

Copy for Dr. Huslam - for information

P.O. BOX 6500.
MONTREAL, P.Q., CANADA

27 FEB 73

Mr. Paul Gannoway,
BAT Company Ltd.,
P.O. Box 482,
Westminster House,
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England.

February 23, 1973

Dear Paul,

With reference to your letter dated Feb. 13th, concerning information on the application of porous cork tipping, we would submit the following:

When tipping adhesive is applied to porous cork it does not completely block the porosity of the cork tipping. The amount which it does reduce the porosity is governed by the type of adhesive, its viscosity, and the thickness of the film which is applied. We are using an adhesive supplied by a Canadian firm, Industrial No. R0214 adhesive supplied with a viscosity of 2900 centipoises. Our Matinee K.S. cigarettes for example, with overall gluing of the tipping using this adhesive and a glue roller undercut of .0012" yield a TPM-Nic value of 14.4 mg. As this value was somewhat higher than our target of 12.5 mg we utilized a Hauni skip tipper on a Hauni Max 5 assembler equipped with a multiple rolling head to pattern the adhesive on the cork tipping so that we had a 3 1/2 mm unglued slot centered around the perforations. The Hauni skip tipper also applies glue to the lap, so that the lap is sealed across the perforated area. Under these conditions the TPM-Nic yield of the cigarette was reduced to our target of 12.5 mg.

From the above it can be seen that there are four criteria being used to control the tar delivery of a given tobacco column. The first is the porosity of the tipping itself, the second is the porosity of the plug wrap used to wrap the filter. The third is the adhesive which reduces but does not eliminate the porosity of the tipping while the fourth is the size of the unglued slot which is used to tailor the tar yields to the exact figure desired.

I trust that the above will prove helpful.

With kind regards,

Yours sincerely,

S.M. Candlish
S.M. Candlish

SMC/cr

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