

GOVERNMENT STANDARD OF TURKMENISTAN

CIGARETTES

General Specifications

Official Edition

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Foreword

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GOVERNMENT STANDARD OF TURKMENISTAN

CILIMLER

Umumy tehniki şertler

CIGARETTES

General specifications

Date entered 08-25-2020

Valid until 08-25-2025

1. Limitation of scope

This standard applies to filter cigarettes made with a blend of raw tobacco that has undergone fermentation and other technological processing of reconstituted tobacco, rolled stem, expanded stem, expanded tobacco and other ingredients.

2. Referenced codes and standards

References to the following standards are used in this standard:

TDS 775-2015 Cardboard for consumer packaging. General specifications.

TDS 1323-2019 Label paper. Technical specifications.

TDS 1344-2019 Liquid-in-glass thermometers. General requirements. Testing methods.

TDS 1396-2019 Laboratory scales. General requirements

TDS 1395-2019 Cargo marking.

TDS-166-89 (ISO 3599-76) Calipers. Technical specifications.

TDS-5709-86 Cigarette paper. Technical specifications.

TDS -6290-74 Two-layer packet paper for packaging of cardboard tube-tipped (papirossi) cigarettes and filter cigarettes. Technical specifications.

TDS -6613-86 Woven wire mesh with square cells. Technical specifications.

TDS -8072-77 Fermented raw tobacco. Technical specifications.

TDS-8273-75 Cigarette paper. Technical specifications.

TDS-13511-2006 Corrugated cardboard for food products, matches, tobacco, and detergents. Technical specifications.

TDS-18510-87 Writing paper. Technical specifications.

TDS-30570-2015 (ISO 10315-2000) Cigarettes. Determination of nicotine content in smoke condensate. Gas chromatography method

TDS-30571-2003 (ISO 4387-2000) Cigarettes. Determination of content of moist condensate and dry nicotine-free concentrate (tar) in cigarette smoke using a laboratory smoking machine

TDS-31630-2012 (ISO 8454:2007) Cigarettes. Determination of carbon monoxide content in the gaseous phase of cigarette smoke using a non-dispersive infrared (NDIR) analyzer

TDS-30622.1-2003 (ISO 10362-1:1999) Cigarettes. Determination of water content in smoke condensate. Gas chromatography method.

TDS-30622.2-98 (ISO 10362-2-95) Cigarettes. Determination of water content in smoke condensate. Karl Fischer method.

TDS-31632-2016 (ISO 8243:2013) Cigarettes. Sampling.

3. Terms and definitions

3.1 The following terms with their corresponding definitions are used in this standard:

cigarette - a type of smoking tobacco product consisting of cut raw tobacco for production of tobacco goods products wrapped in cigarette paper;

filtered cigarette - a type of smoking tobacco product consisting of cut raw tobacco for production of tobacco goods products wrapped in cigarette paper (smoking part) and a filter;

filter - an attachment connected during the production process to the end of the smoking item, intended to retain part of the tobacco smoke;

pack or packet - A unit of consumer packaging made of packing cardboard, label paper, polymer or other material, containing a specific amount of tobacco product;

box - wholesale consumer packaging with a specific number of cigarette packs, packed in a cardboard box, which may be wrapped in polymer film;

carton - wholesale consumer packaging with a certain number of cigarette packs wrapped in polymer film, paper, or paper ribbon;

batch of cigarettes - A number of cigarettes of one brand, one size, and type of packaging intended for control;

cigarette brand - Cigarette designation with given consumer properties assigned by the manufacturer.

trademark - A designation, registered in an established procedure and distinguishing cigarettes of the same name, manufactured by the same legal and physical entities from those prepared by other legal or physical entities;

label for tobacco products - Artistically designed template of cardboard or packet, labeling paper or other materials used for the manufacture of individual consumer and wholesale packaging.

ingredient - A substance (excluding the tobacco leaf or other parts of tobacco) used when producing a tobacco product and present in a finished tobacco product, including a modified form;

tar - Dehydrated tobacco smoke condensate that does not contain nicotine;

nicotine - An alkaloid contained in tobacco leaves and tobacco smoke;

carbon monoxide (carbon monoxide) The product of incomplete combustion of carbon-containing substances formed during smoking of a tobacco product;

4. General requirements

4.1 Cigarettes must meet the requirements of this standard.

The content of harmful substances in the smoke of one cigarette should not exceed: tar – 6 mg, nicotine – 0.6 mg, carbon monoxide – 8 mg.

