



June 25, 1987

Mr. J. Kahima
Suomen Tupakka Oy
P. O. Box 118
00211 Helsinki 21
Finland

Dear Juha:

Enclosed are new General Specification pages 1 thru 4 for NORTH STATE (BLUE) RS FT.

Also enclosed is a new contents page No. 1 for Volume 1 and Volume 2 of your copies of the B&W Products Specification books.

Please replace the corresponding contents pages in your books with these new ones and add these new specifications as indicated.

With kind regards,

Yours sincerely,

P. H. Harper

PHH/cw/907

0215x

Enclosures

cc: Dr. P. L. Aulbach

620420748

SUOMEN TUUPAKKA OY

GENERAL SPECIFICATIONS

Brand: NORTH STATE(BLUE) Country: FINLAND Company: SUOMEN TUUPAKKA OY
 Style: RS FT 9C 2075 Market: FIN
 STY Code: 113

CIGARETTE MARKING

Physical Characteristics

Weights

Overall Rod Length	70 mm	Total Cigarette Weight	646 mg
Tobacco Rod Length	57 mm	Cigarettes/oz.	33.50
Filter Plug Length	13 mm	Cigarette Rod Weight	7.1 mg
Filter Plug Pressure Drop (uncomp.)	N/A mmHg	Cigarette Rod/oz.	39.34
Filter Plug Pressure Drop (comp.)	55 mmHg	Net Net Tobacco	682 mg
Cigarette Circumference	25.9 mm	Tobacco Rod Density	224 mg/ccg
Cigarette Volume	3.737 cm ³		
Total Pressure Drop (uncomp.)	N/A mmHg		
Total Pressure Drop (comp.)	96 mmHg		
Cigarette Rod Pressure Drop	43 mmHg		
Tipping Length	17 mm		
Print Position (from filter end)	20 mm	DPM	9 mg/cig.
Moisture Content (extract)	14.2 %	Nicotine	0.7 mg/cig.
Filter Ventilation Rate	47 %	CO	7 mg/cig.
Menthol Content	N/A		

Tipping and Tipping Application

Tipping Paper:

Adhesive:

Supplier(s)	Tampaper	Type	Polyvinyl SB5
Type	TP 444 F PE B4/215/4	Supplier(s)	Lindex
STDY Code		STDY Code	1103
Color	Cork		
Formation Type	EP		
Number of Lines/Holes	N/A	Application Pattern:	
Position of Holes from Filter End	9 mm	Overall	X
Porosity	936	Other	
Print Description	N/A	Ship	
Bottom Width	34 mm		
Width/Cigarette	28.75 mm		
Bottom Length	3000 mm		
Substance	35 g/m ²	Blue Free Area:	
Seal Width	2.85 mm	Dimension	6 mm
Over-Tipping Length	4 mm	Positioning from Mouth End	X
Usage/Filter	4.8 bobins		

(Indicate N/A if not applicable)

Prepared by: J.KAHIM

Date: 30.03.1997/JK

620420749

SUOMEN TUPAKKA OY

GENERAL SPECIFICATIONS

Brand: NORTH STATE(BLUE) Country: FINLAND
 Styles: RG FT 50 20's Company: SUOMEN TUPAKKA OY
 Market: FCB STDY Code: 113

CIGARETTE MAKING - Cont'd

Cigarette Papers:

Supplier Tervahoski
 Supplier Code Tercig O 8.5 VM
 STDY Code
 Porosity 51 C.U.
 Bobbin Length 6000 mm
 Bobbin Width 28 mm
 Length/Big. 57 mm
 Additive 0.7% Citric Acid+0.06% Phosphate
 Substance 23.5 g/m²
 Usage/Million 9.5 bobbins

Adhesives:

Type Polyvin 3541
 Supplier Lindex
 STDY Code 1102
 Capacity
 Tensile Strength 2000 N/5
 Tearing Resistance 4N

Filters:

Total Rod Length 78 mm
 Circumference 25.7 mm
 Finished Weight/1000 Rods 621 g
 Circumference Grooved Area N/A
 Plasticizer: Tegda
 Type
 Additive:
 Type
 Tow Denier CAL 2,5 Y/36000 VC
 Supplier Courtaulds Acetate
 STDY Code 9803
 Filter Rod P.D., Encap. 330 mmWG
 Filter Rod P.D. After Grooving N/A mmWG
 Plug Wrap Type Porous
 Supplier Du Mauduit PPM 65
 STDY Code
 Plug Wrap Porosity 6500
 Bobbin Width 27.5 mm
 Substance 21 g/m²
 Anchor Line
 Anchor Line Adhesive BAT 124
 Seam Adhesive Crodacel 36 40500
 % of Rod Weight 0.4
 % of Tow Weight 10
 Plasticizer Weight 50.1 mg
 % of Tow Weight
 Tow Weight 500.7 mg
 Usage/Million 80.9 kg
 Filter Rod P.D., Unencap. N/A mmWG
 Usage/Million 0.5 bobbins
 Bobbin Length 5000 mm
 Seam Width 1.6 mm

Making Equipment:

Cigarette Maker Hauni Protos/BK 8
 Filter Attachment Hauni MAX 80/MAX V/II1
 Filter Rod Maker Hauni KDF2/AF2
 Other

Cigarette Die:

Die Description Brand Name
 Ink Type/Color North State Blue 66357
 Supplier(s) Roto
 STDY Code(s) 1101

(Indicate N/A if not applicable)

Prepared by: J.KAHJALA

Date: 30.03.1987/JK

620420750

SUOMEN TUPAKKA OY

PACKING DESCRIPTION

Brand: NORTH STATE(ELUE) Country: FINLAND
 Style: PS FT 30 20's Company: SUOMEN TUPAKKA OY
 Market: FIN STGY Code: 113

Type of Packing (Box, Soft Cup, Etc.) Soft Cup

Packaging Arrangement:

Configuration 7-6-7
 Cigarettes/Pack 20
 Packs/Carton 10
 Bundles, Carton/Case 50
 Other

Label:

Layout/Arbor No. Arbor No. 45
 Type of Label Material Kymecote Label
 Supplier Saipausseilan Kirjapaino
 STGY Code
 Board Substance 85 g/m²
 Type of Printing Offset
 Made-up Dimensions 94x160 mm
 Usage/Million Cig. 50000 pcs

Innerframe:

N/A

Color
 Type of Board
 Supplier
 STGY Code
 Board Substance g/m²
 Foil Substance g/m²
 Bobbin Width mm
 Cut-off Length mm
 Total Substance g/m²
 Usage/Million Cig. kg

Foil Issues:

Color Silver
 Supplier Enso
 STGY Code 8805
 Bobbin Width 88 mm
 Foil Substance 19 g/m²
 Paper Substance 35 g/m²
 Cut-off Length 195 mm
 Total Substance 56 g/m²
 Usage/Million Cig. 48.0 kg

20's Film:

Type P/P
 Supplier Wsiffi walsrode
 Supplier Code Wslothen 01 20
 STGY Code 8501
 Width 104 mm
 Cut-off Length 174 mm
 Substance 19.1 g/m²
 Usage/Million Cig. 17.3 kg

20's Tear-Tape:

Color Silver Hairline
 Type Cellophane MS 600
 Supplier Nathaniel Lloyd & Co Ltd.
 STGY Code 8409
 Bobbin Length 5500 mm
 Width 2.5 mm
 Cut-off Length 174 mm
 Type of Adhesion Wax 882
 Positioning from Top of Pack 7 mm
 Substance 60 g/m²
 Usage/Million Cig. 1.6 bobbins

200's Carton:

N/A

Layout
 Type of Board
 Supplier
 STGY Code
 Board Substance g/m²
 Type of Printing
 Made-up Dimensions mm
 Usage/Million Cig. pcs

