

---

---

**Tobacco and tobacco products —  
Monitor test piece for smoking  
machine — Requirements and use**

*Tabac et produits du tabac — Éprouvette de contrôle pour machine à  
fumer — Exigences et utilisation*





**COPYRIGHT PROTECTED DOCUMENT**

© ISO 2021

All rights reserved. Unless otherwise specified, or required in the context of its implementation, no part of this publication may be reproduced or utilized otherwise in any form or by any means, electronic or mechanical, including photocopying, or posting on the internet or an intranet, without prior written permission. Permission can be requested from either ISO at the address below or ISO’s member body in the country of the requester.

ISO copyright office  
CP 401 • Ch. de Blandonnet 8  
CH-1214 Vernier, Geneva  
Phone: +41 22 749 01 11  
Email: [copyright@iso.org](mailto:copyright@iso.org)  
Website: [www.iso.org](http://www.iso.org)

Published in Switzerland

Contents		Page
Foreword .....		iv
1	Scope .....	1
2	Normative references .....	1
3	Terms and definitions .....	1
4	Requirements .....	2
5	Testing .....	3
6	Data sheet information .....	3
	6.1 General .....	3
	6.2 General production specifications .....	3
	6.3 Analysis values from interlaboratory testing .....	3
7	Use .....	4
	7.1 General .....	4
	7.2 Practical procedures for the use of monitor test pieces .....	5
	7.3 Practical use of control charts .....	6
Annex A (informative) Monitor test piece — Example of specifications .....		7
Bibliography .....		9



## 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.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular, the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see [www.iso.org/directives](http://www.iso.org/directives)).

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights. Details of any patent rights identified during the development of the document will be in the Introduction and/or on the ISO list of patent declarations received (see [www.iso.org/patents](http://www.iso.org/patents)).

Any trade name used in this document is information given for the convenience of users and does not constitute an endorsement.

For an explanation of the voluntary nature of standards, the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT), see [www.iso.org/iso/foreword.html](http://www.iso.org/iso/foreword.html).

This document was prepared by Technical Committee ISO/TC 126, *Tobacco and tobacco products*.

This fourth edition cancels and replaces the third edition (ISO 16055:2019), which has been technically revised.

The main changes compared to the previous edition are as follows:

- the title and scope have been modified by adding “for smoking” machine;
- the former Annex A (Control charts) has been deleted and the subsequent annex has been moved;
- a reference to ISO 7870-2 has been added in place of the omitted Annex A.

Any feedback or questions on this document should be directed to the user's national standards body. A complete listing of these bodies can be found at [www.iso.org/members.html](http://www.iso.org/members.html).



# Tobacco and tobacco products — Monitor test piece for smoking machine — Requirements and use

## 1 Scope

This document describes the requirements for a monitor test piece for smoking machine as well as its use.

## 2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 3308, *Routine analytical cigarette-smoking machine — Definitions and standard conditions*

ISO 4387, *Cigarettes — Determination of total and nicotine-free dry particulate matter using a routine analytical smoking machine*

ISO 5725-2, *Accuracy (trueness and precision) of measurement methods and results — Part 2: Basic method for the determination of repeatability and reproducibility of a standard measurement method*

ISO 7870-2, *Control charts — Part 2: Shewhart control charts*

ISO 8454, *Cigarettes — Determination of carbon monoxide in the vapour phase of cigarette smoke — NDIR method*

ISO 10315, *Cigarettes — Determination of nicotine in total particulate matter from the mainstream smoke — Gas-chromatographic method*

ISO 10362-1, *Cigarettes — Determination of water in total particulate matter from the mainstream smoke — Part 1: Gas-chromatographic method*

ISO 10362-2, *Cigarettes — Determination of water in smoke condensates — Part 2: Karl Fischer method*

ISO 20778, *Cigarettes — Routine analytical cigarette smoking machine — Definitions and standard conditions with an intense smoking regime*

ISO 20779, *Cigarettes — Generation and collection of total particulate matter using a routine analytical smoking machine with an intense smoking regime*

ISO 22253, *Cigarettes — Determination of nicotine in total particulate matter from the mainstream smoke with an intense smoking regime — Gas-chromatographic method*

ISO 22947, *Cigarettes — Determination of carbon monoxide in the vapour phase of cigarette smoke with an intense smoking regime — NDIR method*

## 3 Terms and definitions

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

ISO and IEC maintain terminology databases for use in standardization at the following addresses:

- ISO Online browsing platform: available at <https://www.iso.org/obp>
- IEC Electropedia: available at <https://www.electropedia.org/>



NOTE Other reference standards in the tobacco field require a storage temperature below  $-16\text{ }^{\circ}\text{C}$  for reasons of hygiene. Normally, a storage temperature of  $+4\text{ }^{\circ}\text{C}$  is sufficient for monitor test pieces.

