APPENDIX A3.2.2-1

DETAILED DESCRIPTION OF THE MANUFACTURING PROCESS

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1. DETAILED DESCRIPTION OF THE MANUFACTURING PROCESS

1.1. General Overview

A detailed description of the manufacture and in process testing for the Tobacco Sticks used in THS is provided. Information regarding the specifications for materials used in the manufacturing process for Tobacco Sticks is provided in Section 3.2.2.2.

(b) (4)

PMI has implemented cleaning procedures for the (b) (4) . Cleaning procedures are (b) (4)

(b) (4)

NB: The ranges provided in this document " Indicative ranges" are those present in the current manufacturing specifications and may be adjusted over time to achieve finish good acceptance criteria.

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1.2. Regular Tobacco Stick

All manufacturing processes are carried out under (b) (4) conditions.

1.2.1. Primary Manufacturing Processes

1.2.1.1. Preparing the (b) (4) *(Performed at PMP S.A.)*

(b) (4)
(b) (4) (see Appendix A3.2.2-4 for details on (b) (4)
(b) (4)
.

(b) (4) (see Section 1.2.3).

(b) (4) (b) (4) (see Section 1.2.3) (b) (4) This process is shown in Figure 1.

The material is (b) (4) ready for transportation from PMP S.A. to PMMTB.

The in-process controls are described in Section 1.2.3.

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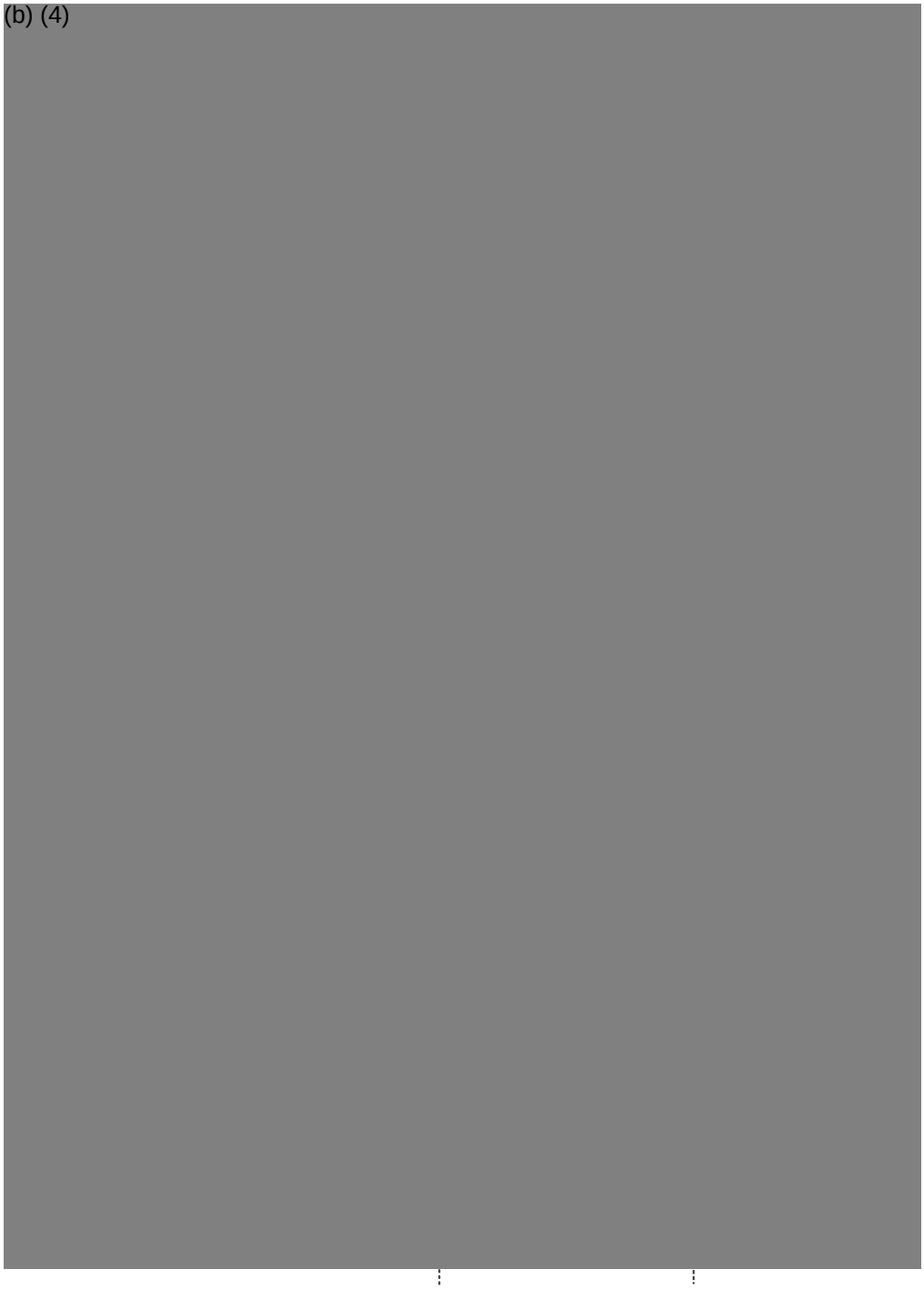


