓	925✓	B-3	13.5✓	13.5✓	30✓	40.48✓
C-13	450✓	450✓	550✓	—	B-9	11.48✓	11.48✓	15✓	—
G-13-23	—	—	—	500✓	F-1	9.45✓	9.45✓	—	13.5✓
					B-4	—	—	30✓	54✓
					B-8	—	—	—	27✓
					(P. Rollout) Cocoa Abs.	4.46✓	4.86	7.5✓	4.46✓
					W-1	320	320	320	320

## Processing Steps

1. Add hot (160°F) casing to K-22
2. Dry to 10-11% moisture
3. Apply steam to K-22, raise moisture to approx. 16-18%
4. Add strips & G-7-10 to barley portion, apply steam and raise moisture for cutting (15-16%)
5. Apply —
 

{ B-3	25g.	for cutting
{ B-9	25g.	
{ W-1	50g.	
6. Cut at 25 cps, add 13 portion

SIGNATURE AND DATE

C.D.M. ~~Mc~~ 6-26-90

READ AND UNDERSTOOD (Signature and Date)



Subject

Date 6-27-90

Ave. Weight/Pressure Drop  
of MTP Candidates for Chicago Test

438221

Ave. of 10 Cigarettes  
Pressure Drop Weight

(A) MARLBORO KS (AN 8422 A)	110 mm ✓	0.99 grams
(B) Winston KS (AN 8422 B)	109 mm ✓	0.96 "
(C) 214 D (AN 8422 C)	106 mm ✓	0.99 "
(D) 218 C (AN 8422 D)	98 mm ✓	0.95 "
(E) 220 B (AN 8422 E)	100 mm ✓	1.00 "
<del>220 C</del>	<del>101 mm ✓</del>	<del>0.96 "</del>
<del>220 D</del>	<del>94 mm</del>	<del>0.94 "</del>
(F) 220 A (AN 8422 F)	93 mm ✓	0.965

• Make Weight Selections of 0.95 grams/cigt. (- + 0.05g.)

• Select Pressure Drop:

ALL prototypes ~~220 B~~ 95mm - 109mm

### Moistures

Marlboro	AN 8422 A	- 10.36
Winston	AN 8422 B	- 11.29
214 D	AN 8422 C	9.59
218 C	AN 8422 D	10.52
220 B	AN 8422 E	11.49
220 A	AN 8422 F	11.38

SIGNATURE AND DATE

READ AND UNDERSTOOD (Signature and Date)

Blend

	A	B	C	D
K-22	1150✓	1150✓	1150✓	1150✓
C-30	1385✓	1385✓	1385✓	1385✓
TB	975	975	975	975
G-7-10	940	940	940	—
G-7-1	—	—	—	940*
C-13	550	550	550	550

\* Apply 1% Cocoa Absolute  
before adding with strips

Burley Casing

	A	B	C	D
HFC5(55)	35✓	—	—	36✓
C-1	10✓	10✓	10✓	10✓
B-3	30✓	30✓	30✓	30✓
B-9	15✓	15✓	15✓	15✓
E-1 (Light)	20✓	20✓	20✓	20✓
<del>B-4</del>	—	—	—	—
Cocoa Absolute (0.342)	7.63✓	7.5✓	7.5✓	—
Sucrose	—	—	30	—
Fig Supreme (Bells)	30✓	65.5✓	30.5	—
B-4	—	—	—	30✓
W-1	400✓	400✓	400✓	440✓

Processing Steps

1. Apply hot casing (160°F) to K-22
2. Dry to 10% moisture, then steam K-22
3. Add strips with K-22 and steam entire blend slightly.
4. Add B-3, B-9, and W-1 for cutting.
5. Cut at 25 cps
6. Dry to 13% and add C-13

For Cutting

B-3	25 g.
B-9	25 g.
W-1	50 g. 53g.

Filling Capacity

	Are
A = 432, 429, 426	— 429
B = 421, 416,	
C = 430, 432	
D = 412, 404	

Subject

MTP MAKE Vantage UL 100  
Prototypes from MTP Learning

Date

438223

Blond

	A	B	C	D	E
K-22	772✓	772✓	772✓	772✓	772✓
C-30	1056✓	1056✓	1056✓	1056✓	1056✓
TB	720✓	720✓	720✓	720✓	720✓
G-7-1	578✓	578✓	—	—	578✓
G-7-2	578✓	578✓	—	—	578✓
GP-1 Shots	197	197	197	197	197
B-23	1007	1007	1007	1007	1007
B-3 <sup>(cutting)</sup>	75	75	75	75	75
	5000				
G-7-10	—	—	1156	1156	—