**4.8** The product design shall ensure that the smoke yields (nicotine-free dry particulate matter, nicotine and carbon monoxide) are sufficiently high per monitor test piece (see example in [Table A.4](#)) so that the influence from a possible offset in the smoking machine settings can be distinguished from the normal variation of the smoke yields.

**4.9** It is essential to make the monitor test piece clearly distinguishable from commercial cigarettes. The monitor test pieces shall be packed in hard boxes of 20 which should be carrying a text.

EXAMPLE Monitor No. X, for laboratory purposes only and not for human consumption [date of production].

## 5 Testing

Testing of the lot, including determination of the values for carbon monoxide, nicotine-free dry particulate matter and nicotine in the smoke, shall be carried out in accordance with ISO 3308, ISO 8454, ISO 4387, ISO 10315 and ISO 10362-1 or ISO 10362-2 in the form of an interlaboratory trial run in accordance with ISO 5725-2. For the intense smoking regime, the test for carbon monoxide and nicotine shall be performed in accordance with ISO 20778, ISO 20779, ISO 22947 and ISO 22253.

Monitor test pieces for daily routine use may be produced by the individual company for its own purposes. However, for the purposes of interlaboratory comparisons or for comparison of analytical consistency between laboratories, it is advised to use monitor test pieces from a common source.

In the case that the monitor test pieces shall be shipped, it is recommended to add an identifier like. Samples are of no commercial value/value given for custom purposes only and/or purpose: For testing purposes only, not for resale. This gives a clear statement about the intended use of the test pieces.

NOTE 1 At present, a monitor test piece is available from CORESTA<sup>[5]</sup> <sup>[6]</sup>.

NOTE 2 The CORESTA monitor test piece is tested annually for consistent smoke yields in an interlaboratory study in accordance with ISO 5725-2.

## 6 Data sheet information

### 6.1 General

A data sheet from the source of supply of the monitor test piece shall be included. It shall contain the information set out in [6.2](#) and [6.3](#).

### 6.2 General production specifications

The specifications for test piece length, test piece diameter, test piece mass (including its standard deviation), filter length, tipping length, filter material.

### 6.3 Analysis values from interlaboratory testing

The results from the interlaboratory testing of the monitor test piece, comprising:

- the smoking regime being used;
- the butt length used;
- the type of smoking machine used;
- the average and standard deviation of the results for nicotine in the smoke;



- the average and standard deviation of the results for nicotine-free dry particulate matter, if applicable;
- the average and standard deviation of the results for carbon monoxide in the smoke;
- the two-sided confidence interval for the mean values, with a confidence level of 95 %.

## 7 Use

### 7.1 General

Monitor test pieces are used to monitor the stability of the analytical processes involved when using a cigarette-smoking machine for routine analyses in accordance with ISO 3308 or ISO 20778. In particular, they are used to assess whether the analytical process related to the machine-smoking of cigarettes is “in statistical control” (see ISO 7870-1).

As monitor test pieces are produced for process-control purposes, the product design is chosen to give smoke yields which are well suited to these purposes and thus may well not conform to official declaration restrictions. In this context, it should be understood that the monitor test piece is not to be regarded as a commercial cigarette.

The routine use of monitor test pieces can vary from laboratory to laboratory and between the two commonly used types of analytical smoking machine. The general principle is to evaluate the consistency of the values of the essential parameters (such as puff number, carbon monoxide in the vapour phase, total particulate matter and nicotine as well as water in total particulate matter of mainstream smoke and nicotine-free dry particulate matter, if applicable) by using control charts.

Monitor test pieces are not to be used for calibration purposes, and the results obtained with monitor test pieces shall not be used for correcting or calculating analytical data from investigation samples.

NOTE 1 The monitor test piece cannot control the process of vent blocking required by the smoking regime specified in ISO 20778.

