



BROWN & WILLIAMSON TOBACCO CORPORATION

RESEARCH & DEVELOPMENT

INTERNAL CORRESPONDENCE

TO: C. J. Radley

CC: K. D. Ruberti K. A. Flaherty
T. J. Hinzman B. A. Bandy
P. H. Doyle Jim Taylor
D. L. Scholten S. W. Linebaugh

FROM: R. A. Gonterman

DATE: June 6, 1991

SUBJECT: ZIRCON MENTHOL FACTORY TRIAL/267

Attached are the specifications for the ZIRCON menthol re-make factory trial which is scheduled for June 17, 1991. The purpose of this factory trial is to:

1. Determine the tipping permeability needed for CPT specifications, and
2. to confirm the smoke quality results at Dupont of previously made Mini-Works samples.

There are a total of 3 samples to be made. The samples differ only by tipping permeabilities (3300, 3950, 4250 C). The specifications for each is attached.

The menthol tobacco (XCF-863Y) used in the previous trial should also be used for this test. The boxes of tobacco are labeled "ZIRCON Menthol (XLF-863Y)."

The major cigarette parameters are:

	<u>Menthol</u>
Cut Tobacco	XLF-863Y
Tipping Length	36 mm
Circumference	23.1 mm
Cigarette Length	98.5 mm
Filter Length	30 mm
Tobacco Weight	701 mg
Density	241 mg/cc
Tow Item	3.6/33,500 (FT-333)
Plug Wrap	65M2 (special width)
Rod Pressure Drop	19.2"
Cigarette Paper	E-556 (special width)

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We are not concerned with a ventilation target for this trial. No attempt should be made to adjust the ventilation rate. However, CTS measurements should be taken as frequently as possible during each of the runs. These data sheets should be sent to Pam Doyle at the Technical Center in Louisville.

During the manufacture of these samples please ensure that the maker is set at normal settings as if in normal production. Please record maker speed and send to Pam Doyle. The normal full glue roller will be used for this trial.

When the maker has stabilized with all parameters at target collect three thousand (3000) sticks of each sample (randomly collected) and place in labeled tupperware containers. Carefully pack tupperware containers for shipment to R&D. Containers should be labeled with cigarette number listed on specification sheets, tobacco blend number, tipping permeability used and date of manufacture.

We also need 400 sticks of each sample (randomly collected) placed in glass jars and labeled with the same information. These samples should be carefully packed. Arrangements will be made to get these samples to R&D by the fastest means. These samples will be used for Dupont testing.

ISSUES OF IMPORTANCE

Filter Rod

The filter rod is a new configuration for Macon (22.8 circumference, 3.6/33,500 tow).

The filter rod specifications are:

Rod Pressure Drop	19.2 "± 0.6"
Rod Length	120 mm
Rod Circumference	22.8 mm
Tow Item	3.6/33,500 (FT-333)
Plasticizer	19-0010 (Tilbox)
Plasticizer Level	7%
Plug Wrap Type	65M2 (special width)
Plug Wrap Permeability	6500 C
Plug Wrap Width	25 mm

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Tipping

The following tippings have been ordered from Hermitite and sent to the attention of Kim Ruberti.

To be used for Menthol Samples

1 bobbin of 3300 C tipping
1 bobbin of 3950 C tipping
1 bobbin of 4250 C tipping

Tipping specifications are:

Length	36 mm
Perforations	15 mm from the mouth end
Holes Per Inch	60, 75, 80
# of Lines	2
Permeability	3300, 3950, 4250

Tippings should be conditioned prior to fabrication.

Please send three (3) samples from each bobbin of tipping to Pam Doyle. These samples should be taken from the beginning, middle and end of the tipping bobbin.

If there are any questions concerning this trial please call Pam Doyle, ext. 7146 or Rick Gonterman ext. 7965. An R&D representative will be on-site for the duration of the trial.



R. A. Gonterman

RAG/11p
p2f62.wp

Attachment

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BROWN & WILLIAMSON TOBACCO CORPORATION
 ** DEVELOPMENT CENTER WORK REQUEST **

CC: P. E. Atkins
 S. Reesor / K. Bobbitt
 R.A.GONTERMAN

Date Requested: 06/06/91
 Approved by: _____
 Requestor Project #: 22-267
 Requestor: R.A.GONTERMAN
 Designer:

Cigarette Description: ZIRCON MENTHOL
 Requestor #:
 Date Manufactured:
 Pilot Plant Project #:
 Purpose: FACTORY TRIAL (3300 C TIPPING)

Labdata Number:

Current Brand:

Cigarette Code: 267184

Analysis Code: 267184

Masked Analysis Code:

End Pack Code:

Tobacco Code:

Blend Designation: XLF-863Y Added Shorts: YES

Primary Location (M/DC): DC

Fab Location (M/DC): M

CASING/FLAVORING

Burley Casing: XCF-1927 Redried: M

Flue Cured Casing: XCF-1945

Top Dressing:

Flavor: XFF-602 F-140 Loc: D

Operation Number:

Date Cased:

Menthol Retention (%): .80 Loc: D

Moisture Content (%): 14.50

Propylene Glycol (%): .70 (T) (A)

Glycerine (%): 3.00 (T) (A)

FILTER ROD

Material:

Tow Item: FT-333

Length (mm): 120

CIRCUMFERENCE (mm): 22.80

PRESSURE DROP: 19.20 (T) (A)

Plasticizer: TILBOX 7.0 (%)

Plug Wrap: KC-65N2

P.W. Porosity (c): 6500

Anchor Lines: Y

PACKAGING

Label Type:

Closure:

Overwrap:

Tear Tape:

Carton Type:

CIGARETTE PAPER

Supplier:

GRADE: E-556

Permeability: 25

Burn Additive (type%): CITRATE .55

Special Instructions:

QUANTITY

Stock Room Quantity:

Distribution Quantity: 3000 STKS

Market Research Quantity:

Other Dept. Name: PRODUCT

Other Dept. Quantity: 400 STKS

TIPPING/FILTER

Supplier:

COLOR: WHITE

Length: 36.0

Perf. Type: ALP

DISTANCE FROM H.E. (mm): 15 (T) (A)

Permeability (c): 3300 (T) (A)

Off Line Laser (Y/N):

Basis Number (g/m2):

Tipping Adhesive:

Bobbin Number:

Filter Length: 30.0

Tip Pressure Drop: 4.80

VENTILATION RATE (%): 52.000 (T) (A)

On Line Laser Vent: (T) (A)

of Lines: 2

Holes / Inch: 60

Mask Width:

Mask Color:

CIGARETTE

Length (mm): 98.5

CIRCUMFERENCE (mm): 23.1 (T) (A)

Maker Speed:

Trim Check: End Stability (G/CC):

Pressure Drop (target); 8.20 (seal) 4.90 (open)

TOBACCO SECTION

Length (mm): 98.5

TOBACCO WEIGHT (mg): 701 (T) (A)

Density(mg/cc): 241 (T) (A)

NON-TOBACCO WEIGHTS

Avg. Rod Weight:

Seam and Paper Weight:

Tipping Weight:

Weight / 100 Cigts.:

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BROWN & WILLIAMSON TOBACCO CORPORATION
 ** DEVELOPMENT CENTER WORK REQUEST **

CC: P. E. Atkins
 S. Reesor / K. Bobbitt
 R.A.GONTERMAN

Date Requested: 06/06/91
 Approved by: _____
 Requestor Project #: 22-267
 Requestor: R.A.GONTERMAN
 Designer:
 Cigarette Description: ZIRCON MENTHOL
 Requestor #:
 Date Manufactured:
 Pilot Plant Project #:
 Purpose: FACTORY TRIAL (3950 C TIPPING)

Labdata Number:

Current Brand:

Cigarette Code: 267185

Analysis Code: 267185

Masked Analysis Code:

End Pack Code:

Tobacco Code:

Blend Designation: XLF-863V Added Shorts: YES

Primary Location (M/DC): BC

Fab Location (M/DC): M

CASING/FLAVORING

Burley Casing: XCF-1927 Redried: M

Flue Cured Casing: XCF-1945

Top Dressing:

Flavor: XTF-602 F-140 Loc: D

Operation Number:

Date Cased:

Menthol Retention (%): .80 Loc: D

Moisture Content (%): 14.50

Propylene Glycol (%): .70 (T) (A)

Glycerine (%): 3.00 (T) (A)

FILTER ROD

Material:

Tow Item: FT-333

Length (mm): 120

CIRCUMFERENCE (mm): 22.80

PRESSURE DROP: 19.20 (T) (A)

Plasticizer: TILBOX 7.0 (Z)

Plug Wrap: KC-65H2

P.W. Porosity (c): 6500

Anchor Lines: Y

PACKAGING

Label Type:

Closure:

Overwrap:

Tear Tape:

Carton Type:

CIGARETTE PAPER

Supplier:

GRADE: E-556

Permeability: 25

Burn Additive (type%): CITRATE .55

Special Instructions:

QUANTITY

Stock Room Quantity:

Distribution Quantity: 3000 STKS

Market Research Quantity:

Other Dept. Name: PRODUCT

Other Dept. Quantity: 400 STKS

TIPPING/FILTER

Supplier:

COLOR: WHITE

Length: 36.0

Perf. Type: NLP

DISTANCE FROM M.E. (mm): 15 (T) (A)

Permeability (c): 3950 (T) (A)

Off Line Laser (V/M):

Basis Number (g/m2):

Tipping Adhesive:

Bobbin Number:

Filter Length: 30.0

Tip Pressure Drop: 4.80

VENTILATION RATE (%): 52.000 (T) (A)

On Line Laser Vent: (T) (A)

of Lines: 2

Holes / Inch: 75

Mask Width:

Mask Color:

CIGARETTE

Length (mm): 98.5

CIRCUMFERENCE (mm): 23.1 (T) (A)

Maker Speed:

Trim Check: End Stability (G/CC):

Pressure Drop (target): 8.20 (seal) 4.90 (open)

TOBACCO SECTION

Length (mm): 98.5

TOBACCO WEIGHT (mg): 701 (T) (A)

Density(mg/cc): 241 (T) (A)

NON-TOBACCO WEIGHTS

Avg. Rod Weight:

Seam and Paper Weight:

Tipping Weight:

Weight / 100 Cigts.:

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BROWN & WILLIAMSON TOBACCO CORPORATION
 ** DEVELOPMENT CENTER WORK REQUEST **

CC: P. E. Atkins.
 S. Reesor / K. Bobbitt
 R.A.GONTIERMAN

Date Requested:	06/06/91	Cigarette Description:	ZIRCON MENTHOL
Approved by:		Requestor #:	
Requestor Project #:	22-267	Date Manufactured:	
Requestor:	R.A.GONTIERMAN	Pilot Plant Project #:	
Designer:		Purpose:	FACTORY TRIAL (4250 C TIPPING)

Labdata Number:				**QUANTITY**	
Current Brand:				Stock Room Quantity:	
Cigarette Code:	267186			Distribution Quantity:	3000 STKS
Analysis Code:	267186			Market Research Quantity:	
Masked Analysis Code:				Other Dept. Name:	PRODUCT
End Pack Code:				Other Dept. Quantity:	400 STKS
Tobacco Code:					
Blend Designation:	XLF-863V	Added Shorts:	YES		
Primary Location (N/DC):	DC			**TIPPING/FILTER**	
Fab Location (N/DC):	N			Supplier:	
				COLOR:	WHITE
				Length:	36.0
CASING/FLAVORING				Perf. Type:	MLP
Burley Casing:	XCF-1927	Redried:	N	DISTANCE FROM M.E. (mm):	15 (T) (A)
Flue Cured Casing:	XCF-1945			Permeability (c):	4250 (T) (A)
Top Dressing:				Off Line Laser (V/M):	
Flavor:	XFF-602	F-140	Loc: D	Basis Number (g/m2):	
Operation Number:				Tipping Adhesive:	
Date Cased:				Bobbin Number:	
Menthol Retention (%):	.80		Loc: D	Filter Length:	30.0
Moisture Content (%):	14.50			Tip Pressure Drop:	4.80
Propylene Glycol (%):	.70 (T) (A)			VENTILATION RATE (%):	52.000 (T) (A)
Glycerine (%):	3.00 (T) (A)			On Line Laser Vent:	(T) (A)
				# of Lines:	2
FILTER ROD				Holes / Inch:	80
Material:				Mask Width:	
Top Item:	FT-333			Mask Color:	
Length (mm):	120				
CIRCUMFERENCE (mm):	22.80			**CIGARETTE**	
PRESSURE DROP:	19.20 (T) (A)			Length (mm):	98.5
Plasticizer:	TILBOX	7.0 (%)		CIRCUMFERENCE (mm):	23.1 (T) (A)
Plug Wrap:	KC-65M2			Maker Speed:	
P.W. Porosity (c):	6500			Trim Check:	End Stability (G/CC):
Anchor Lines:	Y			Pressure Drop (target):	8.20 (seal) 4.90 (open)
PACKAGING				**TOBACCO SECTION**	
Label Type:				Length (mm):	98.5
Closure:				TOBACCO WEIGHT (mg):	701 (T) (A)
Overwrap:				Density(mg/cc):	241 (T) (A)
Tear Tape:					
Carton Type:				**NON-TOBACCO WEIGHTS**	
				Avg. Rod Weight:	
CIGARETTE PAPER				Seam and Paper Weight:	
Supplier:				Tipping Weight:	
GRADE:	E-556			Weight / 100 Cigts.:	
Permeability:	25				
Burn Additive (type%):	CITRATE	.55			
Special Instructions:					

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