Burley Casing

	A	B	C	D	E
B-4	24.6✓	24.6✓	24.6✓	24.4✓	24.4✓
B-2	9.8✓	9.8✓	9.8✓	—	9.8✓
C-1	4.9✓	4.9✓	4.9✓	5.8✓	5.8✓
F-1	9.8✓	—	9.8✓	—	—
Cocoa Absolute	—	9.85✓	5.0✓	4.4✓	4.4✓
St. John's Rd. Light Assist	—	18.0✓	—	11.65✓	11.65✓
HFC5(55)	—	—	—	20.4✓	20.4✓
B-3	—	—	—	17.4✓	17.4✓
B-9	—	—	—	8.7✓	8.7✓
W-1	200✓	200✓	200✓	200✓	200✓

For Cutting

	A	B	C	D	E
B-3*	75✓	75✓	75	75	75
W-1	75✓	75✓	75	75	75

Processing Steps

1. Apply hot casing (160°F) to K-22
2. Dry to 10% with duct heat
3. Adjust K moisture with steam to 16%
4. Add C-30, TB, and G-7-1/G-7-2 to K-22
5. Steam and raise moisture to ~ 16-17%
6. Sprag B-3 and W-1
7. Cut at 25 cpi

SIGNATURE AND DATE

READ AND UNDERSTOOD (Signature and Date)





Subject

TRIPAR in G-7  
(Incorporate in Doral 85 Blend)Date 8-21-90

438224

Doral 85

	<u>%</u>	
Strips	66.4055	} 72.2821
Casing	5.8766	
GP-1	7.7375	
G-13-23	19.9804	
	<u>100.0000</u>	

Strips (5 Kg.)CASING FOR  
each 5 Kg. of Test

	<u>A</u>	<u>B</u>	<u>C</u>		<u>gms</u>
CKPL	2109✓	2109✓	2109✓		
TB	1283✓	1283✓	1283✓	B-4	103.0✓✓
G-7 Test) 90-084A (control)	1608✓	—	—	B-2	44.2✓✓
" 90-084B (10% DGS)	—	1608✓	—	C-1	36.9✓✓
" 90-084C (8% DGS)	—	—	1608✓	F-1	36.9✓✓
yield	<u>5000</u>	<u>5000</u>	<u>5000</u>	B-25	132.7✓✓
				W-1	188.5✓

Cut  
CASED STRIPS  
 GP-1  
 G-13-23

5 Kg. Total Blend  
 3614 gms  
 386 "  
 1000 "

Filling Capacity

A = 442  
 B = 437  
 C = 446

SIGNATURE AND DATE

READ AND UNDERSTOOD (Signature and Date)

C.R. MEYER 10-5-90

51208 6328



R.J. Reynolds Tobacco Company

Subject

Re-Make 214D and 222B  
for Topdressing Work

Project No.

MTP

Date

8-28-90

438225

Bland

[10 Kg. Blends]

Burley Casing

(214D)

(222B)

K-22 ~~280~~  
2,300

HFC5(55)

A  
70B  
—

C-1

20

20

B-3

60

60

B-9

30

30

E-1(Light)

40

40

B-4

60

~~80~~—

Cocoa Abs.

15.0

15.0

Fig Supreme(Bells)

—

13.0

C-30 ~~2000~~ 2770TB ~~2100~~ 1950G-7-10 ~~2000~~ 1,880C-13 ~~550~~ 1,100

SIGNATURE AND DATE

READ AND UNDERSTOOD (Signature and Date)

51208 6329



Subject

MAKE VUL-100 WITH  
High BurleyDate 8-30-90

438226

Blend

K-22 1150

HFC's (55)

C-1

B-3

B-9

E-1 Light Roast

B-4

Abs. Cocoa

Fig Supreme

C-30 802

W-1

TB 720

G-7-1 578

G-7-2 578

GP-1 shorts 197

B-37n Cutting 75

G-13-23 900

5000

~~GP-1~~ K-22

Strip Portion

GP-1

G-13-23

Composition

%

78.29

3.90

17.81

SIGNATURE AND DATE

READ AND UNDERSTOOD (Signature and Date)



438227

227A - 50 grams G-7-1, spray 4.5 ml w-1  
(Control)

227B - 50 grams G-7-1, spray 0.5 gms UREA in 4.5 ml w-1  
(1%)

227C - 50 grams G-7-1, spray 1.0 gms UREA in 4.5 ml w-1

SIGNATURE AND DATE

READ AND UNDERSTOOD (Signature and Date)



Subject

Date \_\_\_\_\_

MTP  
(Test UREA in 222c)

438228

BlendBurley Casing

K-22 1150

C-1 10 ✓ 10 ✓ 10 ✓

B-3 30 ✓ 30 ✓ 30 ✓

B-9 16 ✓ 16 ✓ 16 ✓

St. Johns Bunt (Light) 20 ✓ 20 ✓ 20 ✓

Cocoa Abs. 7.5 ✓ 7.5 ✓ 7.5 ✓

100% Sucrose 30 ✓ 30 ✓ 30 ✓

75% Supreme 30 ✓ 30 ✓ 30 ✓

W-1 (177) (174)

C-30 1385

TB 995

G-7-10 940

UREA — 8.25 16.5

W-1 160 160 160

B-3 25 25 25

B-9 25 25 25

C-13 550.