The smoke yields are normally based upon the smoking of at least 20 monitor test pieces/cigarettes as described in ISO 4387 or in ISO 20779.

The smoking of 20 cigarettes under ISO 3308 conditions or 10 cigarettes under ISO 20778 conditions gives one average result from a rotary smoking machine, whereas a linear smoking machine gives 4 average results from smoking 5 cigarettes in each of 4 channels under ISO 3308 conditions or 3 cigarettes in each of 4 channels under ISO 20778 conditions. This means that the variation in the smoking process shall be determined by different methods for linear and rotary smoking machines. For the rotary machine, the variation may be determined as a “between smoke runs” variation whereas the variation for the linear machine may be determined from the 4 individual results from the 4 channels. In other words, the process variation from the rotary smoking machine is based on “independent” single results while the variation from the linear smoking machine can be based on 4 results from one smoke run but from 4 “independent” channels.

This means that different types of control charts shall be used for linear and rotary smoking machines. The actual choice shall be made according to the actual demands and cannot be specified to fit all needs. ISO 7870-2 gives advice on, and examples of, the practical use of control charts.

NOTE 2 This advice is based on the statistical theory described in ISO 7870-1 and ISO 7870-2 combined with practical experience from daily use.

[Figure 1](#) illustrates the use of monitor test pieces in routine smoking analysis.

