

SRI LANKA STANDARD 471:1979
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SPECIFICATION FOR
CIGARS

BUREAU OF CEYLON STANDARDS

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SLS 471 : 1979

Gr. 4

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Sri Lanka Standards are subject to periodical revision in order to accommodate the progress made by industry. Suggestions for improvement will be recorded and brought to the notice of the Committees to which the revisions are entrusted.

This Standard does not purport to include all the necessary provisions of [REDACTED]

SRI LANKA STANDARD

SPECIFICATION FOR CIGARS

FOREWORD

This Sri Lanka Standard was authorised for adoption and publication by the Council of the Bureau of Ceylon Standards on 1979-12-21 after the draft, finalised by the Drafting Committee on Tobacco and Tobacco Products, had been approved by the Agricultural and Chemicals Divisional Committee.

In Sri Lanka, two distinct types of cigars are manufactured; the dry and the wet cigar. The method of manufacture for these two types differ. The wet cigar which is smoked and to a certain extent chewed is used mostly by the older generation. The wet cigar is gradually going out of vogue and as such requirements for it are not prescribed in the specification.

Different brands of dry cigars are manufactured in this country varying in cost, which is dependent upon the leaf tobacco used, the processing employed, their size and finish. The broad objective of this specification is to lay down minimum requirements so that the consumer will be able to purchase a quality product free from harmful foreign matter and also to facilitate, if possible export of this product.

In Sri Lanka the word 'cheroot' is not used although the finish would enable it to be called a 'cheroot' in the universally accepted terminology. The cigar and the cheroot will differ only in the finish. Both terms are defined in the specification so that the cigar will be referred to as a cheroot only if it has the appropriate finish. This specification identifies the cigar and the cheroot as one as far as all the requirements except the finish are concerned.

All standard values given in this specification are in SI units.

For the purpose of deciding whether a particular requirement of this specification is complied with, the final value, observed or calculated, expressing the result of a test or analysis shall be rounded off in accordance with CS 102. The number of significant places retained in the rounded off value should be the same as that of the specified value in this specification.

In the preparation of this specification, valuable assistance derived from the publications of the Indian Standards Institution is gratefully acknowledged.

1 SCOPE

1.1 This specification prescribes the requirements, methods of test and sampling for dry cigars.

1.2 It does not cover the requirements for flavour and aroma of dry cigars.

2 REFERENCES

CS 102 Presentation of numerical values.

SLS 309 Part 1 Test methods for tobacco in tobacco products.

SLS 428 Random sampling methods.

3 DEFINITIONS

For the purpose of this specification the following definitions shall apply:

3.1 cigar: A cigar shall be closed at one end and open at the other or both ends may be kept opened.

3.2 cheroot: A cheroot shall have both ends opened and may be either conical or cylindrical.

NOTE - Cheroot is a particular kind of cigar.

4 REQUIREMENTS

4.1 Description

Cigars shall be made of filler tobacco forming its central core, the binder tobacco binding the filler and holding it into shape, and the wrapper tobacco wrapped on the outside of cigars. A harmless adhesive shall be used to stick the wrapper in position. As far as practicable, patches shall be avoided in wrapping the cigars. However, where necessary, the patch used shall be of the same colour as the wrapper. Cigars shall be closed at one end and open at the other or both the ends may be kept open.

4.2 Length

The length of cigars shall be between 65 mm and 175 mm.

4.2.1 The length shall be measured to the nearest millimetre.

4.3 Mass

A cigar shall weigh between 1.5 g and 11.0 g.

4.3.1 The mass of a cigar shall be determined to the nearest 0.1 g.

4.4 Freedom from mould attack

Cigars shall be free from any mould attack when examined by the method prescribed in Clause 5 of SLS 309 : 1974.

4.5 Freedom from tobacco beetle attack

Cigars shall be free from any tobacco beetle attack when examined by the method prescribed in Appendix A.

4.6 Harmful additives

Cigars shall not contain any additives injurious to health as covered by the Food and Drugs regulations. Any added substances shall be of a nature and purity which are suitable for use as food additive or for use in medicinal or pharmaceutical products in proportions of proved harmless character.

4.7 Burning quality

Cigars shall burn evenly and without causing any irritation to the throat when tested by the method prescribed in Appendix B. Chemical agents considered injurious to health shall not be used for obtaining a better burn of cigars.

4.8 Filler tobacco

The filler tobacco used in the manufacture of cigars shall consist of air-cured tobacco, sweated or non-sweated.

4.9 Chemical requirements

All tobacco used shall also conform to the chemical requirements specified in Table 1 when tested by the relevant methods indicated in Column 4 of Table 1.