SIGNATURE AND DATE

READ AND UNDERSTOOD (Signature and Date)

Subject

Test Urea in Dakota  
(Harvey Young)

Project No.

Date 9-24-90

438229

229 A - Dakota Control

229 B - Same as A except add 0.20% Urea  
(10gms) by total weight --- added to the C-30, TB, G-7-10

229 C - Same as B except add 0.40% Urea (20gms)

Barley Casing - K-22 - 3500 grams

B-4	11.8 gms ✓
B-2	39.33" ✓
C-1	19.67 " ✓
F-1	19.67 " ✓
W-1	374 " ✓

5 Kg Lot of Dakota

For Cuttings

B-3	85
B-9	85
W-1	60

Cased K-22

{	C-30
	TB
	G-7-10

A	B	C
890 ✓	890 ✓	890
1615 ✓	1615 ✓	1615 ✓
865 ✓	865 ✓	865
965 ✓	965 ✓	965

10% G-13-23

Topdress with S-183

SIGNATURE AND DATE

READ AND UNDERSTOOD (Signature and Date)

C.D.M. 9-27-90



Subject

Test Meen Coffee S.E.  
in MTP (#24 type)

Project No. MTP

Date 10-2-90

438230

BlendBurley Casing

K-22

1150

HFCS(55)

A

B

C

35✓

35✓

35✓

C-1

10✓

10✓

10✓

B-3

30✓

30✓

30✓

B-9

15✓

15✓

15✓

Light Roast St. John Bd

20✓

20✓

20✓

B-4

30✓

30✓

30✓

S.E. Coffee (Meen)

7.0✓

10✓

5.0✓

W-1

280

280✓

280

C-30

1385

Casing for Cutting

A

B

C

B-3

25

25

25

TB 975

B-9

25

25

25

W-1

50

50

50

G7-10 940

S.E. Coffee (Meen)

-

-

5.0

C-13 550

Processing

1. Apply hot (160°F) casing to K-22
2. Dry with duct heat to 10-11°.
- 3.

SIGNATURE AND DATE

READ AND UNDERSTOOD (Signature and Date)

Subject

Project XB  
Amor Westmoreland

Project No.

XB

Date

10-3-90

438231

No. 1 — VUL Cut Filler — 10g. w-1/ Kg. of VUL cut Filler

Blend  
2. — VUL

Flavor

Nicotine Levulinate 3:1

Appli: 0.5, 1.0, 2.0%

Water

3 Kg. — ✓ 0.5% = 15.0g. + 30.0g.

✓ 1.0% = 30.0g. + 30.0g.

✓ 2.0% = 60.0g. + 30.0g.

3. VUL ✓ 2% of 3:1 Mixture (Nic. Levulinate) = 60g. 30g. Water

2.32% of 2:1 " " " = 46.6 30g.

3 Kg. 3.27% of 1:1 " " " = 95.1 30g.

SIGNATURE AND DATE

C. D. M. 10-3-90

READ AND UNDERSTOOD (Signature and Date)





Subject \_\_\_\_\_

Date \_\_\_\_\_

438232

Burley Casing

K-22 - 2,400 gms	B-4	80.9 x
	B-2	27.0 x
	C-1	13.5 x
	F-1	13.5 x
	K-1	256 ✓

Kg.  
5<sup>th</sup> Lot (Dakota)

For Cutting

		<u>A</u>	<u>B</u>
B-3 85 B-9 85 K-1 70	Cased K-22	890	890
	C-30	1615	1615
	TB	865	865
	G7 (90-109) Control	965	—
	G7 (90-110B) Test	—	965

Add 10% G-13-23 to total Blend

	<u>C</u>	<u>D</u>
Cased K-22	890	890
C-30	1615	1615
TB	865	865
G7 (90-084 <sup>Control</sup> <del>Part B</del> )	965	—
G7 (90-084 <sup>10%</sup> Part B) <sup>10%</sup>	—	965

SIGNATURE AND DATE

READ AND UNDERSTOOD (Signature and Date)

51208 6336

Subject

Urea in R-7  
(Harvey Young Test)

