



E3

BROWN & WILLIAMSON TOBACCO CORPORATIONSTANDARD INSPECTION PROCEDURE

TITLE: INTERLABORATORY CROSS-CHECK - CIGARETTE VENTILATION & CIRCUMFERENCE GAUGES

DEPARTMENT: DEVELOPMENT CENTER - QUALITY ASSURANCE

BRANCH: DEVELOPMENT CENTER

SAMPLE PREPARATION PROCEDURE:

1. Cigarette ventilation and circumference cross-checks are conducted between Development Center, Technical Center, and Macon Branch. Cross-checks are done to standardize Filtrona Ventilation Meters and Circumference Gauges situated at each facility. The cigarettes used in the cross-checks are produced in Development Center. Usually two production runs a year are enough to provide all the cigarettes required to do the checks. During production, both ventilation and circumference are tightly controlled. After manufacture, the cigarettes are randomized before and after packaging to insure that each participant uses cigarettes from the same population. The cigarettes are kept in Technical Center and are distributed to the participants. Development Center's Quality Assurance Laboratory will issue the cigarettes each day.

TESTING PROCEDURE:

1. Each morning, the Filtrona Circumference Gauge and Ventilation Meter will be calibrated using designated standards for each.
2. After calibration each day, 25 of the cigarettes mentioned in Item 1 under Sample Preparation Procedure will be measured in the Filtrona Circumference Gauge. This same group of 25 will be measured in Filtrona Ventilation Meter. The cigarettes are discarded, and a new group is used the following day.
3. The data generated under Item 2 will be recorded on a Cross-Check Sheet. A copy of the Cross-Check Sheet is attached.
4. The Cross-Check Sheet is sent to Technical Center and the data is compared to that generated in Technical Center and Macon Branch.
5. The results are compiled on a data sheet by Technical Services, and a copy is sent to Development Center. A copy of the Data Sheet is attached.

0490M/(5/20/89)
Attachments

623085522

TO: Mr. J. F. Hall
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FROM: C. Owens

Listed below are current statistics by method for each laboratory for the week beginning 4/9/83 and ending 4/15/83. Problem areas are indicated by a (✓) in the columns with the heading "Difference Unacceptable".

Reference Sample = KCC 20, SERIES 24, PKSL6, BFV4

ANALYSIS	RESEARCH		MACON		DEVELOPMENT CENTER		WINSTON SALEM		Difference Unacceptable		
	X	S	X	S	X	S	X	S	R*	M* DC WS*	
Propylene Glycol (Cross-check Cig)	1.22	.02	1.29	.01	(1)	(1)	(1)	(1)			
Glycerin (Cross-check Cig)	1.93	.08	1.94	.03	(1)	(1)	(1)	(1)			
Propylene Glycol (20 mg solution)	19.87	.13	19.98	.12	(1)	(1)	(1)	(1)			
Glycerin (20 mg solution)	20.25	.57	19.82	.50	(1)	(1)	(1)	(1)			
Menthol	.59	.01	.61	.01	(1)	(1)	(1)	(1)			(✓)
Pressure Drop	(2)	(2)	6.5	.13	(1)	(1)	(1)	(1)			
Ventilation	(2)	(2)	35.1	.74	35.7	2.43	(1)	(1)			
Ends Stability	2.1	.32	2.9	.31	(1)	(1)	(1)	(1)			
Gross Weight	997	8.05	1003	6.05	(1)	(1)	(1)	(1)			
Non-Job. Weight	(1)	(1)	2.64	1.62	(1)	(1)	(1)	(1)			
Oven Moisture	15.43	.08	15.25	.10	15.44	.15	15.36	.41			
Circumference	(2)	(2)	24.96	.01	24.94	.03	(1)	(1)			
Coal Retention	55	2.18	(1)	(1)	(1)	(1)	(1)	(1)			
Cigarette Moisture	13.67	.06	13.59	.13	(1)	(1)	(1)	(1)			
Fill-Val. (as-is)	7.85	.03	7.78	.04	(1)	(1)	(1)	(1)			
Fill-Val. (corrected)	6.79	.17	6.78	.07	(1)	(1)	(1)	(1)			
Fill-Val. (moisture)	11.89	.25	11.82	.09	(1)	(1)	(1)	(1)			
Pack Leak Detector	75	5.80	(1)	(1)	75	14.62	(1)	(1)			
Menthol (10 mg solution)	10.05	.03	9.99	.05	(1)	(1)	(1)	(1)			

* R = Research M = Macon D.C. = Development Center WS = Winston-Salem

COMMENTS: (1) = Analysis not performed routinely.

(2) = NO DATA AVAILABLE

(3) = METHOD UNDER INVESTIGATION

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CROSS CHECK SHEET

VENTILATION (%)

1	_____
2	_____
3	_____
4	_____
5	_____
6	_____
7	_____
8	_____
9	_____
10	_____
11	_____
12	_____
13	_____
14	_____
15	_____
16	_____
17	_____
18	_____
19	_____
20	_____
21	_____
22	_____
23	_____
24	_____
25	_____

CIRCUMFERENCE (MM)

24.60	_____
24.65	_____
24.70	_____
24.75	_____
24.80	_____
24.85	_____
24.90	_____
24.95	_____
25.00	_____
25.05	_____
25.10	_____
25.15	_____
25.20	_____

FILTRONA-1 CIRCUMFERENCE (MM) FILTRONA-2

\bar{X} = _____
S. D. = _____
R = _____

\bar{X} = _____
S. D. = _____
R = _____

DATE: _____ TEMP. _____

SUPERVISOR: _____ R/HZ _____

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