4.2 Cigarettes are manufactured under different names. Each brand of cigarettes should differ from the others by one or more of these attributes: recipe, type of filter used, as well as other consumer properties established by the product manufacturer or licensor.

4.3 Cigarettes are to be packaged in a simple package of standardized form and dimensions, black-and-white, grey, or brown color in accordance with the requirements of the authorized agency; indicating the name of the cigarettes in a prescribed style and size of font; the name of the manufacturer; without any logotypes or other trademarks; photo images and health warnings and other established information or labeling in accordance with point 4.8.

Consumer packaging of cigarettes should be marked with excise stamps.

4.4 Requirements for raw materials and materials

4.4.1 The following are used for the manufacture of cigarettes:

- raw tobacco fermented according to TB8-8072;
- raw tobacco with separated or unseparated main stem according to the normative document;
- tobacco reconstituted according to the regulations;

- expanded or rolled tobacco stem according to the regulatory document;
- cigarette paper according to TO8-5709 or the current regulation;
- korkophan tipping paper, paper for wrapping filters and perforated paper – according to the normative documents in effect;
- acetate filters according to the current regulation;
- filters with acetate perforated insert according to the regulatory document;
- paper filters according to the current regulation;
- polypropylene filters according to the current regulation;
- viscous filters according to the current regulation;
- combination filters (carbon, biofilters) according to the current regulation.

4.4.2 Other raw materials and materials can be used, as well as ingredients needed for the production of tobacco products and not related to their eye appeal (sweeteners, softeners, non-tobacco raw materials) that correspond to the current regulations and are permitted for use in a manner established by Turkmenistan law.

4.4.3 Not permitted for use as ingredients of cigarettes:

- flavorings that can be used to increase the taste appeal of cigarettes (with the taste of food products, menthol, vanilla, etc.);
- stimulating additives (caffeine, taurine, etc.), and vitamins and other additives containing carcinogens and mutagens;
- coloring substances added to various components of tobacco goods, intended to increase the eye appeal of the end product;
- substances whose commerce is forbidden by Turkmenistan law or international agreements with Turkmenistan.

4.5 Organoleptic characteristics of cigarettes.

4.5.1 In their external appearance cigarettes should be whole and clean with a firmly adhering filter. The method of assessing possible defects in the external appearance of cigarettes and packs is established by the product manufacturer.

One of the possible techniques for assessing the external appearance of cigarettes and packs is provided in Appendix A.

The total point score of evident defects of the external appearance of cigarettes should not exceed 120.

4.5.2 Cigarettes are made round with a filter; the color of the cigarette and tipping paper is white. Production and import of non-filter cigarettes are not allowed.

4.5.3 The aroma and smoke flavor attributes of each cigarette are determined by the manufacturer or licensor and controlled by tasting. Smells and flavors that are not characteristic of a particular brand of cigarettes are not allowed.

4.6 Physical characteristics of cigarettes.

4.6.1 Physical characteristics of cigarettes are bound to the following limits:

- length of cigarettes - 84 mm with size tolerance of ± 1.0 mm;
- diameter of cigarettes at least 7.5 mm;
- length of filter mouthpiece - 25 mm with selected size tolerance of ± 0.5 mm;
- moisture of the tobacco in cigarettes - 13(± 2) %;
- mass fraction of dust in cigarette tobacco – no more than 3.5%.
- number of cigarettes in a pack – 20.

