

# Tobacco

## Introduction

Tobacco is an agricultural product processed from the fresh leaves of plants in the genus *Nicotiana*. Tobacco leaves are rolled into cigars, shredded for use in cigarettes, processed for chewing and ground to use as snuff powder.

Tobacco is an annual plant and flourishes in counties with tropical and semi-tropical climate conditions. It is grown in India, China, Java, Brazil, Russia, America, Cuba, Sumatra, Jamaica and Philippines. Tobacco contains nicotine.

## Cultivation and Processing Tobacco

### Harvesting

Tobacco is harvested in two ways. In the oldest method, the entire plant is cropped off the stalk at the ground with a sickle. In the other method, individual leaves are pulled off from the plant as and when they ripen. Leaves are cropped as they ripen, from the bottom to the top of the stalk. After harvesting, the leaves are bundled and put across long sticks. Then they are transported to barn for curing.

### Curing

Curing is the process of drying the leaves. This process improves flavor and aroma of tobacco leaves. There are four common methods of curing – air curing, fire curing, flue curing and sun curing. The method of curing applied depends on the type of tobacco and its use.

**Flue-curing:** Tobacco was originally strung onto tobacco sticks, which were hung on tier-poles running across the barn. These barns have flues (ducts) that distribute heat from externally fed fire boxes. This process heat-cure the tobacco leaves without exposing them to smoke, slowly raising the temperature over the course. The process will generally take about a week. This method produces tobacco that is high in sugar and has medium to high levels of nicotine. Flue cured tobacco is extensively used in cigarettes. Virginia tobacco is usually flue-cured and termed as bright tobacco.

**Fire-curing:** This method uses smoke from low burning fire to cure the leaves in barn. The smoke gives the tobacco its distinctive flavor and aroma. This process takes between three days to ten weeks, depending on the process and the tobacco. It produces a tobacco low in sugar and high in nicotine. Fire cured tobacco is used in manufacturing of pipe tobacco, chewing tobacco, and snuff powder.

**Air-curing:** Tobacco leaves are hung in well-ventilated barns and allowed to dry over a period of four to eight weeks. Air-cured tobacco is low in sugar, which gives the tobacco smoke a light, sweet flavor, and high in nicotine. This tobacco is used in making of cigars usually.

**Sun-curing:** Tobacco leaves are dried uncovered in the sun. This method is used in Turkey, Greece and other Mediterranean countries to produce oriental tobacco. Sun-cured tobacco is low in sugar and nicotine. It is used in making of cigarettes.

Freshly cured tobacco has a sharp aroma and bitter taste. The cured leaves are tied into small bundles of about 20 each and then moved to a storage area for further processing. Leaves are stored here for 2-3 years to carry out the process of aging. During this period some water is sprinkled over the leaves to maintain the moisture content and to prevent the leaves from getting dried. The process of fermentation or aging gives the tobacco a sweeter and milder flavor with reduced nicotine content.

## **Cigarette**

A cigarette is a product, manufactured out of cured and finely shredded tobacco leaves, is often combined with additives and then rolled into a cylindrical paper wrapper (generally less than 120 mm in length and 10 mm in diameter). They are sometimes smoked with a cigarette holder.

A cigarette is distinguished from a cigar by its smaller size, usage of processed leaf, and white paper wrapping. Cigars are typically composed of whole leaf tobacco.

## **Manufacturing of Cigarette**

Cigarettes are composed of three components – paper, PVA glue to bond the outer layer of paper together, tobacco blend and a butt that constitute tissue tube. Much focus is given to the creation of each of these components, in particular the tobacco blend, which may contain over 100 ingredients, many of them flavorings for the tobacco.

