

**PHILIP MORRIS**

U.S.A.

**DIRECT MATERIAL SPECIFICATION**

MAT'L CODE: 10-706A REF. No. 4

SUPERCEDES: ORIGINAL

APPLICABLE G.S.: 10A

DESCRIPTION: 27.25 X 67 / 46CU / 2.0% / 0  
Individual Specification for Flax Pulp Cigarette Papers

DATE: 01/07/91

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REASON FOR CHANGE: Increased bobbin meterage.

APPROVED BY: *JAY HOS P. IV.*

PROPERTY		UNITS	MINIMUM	TARGET	MAXIMUM	PROCEDURE
Basis Weight	Critical	gms/m <sup>2</sup>	23.4	25.2	27.0	PMP-040-81A
Caliper	Typical	0.001"		1.65		PMP-163-83C
Porosity	Critical	ml/min/CM <sup>2</sup> @ 10cm Wg	37	46	55	PMP-176-86A
Tensile Strength	Critical	kg/mm width	0.080			PMP-161-83C
Elongation	Typical	percent	0.7			PMP-161-83C
Opacity	Critical	percent	71			PMP-060-85C
Citrate	Critical	percent	1.50	2.00	2.50	PMP-168-83A
Filler CaCO <sub>3</sub>	Typical	percent	24.0	30.5	37.0	*
Edge Tear	Typical	kg	0.25			PMP-162-83B

**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, and opacity.
- 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 citrate, CaCO<sub>3</sub> 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.

**BOBBINS PER  
PALLET**

216

**APPROXIMATE BOBBIN  
WEIGHT - POUNDS**

10.09

**APPROXIMATE NET PALLET  
WEIGHT - POUNDS**

2189

2058268170