

BROWN & WILLIAMSON TOBACCO CORPORATION
Development Center Work Request

DATE: July 5, 1989
REQUESTED BY: R. R. Black
ALTERNATE: D. V. Cantrell
PROJECT NO.: 21-377

TO: J. L. Barnett
COPIES: S. D. Oliver
B. A. Bandy (3)
P. A. Dearing

Copy Without Attachments:

M. L. Reynolds
T. F. Riehl
D. L. Gordon
A. McMurtrie
P. R. Fisher

PURPOSE: Y1 Lights & Ultra Mini-CPT

DESCRIPTION (Test Outline And/Or Special Instructions):

Specifications for the Mini-CPT of Y1 Lights and Y1 Ultra are attached. These products are to be made in the D.C. (Primary and Fabrication). The samples are:

541 372 372 ← 377122 - Y1 Lights, XLF-912S, XFF-547
542 372 372 ← 377128 - Y1 Ultra, XLF-912N, XFF-544

Quantities needed for the Mini-CPT will be requested by MRD.

Additional Quantities

In addition to the quantities required by Market Research, R&D will need the quantities shown in the following table for Dupont methodology testing.

Y1 Lights Mini-CPT

<u>Product</u>	<u>Additional Quantity</u>
Y1 Lights KS	70 Cartons ¹
Merit KS	35 Cartons
Winston KS	35 Cartons

Y1 Ultra Mini-CPT

<u>Product</u>	<u>Additional Quantity</u>
Y1 Ultra KS	105 Cartons ¹
Merit KS	35 Cartons
Merit Ultra	70 Cartons

¹For Y1 Lights and Y1 Ultra, these quantities are noted on the specification sheets under "Distribution Quantity."

SCOPE OF WORK (CHECK APPROPRIATE CATEGORIES)

<input checked="" type="checkbox"/> DOMESTIC PRODUCT	<input checked="" type="checkbox"/> NEW PRODUCT
<input type="checkbox"/> INTERNATIONAL PRODUCT	<input type="checkbox"/> PRESENT PRODUCT
<input type="checkbox"/> PROCESS	<input checked="" type="checkbox"/> CPT
<input type="checkbox"/> EXPLORATORY	<input type="checkbox"/> INTERNAL

DEVELOPMENT CENTER PROJECT NO.: _____
SCHEDULED: _____
COMPLETED: _____

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The Y1 and competitive products are to be masked for the Dupont testing the same as for the CPT. Also, it is important that the competitive products come from the same sample population as the CPT products. These additional products are to be charged to R&D 22-311 (Sensory & Preference Research).

If there are any questions, please call me (7822).



R. R. Black

RRB/sek/3944n

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

CC: P. E. Atkins
 P. A. Bearing
 R. R. BLACK

Date Requested: 07/03/89 Cigarette Description: Y1 LIGHTS CPT CANDIDATE
 Approved by: _____ Requestor #: 224
 Requestor Project #: Z1-377 Date Manufactured:
 Requestor: R. R. BLACK Pilot Plant Project #:
 Designer: R. R. BLACK Purpose: Y1 LIGHTS CPT