Figure 1: Summary of the (b) (4) Process

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1.2.1.2. (b) (4)

This manufacturing step (b) (4) (see Section 1.2.3) to ensure (b) (4).

1.2.1.2.1. (b) (4)

(b) (4). This step in the process occurs (b) (4) (b) (4).

(b) (4)
).

(b) (4)
.

(b) (4)
).

This process is shown in Figure 2.

(b) (4):

- (b) (4)
- (b) (4)
.

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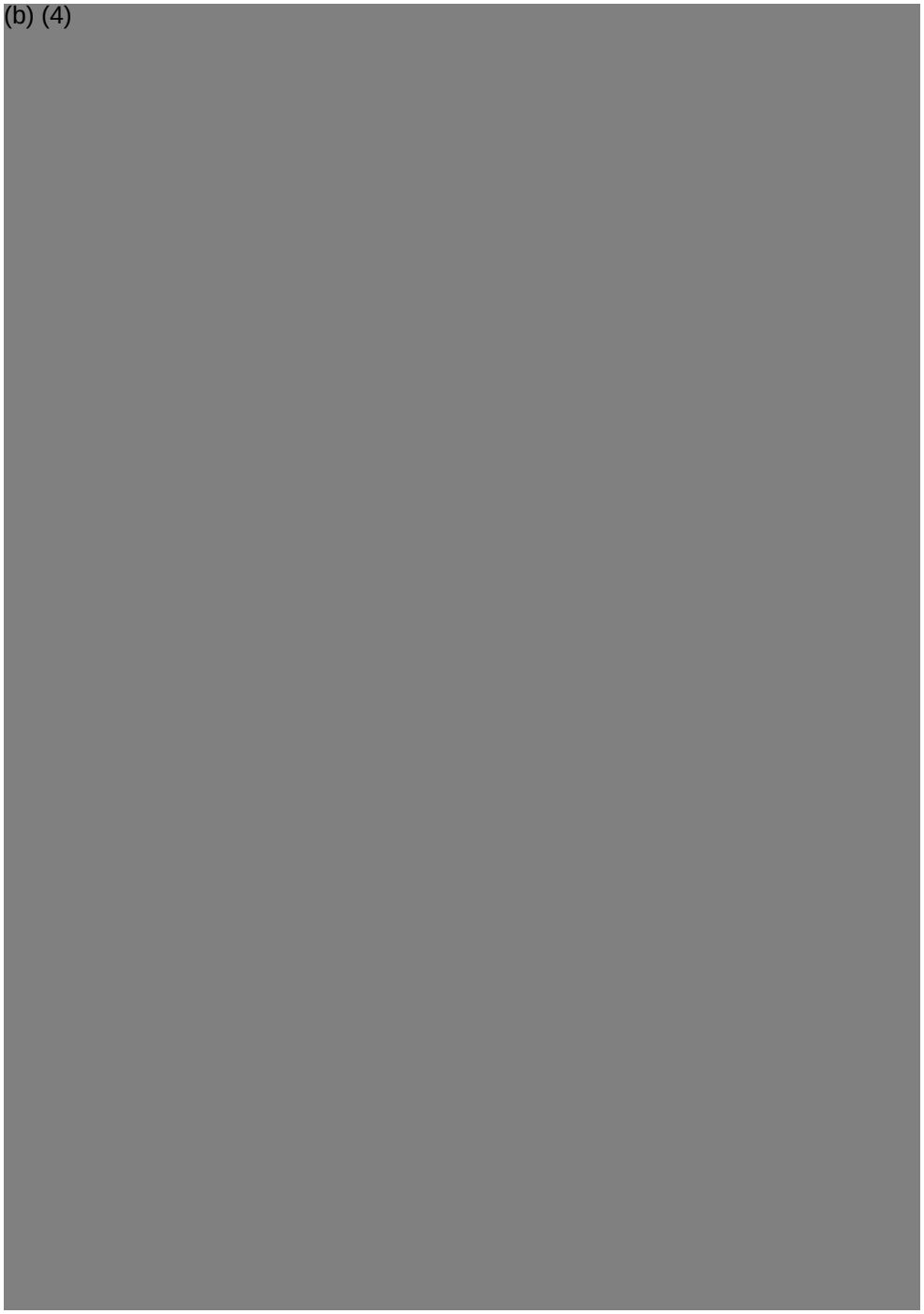