Date

10-22-90

438233

Burley Casing for Dakota10 Kg. of Strips

B-4	337.1 grams ✓
B-2	112.4 " ✓
C-1	56.2 " ✓
F-1	56.2 " ✓
W-1	1070 " ✓

4 Kg. Lot Dakota

	<u>A</u>	<u>B</u>	<u>C</u>	<u>D</u>	<u>E</u>	<u>F</u>	<u>G</u>
Ased K-22	712 ✓	712 ✓	712 ✓	712 ✓	712 ✓	712 ✓	712 ✓
C-30	1292 ✓	1292 ✓	1292 ✓	1292 ✓	1292 ✓	1292 ✓	1292 ✓
TB	692 ✓	692 ✓	692 ✓	692 ✓	692 ✓	692 ✓	692 ✓
<del>ANP578 AB 1.5 DAP/2 eg Urea</del>	<del>772</del>	<del>772</del>	<del>772</del>	<del>772</del>	<del>772</del>	<del>772</del>	<del>772</del>
<del>ANP578 AB 1.5 DAP/3 eg Urea</del>	<del>772</del>	<del>772</del>	<del>772</del>	<del>772</del>	<del>772</del>	<del>772</del>	<del>772</del>
ANP578 AC 1.5 DAP/1 eg Urea	772	772	772	772	772	772	772
ANP578 AD 1.0 DAP/1 eg Urea	772	772	772	772	772	772	772
ANP578 AE 1.0 DAP/2 eg Urea	772	772	772	772	772	772	772
ANP578 AF 1.0 DAP/3 eg Urea	772	772	772	772	772	772	772
ANP578 AG Control	772	772	772	772	772	772	772

For Cutting (each Lot)

B-3	68	} 136 <sup>grams</sup> of 50/50 mixture
B-9	68	
W-1	1002	

Add 10% G-13-23

Topdress with 8 S-183.

SIGNATURE AND DATE

READ AND UNDERSTOOD (Signature and Date)



Subject

G7 Runs  
for Harvey Young

Date 10-30-90

438234

Dakota BlendAB

Cased K-22

890 ✓

890 ✓

C-30

1615 ✓

1615 ✓

TB

865 ✓

865 ✓

G7 Test 90-113 Part A  
" " " Control  
" " " Part B  
" " " 3% Quest

965

—

—

965

For Cutting

B-3 85

B-9 85

W-1 100

SIGNATURE AND DATE

READ AND UNDERSTOOD (Signature and Date)

Subject Re-Test Aged G-7-10 sheetDate 11-6-90

438235

Dakota Type for  
Steve John

Wt. in Grams

	<u>A</u>	<u>B</u>	<u>C</u>	<u>D</u>	<u>E</u>
Cased K-22	534 ✓	534 ✓	534 ✓	534 ✓	534 ✓
C-30	969	969	969	969	969
TB	519	519	519	519	519
G7-10 (TPD-405 1/8)	579	—	—	—	—
" (TPD-391 Cords 7/5 <sup>20 Wks</sup> )	—	579	—	—	—
" (TPD-387) Batch	—	—	579	—	—
" (TPD-395) 20 <sup>8-1-90</sup> Wks Aging	—	—	—	579	—
" TPD-395 20 <sup>8-1-90</sup> Wks Aging	—	—	—	—	579

B-3	51	} 102 gms / Lot
B-9	51	
W-1	70	

SIGNATURE AND DATE

C.D. McEhee 11-7-90

READ AND UNDERSTOOD (Signature and Date)

Subject

Test TRIPAR  
Reactor Flavors  
(Jack White)

Date 11-19-90

438286

Doral 85 Blend

Casing for 3 Kg. Lot

		A			
		Control	B	C	D
Strips	B-4	61.8✓	61.8✓	61.8✓	61.8✓
	B-2	26.5✓	26.5✓	26.5✓	26.5✓
	C-1	22.1✓	22.1✓	22.1✓	—
	F-1	22.1✓	22.1✓	22.1✓	—
	B-25	79.6✓	79.6✓	—	79.6✓
CKPL	1265	188.5	130✓	185	—
TB	770	—	297✓	—	297✓
G7	965	—	—	—	—
	<u>3000</u>				
(69.7% W-1)		TRIPAR P. Bomb Reacted # 440712-1			
		TRIPAR - P. Bomb Reacted # 440712-2			
(64.6% W-1)		—			
		254			

Doral 85 (A)

Strips	66.4055	72.2821	Cased Cut Strips
Casing	5.8766		GP-1
GP-1	7.7375		G-13-23
G-13-23	19.9804		
	<u>100.0000</u>		

	A	B	C	D
Cased Strips	2500✓	1804	1911✓	2187✓
GP-1	268✓	201	205✓	234
G-13-23	692✓	521	529✓	606
Total	3462	2606	2647	3029

SIGNATURE AND DATE

READ AND UNDERSTOOD (Signature and Date)

51208 6340



R.J. Reynolds Tobacco Company

Subject

MAKE Cased Bunking (DAKOTA)  
for Upcoming 6-7-10 Improvement Study

Project No.

