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**Routine analytical cigarette-smoking  
machine — Definitions and standard  
conditions**

*Machine à fumer analytique de routine pour cigarettes — Définitions et  
conditions normalisées*

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## Contents

Page

Foreword.....	iv
Introduction.....	v
1 Scope .....	1
2 Normative reference .....	1
3 Terms and definitions .....	1
4 Standard conditions .....	4
4.1 Machine pressure drop (see 3.5).....	4
4.2 Puff duration (see 3.7) .....	4
4.3 Puff volume (see 3.8) .....	4
4.4 Puff frequency (see 3.10) .....	4
4.5 Puff profile (see 3.12).....	4
4.6 Restricted smoking (see 3.3) .....	4
4.7 Puff number (see 3.9) .....	4
4.8 Cigarette holder (see 3.14) .....	4
4.9 Cigarette position (see 3.19).....	6
4.10 Ashtray position (see 3.22) .....	6
5 Specification for the routine analytical smoking machine.....	6
5.1 General.....	6
5.2 Operating principle and puff profile.....	6
5.3 Reliability and compensation .....	7
5.4 Cigarette holders and smoke traps.....	8
5.5 Test atmosphere .....	9
5.6 Puff counting.....	9
5.7 Ignition .....	9
5.8 Smoking enclosure.....	9
Annex A (normative) Ambient air flow around cigarettes in routine analytical smoking machines: Control and monitoring.....	11
Annex B (informative) Description of the puffing mechanism of a piston-type smoking machine.....	18
Annex C (informative) Diagrammatic representation of a puff profile.....	21
Bibliography .....	23

## Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

International Standards are drafted in accordance with the rules given in the ISO/IEC Directives, Part 3.

Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

Attention is drawn to the possibility that some of the elements of this International Standard may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights.

International Standard ISO 3308 was prepared by Technical Committee ISO/TC 126, *Tobacco and tobacco products*.

This fourth edition cancels and replaces the third edition (ISO 3308:1991), which has been editorially revised.

Annex A forms a normative part of this International Standard. Annexes B and C are for information only.

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## Introduction

This International Standard describes the requirements found necessary to be specified in the light of knowledge and experience gained with analytical cigarette-smoking machines.

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# Routine analytical cigarette-smoking machine — Definitions and standard conditions

## 1 Scope

This International Standard

- defines smoking parameters and specifies the standard conditions to be provided for the routine analytical machine smoking of cigarettes;
- specifies the requirements for a routine analytical smoking machine complying with the standard conditions.

Annex A specifies the ambient air velocities surrounding cigarettes in a routine analytical smoking machine, the mechanical design of the enclosures immediately surrounding them, and the methods of air velocity measurement including the location where air velocity is measured.

Annex B describes, as an example, the special characteristics of a typical smoking machine incorporating a piston type of puffing mechanism.

Annex C includes a diagram of a puff profile and illustrates definitions and standard conditions.

## 2 Normative reference

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The following normative document contains provisions which, through reference in this text, constitute provisions of this International Standard. For dated references, subsequent amendments to, or revisions of, this publication do not apply. However, parties to agreements based on this International Standard are encouraged to investigate the possibility of applying the most recent edition of the normative document indicated below. For undated references, the latest edition of the normative document referred to applies. Members of ISO and IEC maintain registers of currently valid International Standards.

ISO 3402, *Tobacco and tobacco products — Atmosphere for conditioning and testing*.

## 3 Terms and definitions

For the purposes of this International Standard, the following terms and definitions apply.

### 3.1

#### test atmosphere

atmosphere to which a sample or test piece is exposed throughout the test

NOTE 1 It is characterized by specified values for one or more of the following parameters: temperature, relative humidity and pressure, which are kept within the specified tolerances.

NOTE 2 The test may be carried out either in the laboratory or in a special chamber termed the "test chamber", or in the conditioning chamber, the choice depending on the nature of the test piece and on the test itself. For example, close control of the test atmosphere may not be necessary if the change in properties of the test piece is insignificant over the test period.

NOTE 3 Adapted from ISO 558:1980, definition 2.3.