(Indicate N/A if not applicable)

Prepared by: J.KAHIMA

Date: 25.03.1987/JK

620420751

SUOMEN TUPAKKA OY

PACKING DESCRIPTION

Brand: NORTH STATE(BLUE)
 Style: RS FT 30 20's

Country: FINLAND
 Company: SUOMEN TUPAKKA OY
 Market: FIN

STGY Code: 113

200's Wrapper:

Type P/P
 Supplier Mobil
 Supplier Code Bicolor 21MB621
 STGY Code B207
 Width 352 mm
 Cut-off Length 247 mm
 Substance 19.2 g/m²
 Usage/Million Cig. 8.3 kg

Barcode:

Type of Paper Kymexcote Label
 Supplier Salpausselän Kirjapaino
 STGY Code
 Dimensions 19x44 mm
 Positioning Top and Center
 Substance 60 g/m²
 Usage/Million Cig. 50000 pcs

Sealing Tape:

Color Transparent
 Type P/P
 Supplier Yhtyneet Paperitentaat
 Supplier Code 1215
 STGY Code 1105
 Width 50 mm

200's Tear-Tape:

Color Gold, printed
 Type Cellophane MS 630
 Supplier Wolff Walzrode
 STGY Code 843E
 Bobbin Length 8000 m
 Width 2 mm
 Cut-off Length 247 mm
 Positioning from edge of p 150 mm
 Substance 65 g/m²
 Usage/Million Cig. 0.2 bobbins

Case:

Type Corrugated Board 8201 Ap GEM
 Supplier Kotelenokia Oy
 STGY Code B198
 Made-up Dimensions 475x500x360 mm
 Usage/Million Cig. 100 pcs

Packing Equipment:

Packer Type Schmaund FES/ES
 Arbor No.
 Wrapper Schmaund FFK
 Parceller or Boxer Ayers-Grishaw ET-1, Schmaund HW
 Outer Wrapper N/A
 Other

(Indicate N/A if not applicable)

Prepared by: J. KAHINA

Date: 25.03.1987/JK

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BLEND: NSF/SR/PR/BUE

DATE: 25.03.1987\JK

SC GRADE	Quantity	%
10115 L1F	204	3.2
10125 T1F	204	3.2
10205 C1B*	200	3.1
10210 CH4	200	3.1
10315 BLAF2	200	3.2
10605 BKBT	400	6.2
10905 ZAF2	408	6.3
10910 ZCF2	408	6.3

2224 34.6

BU GRADE	Quantity	%
20115 B1B	191	3
20120 B2B	191	3
20505 M84S	190	2.9
20605 TB3X	200	3.1
20705 X83L	200	3.1
21100 ITB2B	400	6.2
21100 ZB1B	180	2.8

1552 24.1

DR GRADE	Quantity	%
31005 M1B	227	3.5
31015 YB	106	1.7
31020 Y4	248	3.8
31105 N111AGb	174	2.7
31110 K1/111	174	2.7

929 14.4

ST GRADE	Quantity	%
40105 RXS	306	4.8
40315 GZ	190	3
40620 TV	200	3.1
40925 ZR	408	6.2

1104 17.1

REC GRADE	Quantity	%
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ET GRADE	Quantity	%
71310 ETE-6	630	9.8

TOTAL 6439 100

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BLEND: NSF/SR/PR/BLUE 6439 KG DATE: 25.03.1987\JK