Figure 2: (b) (4) Process

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1.2.1.2.2. (b) (4)

The second stage (b) (4) as shown in Figure 3. (b) (4)
(b) (4) (see Section 1.2.3) (b) (4)).
(b) (4)
(b) (4

Section 1.2.3).

(b) (4)

(b) (4)

(b) (4)

(b) (4)
(b) (4) (see Section 1.2.3). (b) (4)
(b) (4)
(b) (4)

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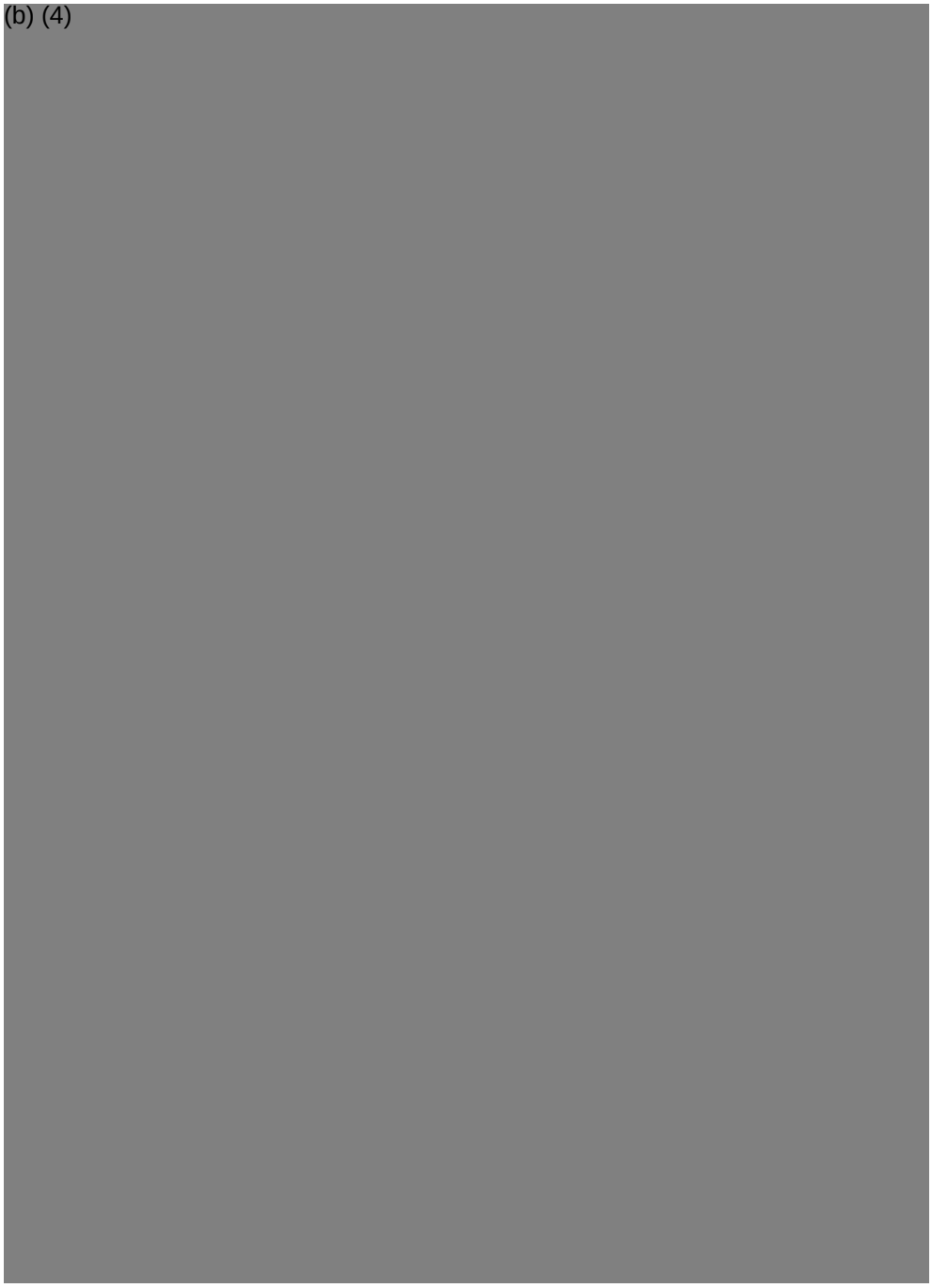


