

01/06/94 10:08  
Item: 20100212 AC  
Stat: APPROVED  
Eff : 10/27/93

TI Manufacturing Standards System  
Inquire Finished Cigarette Specifications  
Desc: WIME WINSTON MENTHOL:WINSTON MENTHOL  
Prod Loc: 392 RJR PUERTO RICO

HSP104IN  
HSP104M1  
Page 01

* Dimensions *	Target	Control Low	Limits High	Reject Low	Limits High
Rod Len mm.....	63.00	0.10	+/-	0.00	0.00
Cigt Len mm.....	84.00	0.00	0.00	0.00	0.00
Tape Circum ..	24.85	24.75	24.95	24.70	25.00
In Process Circum..	24.80	24.70	24.90	24.65	24.95
Air Circum ..	24.80	24.70	24.90	24.65	24.95
	0.00	0.00	0.00	0.00	0.00

  

* Weights *					
Tobacco.....	0.6978	0.6838	0.7118		
Filter Segment.....	0.1343				
Tipping Paper.....	0.0264				
Cigarette Paper.....	0.0425				
Rod Ahesives.....	0.0000				
Tipping Adhesives...	0.0000				
Total.....	0.9010	0.8894	0.9294	0.8712	0.9476

Enter-PF1---PF2---PF3---PF4---PF5---PF6---PF7---PF8---PF9---PF10---PF11---PF12---  
PRINT NEXT MENU MAIN

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TI Manufacturing Standards System  
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Desc: WIME WINSTON MENTHOL:WINSTON MENTHOL  
Prod Loc: 392 RJR PUERTO RICO

HSP104IN  
HSP104MT  
Page 02

* Physical *	Target	Control Low	Limits High	Reject Low	Limits High
Draft (HO), mm.....	112	102	122	92	132
Draft (HC), mm.....					
Rod Draft, mm.....	55	50	60		
Dilution, .....	19	13	25	9	29
Firmness, mm.....	8.00	7.00	9.00		
Filling Capacity....					
Density.....	0.2253				

  

* Chemical *					
Moisture.....	11.75	11.30	12.20	10.75	12.75
Menthol .....	0.30	0.27	0.33	0.24	0.36
Nicotine, mg/cig....	1.05	1.00	1.10	0.90	1.20

Enter-PF1---PF2---PF3---PF4---PF5---PF6---PF7---PF8---PF9---PF10---PF11---PF12---  
PRINT PREV NEXT MENU MAIN

*G-137a Target 1872*

51317 0768

01/06/94 10:09  
Item: 20100212 AC  
Stat: APPROVED  
Eff : 10/27/93

TI Manufacturing Standards System  
Inquire Finished Cigarette Specifications  
Desc: WIME WINSTON MENTHOL:WINSTON MENTHOL  
Prod Loc: 392 RJR PUERTO RICO  
Local Item id:

HSP104N6  
HSP104M7  
Page 03

* Smoke Delivery *	Target	Control Low	Limits High	Reject Low	Limits High
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QA Brand:

Test Method.....: FTC  
Batt Length.....: 28.0  
Tar, mg/cig cond...: 14.2      13.0      15.4      12.2      16.2  
uncond....:

\* TICARS Codes \*

Brand-Styles: WIME1 : WINSTON MEN 20'S KS CPB 84MM

Markets .....: 072 : ICELAND DOMESTIC

Enter-PF1---PF2---PF3---PF4---PF5---PF6---PF7---PF8---PF9---PF10---PF11---PF12---  
PRINT PREV NEXT MENU MAIN

01/06/94 10:09 TI Manufacturing Standards System HSP104IN  
Item: 20100212 AC Inquire Finished Cigarette Specifications HSP104M3  
Stat: APPROVED Desc: WIME WINSTON MENTHOL:WINSTON MENTHOL Page 04  
Eff : 10/27/93 Prod Loc: 392 RJR PUERTO RICO

Component Desc: WINSTON MENTHOL

\* Certified Process Configuration \*

Makers:

MOLINS MARK-9

Tipppers:

HAUNI MAX-S

\* Component List \*

Spec Type	Item ID	Description							
Tipping Paper...	10600129	50.00 ML 550.0 30966	33.10	WIME1	( )				
Cigt Paper.....	10100027	454 27.00 38.0 0.55% CITRATE			(EC)				
Mfg. CFT.....									
Purchased CFT...	10800001	I992; SA-7							
Mfg. Filter.....	20200125	3.0 35000 126.00 21.00 24.53	64	384					
Purchase Filter:									

Enter-PF1---PF2---PF3---PF4---PF5---PF6---PF7---PF8---PF9---PF10---PF11---PF12---  
PROC PRINT PREV NEXT MENU MAIN

01/06/94 10:09 TI Manufacturing Standards System HSP104IN  
Item: 20100212 AC Inquire Finished Cigarette Specifications HSP104MA  
Stat: APPROVED Desc: WIME WINSTON MENTHOL:WINSTON MENTHOL Page 05  
Eff : 10/27/93 Prod Loc: 392 RJR PUERTO RICO

\* Change Documentation \*

Change Order: 9300087

Reason:

: FILTER TOW CONSOLIDATION

Approval Date: 10/27/93

Approved By: WHHNK

: M WILLIAMS

\* Remarks \*

\* Spec Description \*

FILTER TOW CONSOLIDATION FOR PUERTO RICO

51317 0769

01/06/94 10:05  
Item: 20100211 AB  
Stat: APPROVED  
Eff : 09/23/93

TI Manufacturing Standards System  
Inquire Finished Cigarette Specifications  
Desc: WIML WINSTON MEN LIGHTS:WINSTON LTS. MENTHOL  
Prod Loc: 392 RJR PUERTO RICO

HSP104IN  
HSP104M1  
Page 01

* Dimensions *	Target	Control Low	Limits High	Reject Low	Limits High
Rod Len mm.....	57.00	0.10	+/-	0.00	0.00
Cigt Len mm.....	84.00	0.00	0.00	0.00	0.00
Tape Circum ..:	24.85	24.75	24.95	24.70	25.00
In Process Circum.:	24.80	24.70	24.90	24.65	24.95
Air Circum ..:	24.80	24.70	24.90	24.65	24.95
	0.00	0.00	0.00	0.00	0.00

\* Weights \*

Tobacco.....	0.6314	0.6188	0.6440		
Filter Segment.....	0.1774				
Tipping Paper.....	0.0310				
Cigarette Paper.....	0.0385				
Rod Ahesives.....	0.0000				
Tipping Adhesives...	0.0000				
Total.....	0.8783	0.8590	0.8976	0.8414	0.9152

Enter-PF1---PF2---PF3---PF4---PF5---PF6---PF7---PF8---PF9---PF10---PF11---PF12---  
PRINT NEXT MENU MAIN

01/06/94 10:05  
Item: 20100211 AB  
Stat: APPROVED  
Eff : 09/23/93

TI Manufacturing Standards System  
Inquire Finished Cigarette Specifications  
Desc: WIML WINSTON MEN LIGHTS:WINSTON LTS. MENTHOL  
Prod Loc: 392 RJR PUERTO RICO

HSP104IN  
HSP104MT  
Page 02

* Physical *	Target	Control Low	Limits High	Reject Low	Limits High
Draft (HO), mm.....	120	110	130	100	140
Draft (HC), mm.....					
Rod Draft, mm.....	59	54	64		
Dilution, .....	27	22	32	22	32
Firmness, mm.....	8.00	7.00	9.00		
Filling Capacity....					
Density.....	0.2254				

\* Chemical \*

Moisture.....	11.75	11.30	12.20	10.75	12.75
Menthol .....	0.35	0.32	0.38	0.28	0.42
Nicotine, mg/cig....	0.60	0.55	0.65	0.45	0.75

Enter-PF1---PF2---PF3---PF4---PF5---PF6---PF7---PF8---PF9---PF10---PF11---PF12---  
PRINT PREV NEXT MENU MAIN

6132 TARGET 187

51317 0770

01/06/94 10:05  
Item: 20100211 AB  
Stat: APPROVED  
Eff : 09/23/93

TI Manufacturing Standards System  
Inquire Finished Cigarette Specifications  
Desc: WIML WINSTON MEN LIGHTS:WINSTON LTS. MENTHOL 8  
Prod Loc: 392 RJR PUERTO RICO  
Local Item id: QA Brand:

HSP104N6  
HSP104M7  
Page 03

* Smoke Delivery *	Target	Control Low	Limits High	Reject Low	Limits High
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Test Method.....: FTC  
Butt Length.....: 34.0  
Tar, mg/cig cond...: 8.5            7.5            9.5            7.0            10.0  
                  uncond....:

\* TICARS Codes \*

Brand-Styles: WIML1 : WINSTON MEN LTS 20'S KS CPB 84MM

Markets .....: 072 : ICELAND DOMESTIC

Enter-PF1---PF2---PF3---PF4---PF5---PF6---PF7---PF8---PF9---PF10---PF11---PF12---  
                                  PRINT            PREV    NEXT                    MENU    MAIN

01/06/94 10:06                    TI Manufacturing Standards System                    HSP104IN  
Item: 20100211 AB            Inquire Finished Cigarette Specifications            HSP104M3  
Stat: APPROVED    Desc: WIML WINSTON MEN LIGHTS:WINSTON LTS. MENTHOL 8    Page 04  
Eff : 09/23/93                    Prod Loc: 392 RJR PUERTO RICO

Component Desc: WINSTON LTS. MENTHOL 84M

\* Certified Process Configuration \*

Makers:

MOLINS MARK-9\_\_

Tipppers:

HAUNI MAX-S\_\_

\* Component List \*

Spec Type	Item ID	Description							
Tipping Paper...	10600128	62.00 ML 546.0 36WC2	39.90	WIML	( )				
Cigt Paper.....	10100026	453 27.00 38.0 1.00%		CITRATE	(EC)				
Mfg. CFT.....									
Purchased CFT...	10800001	I992; SA-7							
Mfg. Filter....	20200012	2.7 35000 108.00	27.00	24.53	97	388			
Purchase Filter:									

Enter-PF1---PF2---PF3---PF4---PF5---PF6---PF7---PF8---PF9---PF10---PF11---PF12---  
                                  PROC                    PRINT            PREV    NEXT                    MENU    MAIN