	VIRGINIA CASING:	Quantity	%
F/C+ORIENTAL+REC.	PROPYLENE GLYCOL	65	2.95
3153 KG			

	BURLEY CASING BEFORE CLO:	Quantity	%
BURLEY	PROPYLENE GLYCOL	42	2.8
1552 KG	SUGAR	42	2.8
	HUMIDOR	10	0.66

	BURLEY CASING AFTER CLO:	Quantity	%

ORIENTAL

325 KG

STEMS

1184 KG

EXPANDED

639 KG

CUTTINGS/INCH.: TOBACCO - 30 STEMS - 160

FLAVORS PER 100 KG TOBACCO

FLAVORS:	Quantity

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SUOMEN TUPAKKA OY

PROCESS SPECIFICATIONS

BLEND: NET/SR/FR/BUE

ITEM	INFORMATION	EQUIPMENT/ADDITIVE
FLUE CURED LEAF/STRIPS/ORIENTAL/RL	:	:
Precondition Method/Time	: One Cycle 30 min.	: C.T.C
Moisture Content IN/OUT	: 12% / 16%	:
Temperature IN/OUT Leaf	: 22C / 75C	:
Temperature IN/OUT Oriental	: 22C / 50C	:
Moisture Content After Casing	: 22%	: Legg Casing Cylinder,
	:	: 4 Schlick Sprays
BURLEY LEAF/STRIPS	:	:
Precondition Method/Time	: One Cycle 30 min.	: C.T.C
Moisture Content IN/OUT	: 12% / 16%	:
Temperature IN/OUT	: 22C / 65C	:
Casing Method	: Spray / Steam	: 4 Schlick Sprays
Moisture Content After Casing	: 22%	: Legg Casing Cylinder
Drying Chamber Temperatures	:	:
Moisture After Drying	:	:
Moisture Before Top Dressing	:	:
Moisture After Top Dressing	:	:
BLENDING: SEITAL (Method Used)	: Blending Bin	: Legg

Prepared by: J,KAH:MA

Date: 25.03.1987\JK

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SUOMEN TUOPAKKA OY

PROCESS SPECIFICATIONS

BLEND: NSF/SP/FR/BLE

ITEM	INFORMATION	EQUIPMENT/ADDITIVE
TOTAL STRIPS	:	:
Cutting Moisture	: 22%	: Hauni KTF1 2x2000 kg/h
Cutting Width	: 30"	:
Small Strip Bypass Details	: Screen 1.8 mm Before Cutting	: Legg Screen
Steam Tunnel Details:	:	:
Moisture Content	: 22% / 25%	: Hauni Steaming and Conditioning Tunnel
Temperature	: 22C / 80C	:
Dryer Air Temperature	:	: Hauni Drier XLK-H
Cooler Air Temperature	: 22C	: Dickinson I.T.M. Cooler
Tobacco Moisture ex Dryer	: 16.5%	:
Tobacco Moisture ex Cooler	: 15.0%	:
Tobacco Moisture ex Bin	: 14.7%	: Legg, Modified in STDY
Additional Smalls	: Max. 7%	:
Tobacco Temperature AFTER Top Flavor	: < 30C	: Flavour Spray Insc Pump Drive
Moisture Content AFTER Top Flavor	:	:
Minimum Storage Time Before CMB	: 12h	:
Storage Conditions R.H.	: 60% / 22C	:
Moisture Content at Making (Hopper)	:	:
STEM	:	:
-----	:	:
Preconditioning Method:	:	:
Tobacco Moisture After Wetting Tunnel	: 33%	: Hauni WD Conditioning Tunnel
Tobacco Moisture After Steaming Tunnel	: 34%	: Hauni WD Steaming Tunnel
Tobacco Temp. After Steaming Tunnel	: 87C	:
Moisture Content Pre-rolling	: 34%	: Legg Stem Flattener
Roller Gap	: 1.0 mm	:
Width of Cut	: 160 /"	: Legg Stem Cutter SSB
Expansion Process Used:	:	:
Moisture Content IN/OUT	: 34% / 50%	: Legg Super Conditioning Cylinder
Temperature IN/OUT	: 22C / 90C	:
Temperature AFTER Cooling	: 25C	: Tower Separator-Airlift
Moisture Content AFTER Dryer	: 16%	: Legg CO Current Dryer
Moisture Content AFTER Bin	: 14%	:
Add-Back Point	: Weighing Band Conveyor	: Before Cooler and Flavour

Prepared by: J.KAHIMA

Date: 25.03.1987\JK

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