4.7 Packaging

4.7.1 Cigarettes are packaged in packs, and the packs in boxes or cartons that must be clean and whole.

4.7.2 The design of the pack and box should correspond to the sample confirmed by the manufacturer or licensor.

4.7.3 For packaging cigarettes use:

- labels from boxboard according to TDS 775;
- labels from label paper according to TDS 1323;
- labels from two-ply packet paper according to TDS-6290;
- labels from single-ply packet paper according to the current regulation;
- writing paper according to TDS-18510;
- wrapping paper according to TDS- 8273;
- caporal tobacco paper according to the current regulation;
- laminated or metallized foil according to the current regulation;
- polymer film according to the current regulation;
- tear-off ribbon according to the current regulation.

4.7.4 Other packaging materials can be used that meet the current regulations, or are allowed for use in a manner established by Turkmenistan law.

4.7.5 Cartons and boxes are packed in transport packaging – corrugated cardboard boxes according to TDS-13511, or in boxes according to other regulations.

As agreed with the customer (recipient), packs of cigarettes may be packed into shipping containers without being placed in cartons.

4.7.6 Boxes should be tightly packed to ensure preservation of cigarettes during transportation and storage.

4.8 Consumer packaging labeling.

4.8.1 The information on the immediate container shall contain the following:

4.8.1.1 Name of the type of tobacco, that is cigarettes. It is allowed to combine the name of the type with other information about cigarettes, for example: "20 filter cigarettes".

4.8.1.2 Name of the cigarettes and the manufacturer or licensor that is the owner of that type of cigarettes shall be written in "Arial" font, which is legally accepted in the country in which the manufacturer or licensor are located.

4.8.1.3 Name and location (office address, including country) of the manufacturer of the product, as well as the licensor (if cigarettes are manufactured under license).

4.8.1.4 If the production process, the quality of cigarettes, raw materials and materials used in production are controlled by an organization (controlling authority) with cigarettes being produced at such an organization, then the following information, together with the name and location (address) of the organization as a manufacturer producing cigarettes of that type may be placed on the package, pack: "Produced under the control of (name and location/address)". The name of the country of manufacture of cigarettes is labeled after the words: "Made in (name of the country)".

4.8.1.5 Each container, box is labeled as follows:

- The name and location (address) of the organization registered in the territory of Turkmenistan and authorized to receive consumer complaints shall be indicated. In the absence of such an organization, it shall be indicated that consumer complaints should be directed to the cigarette manufacturer.

The name and address of the authorized body shall be specified conspicuously on the container;

- date of manufacture (month, year);
- barcode;
- "QR" code (if available).

4.8.1.6 Number (pieces) of cigarettes.

4.8.1.7 Any cigarette package and any box used in retail trade shall carry a warning label on the dangers of smoking, the text of which shall be approved by the competent authority.

The text of warning labels on the dangers of smoking, the devastating consequences of consumption of tobacco products and inhalation of tobacco smoke for the human body shall be accompanied by pictures (photographic images or pictograms) approved by the authorized body on the consumer packaging of cigarettes. Pictures (pictograms), photographic images may be changed once every three years by decision of the authorized body.

Warning notices and figures (pictograms), photo images on consumer packaging may be changed by a decision of an authorized body once every three years.

4.8.1.8 A figure (pictogram) or photo image is to be printed in high-resolution (CMYK at least 300 dpi) and placed in the upper part of both large sides of the cigarette pack.

The size of the figure (pictogram) or photo image on a pack of cigarettes is determined by the authorized agencies.

4.8.1.9 The text of a warning notice is written over the figure in capital bold letters in a legible, easy-to-read font, and the line spacing should not exceed the height of the font. The name of the font is “Arial”; the color of the notice contrasts with the main background of the figure. The text is placed parallelly below or above the edge of the pack or packaging (carton, box) of cigarettes, ensuring maximal view of the figure or photo image. The factual part of the warning notice should be larger than the rest of the text.

Depending on the size of the cigarette pack, the size of the font is 14–16 and 10–11 respectively. The size of the font on the carton or box increases according to an increase in the scale of the photo image.

The warning notice should be placed such that it remains intact when the consumer package is opened.

4.8.1.10 Designation of this standard, if the cigarettes are manufactured in accordance with this standard. Designation of a regulatory document may apply without specifying the year of approval. Designation of a regulation is not applicable for imported tobacco products.