Date 12-3-90

438237

10 Kgs of K-22<sup>\*</sup> Strips

B-4	337.1 gms	X
B-2	112.4 "	X
C-1	56.2 "	X
F-1	56.2 "	X
K-1	1070 "	

\* K-22 = { KG-1 1900 gms  
          { KG-2 8100 gms  
                  10,000 gms

SIGNATURE AND DATE

READ AND UNDERSTOOD (Signature and Date)

Subject

Date

G7-10 Test  
(~~11-10-89~~)

12-5-90

438238

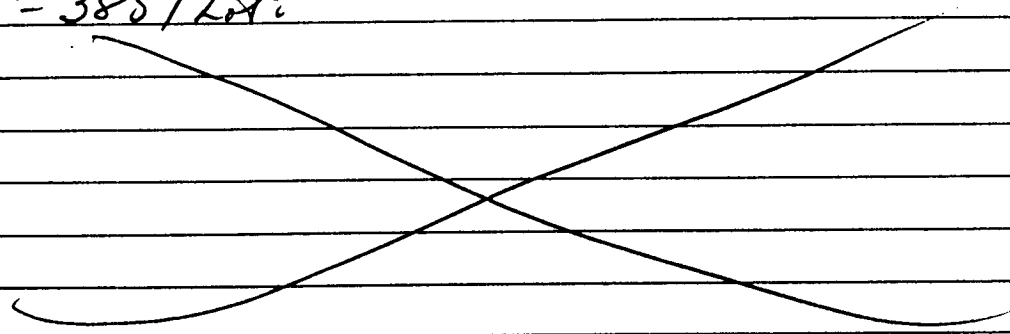
4 Kg. Lots (Dakota)

	A	B	C	D	E	F	G	H	I
Cased K-22	712✓	712✓	712✓	712✓	712✓	712✓	712✓	712✓	712✓
C-30	1292✓	1292✓	1292✓	1292✓	1292✓	1292✓	1292✓	1292✓	1292✓
TB	692✓	692✓	692✓	692✓	692✓	692✓	692✓	692✓	692✓
90-124 A ✓	772✓								
B ✓		772✓							
C ✓			772✓						
D ✓				772✓					
E ✓					772✓				
F ✓						772✓			
G ✓							772✓		
H ✓								772✓	
I ✓									772✓

For Cutting (Per Lot)

B-3	68 gms	} 136 gms
B-9	68 gms	
W-1	100 gms	

B-13-23 = 385/Lot.



SIGNATURE AND DATE

READ AND UNDERSTOOD (Signature and Date)

C.D. McE... 12-7-90

Subject Test Flavor Ingredients  
in Burley CasingDate 12-18-90

438239

Burley Casing

			A	B	C	D
K-22	1150	B-26 (HFCS (55))	35✓	—	35✓	35✓
		C-1	10✓	10✓	10✓	10✓
		B-3	30✓	30✓	30✓	30✓
		B-9	15✓	15✓	15✓	15✓
		E-1 (Light)	20✓	20✓	20✓	20✓
C-30	1385 ✓ ✓ ✓	B-4	30✓	30✓	30✓	30✓
		O-342	7.5✓	9.5✓	—	—
TB	975 ✓ ✓ ✓	Peach Conc. (1:8)	—	180✓	—	—
		(Unsweet) Cocoa Dist.	—	—	19.8✓	—
G7-10	940 ✓ ✓ ✓	S.E. Yerba Santa (mte)	—	—	—	1.5
		W-1	250	250	250✓	250

For Cutting

		A	B	C	D
	Honey 01	25✓	—	—	—
	HFCS	25✓	—	—	—
* 1 Part Peach Con. to	W-1	80✓	80	80	80
8 Parts Water	B-3	—	25	25	25
	B-9	—	25	25	25

Filling Capacity

A - 423, 426

B - 439, 434

C - 423, 433

D - 416, 420

SIGNATURE AND DATE

READ AND UNDERSTOOD (Signature and Date)