Labdata Number:
 Current Brand: **QUANTITY**
 Cigarette Code: Stock Room Quantity:
 Analysis Code: 377122 Distribution Quantity: 70 CTN
 Masked Analysis Code: 377123 Market Research Quantity:
 End Pack Code: Other Dept. Name:
 Tobacco Code: Other Dept. Quantity:
 Blend Designation: XLF-912S Added Shorts: YES
 Primary location (N/DC): DC **TIPPING/FILTER**
 Fab Location (N/DC): DC Supplier:
 CASING/FLAVORING COLOR: C/W
 Redried (Y/N): Y Length: 32.0
 Burley Casing: XCF-2175 Perf. Type: NLP
 Fine Cured Casing: XCF-2178 DISTANCE FROM N.E. (mm): 15 (T) (A)
 Top Dressing: XCF-2080 Permeability (c): 900 (T) (A)
 Flavor: XFF-547 Off Line Laser (Y/N):
 Operation Number: Basis Number (g/m2):
 Date Cased: Tipping Adhesive:
 Menthol Retention (%): Bobbin Number:
 Moisture Content (%) 14.50 Filter Length: 27.0
 Menthol Loc: Flavor Loc: B VENTILATION RATE (%): 26.000 (T) (A)
 On Line Laser Vent: (T) (A)
 FILTER ROD
 Material:
 Tow Item: FT-107
 Length (mm): 108
 CIRCUMFERENCE (mm): 24.40
 PRESSURE DROP: 15.20 (T) (A)
 Plasticizer: TILBOX 7.0 (%)
 Plug Wrap: KC-65M2
 P.W. Porosity (c): 6500
 Anchor Lines: YES
 PACKAGING
 Label Type: NR
 Closure: GOLD
 Overwrap: FILM
 Year Tape: GOLD
 Carton Type: NR
 CIGARETTE PAPER
 Supplier:
 GRADE: E-609
 Permeability: ZB
 Burn Additive (type%): CITRATE .75
 CIGARETTE
 Length (mm): 84.0
 CIRCUMFERENCE (mm): 24.7 (T) (A)
 Maker Speed:
 Trim Check:
 End Stability (g/cc):
 TOBACCO SECTION
 Length (mm): 57.0
 TOBACCO WEIGHT (mg): 725 (T) (A)
 Density(mg/cc): 262 (T) (A)
 NON-TOBACCO WEIGHTS
 Avg. Rod Weight:
 Seam and Paper Weight:
 Tipping Weight:
 Weight / 100 Cigts.:

Special Instructions:
 ON-LINE LASER MAY BE USED.

ADJUST TIPPING TO MAINTAIN VENT.

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

U: P. E. ATKINS
 P. A. DEARING
 R.R. BLACK

Date Requested: 07/03/89 Cigarette Description: Y1 ULTRA CPT CAND
 Approved by: _____ Requestor #: 224
 Requestor Project #: 21-377 Date Manufactured:
 Requestor: R.R. BLACK Pilot Plant Project #:
 Designer: R.R. BLACK Purpose: Y1 ULTRA CPT

Labdata Number:

Current Brand:
 Cigarette Code:
 Analysis Code: 377128
 Masked Analysis Code: 377129
 End Pack Code:
 Tobacco Code:
 Blend Designation: XLF-912M Added Shorts: YES
 Primary Location (M/DC): DC
 Fab Location (M/DC): DC

CASING/FLAVORING

Redried (Y/N): Y
 Burley Casing: XCF-2175
 Flue Cured Casing: XCF-2172
 Top Dressing: XCF-2174
 Flavor: RFF-544
 Operation Number:
 Date Cased:
 Menthol Retention (%):
 Moisture Content (%) 14.50
 Menthol Loc: Flavor Loc: 0

FILTER ROD

Material:
 Tow Item: 2.5/42
 Length (mm): 108
 CIRCUMFERENCE (mm): 24.40
 PRESSURE DROP: 18.40 (T) (A)
 Plasticizer: TILBOX 7.0 (%)
 Plug Wrap: KC-95M2
 P.M. Porosity (c): 9500
 Anchor Lines: YES

PACKAGING

Label Type: NR
 Closure: GOLD
 Overwrap: FILM
 Tear Tape: GOLD
 Carton Type: NR

CIGARETTE PAPER

Supplier:
 GRADE: KC-654
 Permeability: 26
 Burn Additive (type%): CITRATE 1.74

QUANTITY

Stock Room Quantity:
 Distribution Quantity: 105 CTNS
 Market Research Quantity:
 Other Dept. Name:
 Other Dept. Quantity:

TIPPING/FILTER

Supplier:
 COLOR: C/N
 Length: 32.0
 Perf. Type: RLP
 DISTANCE FROM N.E. (mm): 15 (T) (A)
 Permeability (c): 2630 (T) (A)
 Off Line Laser (Y/N):
 Basis Number (g/m²):
 Tipping Adhesive:
 Bobbin Number:
 Filter Length: 27.0
 Tip Pressure Drop: 4.60
 VENTILATION RATE (%): 48.800 (T) (A)
 On Line Laser Vent: (T) (A)
 # of Lines:
 Holes / Inch:
 Mask Width:
 Mask Color:

CIGARETTE

Length (mm): 84.0
 CIRCUMFERENCE (mm): 24.7 (T) (A)
 Maker Speed:
 Trim Check:
 End Stability (g/cc):

TOBACCO SECTION

Length (mm): 57.0
 TOBACCO WEIGHT (mg): 652 (T) (A)
 Density (mg/cc): 235 (T) (A)

NON-TOBACCO HEIGHTS

Avg. Rod Height:
 Seam and Paper Weight:
 Tipping Height:
 Weight / 100 Cigts.:

Special Instructions:

ON-LINE LASER MAY BE USED.

ADJUST TIPPING TO MAINTAIN VENT.

576100895

PRIMARY PROCESSING REPORT

OPERATION #: TEMP264 (D) DESCRIPTION: 20% Y1 SAMPLE

BLEND NUMBER:	XLF-912S	DATE DRIED:	00/00/00
FLUE CURED CASING:	XCF-2178	% OF TARGET APPLIED:	
2ND FLUE CURED CASING:		% OF TARGET APPLIED:	
BURLEY CASING:	XCF-2175	% OF TARGET APPLIED:	
BURLEY TOP DRESSING:	XCF-2080	% OF TARGET APPLIED:	
2ND BURLEY TOP DRESSING:		% OF TARGET APPLIED:	

STEAM FLUE CURED AFTER CASING TO:	135	DEGREES (F)
STEAM BURLEY AFTER CASING TO:	160	DEGREES (F)
STEAM BURLEY AFTER TOP DRESSING TO:	135	DEGREES (F)

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LOCATION                                     % MOISTURE
                                     TARGET    ACTUAL    S.D.
FLUE CURED EXIT CONDITIONING            15.00
    FLUE CURED EXIT CASING              21.00
BURLEY EXIT CONDITIONING                15.00
    BURLEY EXIT CASING                  30.00
    BURLEY COOLING SECTION              6.00
    BURLEY EXIT REDRYER                 16.00
BURLEY EXIT TOP DRESSING                21.00
    EXIT CUTTER                         21.00
    IN CIGARETTE                        14.50
    EXIT DRYER                          13.50
    
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% HUMECTANTS (EXIT DRYER)
    
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	PROPYLENE GLYCOL	GLYCERIN
THEORETICAL	1.50	2.20
ACTUAL		
% OF THEORETICAL		

APPROVED BY: _____

DATE: 06/23/89

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PRIMARY PROCESSING REPORT

OPERATION #: TEMP265 (D) DESCRIPTION: 20% Y1 ULTRA

BLEND NUMBER: XLF-912N DATE DRIED: 00/00/00
 FLUE CURED CASING: XCF-2172 % OF TARGET APPLIED:
 2ND FLUE CURED CASING: % OF TARGET APPLIED:
 BURLEY CASING: XCF-2175 % OF TARGET APPLIED:
 BURLEY TOP DRESSING: XCF-2174 % OF TARGET APPLIED:
 2ND BURLEY TOP DRESSING: % OF TARGET APPLIED:

STEAM FLUE CURED AFTER CASING TO: 135 DEGREES (F)
 STEAM BURLEY AFTER CASING TO: 160 DEGREES (F)
 STEAM BURLEY AFTER TOP DRESSING TO: 135 DEGREES (F)

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LOCATION	% MOISTURE		
	TARGET	ACTUAL	S.D.
FLUE CURED EXIT CONDITIONING	15.00		
FLUE CURED EXIT CASING	21.00		
BURLEY EXIT CONDITIONING	15.00		
BURLEY EXIT CASING	30.00		
BURLEY COOLING SECTION	6.00		5.85 MAX
BURLEY EXIT REDRYER	16.00		
BURLEY EXIT TOP DRESSING	21.00		
EXIT CUTTER	21.00		
IN CIGARETTE	14.50		
EXIT DRYER	13.50		

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% HUMECTANTS (EXIT DRYER)

	PROPYLENE GLYCOL	GLYCERIN
THEORETICAL	1.34	2.20
ACTUAL		
% OF THEORETICAL		

APPROVED BY: _____

DATE: 06/23/89

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