Figure 3: (b) (4) Process

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1.2.1.2.3. (b) (4)

The final stage of this process is (b) (4)

.

(b) (4)

At the end of this stage, a (b) (4)

(see Section 1.2.3).

1.2.2. The Secondary Manufacturing Processes (Performed at PMMTB)

1.2.2.1. Manufacture of (b) (4)

1.2.2.1.1. (b) (4)

(b) (4)

.

(b) (4)

(b) (4)

(b) (4)

(b) (4)

(b) (4)

(see Section 1.2.3).

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(b) (4)

The process to this point is shown in Figure **4** and Figure 5.

(b) (4)

Figure 4: (b) (4)

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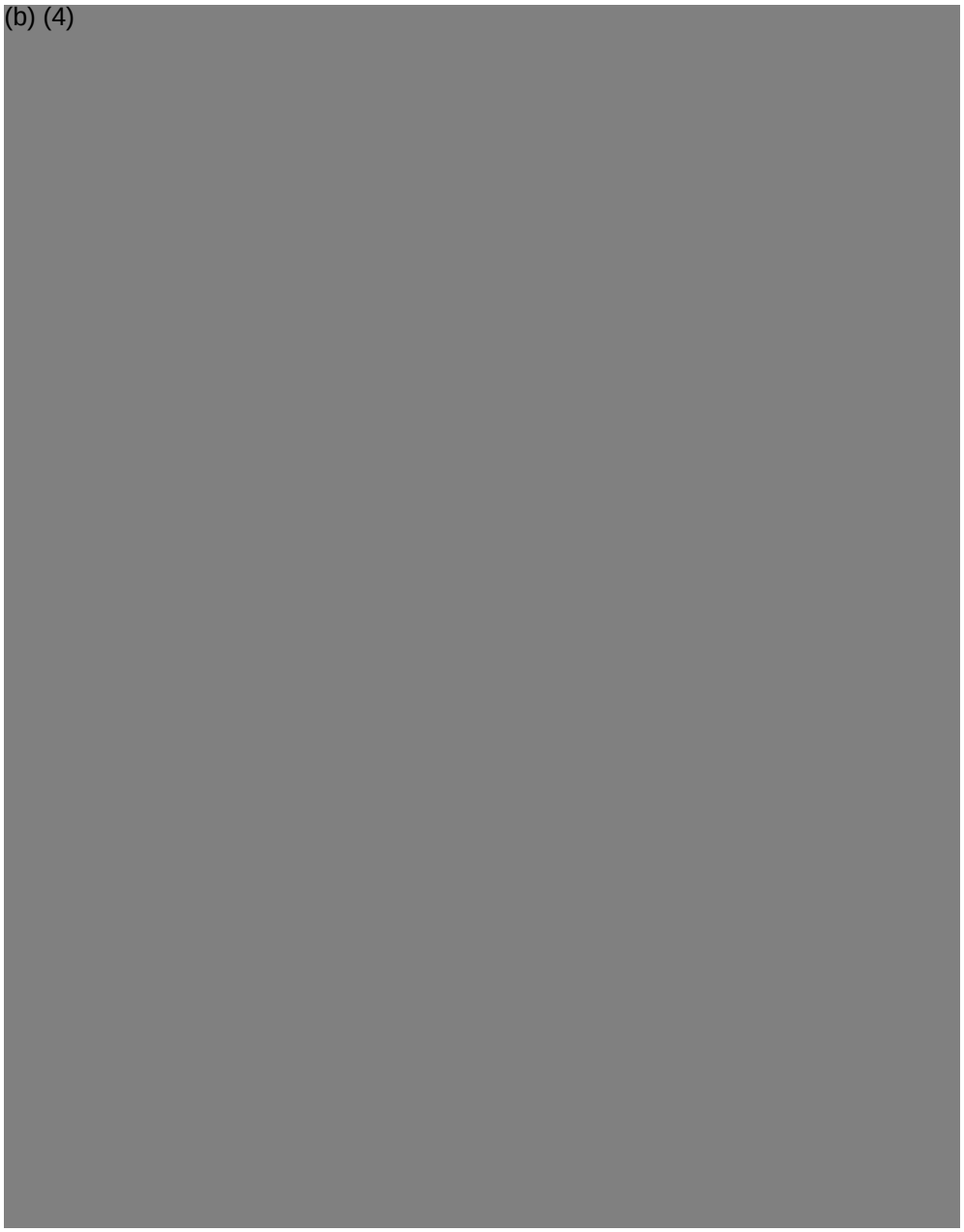