**3.2**

**butt length**

length of unburnt cigarette remaining at the moment when the smoking is stopped

**3.3**

**restricted smoking**

condition that exists when the butt end of a cigarette is closed to the atmosphere between successive puffs

**3.4**

**free smoking**

condition that exists when the butt end of a cigarette is completely exposed to the atmosphere between successive puffs

**3.5**

**pressure drop**

static pressure difference between the two ends of

— the test piece completely encapsulated in a measuring device such that no air can pass through the outer membrane (or wrapping); or

— a pneumatic circuit when it is traversed by an air flow under steady conditions in which the measured volumetric flow, under standard conditions, at the output end is 17,5 ml/s

**3.6**

**draw resistance**

negative pressure which has to be applied to the butt end, under test conditions (see ISO 3402) in order to sustain a volumetric flow of 17,5 ml/s, exiting at the butt end, when the cigarette is encapsulated in a measurement device to a depth of 9 mm

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NOTE 1 Any ventilation zones and the tobacco rod are exposed to the atmosphere.

NOTE 2 Measurement values are expressed in pascals (Pa). They used to be expressed in millimetres water gauge (mm WG). The values given previously in mm WG are converted into pascals using the following conversion factor: 1 mm WG = 9,8067 Pa.

NOTE 3 The concept of draw resistance may also be subjectively judged when a cigarette is smoked by a consumer/taste panel. Under such circumstances, draw resistance is not measured objectively because the conditions of the formal definition are not met.

**3.7**

**puff duration**

interval of time during which the port is connected to the suction mechanism

**3.8**

**puff volume**

volume leaving the butt end of a cigarette and passing through the smoke trap

**3.9**

**puff number**

number of puffs necessary to smoke a cigarette to a specified butt length

**3.10**

**puff frequency**

number of puffs in a given time

**3.11**

**puff termination**

termination of the connection of the port to the suction mechanism



**3.12****puff profile**

flow rate measured directly behind the butt end of a cigarette and depicted graphically as a function of time

**3.13****dead volume**

volume which exists between the butt end of a cigarette and the suction mechanism

**3.14****cigarette holder**

device for holding the mouth end of a cigarette during smoking

**3.15****smoke trap**

device for collecting such part of the smoke from a sample of cigarettes as is necessary for the determination of specified smoke components

**3.16****port**

aperture of the suction mechanism through which a puff is drawn and to which is attached a smoke trap

**3.17****channel**

element of a smoking machine consisting of one or more cigarette holders, one trap and a means of drawing a puff through the trap

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**3.18****compensation**

ability to maintain constant puff volumes and puff profiles when the pressure drop at the port changes

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**3.19****cigarette position**

position of a cigarette on the smoking machine

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NOTE In particular, it is determined by the angle made by the longitudinal axis of the cigarette and the horizontal plane when a cigarette is inserted into a cigarette holder in an analytical smoking machine.

**3.20****mainstream smoke**

all smoke which leaves the butt end of a cigarette during the smoking process

**3.21****sidestream smoke**

all smoke which leaves a cigarette during the smoking process other than from the butt end

**3.22****ashtray**

device positioned under the cigarettes in their holders to collect ash falling from the cigarettes during smoking

**3.23****clearing puff**

any puff taken after the cigarette has been extinguished or removed from the cigarette holder

**3.24****ambient air flow**

air flow around the cigarettes during the smoking process

NOTE See annex A.

## 4 Standard conditions

### 4.1 Machine pressure drop (see 3.5)

The whole of the flow path between the butt end of the cigarette and the suction mechanism shall offer the least possible resistance, and its pressure drop shall not exceed 300 Pa.

### 4.2 Puff duration (see 3.7)

The standard puff duration shall be  $(2,00 \pm 0,02)$  s.

### 4.3 Puff volume (see 3.8)

The standard puff volume measured in series with a pressure drop device of  $1 \text{ kPa} \pm 5 \%$  shall be  $(35,0 \pm 0,3)$  ml. In one puff duration (see 3.7) not less than 95 % of the puff volume shall leave the butt end of the cigarette.

### 4.4 Puff frequency (see 3.10)

The standard puff frequency shall be one puff every  $(60 \pm 0,5)$  s measured over 10 consecutive puffs.