**IMPORTANT — When analysing the control chart, always test for assignable causes in accordance with ISO 7870-2.**



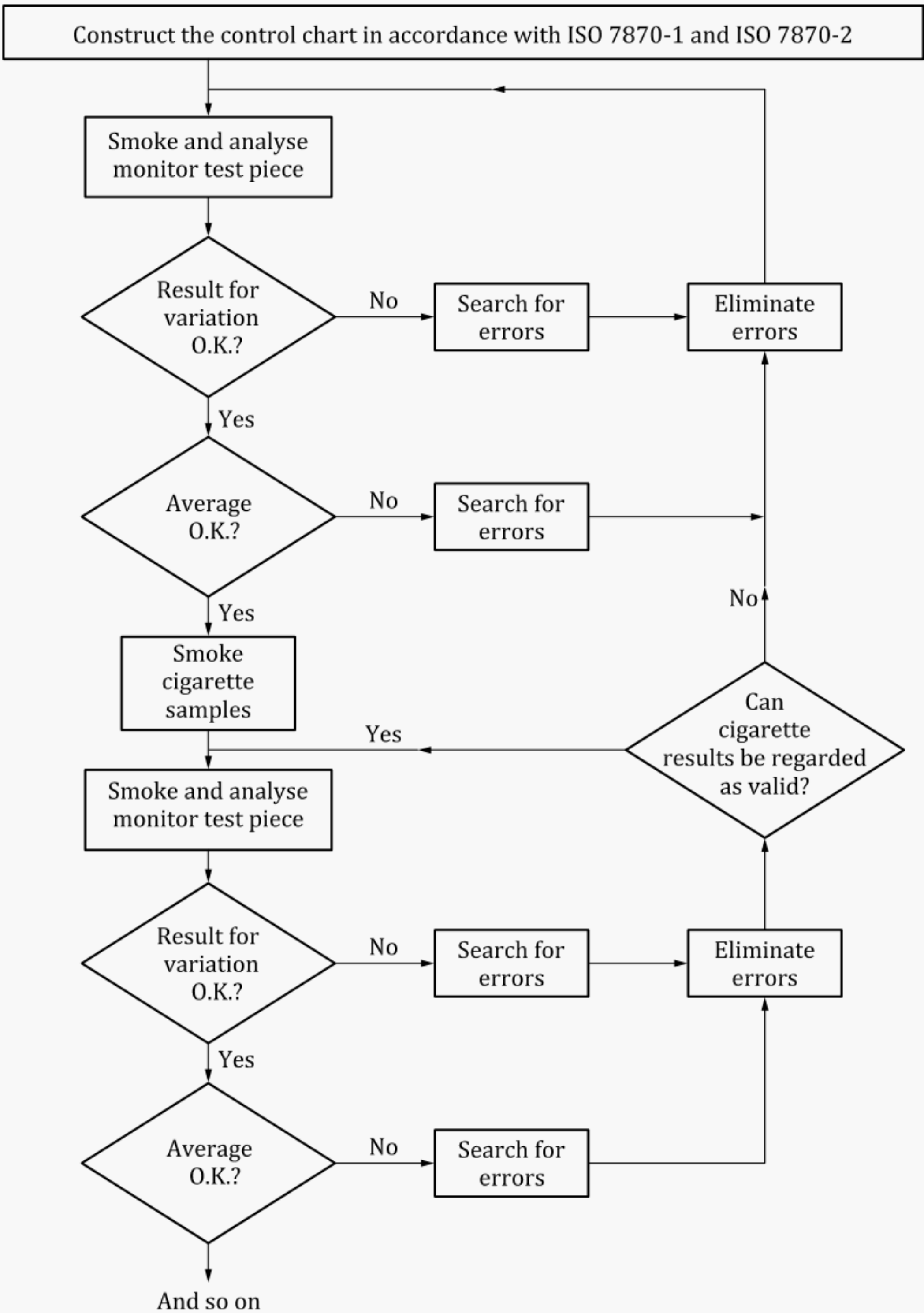


Figure 1 — Flow chart for use of monitor test pieces in routine analytical smoking

7.2 Practical procedures for the use of monitor test pieces

The practical procedures for use of monitor test pieces are based upon the condition that the consistency of a process can be evaluated by analysing control samples at chosen intervals, and comparison of the test results graphically in a control chart (see ISO 7870-1).



The frequency at which the monitor test pieces shall be analysed cannot be specified. It depends on the local need. However, the following considerations describe the importance of a practical choice (see also ISO 7870-2:2013, 11.4).

Under the condition that the analytical process is consistent (stable), it is assumed that all the analytical results obtained between two valid results from the monitor test pieces are also valid. In contrast, results obtained during a period which begins with a valid check result and ends with a non-valid check result shall be regarded as non-valid until further investigations have indicated their validity. Thus, there is a risk of having to reject these results and having to repeat the analysis. To avoid the loss of large numbers of results, it is important to analyse the monitor test piece at sufficient intervals to reduce this risk. It becomes a balance between analytical capacity and need for confirmation of consistency.

The procedure for the two types of smoking machine will be different but based, of course, upon the same principle: sequential smoking and confirmation of the validity of the smoking results.

The following procedure can be recommended.

a) For the rotary smoking machine

At the beginning of a series of smoking analyses, a smoking run and an analysis is performed with the monitor test piece. At practical intervals (for example for each 10 to 15 smoke runs), this procedure should be repeated, ending the day with smoking of the monitor test piece.

b) For the linear smoking machine

At the beginning of a series of smoking analyses, the monitor test piece is smoked on a selection of channels (4 would normally fit into a smoking plan). During the daily smoking, this can be repeated at a practical frequency, with test pieces being smoked on 4 channels for every 2 or 3 smoke runs. To secure the best information, it is important that smoking of the monitor test piece is evenly distributed on all channels over a period of time.

### 7.3 Practical use of control charts

The analysis values from smoking and analysis of monitor test pieces are plotted on the appropriate control charts (see ISO 7870-1 and ISO 7870-2) so that the results for average and for variation can be evaluated.

It is possible to use control charts both where standard values are given and also where the standard values are not given (see ISO 7870-2:2013, 5.1, 5.2). This means that control charts can be constructed for the individual laboratory without knowledge of the official target values for the test piece, but the control chart can also be constructed with reference to target values.

The control charts may have both warning and action limits (see ISO 7870-2) or only one set of control limits (see ISO 7870-2). Either kind of control chart can be used, but for the correct evaluation of the consistency of the analytical process, it is very important that the rules for testing for assignable causes (see ISO 7870-2:2013, Introduction and Clause 8) are followed.

It is a matter of choice whether to use control charts with or without target values combined with one set or two sets of control limits. It depends on the actual needs. It might be practical to combine the target values from the interlaboratory testing with the results from the individual laboratory's own routine check. On the other hand, this can be impractical for laboratories which have analytical averages which differ from the target values. In these cases, the consistency check will be affected by the obstruction of the control limits by the official target values, and it can be better to determine any difference between the local average and the official average by other statistical methods for differences between variances and between averages.



Annex A  
(informative)

Monitor test piece — Example of specifications

It is recommended that the specifications in [Tables A.1](#) to [A.4](#) be met for CORESTA monitor test piece production.