Figure 5: (b) (4) (continued)

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1.2.2.2. (b) (4)

(b) (4)

The process to this point is shown in Figure 6 and Figure 7.

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Figure 6: (b) (4) Manufacturing

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(b) (4)



Figure 7: (b) (4) Manufacturing (continued)

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1.2.2.3. Manufacturing (b) (4)

(b) (4)

(b) (4)

(see Section 1.2.3). (b) (4)

Section 1.2.3).

(b) (4)

(b) (4)

the next processing step and (b) (4)

(b) (4) (see Section 1.2.3).

(b) (4)

The manufacturing process for the (b) (4) is shown in Figure 8.

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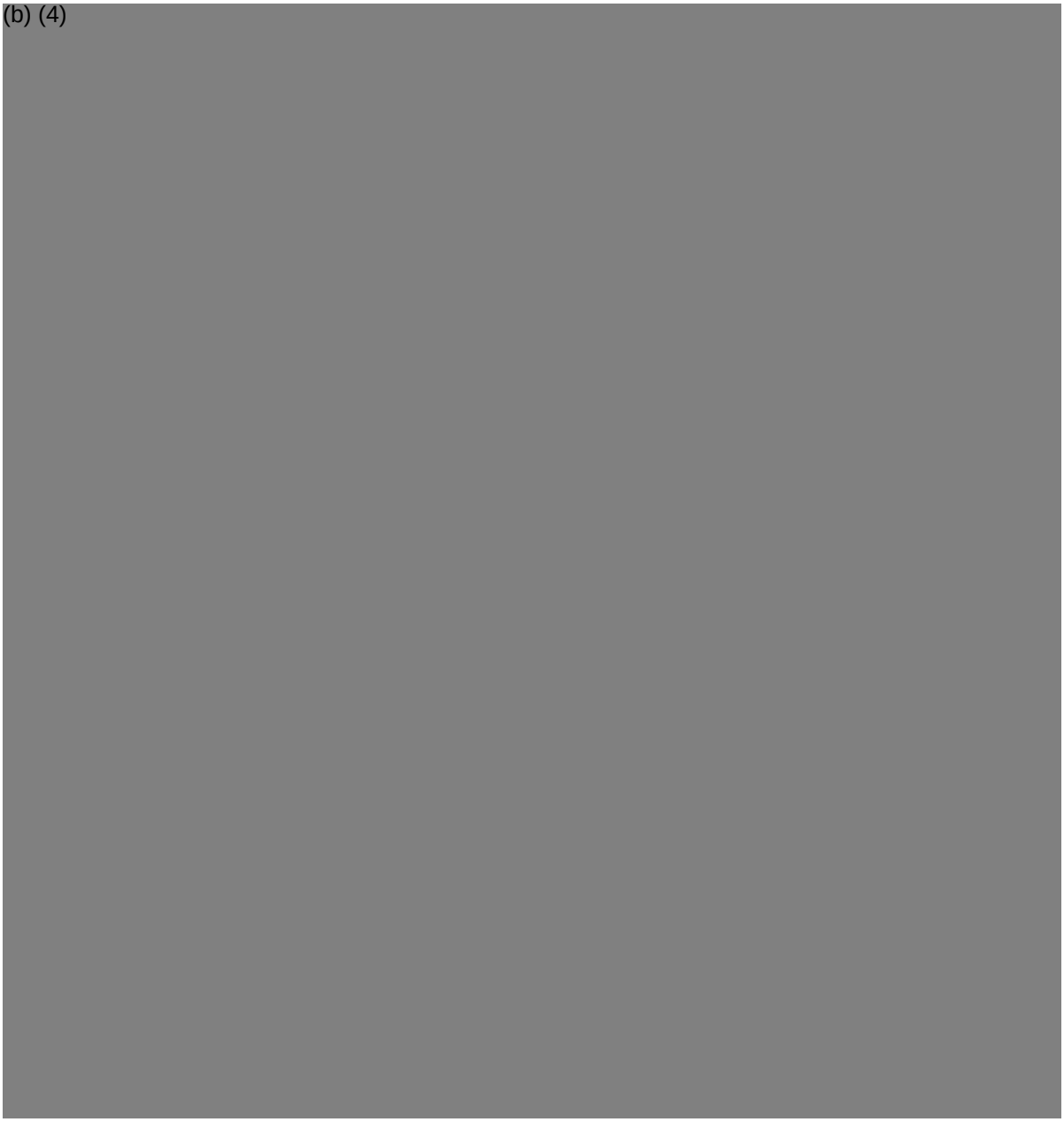


Figure 8: (b) (4)

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1.2.2.4. (b) (4)

(b) (4)

1.2.2.5. Assembling (b) (4)

(b) (4) . The commercial process is provided below.

1.2.2.5.1. Assembling (b) (4)

(b) (4)

(b) (4) as shown in Figure 9.

(b) (4)

Figure 9: (b) (4)

(b) (4)

(see Section 1.2.3).

(b) (4)

1.2.2.5.2. (b) (4)

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This process is illustrated in Figure **10** with steps (i) to (iv). (b) (4) (see Section 1.2.3), (b) (4) (b) (4) (b) (4) (b) (4) . The overall process flow is shown in Figure 11 and Figure 12.

(b) (4)

Figure 10: (b) (4)