R.J. Reynolds Tobacco Company

Project No. MTP

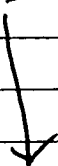
Subject

For Project QC NM 85Date 12-27-90

438240

Barley Casing

	<u>A</u>	<u>B</u>	<u>C</u>	<u>D</u>
<del>HC5 (55)</del>	35✓	35✓	35✓	35✓
C-1	10✓	10✓	10✓	10✓
B-3	30✓	30✓	30✓	30✓
B-9	15✓	—	15✓	15✓
E-1 (Light)	20✓	20✓	20✓	20
B-4	30✓	30✓	30✓	—
Cocoa Alk.	7.5✓	7.5✓	7.5✓	7.5✓
B-8	—	15✓	—	15✓
<u>Blend Conf.</u>	—	—	—	40✓
<u>Raisin Conc.</u>	—	—	—	—
N-1	250	250	250✓	250

A B C D

K-22	1150✓	1150✓	1250✓	1150✓
C-30	1385✓	1385✓	1300✓	1385✓
TB	975	975	1100✓	975✓
G-7-10	940	940	800✓	940
C-13	550	550	550	550
				B-3
				B-9
				N-1
				B-8

For Cutting

<u>A</u>	<u>B</u>	<u>C</u>	<u>D</u>
25	25	25	25
25	—	25	25
250	250	100	100
—	25	—	25

SIGNATURE AND DATE

READ AND UNDERSTOOD (Signature and Date)

Subject EVALUATE NEW F-7-10  
TPD 90-124B

Date \_\_\_\_\_

438241

BlendBurley Casing

	<u>DAKOTA</u>	<u>DAKOTA</u>	<u>214D</u>	<u>214D</u>
	<u>Control</u>	<u>with 90-124B</u>	<u>Control</u>	<u>with 90-124B</u>
	<u>A</u>	<u>B</u>	<u>C</u>	<u>D</u>
K-22	—	—	35	35
C-30	5.0	5.0	0	10
TB	—	—	30	30
F-7-10	—	—	15	15
90-124B	—	—	20	20
✓ F-1 Light Root	30.0	30.0	30	30
B-4	—	—	7.5	7.5
Cocoa Abs.	5.0	5.0	—	—
F-1	9.93	9.93	—	—
B-2	250	250	250	250
N-1				

K-22 A B C D  
890 890 1150 1150

C-30 1615 1615 1385 1385

TB 865 865 975 975

F-7-10 965 — 940 —

90-124B — 965 — 940

For Cutting

	<u>A</u>	<u>B</u>	<u>C</u>	<u>D</u>
B-3	81	81	25	25
B-9	81	81	25	25
N-1	50	50		

CANCEL

SIGNATURE AND DATE

READ AND UNDERSTOOD (Signature and Date)



R.J. Reynolds Tobacco Company

Project No. MTPSubject Test Ingredients  
on G7-10 sheet (TPD 90-124B)Date 1-14-91

438242

Spray different ingredients on G7-10  
(TPD-90-124B) to test flavor/taste characteristics  
in the total blend (Dakota).

	<u>1 Kg. of TPD-90-124B</u>								<u>Total</u>
	<u>A</u>	<u>B</u>	<u>C</u>	<u>D</u>	<u>E</u>	<u>F</u>	<u>G</u>	<u>H</u>	
<u>St. John's Bd. Powder</u>	<u>15g.</u>	<u>-</u>	<u>-</u>	<u>-</u>	<u>-</u>	<u>-</u>	<u>-</u>	<u>-</u>	
<u>C-1</u>	<u>-</u>	<u>10g.</u>	<u>5g.</u>	<u>-</u>	<u>-</u>	<u>-</u>	<u>-</u>	<u>-</u>	
<u>F-1</u>	<u>-</u>	<u>-</u>	<u>5g.</u>	<u>-</u>	<u>-</u>	<u>-</u>	<u>-</u>	<u>-</u>	
<u>Potassium sorbate</u>	<u>-</u>	<u>-</u>	<u>-</u>	<u>6g.</u>	<u>-</u>	<u>-</u>	<u>-</u>	<u>-</u>	
<u>S.E. Chamomille (Mar)</u>	<u>-</u>	<u>-</u>	<u>-</u>	<u>-</u>	<u>1.7g.</u>	<u>-</u>	<u>-</u>	<u>-</u>	
<u>Licorice Extract</u>	<u>-</u>	<u>-</u>	<u>-</u>	<u>-</u>	<u>-</u>	<u>20.0g.</u>	<u>-</u>	<u>-</u>	
<u>Vanillin</u>	<u>-</u>	<u>-</u>	<u>-</u>	<u>-</u>	<u>-</u>	<u>-</u>	<u>0.10g.</u>	<u>-</u>	
<u>Quest Irritation Reducer</u>	<u>-</u>	<u>-</u>	<u>-</u>	<u>-</u>	<u>-</u>	<u>-</u>	<u>-</u>	<u>40.0g.</u>	

SIGNATURE AND DATE

READ AND UNDERSTOOD (Signature and Date)



R.J. Reynolds Tobacco Company

Project No. MYP

Subject Incorporate G7-10's (TPD-90-124B)  
with Different Ingredients Into  
a DAKOTA Blend.