Table A.1 — Tobacco blend and cut rag

Parameter	Description
Type of tobacco	Flue cured lamina without stems
Additives	Preferably none, but absolutely no more than 2 % glycerol
Cut width	≈0,9 mm

Table A.2 — Monitor test piece dimensions

Parameter	Value
Test piece length	≈83 mm (king size)
Test piece diameter	≈7,8 mm
Test piece mass	≈980 mg (with a standard deviation of equal or below 25 mg)
Test piece pressure drop	≈1,4 kPa <sup>a</sup>
Rod length	≈62 mm
Rod mass	≈820 mg
Tobacco mass	≈780 mg
Tobacco density	≈260 mg/cm <sup>3</sup>
Tobacco moisture	≈12,0 %
<sup>a</sup> Pressure drop may also be expressed in millimetres water gauge (mmWG). 1,4 kPa ≈ 140 mmWG.	

NOTE Detailed information is published in the “CORESTA Technical Guide No 8” [\[5\]](#).



Table A.3 — Monitor test piece non-tobacco materials

Parameter	Value
Filter rod diameter	≈7,8 mm
Tow specification	High-crimp cellulose acetate tow of type 2,8Y36HK (dtex units) (in denier units 2,5Y32HK) or similar
Filter pressure drop	In the range 0,75 kPa to 0,8 kPa <sup>a</sup>
Plasticiser	≈7 % triacetin
Plug wrap	Non-porous
Filter length	≈21 mm
Tipping	Distinguishable from commercial products (i.e. grey tipping) with CM logo, no perforation preferable
Tipping width	≈29 mm
Test piece paper	Wood pulp, filler precipitated calcium carbonate ≈ 30 %, air permeability ≈ (40 to 50) cm <sup>3</sup> min <sup>-1</sup> cm <sup>-2</sup> at a pressure differential of 1 kPa <sup>b</sup> , citrate (expressed as anhydrous citric acid) ≈ 0,7 %
Paper width	≈26 mm
<sup>a</sup> Pressure drop may also be expressed in millimetres water gauge (mmWG). 0,75 kPa to 0,8 kPa ≈ (75 to 80) mmWG.	
<sup>b</sup> Air permeability may also be expressed in CORESTA units (CU). 1 CU = 1 cm <sup>3</sup> min <sup>-1</sup> cm <sup>-2</sup> .	

Table A.4 — Expected smoke yields

Parameter	Value (ISO 3308)	Value (ISO 20778)
NFDPM	≈14 mg/monitor test piece	—
Nicotine	≈1,4 mg/monitor test piece	≈2,7 mg/monitor test piece
CO	≈14 mg/monitor test piece	≈26 mg/monitor test piece
Puff number	≈9	≈12

## Bibliography

- [1] ISO 3402, *Tobacco and tobacco products — Atmosphere for conditioning and testing*
- [2] ISO 7870-1, *Control charts — Part 1: General guidelines*
- [3] ISO/TR 19478-1, *ISO and Health Canada intense smoking parameters — Part 1: Results of an international machine smoking study*
- [4] ISO/TR 19478-2, *ISO and Health Canada intense smoking parameters — Part 2: Examination of factors contributing to variability in the routine measurement of TPM, water and NFDPM smoke yields of cigarettes*
- [5] CORESTA Technical Guide No 8, *Monitor Test Piece Production and Evaluation Requirements December 2020*
- [6] CORESTA Technical Report *Influence of Standard Deviations for CORESTA Monitor Test Piece*



## Bibliography

- [1] ISO 3402, *Tobacco and tobacco products — Atmosphere for conditioning and testing*
- [2] ISO 7870-1, *Control charts — Part 1: General guidelines*
- [3] ISO/TR 19478-1, *ISO and Health Canada intense smoking parameters — Part 1: Results of an international machine smoking study*
- [4] ISO/TR 19478-2, *ISO and Health Canada intense smoking parameters — Part 2: Examination of factors contributing to variability in the routine measurement of TPM, water and NFDPM smoke yields of cigarettes*
- [5] CORESTA Technical Guide No 8, *Monitor Test Piece Production and Evaluation Requirements December 2020*
- [6] CORESTA Technical Report *Influence of Standard Deviations for CORESTA Monitor Test Piece*