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TOBACCO PROCESSING TEST

TEST NO. TPD 975

TEST NO. TPD 976

TEST NO. TPD 977

TEST NO. TPD 978

Date: 6-8-92

Subject: Diet at Varied Filling Capacities

Requestor: Steve Jakob

Summary: A previous test at 890 filling capacity (TPD 972) experienced problems with loose ends at the maker in the Pilot Plant. As a result, these products are being evaluated from Diet production through making in the Pilot Plant. Yields will be tracked through Diet production and making. Machinability and loose ends will be tracked through making, and effective filling capacity will be determined by PT&D. Products inventoried in cans and boxes will be tested for moisture retention, sugar change and aroma change. Diet process data will be reviewed by Scientific Affairs for possible substitution of one or two of these items into the toxicological evaluation of Diet.

Procedure: Infeed

- Use ICF-23 (standard Diet blend)
- 20% infeed moisture
- 20,000 lbs for each TPD test - keep each separated

Tobacco Expansion

Each test will start up at the following conditions and be adjusted as necessary to produce the target filling capacities:

	TPD <u>975</u>	TPD <u>976</u>	TPD <u>977</u>	TPD <u>978</u>
Filling Capacity Target -	780	815	850	890
Feedrate (lb/hr) -	5000	6000	6000	6000
Sublimator Temp. -	700°	750°	850°F	860°F
Sublimator Steam (lb/hr) -	5000	3000	3000	3000
Differential Pressure -	88	88	88	88
Static Pressure -	-2 (±2)	-2 (±2)	-2 (±2)	-2 (±2)
Stator Bars -	1/2	1/2	1/2	1/2
CO ₂ Gas Injection -	On	On	On	On
Outlet A.L. Spray -	Off	100	200	300
(No. of Nozzles)	(0)	(2-centers)	2-centers)	(4)
Re-order - Z1	100	100	100	100
Z2	250	250	275	300
Z3	400	400	400	425

Keep all product from each test in the same bulker. Put the start-up product in one end and switch to the other end of the bulker when the filling capacity has been adjusted to target.

Control Room Operator - take "Process Summary" prints every 5 minutes; hot end sublimator (OV3, DG1), cold end (OV2), OV3/DG1 and OV3 DG2 every 15 minutes, or whenever a change is made.

Keep each TPD test completely separated through the process. Record infeed pounds and finished product pounds for each test. Let the product completely clear the sublimator before starting the next test.

- Testing:**
- QA - do normal QA testing - raw and corrected filling capacity and fines, and test moistures in boxes before going to Cold Storage, and can moisture or those cans going to 611-16. Sample infeed (bag - mark date and time).
 - Head Space Analysis - Dinah Myers and Bill Coleman (R&D Analytical) will sample the product during production - after sublimator, before re-order, and after re-order.
 - Moisture Retention/Sugar Analysis/Headspace Analysis - product from each test will be stored at 120 Shed (8 cans), Cold Storage (8 boxes) and the R&D Pilot Plant, 611-16 (4 cans). Samples will be pulled for each of these tests each day the first week, every other day the second week, twice a week for the third and fourth weeks, and once a week for the remaining fifth through eight weeks (for a total of 2 months testing).

Disposition

of Product: From Each test:

- (1) Ship 8 cans (2000 lbs) to 611-4 Dock 1,
Attn: Steve Jakob
- (2) Ship 4 cans (1000 lbs) to 611-16 Dock 1,
Attn: Sara Devine
- (3) Ship 8 cans (2000 lbs) to 120 Shed and segregate from other inventory.
Attn: Sara Devine
- (4) Ship 8 boxes to Cold Storage
(T'ville export boxes - 4 boxes with liners, 4 boxes without)
Attn: Sara Devine

(Each can or box should be labeled with its TPD Number, Manufacture Date, Weight, and to whom it is sent to attention; label boxes as "lined" or "unlined".)

Balance of product is to be used as usual for Diet blend-off into G-13.

Date: These tests will be run on 6/10 and 6/11 on the day and evening shifts. TPD 976 and 977 will be run on 6/10; TPD 975 and 978 on 6/11. Ship TPD 976 ASAP to 611-4 (by 3:30, 6/10), Attn: S. Jakob; ship remaining tests to 611-4 by 3:30 6/12.

If anyone has any questions or sees any problems regarding this plan, please let me know right away.

Thanks.



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Tobacco Process Engineering

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