4.8.1.11 Information about certification of cigarettes in accordance with regulatory documents adopted in Turkmenistan.

4.8.1.12 One of the large side surfaces of a consumer pack of cigarettes bears an additional notice, occupying at least 10%: “Sale to minors is prohibited.”

4.8.1.13 The telephone number of the hotline (for those wishing to give up smoking). The notice is placed on the upper small side surface of a pack of cigarettes. Written in Arial font, size 11, the text of the notice is confirmed by the authorized agency.

4.8.2 It is prohibited to place on a consumer package:

- information about the content of tar, nicotine and carbon monoxide;

Note – The supplier of tobacco goods provides this information to the authorized agency by submitting protocols of tests conducted in the manufacturer’s country.

- information that misleads consumers by directly or indirectly creating the false impression that the tobacco product is less harmful than other tobacco products;

-information summoning up an association of the tobacco product with a food product or medicine (herbal remedies), including the case suggesting the tobacco product has the taste of a food product, by using such words and phrases as “cherry,” “strawberry,” “apple,” “chocolate,” “mint,” “ginseng,” “menthol,” and others, or analogues of such words in foreign languages that are translatable into Turkmen or Russian.

4.8.3 Prohibited:

- use of a design, images, color or color compositions related to the packaging of tobacco products and cigarettes, including trademarks, logotypes, names of tobacco companies or other brand identifiers;

- use of the words and phrases “low-tar,” “light,” “ultra-light,” “mild,” or similar words and phrases.

4.8.4 It is not permitted to place on consumer packaging any information asserting that:

- the use of this type of cigarettes reduces the risk of diseases linked to the use of tobacco products;

- this tobacco product (cigarettes) is less dangerous to health than other tobacco products (other type of tobacco product);

- the risk of diseases linked to the use of this tobacco product (cigarettes) is lowered due to the presence, absence or reduced amount of a substance other than nicotine, tar and carbon monoxide that is emitted when using the tobacco product.

4.8.5 Information is written in the government language. The text and notices may be duplicated in foreign languages. The name of the manufacturer and licensor, and the brand of the cigarettes can be given using letters of the Latin alphabet.

4.8.6 Information is to be placed directly on a unit of consumer packaging (pack, carton) in the same place for a given brand of cigarettes.

4.8.7 Information may be applied in any manner and should be clear and easy to read.

Means and methods for applying the information must ensure its permanence storage, transport, or sale of cigarettes to consumers.

4.8.8 The name of the cigarettes should be applied to every cigarette in a consumer package.

4.9 Shipping label

4.9.1 The outer shipping container with cigarettes should bear a label with the following information:

- name and legal address of the manufacturer;
- brand of cigarettes;
- number of cigarettes in the container;
- date of manufacture;
- designation of the current standard;
- handling indications “Keep away from moisture,” “Keep away from heat” according to TDS 1395;
- barcode;
- code “SD1” (when available).

4.9.2 Additional information describing the product may be placed on the box.

4.9.3 It is prohibited to apply any information of a marketing nature to the consumer package and/or shipping container of cigarettes.

5. Acceptance rules

5.1 Cigarettes are received in batches. Each batch is to be accompanied by a document of quality.

5.2 Sampling for quality control of cigarettes is to be carried out according to TOB-31632.

5.3 When the result of testing is negative, a second sampling is performed, the results of which are final.

6. Control methods

6.1 Sampling and preparing a laboratory sample according to TOB-31632.

6.2 Determination of the length and diameter of cigarettes and filter mouthpieces

6.2.1 Equipment

Calipers according to TSD-166 or other means of measurement that permit measurements with a margin of error no greater than 0.1 mm.

6.2.2 Testing

Two packs are randomly selected from the laboratory sample according to 6.1; the cigarettes are removed from them; ten are selected and their lengths and diameters measured. Then the filter mouthpieces are removed and their length is measured.

6.2.3 Results processing

The mean arithmetic value of ten measurements is taken as the result of the test. The computations are carried out with accuracy to the first decimal place.

6.3 Determination of the moisture of tobacco in cigarettes

6.3.1 Equipment

A drying cabinet providing the required conditions for drying according to the current regulations.