### 4.5 Puff profile (see 3.12)

The puff profile shall be measured with an impedance of  $1 \text{ kPa} \pm 5 \%$  as specified in 4.3. It shall be bell-shaped with a maximum between 0,8 s and 1,2 s from the start of the puff. The increasing and decreasing parts of the profile shall not have more than one point of inflection each. The maximum flow rate shall be between 25 ml/s and 30 ml/s (see annex B). At no point shall the direction of flow be reversed.

NOTE Principles of suction mechanisms using a piston pump to obtain the puff profile are given in annex B.

### 4.6 Restricted smoking (see 3.3)

An analytical smoking machine shall be a restricted smoker (i.e. fulfil the conditions for restricted smoking).

### 4.7 Puff number (see 3.9)

Each individual puff shall be counted and recorded and the puff number rounded off to the nearest one-tenth of a puff, based on the puff duration.

### 4.8 Cigarette holder (see 3.14)

The design of the standard cigarette holder is such that it shall cover 9,0 mm, with a range of 8,0 mm to 9,5 mm, from the butt end of a cigarette, and shall be impermeable to smoke components and to air. Labyrinth seals with dimensions appropriate for the diameter of the cigarettes under test shall be used in the cigarette holder.

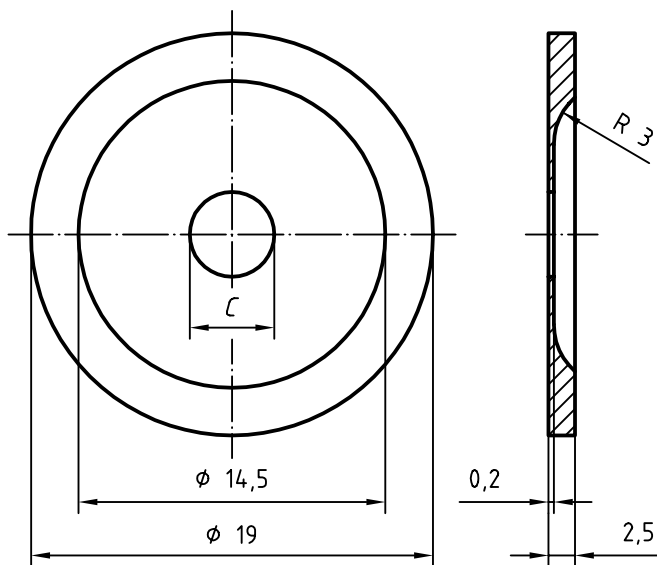
Either the cigarette holder or the smoke trap shall be equipped with a perforated disc (washer) of plain expanded synthetic rubber, closed-cell sponge grade, which partly obstructs the butt end of the cigarette. The synthetic rubber shall have a density of  $150 \text{ kg/m}^3$ , low swell oil resistance and compression-deflection range of 35 kPa to 63 kPa. Four labyrinth seals shall be used; the one closest to the butt end (back seal) shall be reversed. The dimensions of the washer and labyrinth seals are given in Figure 1. The washer shall be supported by a structure with a hole in its centre of 4 mm diameter.

The axis of the holder shall be within  $0^\circ$  to  $+5^\circ$  of the horizontal and the holder shall ensure that the cigarette is held within  $\pm 5^\circ$  of the holder axis.

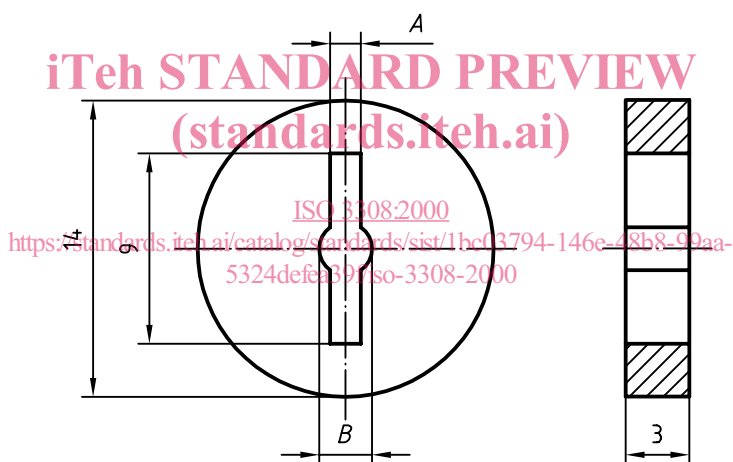
An example of a suitable assembly is given in Figure 2.