Date 1-16-91

438243

Mod. Dakota  
4 Kg. Lots

	<u>A</u>	<u>B</u>	<u>C</u>	<u>D</u>	<u>E</u>	<u>F</u>	<u>G</u>	<u>H</u>	<u>I</u>
<u>Cased K-22*</u>	712✓	✓	✓	<u>same</u>	✓	✓	✓	✓	✓
<u>C-30</u>	1292✓	✓	✓	<u>same</u>	✓	✓	✓	✓	✓
<u>TB</u>	692✓	✓	✓	<u>same</u>	✓	✓	✓	✓	✓
<u>NBP#</u>									
<u>438242 A</u>	772✓	-	-	-	-	-	-	-	-
<u>" B</u>	-	772✓	-	-	-	-	-	-	-
<u>" C</u>	-	-	772✓	-	-	-	-	-	-
<u>" D</u>	-	-	-	772✓	-	-	-	-	-
<u>" e</u>	-	-	-	-	772✓	-	-	-	-
<u>" F</u>	-	-	-	-	-	772✓	-	-	-
<u>" G</u>	-	-	-	-	-	-	772	<del>772</del>	-
<u>" H</u>	-	-	-	-	-	-	-	772	<del>772</del>
<u>TPD-90124B Control</u>	-	-	-	-	-	-	-	-	772

Pressing

\*

SIGNATURE AND DATE

READ AND UNDERSTOOD (Signature and Date)

Subject MAKE 10 Kg of 214D  
for Project X C (Shaun Dunlap)Date 1-17-91

438244

214DBlendBurley Casing~~K-22~~ ~~2,250~~

B-26

70 ✓ ✓

C-1

20 ✓ ✓

K-1 — 427.5 ✓

B-3

60 ✓ ✓

K2 — 1822.5 ✓

B-9

30 ✓ ✓

St. Johns Blend (light)

40 ✓ ✓

B-4

60 ✓ ✓

D-342

15.0 ✓

W-1

500 g.

~~C-30~~ ~~2,770~~Processing

C-1 886 ✓ ✓

1. Add hot casing to R-22

C-3 1,884 ✓ ✓

2. Dry to 10-11%

3. Re-order (steam) to <sup>14.15</sup> ~~10-11~~% for cutting

TB 1,950 ✓

4. Add C-30, TB, and G7-10, steam slightly and add;

G7-10 1,880

B-3 50 g.

B-9 50 g.

C-30 1,100

W-1 100 g.

5. Cut at 25 cpl, dry to 13% and add C-13.

SIGNATURE AND DATE

READ AND UNDERSTOOD (Signature and Date)

C. D. McEwen 1-17-91



Subject

Blends for Dr. Tom Perfetti

Date 1-25-91

438245

A Vantage 4L 85 control blend and two test products with new casings were made for Tom Perfetti. One - One casing is the 60/30 casing developed by Jack Senanbaugh and George Fearington in 1979.

• The second casing is MTP 214D with Lactic acid.

wt. in GRAMS

<u>Cut Filler Portion</u>		<u>VUL 55</u> Control <u>245A</u>	<u>Burley Casing</u> <u>245B</u>	<u>245C</u>	
K1	325	B-4	75	49.27	30
K2	725	B-2	25	—	—
		C-1	15	16.53	10
		F-1	25	14.20 *	—
		W-1	250	250	250
	100% Cocoa Butter	—	3.98 *	—	—
	B-3	—	41.45	30	—
	B-9	—	16.53	15	—
	Lactic acid 0-227	—	3.31	4.1	—
	H-13	—	0.04	—	—
	H-4	—	1.67	—	—
	B-26	—	—	32	—
	St. Johns Blend (Light)	—	—	20	—
	O-342	—	—	7.5	—

\* F-1 AND Cocoa Butter equivalent to 30%.

- Add 2% B-3 to cut filler before cutting.
- Topdress with S-112

SIGNATURE AND DATE

C.D. Moore 1-29-91

READ AND UNDERSTOOD (Signature and Date)



R.J. Reynolds Tobacco Company

Project No. Project XB

Subject

Blends for Project XB  
Tom PerfettiDate 2-1-91

438246

Dakota F.F. Lights Blend6 Kg. Blend[Wt. in Grams]Burley Casing

KG-1 354

KG-2 780

B-4

B-2

C-1

F-1

B-3

B-9

Gill & Duffus  
Cocoa Powder (22-24% Fat)

Lactic Acid (0-227)

H-13

H-4

St. Johns Brand (Light)

B-26

O-342

W-1

246A246B246C

42

18

6

6

—

—

—

—

—

—

—

—

—

—

—

260

53.2

—

17.84

—

44.77

17.85

19.63

3.57

0.045

1.78

—

—

—

—

—

200

32.4

—

10.8

—

32.4

16.2

—

4.43

—

—

—

21.6

34.6

7.5

200

CG-1 882

CG-2 1170

TB 1026

G7-10 1140

W-1 — 100g.