- **Paper :** The paper for holding the tobacco blend may vary in porosity to control the burning rate of the cigarette and to stabilize the produced ash. The papers used in tipping the cigarette (forming the mouthpiece) and the surrounded filter stabilize mouthpiece from saliva moderate the delivery of smoke with the presence of one or two rows of small laser-drilled air holes. The burn rate of the cigarette is regulated through the application of microcrystalline cellulose to the paper.
- **Tobacco blend :** The tobacco grown in different parts of a country are carefully blended to produce a well-balanced tobacco blend, which can be filled into cigarette wrappers. The tobacco blend is made mainly from the leaves of flue-cured bright leaf, burley tobacco, and oriental tobacco.
- **Butt :** The common name for the residual part of the cigarette is “cigarette butt” or simply “butt”. The butt consists of a tissue tube which holds a filter and some remains of tobacco mixed with ash. The filter in the butt helps to collect impurities and to make it less harsh to inhale. It comprises about 30% of cigarette’s original length.

## **International brands of cigarettes**

- Benson & Hedges
- Marlboro
- Dunhill
- Rothmans

- Viceroy
- Camel

### **Service of Cigarette**

- Take down the brand that the guest asked for
- Remove the cellophane wrapper
- Open the packet and remove the foil to expose the cigarettes.
- Pull out few cigarettes partially.
- Present the cigarette packet to the guest on a quarter plate along with a match box.
- Assist the guest in lighting the cigarette
- Ensure the table has a clean ashtray in the center.

### **Cigar**

A cigar is a tightly rolled bundle of dried and fermented tobacco. The word cigar comes from the Spanish cigarro. Tobacco used to make Cigar is grown in Cuba, Brazil, Russia, America, Mexico, Cameroon and Philippines.

### **Manufacturing of Cigars**

Cigars are usually composed of three types of tobacco leaves, whose variations determine smoking and flavor characteristics. They are filler, binder and wrappers.

#### **Fillers**

Filler forms the inner part of the cigar and makes it most of the cigar. It constitutes 85% of the cigar. Fillers of various strengths are usually mixed well to produce desired cigar flavors. In the cigar industry, this is referred to as “blend”.

Fillers can be either long or short. Long fillers are made up of whole leaves and are of better quality. Long fillers are mostly used in hand made cigars. Short filler uses chopped leaves, stems, and other bits. Machine made cigars use short fillers.

#### **Binders**

Binders are the elastic leaves that hold the filler tobacco together and constitutes 10% of the cigar. Filler with binder is termed as bunch. Binder leaves are from part of the plant usually, as they have high tensile strength.

#### **Wrappers**

It is the outer layer of the cigar. It dictates appearance of the cigar. It constitutes 5% of the cigar. A whole leaf of finest quality is chosen as wrapper. Wrapper leaves are fermented separately from other leaves to ensure that it is smooth, not too oily and has a subtle bouquet. Good wrapper leaves have to be smooth, elastic and must have no protruding veins.

The wrapper should have a good aroma since it is the most vital ingredient in the taste of the cigar. The wrapper determines much of the cigar's character and flavor, and as such its color is often used to describe the cigar as a whole.

### **Wrapper Colors**

The leaf used for cigar wrapper varies in color from one cigar to other cigar. Once the cigars are made, they graded according to the color of the wrapper and are packed separately in the boxes. The color of wrapper is marked on the boxes. Cigar wrappers can be classified into seven basic colors, although there are dozens of shades. The terms used to denote the color are the following;

<b>Wrapper Terms</b>	<b>Color of the wrapper</b>
Double Claro	Greenish brown in color. The color is achieved by picking the leaf before it reaches maturity and then drying it rapidly. It is also called as Candela.
Claro (CCC)	Pale golden brown in color.
Colorado – Claro (CC)	Mid-brown, tawny in color.
Colorado (C)	Reddish brown and aromatic. These are also called Rosado.
Colorado Maduro (CM)	Dark brown in color. Honduran cigars are of this type.
Maduro (M)	Very dark brown.
Oscuro	Black and oily in appearance. It is also termed as double maduro.