Highly precise laboratory scales according to TDS 1396 with a limit of absolute error for a single weighing of ± 0.001 g.

Tinplate trays with an area of (120 ± 2) cm² and a side height of (10 ± 2) mm.

Thermometer according to TDS 1344 with a measurement range up to 200 °C and graduation from 0.5 to 2.0°C.

Wristwatches, table clocks or other means of measuring time with a margin of error no greater than 2%.

Other methods of measurement, testing equipment, and techniques for testing under conditions maintaining the accuracy of the results may be used.

6.3.2 Testing

According to 6.1, ten packs are randomly selected from the laboratory sample; the cigarettes withdrawn; and the wrapper cut carefully lengthwise. The tobacco is removed and weighed.

To determine moisture, two samples of tobacco weighing 4-5 g each are selected, placed in individual dry trays, and weighed. The trays with the tobacco are placed in a drying cabinet. The tobacco is dried for (30 ± 1) minutes at a temperature of (108 ± 2) °C. The countdown begins when the given temperature in the cabinet is reached. The ventilation holes in the cabinet should be fully open. The trays with the tobacco should be weighed immediately when drying is finished. All weighings are to be conducted with a margin of error of no greater than 0.01 g. The results of weighing are recorded with accuracy to the second decimal place.

6.3.3 Processing the results

The moisture of the tobacco W , %, calculated for each sample individually according to the formula:

$$W = \frac{m_1 - m_2}{m_1 - m} \cdot 100, \quad (1)$$

where m_1 — weight of the tray with tobacco before drying, g;
 m_2 — weight of the tray with tobacco after drying, g;
 m — weight of the empty tray, g.

The mean arithmetic value of two parallel determinations is taken as the result of the testing, where the discrepancy between the numerical values should not exceed 0.5. Calculations are conducted with precision to the first decimal place.

6.4 Determination of mass fraction of dust in tobacco

6.4.1 Equipment

As specified by TDS 1396, highly precise laboratory scales with a limit of absolute error for a single weighing of ± 0.01 g.

Screening machines of various designs and metrological characteristics. The time for a complete filtering of dust for the design of the machine being used is determined by sifting artificially formulated mixtures of cut tobacco with dust content of $(5 \pm 0.5) \%$.

A set of sieves with a diameter of (200 ± 5) mm, consisting of:

- an upper sieve, having a sieve plate of 1-29 -1 x 0.8 or 1-30-1 x 0.8 according to the technical document;
- a lower sieve, made of semi-compact mesh 028 or 0315 according to TDS- 6613;
- dust collection tray.

A stopwatch with a measurement margin of error no greater than 0.2 s per minute.

Another device with analogous metrological characteristics may be used.

6.4.2 Testing

Following the specifications of 6.3.2, two samples weighing (50 ± 1) g each are taken from the tobacco. Each sample is placed on the upper sieve and sieved for a specified time. Tobacco dust collected in the dust collection tray is weighed with a margin of error no greater than 0.01 g. The results of weighing are recorded with precision to the second decimal place.

When using screening machines with other designs, corresponding methods for conducting tests can be used.

6.4.3 Processing results

The mass fraction of dust X in the tobacco is calculated for each sample according to the formula:

$$X = \frac{m_3}{m_4} \cdot 100, \quad (2)$$

where m_3 — mass of dust, g;

m_4 — mass of tobacco sample, g.

The mean arithmetic value of two parallel determinations is taken as the result; the permissible discrepancy between these numerical values should not exceed 0.5.

Calculations are conducted with precision to the first decimal place.

6.5 Determination of nicotine content in cigarette smoke according to TDS-30570.

6.6 Determination of tar content in cigarette smoke according to TDS- 30571.

6.7 Determination of carbon monoxide content in cigarette smoke according to TDS- 31630.

6.8 Determination of water content in condensate of smoke according to TDS-30622.1, TDS-30622.2

6.9 The control (i.e., testing) of water content in smoke condensate, tar, nicotine and carbon monoxide in cigarette smoke is conducted in accordance with the procedure determined by the manufacturer.

