

SUBJECT: CIGARETTE PAPER  
BOBBIN TO BOBBIN TEST

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PREVIOUS TESTING FOR SIGNIFICANT CIGARETTE PAPER RELATED FACTORS ON ROD BREAKS HAVE CONCENTRATED ON WIDER CIGARETTE PAPER AND WOOD PULP TO FLAX COMPARISONS ON A PALLET TO PALLET BASIS. OTHER FACTORS WERE CONSIDERED FIXED AND WERE NOT VARIED OR WERE NOT CHECKED DURING PREVIOUS TESTING. SUCH FACTORS INCLUDE BOBBIN TO BOBBIN DIFFERENCES IN BASE WEIGHT, WIDTH, CROSS-DIRECTIONAL TEAR STRENGTH, TENSILE STRENGTH, AND ADDITIVES OR SIZING; AND WITHIN BOBBIN DIFFERENCES FOR THE SAME CATEGORIES. THESE FACTORS HAVE TYPICALLY BEEN SET THROUGH CIGARETTE DESIGN AND VENDOR DISCUSSIONS AND ARE CHECKED AT SOME FREQUENCY BY THE VARIOUS VENDORS AND BY QC UPON RECEIPT OF MATERIALS. THE EFFECTS OF THESE FACTORS ON MACHINE EFFECIENCY, REJECTS, AND ROD BREAKS HAVE NOT BEEN EVALUATED.

THIS TEST WILL EVALUATE THE EFFECTS OF THE FOLLOWING FACTORS ON ROD BREAKS, PAPER BREAKS, AND AIR LEAKAGE REJECTS.:

VENDOR  
MACHINE > take out is pilot plant  
OPERATOR  
GRADE (WOOD PULP VS. FLAX)  
BASE WEIGHT  
CROSS-DIRECTIONAL TEAR STRENGTH  
TENSILE STRENGTH  
WIDTH  
BOBBIN  
SET

force issues:  
get extremes on  
all issues

USING THE ASSUMPTION THAT THE BOBBIN RUNNING ON A MACHINE IS THE SAME AS THE SISTER BOBBIN (THE BOBBIN NEXT TO) FROM THE SAME SET, DATA WILL BE COLLECTED ON EACH BOBBIN RUN ON A MACHINE. THE SISTER BOBBIN WILL BE MARKED AND SAVED FOR DESTRUCTIVE TESTING. COMPLEX, BRAND, AND OPERATOR WILL BE RECORDED BY THE TESTER. ROD BREAKS, PAPER BREAKS, AND AIR LEAKAGE REJECTS PER BOBBIN WILL BE COLLECTED FROM THE SRM BY THE TESTER. PAPER WIDTH WILL BE CHECKED BY THE TESTER USING CALIPERS BEFORE THE BOBBIN IS RUN ON THE MACHINE. GRADE, BOBBIN SET AND POSITION WILL BE RECORDED BY THE TESTER FROM THE BOBBIN LABEL AS THE BOBBIN IS PUT ON THE MACHINE. BASE WEIGHT, CD TEAR, AND TENSILE

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