Manufacturing tolerances for the individual components of the cigarette holder result in an uneven tolerance about the specified 9 mm insertion depth.

Dimensions in millimetres



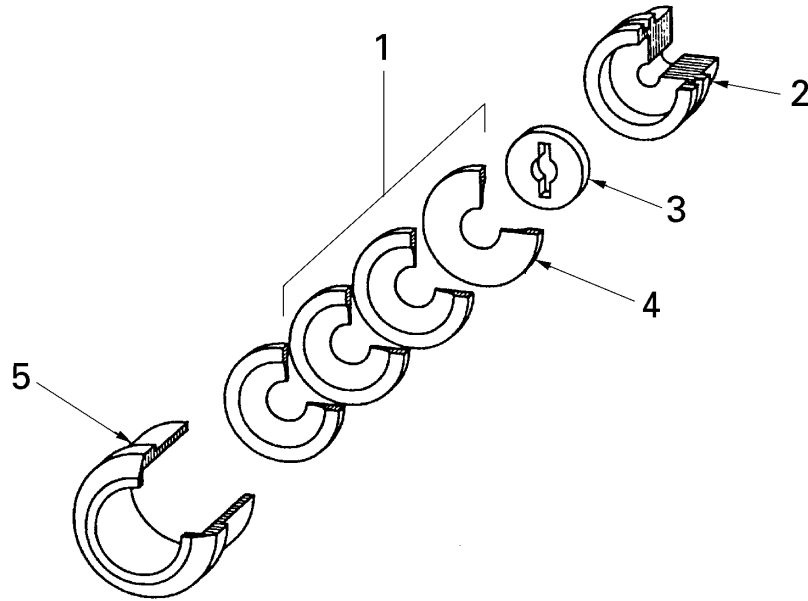
a) Labyrinth seal



b) Washer

Cigarette diameter	A	B	C
4,5 to 5,49	1,45	2,5	4
5,5 to 6,49	1,7	3	4,5
6,5 to 7,49	1,95	3,5	5,5
7,5 to 9	2,2	4	6,5

Figure 1 — Cigarette holder — Labyrinth seal and perforated disc (washer) (dimensional details)



**Key**

- |                   |                             |
|-------------------|-----------------------------|
| 1 Labyrinth seals | 4 Labyrinth seal (reversed) |
| 2 Washer support  | 5 Labyrinth cap             |
| 3 Washer          |                             |

NOTE Washer support is for use where a central glass fibre smoke trap is used to trap smoke from more than one cigarette.

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**Figure 2 — Cigarette holder (schematic)**

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**4.9 Cigarette position** (see 3.19) [\(see/standards.itech.ai/catalog/standards/sist/1bc03794-146e-48b8-99aa-5324defea39f/iso-3308-2000\)](#)

The cigarette holders shall be arranged so that no cigarette influences the burning of any other cigarette.

The cigarette shall be positioned in the holder so that the butt end is in contact with the washer when inserted.

**4.10 Ashtray position** (see 3.22)

The ashtray shall be placed in a horizontal plane between 20 mm and 60 mm below the plane of the axes of the cigarettes.

**5 Specification for the routine analytical smoking machine**

**5.1 General**

The smoking machine shall comply with the standard conditions (see 4.1 to 4.10) and the special conditions given in 5.2 to 5.8.

**5.2 Operating principle and puff profile**

**5.2.1** The machine shall include a device to draw a fixed volume of air (puff) through a cigarette. A schematic diagram is shown in Figure 3.

**5.2.2** The machine shall produce a bell-shaped puff profile (see 4.5).

**5.2.3** The machine shall be a restricted smoker (i.e. fulfil the conditions for restricted smoking, see 3.3).