### **Size of Cigars**

The size of a cigar is measured by two dimensions: its ring gauge and its length. Cigars' length is measured in inches. The girth of cigar is customarily expressed in terms of its ring gauge in 1/64 of an inch. Thus if a cigar has a ring gauge of 49, it is 49/64 of an inch thick. Similarly, if a cigar had a ring gauge of 64, it would be an inch thick. Listed below is the most popular variety of cigar sizes.

<b>Term</b>	<b>Size (inches)</b>	<b>Ring Gauge (girth)</b>
Gran Corona	9 ¼	47
Double Corona	7 ½	49
Julietta 2 / Churchill	7	48
Corona Grande	6 1/8	42
Corona	5 ½	42
Lonsdale	6 1/4	42
Panatela	5	34
Petit Corona	4 ½	40
Robusto	5	50
Minuto	4 3/8	42
Entreacto	3 7/8	30

## International Brands of Cigars

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- Aliados Honduras
- Don Ramos Honduras
- Don Tomas Honduras
- Excalibr Honduras
- Cohiba Cuba
- Diplomaticos Cuba
- La Gloria Cubana Cuba
- Punch Cuba
- Romeo Y Julieta Cuba
- Partagas Cuba
- H.Upmann Cuba
- Ashton Dominican Republic
- Dunhill Dominican Republic
- Henry Clay Dominican Republic
- La Corona Dominican Republic
- Casa Blanca Dominican Republic
- Jose Benito Dominican Republic
- Davidoff Dominican Republic
- Oscar Dominican Republic
- Matacan Mexico
- Santa Clara Mexico

### **Storage of Cigar**

Cigars are like any other natural products and they get easily damaged to dry heat, temperature fluctuations, smells and damp climate conditions. Cigars should be best stored at a temperature of 15 -18<sup>0</sup>C and a humidity of 65-70 percent.

Cigars are stored in Humidor. Humidor is a polished cedar wood box with half a dozen sections, each holding a different size and type of cigar. The cedar wood blends well with the cigars and allow them to breathe. A pad containing a mixture of silica gel is kept inside the humidor to maintain humidity by moisturizing air if it is too dry. A Small Hygrometer fixed to the box would show the humidity level in the box. Humidors come in different sizes. They range from small travel carry cases to large cigar chests holding 600 cigars.

### **Service of Cigars**

In fine dining establishments, where smoking is permitted, cigars are served at the end of meal with digestifs or coffee by the sommelier. The cigars may be served either from trolley or humidors. Sommelier must ensure that the trolley is equipped with side plates, cigar cutter, match boxes and ash trays.

- Present the humidor from left side of the guest to select his choice.
- Remove, guests' selection carefully making sure your finger nails does not touch the wrapper of the cigars
- Check with the guest, if the band of the cigar may be removed and what type of cut he prefers, straight or V-cut.
- Take the cigar to the side board to prepare according to guest's preparation
- If the cigar is covered with cellophane, tear the tube and remove the cigar by applying gentle pressure at the end of the cellophane tube. Place the cellophane wrapper in the pocket.
- Apply the pressure, just below the band and remove it
- Open the closed end of the cigar by making a flat or V-cut with appropriate cigar cutter. (If guest prefers to make cut the cigar on his own, provide him the cigar cutter). Do not pierce the cigar. Piercing the cigar allows an inadequate draught and leaves a bitter taste in the mouth.
- Present the cigar on quarter plates from guests' right hand side.
- Offer the help to the guests, while cigar is lit.

### **Lighting the Cigar**

As a rule of thumb, 'foot' end of the cigar is lit with wooden matches or gas lighter (never with petrol lighters as it spoils the flavor of the cigar). The cigar should be rotated while lighting. Well-matured cigars burn more easily than younger cigars.

### **Pipe Tobacco**

This is one of the oldest ways of smoking tobacco. The pipe consists of two parts. The bowl is the prime part in which flaked tobacco is stuffed. A fancy pipe is attached to this bowl bottom, which is called as mouthpiece. Usually 'ready rubbed' tobacco is used in pipes. The tobacco is lighted and smoke is inhaled through the mouthpiece. In recent days smoking pipe is very expensive and a status symbol