TABLE 1 Chemical requirements for cigars

(1) Sl. No.	(2) Characteristic	(3) Limits	(4) Method of test (Ref. to Clause of SLS 309:1974)
1	Loss on heating, per cent by mass	11.0 to 15.0	4
2	Nicotine (on dry basis), per cent by mass, max.	3.0	6
3	Total ash (on dry basis), per cent by mass, max.	25.0	8
4	Acid insoluble ash (on dry basis), per cent by mass, max.	5.0	9
5	Total chloride (on dry basis), per cent by mass, max.	1.5	10

5 SORTING

After manufacture, cigars shall be graded according to the colour of the wrapper and cigars of uniform colour shall be packed in one packet.

6 PACKAGING AND MARKING

6.1 Packaging

Cigars shall be packed in packets of 5, 10, 25, 50 or 100. Each such packet shall consist of a wooden, tin or cardboard box opening only at the top; or of a paper wrapper completely closed on all sides and with all other edges gummed down; or as agreed to between the purchaser and the vendor. Each cigar shall be made identifiable to its trade brand or manufacturer by means of a special ring label. The packets shall be packed in a bulk container as agreed to between the purchaser and the vendor.

6.2 Marking

The following particulars shall be marked on the side of each packet:

- a) Description of contents,
- b) Name and address of the factory,
- c) Brand or brand code,
- d) Number of cigars,
- e) Date of manufacture or date code,
- f) Colour of the wrapper,
- g) The words 'Produce of Sri Lanka'.

7 TESTS

7.1 Tests shall be carried out as prescribed in 4.2.1, 4.3.1, 4.4, 4.5, 4.7 and Column 4 of Table 1.

7.2 Unless specified otherwise, pure chemicals and distilled water shall be employed in tests.

NOTE - 'Pure chemicals' shall mean chemicals that do not contain impurities which affect the results of tests.

8 SAMPLING

Representative samples of cigars shall be drawn as prescribed in Appendix C for testing conformity to this specification, before or at the time of delivery by the vendor.

9 CRITERIA FOR CONFORMITY

9.1 The lot shall be considered as conforming to this specification if the conditions specified in 9.2 to 9.5 are satisfied.

9.2 Each of the test results for length and mass as determined in accordance with C.4.1 satisfies the corresponding requirements specified in 4.2 and 4.3. All cigars in the composite sample shall satisfy the description given in 4.1.

9.3 All cigars tested under C.4.2 shall satisfy the burning quality requirement specified in 4.7.

9.4 Each of the test results on individual samples for loss on heating and nicotine shall satisfy the corresponding requirements specified in Table 1. If however, one or more of the test results do not satisfy the respective requirements, the conformity of the lot to these two characteristics shall be ascertained in accordance with 9.4.1.

9.4.1 The mean and the range of the corresponding test results shall be calculated as follows:

$$\text{Mean } (\bar{X}) = \frac{\text{Sum of the results}}{\text{Number of the test results}}$$

Range (R) = Difference between the maximum and the minimum of the test results.

The appropriate expressions as shown in Column 6 of Table 2 shall be calculated. If the values of these expressions satisfy the relevant condition as given in Column 6 of Table 2, the lot shall be deemed to have satisfied the requirements for loss on heating and nicotine.

9.5 The test results on the composite sample for freedom from mould attack, freedom from tobacco betel attack, total ash, total insoluble ash, and total chloride shall satisfy the corresponding requirements specified respectively in 4.4, 4.5 and Table 1.

APPENDIX A

(See 4.5)

EXAMINATION FOR FREEDOM FROM TOBACCO BEETLE ATTACK

A.1 PROCEDURE

A.1.1 Take 5 cigars and visually examine the surface of each for the presence of any penetration by tobacco beetles. Cut open these cigars one by one on a clean white sheet of paper.

A.1.2 Examine the cut material carefully for the presence of *Lasioderma serricornis* (tobacco beetle) in all its

TABLE 2 Criteria for conformity for loss on heating and nicotine

Sl No.	Characteristic	Test results 1, 2, 3,	Average	Range	Criterion for conformity
(1)	(2)	(3)	(4)	(5)	(6)
1	Loss on heating	-	\bar{X}_1	R_1	$\bar{X}_1 + 0.4 R_1$ shall lie between 11.0 and 15.0
2	Nicotine	-	\bar{X}_2	R_2	$\bar{X}_2 + 0.4 R_2 \leq 3.0$

stages, that is, egg, larval, pupal and alive or dead adult, either visually or with the help of a hand lens (magnification x 10).