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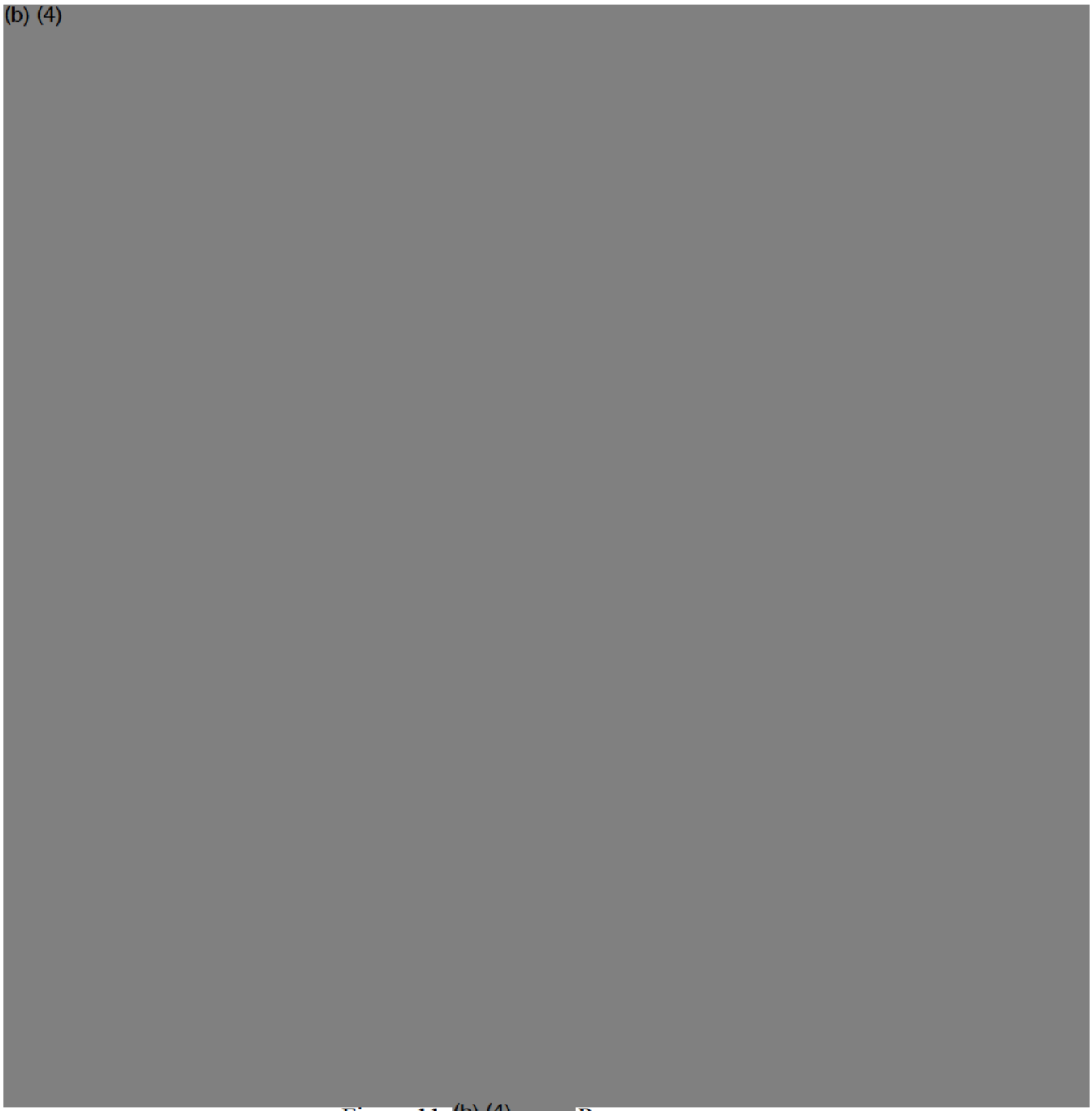


Figure 11: (b) (4) Process

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(b) (4)



Figure 12: (b) (4) Process (continued)

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1.2.2.6. Packing the Tobacco Sticks

The final stage in the process is the packing and wrapping of the Tobacco Sticks in a pack. The core operations are:

(b) (4)

The manufacturing process allows for:

- (b) (4)

1.2.3. In Process Testing

The main in-process controls (b) (4) used during the manufacturing process for regular Tobacco Sticks are described in Table 1.

Table 1: Critical In-Process Controls for Regular Sticks

(b) (4)

[1] (b) (4)

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(b) (4)

1.3. (b) (4)

(b) (4)

.

[1] (b) (4)

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1.3.1. Making the (b) (4)

The manufacture of (b) (4) (as described in Section 1.2.2.2) with the following exceptions.

(b) (4)

(b) (4)

1.3.2. In Process Testing

The critical process controls for manufacture (b) (4) s with the exceptions listed in Table 2.

Table 2: Critical Process Controls (b) (4)

(b) (4)

1.4. (b) (4)

The manufacturing process for the (b) (4) described in Section 1.3 (b) (4)

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1.4.1. Making the (b) (4)

The manufacture of the (b) (4) (as described in Section 1.3.1) (b) (4)

1.4.2. In Process Testing

The critical process controls for manufacture (b) (4) s listed in Table 3.

Table 3: Critical Process Controls (b) (4)

(b) (4)

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2. APPROVALS

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SME	Gurhan Coban	QMS Compliance Officer		28.10.2016
Owner	**Pedro Campelos**	**Supervisor Process Charachterization**		28.10.2016
QA Review	**Stefano Ceriali**	Director Operational QA		28/10/16

[1] HTP = Heated Tobacco Product

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