



PHILIP MORRIS

U.S.A.

DIRECT MATERIAL SPECIFICATION

MATL. CODE:

Per Purchase Order

SUPERCEDES:

N/A

APPLICABLE G.S.:

10A

DESCRIPTION:

Ref. No. 8

Individual Specification for Cigarette Papers

Porosity Target: 5 Coresta

DATE

06/12/89

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APPROVED BY:

R. L. X. J. W.

REASON FOR CHANGE: TENTATIVE

PROPERTY		UNITS	MINIMUM	TARGET	MAXIMUM	PROCEDURE
Basis Weight	Critical	gms/m ²	46	50	54	PMP-040-81A
Caliper	Typical	0.001"		2.70		PMP-163-83C
Porosity	Critical	ml/min/CM ² @ 10cm Hg	4	5	6	PMP-179-90A
Tensile Strength	Critical	kg/cm width	0.080			PMP-161-83C
Elongation	Typical	percent	0.7			PMP-161-83C
Opacity	Critical	percent	75			PMP-060-85C
Filler CaCO ₃	Typical	percent	26.5	33.0	39.5	*
Edge Tear	Typical	kg	0.25			PMP-162-83B
Potassium Succinate	Critical	percent	3.5	4.5	5.5	GC Method
Monoammonium Phosphate (MAP)	Critical	percent	0.4	0.5	0.6	Colorimetry
Carboxymethyl Cellulose	Critical	percent	0.3	0.4	0.5	Calculation

NOTES:

Critical - Accept/reject criteria.

Typical - Monitored for trends. Could result in a rejection as a result of machinability problems.

Limits apply to averages of 10 samples tested at random from a pallet or strip cards representing a pallet for: basis weight, caliper, porosity, tensile, elongation, opacity, potassium succinate, monoammonium phosphate, and carboxymethyl cellulose.

To obtain valid test results, when samples are obtained from vendor sample cards, one strip will be selected from each of ten different sample card positions. If less than ten positions are available, each position will be sampled at least once and not more than twice per test.

Limits apply to averages of 10 samples tested at random from the lot for CaCO₃, and edge tear.

To obtain valid test results, samples must be conditioned/tested using TAPPI T402M.

Stated values are based on Philip Morris Richmond QA instruments.

* Determined by X-ray fluorescence. Procedure to be issued at a later date.

Material Code	Description	Approximate Bobbin Weight Pounds	Approximate Wet Pallet Weight Pounds
10-043A	19.5 X 4000	8.6	2579

- 1) Paper Width Tolerance: $\pm 0.25\text{mm}$
- 2) Core Width Tolerance: $\pm 0.25\text{mm}$
- 3) Inside Core Dimensions: 119.4 - 121.3mm
- 4) Maximum Bobbin Dimensions: 22.5 inches

File 0812A

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