APPENDIX B

(See 4.7)

TEST FOR BURNING QUALITY

B.1 PROCEDURE

Light the cigar thoroughly by puffing for a few minutes. The cigar should burn continuously and evenly if puffed for 10 seconds after every 50 seconds interval.

B.2 REPORT

The cigar shall be deemed to have satisfied the test for burning quality if it burns continuously throughout its length and also causes no irritation to the throat.

APPENDIX C

(See 8)

SAMPLING OF CIGARS

C.1 GENERAL REQUIREMENTS FOR SAMPLING

C.1.1 In drawing, preparing, storing and handling samples the following precautions and directions shall be observed.

C.1.2 Precautions shall be taken to draw the samples so as to protect the samples, the material being sampled

and the receptacles for samples from loss or gain of moisture and from adventitious contamination.

C.1.3 The samples shall be placed in clean and dry receptacles. The sample receptacle shall be sealed air-tight after filling and marked with full details of sampling, date of manufacture, name of the manufacturer and other important particulars of the consignment.

C.2 SCALE OF SAMPLING

C.2.1 All the packets containing an equal number of cigars in a single consignment of the material pertaining to the same brand shall constitute a lot.

C.2.2 Samples shall be tested from each lot for ascertaining the conformity of cigars to the requirements of this specification.

C.2.3 The number of packets to be selected from a lot shall depend on the size of the lot and also on the contents of the packet and shall be in accordance with Columns 1 and 2 or 3 of Table 3.

C.2.4 The packets and cigars shall be drawn at random. For this purpose, random number tables given in SLS 428 shall be used.

C.3 PREPARATION OF SAMPLES

C.3.1 Composite sample

From each of the packets selected as in C.2.3, an equal number of cigars as far as possible shall be drawn to form a composite sample containing a minimum of 30 cigars and a maximum of 50 cigars.

TABLE 3 Selection of sample

(1) Lot size	(2) If a packet contains 5 or 10 cigars, No. of packets to be selected	(3) If a packet contains 25, 50 or 100 cigars, No. of packets to be selected
Up to 150	15	3
151 to 300	20	4
301 to 500	25	5
501 to 1000	35	7
1001 and above	50	10

C.3.2 Individual sample

After drawing the composite sample as indicated in C.3.1, individual sample containing approximately 25 g of tobacco shall be drawn according to either C.3.2.1 or C.3.2.2.

C.3.2.1 If the packets contain 25, 50 or 100 cigars, each packet of the sample shall be considered as an individual sample.

C.3.2.2 If the packet contains 5 or 10 cigars, packets of the sample shall be grouped to form sets in such a way that each set contains three packets. Such a set shall be considered as an individual sample.

C.4 TESTING OF SAMPLES

C.4.1 Tests for determination of length and mass and also description shall be conducted on each of the cigars in the composite sample.

C.4.2 Test for burning quality shall be conducted on 5 cigars drawn randomly from the composite sample.

C.4.3 Test for determination on loss on heating, nicotine shall be conducted on each of the individual samples.

C.4.4 Test for freedom from tobacco betel attack, freedom from mould attack, total ash, total insoluble ash and total chloride shall be conducted on the composite sample remaining after testing for burning quality.

SLS CERTIFICATION MARK

The Sri Lanka Standards Institution is the owner of the registered certification mark shown below. Beneath the mark, the number of the Sri Lanka Standard relevant to the product is indicated. This mark may be used only by those who have obtained permits under the SLS certification marks scheme. The presence of this mark on or in relation to a product conveys the assurance that they have been produced to comply with the requirements of the relevant Sri Lanka Standard under a well designed system of quality control inspection and testing operated by the manufacturer and supervised by the SLSI which includes surveillance inspection of the factory, testing of both factory and market samples.

Further particulars of the terms and conditions of the permit may be obtained from the Sri Lanka Standards Institution, 17, Victoria Place, Elvitigala Mawatha, Colombo 08.



SRI LANKA STANDARDS INSTITUTION

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The principal objects of the Institution as set out in the Act are to prepare standards and promote their adoption, to provide facilities for examination and testing of products, to operate a Certification Marks Scheme, to certify the quality of products meant for local consumption or exports and to promote standardization and quality control by educational, consultancy and research activity.

The Institution is financed by Government grants, and by the income from the sale of its publications and other services offered for Industry and Business Sector. Financial and administrative control is vested in a Council appointed in accordance with the provisions of the Act.

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All members of the Technical and Sectoral Committees render their services in an honorary capacity. In this process the Institution endeavours to ensure adequate representation of all view points.

In the International field the Institution represents Sri Lanka in the International Organization for Standardization (ISO), and participates in such fields of standardization as are of special interest to Sri Lanka.