7 Transportation and storage

7.1 Cigarettes are transported by all types of transport according to the regulations for the hauling of goods that are in effect for a given type of transport.

7.2 The means of transport should be covered, dry, clean and without a foreign aroma.

7.3 Boxes with cigarettes in the means of transport should be stacked in a manner that prevents deformation of the boxes at lower tiers.

7.4 The storage location should be dry, clean, with relative humidity of $(60 \pm 10) \%$.

7.5 The floor of the location should be at a height of at least 50 cm from ground level. Boxes with cigarettes are stacked on pallets, beams, or other structures (devices) at a height of at least 10 cm from the floor with gaps between them for air circulation.

7.6 The boxes of cigarettes are stacked at a height that prevents deformation of a lower box. The distance from a stack to a heat source and to walls should be at least one meter.

7.7 Perishable food and goods with an odor may not be stored in the same location as the cigarettes.

Appendix A

(recommended)

Assessment of the external appearance of cigarettes and packs

Assessment of the external appearance of cigarettes is conducted according to the method set forth below. When using this method, the total point score of evident defects should not exceed 120.

A.1 From a laboratory sample, according to 6.1, ten packs are randomly selected and serve as the prototype sample.

A.2 The assessment of the external appearance of the cigarettes, packs, cartons and boxes is performed by identifying possible defects, which, according to their degree of severity, are divided into three categories: significant, moderate, and insignificant.

A.3 Significant defects include

— when inspecting the external appearance of the pack, carton or box — damage to the integrity of the polymer film wrapping; one side of the pack, carton or box – totally unglued; presence in the pack of cigarettes of another brand; sticking of a cigarette to the pack with damage the integrity of the cigarette when withdrawing; underfilling of the cigarettes;

— when inspecting the external appearance of the cigarettes — absence of a filter on a filtered cigarette; puncture of the paper wrapper; ungluing of the seam along the length of the cigarette; loose end greater than 3 mm; spot of motor oil greater than 3 mm; foreign matter in the tobacco besides scraps of cigarette paper.

A.4 Moderate defects include

— when inspecting the external appearance of the pack, carton or box — partial ungluing of several sides of the pack, carton, box, souvenir box; paint smudging; indistinctness or print offset on the label; absence of a tear-off ribbon;

— when inspecting the external appearance of the cigarettes — peeling edge of the tipping paper; absence of the brand on the cigarette; tearing of the butt end greater than 3 mm; motor oil spot up to 3 mm; presence in the tobacco of scraps of cigarette paper.

A.5 Insignificant defects include

— in the external appearance of the pack — slight misalignment of the pack; displacement of the ends of the tear-off ribbon greater than its width; tip of the tear-off ribbon is glued; jamming or damage of the inner foil or paper liner;

— in the external appearance of the cigarettes — torn edge; indistinct markings; paint spot; folds on the tipping paper; contamination of the cigarettes with glue; loose tobacco up to 3 mm; tearing of the butt end or ungluing of the seam at the butt end of the cigarette up to 3 mm.

A.6 Packs selected according to A.1 are subjected to inspection and the uncovered defects are divided according to the degree of severity. Then the cigarettes are combined into a single sample and the defects of the cigarettes are identified and then separated according to degree of severity. If a pack or cigarette has several defects of different significance, then the assessment is performed according to the more significant defect. If a pack or cigarette has several defects of the same significance, then the assessment is performed as for one defect.

A.7 A significant defect is scored as 10 points, a moderate defect as 3 points, and an insignificant defect as 0.3 points.

The number of defects of packs and cigarettes is counted for each category. The total assessment of the external appearance of cigarettes and packs is calculated according to the formula:

$$\text{Score} = 10A + 3B + 0.3C, \quad (\text{A.1})$$

where A - number of units of cigarettes and packs with significant defects;

B - number of units of cigarettes and packs with moderate defects;

C - number of units of cigarettes and packs with insignificant defects.

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Regarding the change to the effective date, TDS 596– 2020 Cigarettes. General Specifications renews the effect of the standard: TDS 596–2014 Cigarettes. General Specifications in effect until December 1, 2020

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