B-3 — 108g.

B-9 — 108g.

• For Cutting —

• Add 7 1/2 G-13-23 for total blend

• Topdress with S-128

SIGNATURE AND DATE

READ AND UNDERSTOOD (Signature and Date)

C.L.M. 1-4-91



R.J. Reynolds Tobacco Company

Project No.

MTP

Subject

Test puffed tobaccos in  
MTP Prototype - 214D (See #244)

Date

2-25-91

438247

Make a large batch of #214D without  
any puff tobacco. Divide into 3 parts

Part A = 11% of the blend is G-13-23

" B\* = 11% of " " " FC-137 } 60% SFC  
40% SF

" C = 11% of " " " C-13 (TPD-932A)

\* Part B was obtained from Gary Sklar

Filling Capacity

A = (Ave). 429

B = 418

C = 393

SIGNATURE AND DATE

C. D. M. 3-1-91

READ AND UNDERSTOOD (Signature and Date)





Subject Make Dakota FF Lights Blends  
for XB Project (Donna Wilson/Tom Perfette)

Date 2-28-91

438248

Dakota F.F. Lights[Wt. in grams]8 Kg. Blend

	<u>A</u>	<u>B</u>	<u>C</u>	<u>D</u>
KG1	472	472	472	472
KG2	1040	1040	1040	1040

Burley CasingA, B, C, D

B-4	56
B-2	24
C-1	8
F-1	8
W-1	200

Note: For Part C, add 72 gms (90%)  
 to the casing after it is heated and  
 ready for spraying.

C-1	1176	1176	1176	1176
C-3	1560	1560	1560	1560

Casing for Cutting

TB	1368	1368	1368	1368
G <sup>7-1</sup> <sub>91-029</sub>	1520	-	-	-
G <sup>7-1</sup> <sub>91-030</sub>	-	1520	-	-

	<u>A, B, C</u>	<u>D</u>
B-3	144	116
B-9	144	116
W-1	100	80

G <sup>7-1</sup> <sub>91-028 (Control)</sub>	-	1520	-
--	---	------	---

Part A = FL 91061 E

B = FL 91061 F

C = FL 91061 G

• Add 7% G-13-23 to total Blend

• Topdress A, B, C with S-128

• In addition, cut 5 1/2 lbs. of G7-1 (91-028) Control

SIGNATURE AND DATE

READ AND UNDERSTOOD (Signature and Date)

51208 6352



R.J. Reynolds Tobacco Company

Subject

Evaluate Q7-10's (Dakota Bland)

Project No.

Date 3-5-91

438249

Make Cased K-22

K-1 1900 gms

K-2 8100 gms

B-4

B-2

C-1

F-1

W-1

Casing

337.1 gms

112.4 "

56.2 "

56.2 "

1070 "

4 Kg. BatchABCDEF

Cased K-22

712

712

712

712

712

712

C-30

1292

1292

1292

1292

1292

1292

TB

692

692

692

692

692

692

91-036A

772

-

-

-

-

-

" B

-

772

-

-

-

-

" C

-

-

772

-

-

-

" D

-

-

-

772

-

-

" E\*

-

-

-

-

772

-

" F

-

-

-

-

-

772

\* High Solids 38.75%

• For Casing = B-3 68 gms

B-9 68 gms

W-1 115 "

• Add Q-13-23 to be 10% of the blend

SIGNATURE AND DATE

READ AND UNDERSTOOD (Signature and Date)

C.R.M. 3-5-91



Subject

238BDate 3-11-91

438250

A 10 Kg. batch of #238B cut filler was made in the laboratory ~~and~~ for Ms. Sharon Dunlap of the XA project. This blend contains the modified R-7-10 sheet (TPD-90-12-4) made on Dec-4, 1990. The blend ~~and~~ is the Dakota FF product replacing R-7-10 with the modified version.

238B - 10 Kgs.

	(gms)	
C-1	1,034	} For Cutting
C-3	2,196	
TB	1,730	
90-124B	1,930	
Cased K-22	1,780	
G-13-23	963	B-3 170 gms
		B-9 170 gms
		W-1 250 gms

SIGNATURE AND DATE

READ AND UNDERSTOOD (Signature and Date)

C.D. Moore 3-11-91