

TOBACCO

CIGAR

CIGAR

➤ Session Objectives-

- After completion one would be able to recall what is a Cigar, how it is made, types, service, storage and list the popular international brands

CONTENTS

- DEFINITION
- ETYMOLOGY
- HISTORY
- COMPOSITION
- MANUFACTURING
- CLASSIFICATION
- SMOKING
- STORAGE
- BRANDS

DEFINITION

- A **cigar** is a tightly-rolled bundle of dried and fermented tobacco that is ignited so that its smoke may be drawn into the mouth

ETYMOLOGY

- The word cigar originated from "sikar," the Mayan-Indian word for smoking, which became 'cigarro' in Spanish, probably from Maya 'sicar
- Although the word itself, and variations on it, did not come into general use until 1730

HISTORY OF CIGAR

- The cigar was smoked throughout the islands of the **Caribbean Sea** and in **Mesoamerica** for centuries before the Europeans discovered the Americas in the late **15th century**

HISTORY OF CIGAR

- In the 19th century cigar smoking was common while cigarettes were still comparatively rare
- The cigar business was an important industry, factories employed many people before mechanized manufacturing of cigars became practical

HISTORY OF CIGAR

- To this day, however, the higher-quality cigars are still made by hand (some boxes bear the phrase "Hecho a Mano", or "Made by Hand", as proof)

HISTORY OF CIGAR

- In Europe, cigars date back to the arrival of Columbus in the West Indies in 1492, where he found people smoking primitive forms of cigar in the shape of rolled leaves made of aromatic herbs

HISTORY

- Much of the territory in the West Indies, Central and South America were Spanish colonies at this time and the Spanish were responsible for the early development of tobacco, which is why most cigar types have Spanish names

COMPOSITION

- **The Three parts of a Cigar are-**
 - **FILLER**
 - **BINDER**
 - **WRAPPER**

COMPOSITION

- **Parts of a cigar**
- The **filler** is a blend of up to 20 different types of tobacco and is the part of the cigar that gives most of the flavor. Small or broken tobacco leaves are used for the filler of the cigar

COMPOSITION

- **Parts of a cigar**
- The **binder** is made of tobacco leaf, sometimes ground up and reconstituted to create sheets like paper. It encloses the filler and gives the cigar its shape and size. Whole leaves are used for the inside wrapper or binder, of the cigar

COMPOSITION

- The **wrapper** is the outer layer which is visible on every cigar and is usually made of natural tobacco leaf
- The wrapper makes a considerable contribution to the flavor of the cigar. A large, finely textured leaf is used for the outside wrapper of the cigar

MANUFACTURING

- The process of **cigar manufacturing** also requires additional secondary raw materials such as a tasteless gum that is used to stick the end of the outside wrapper together

MANUFACTURING

- Flavouring agents are also sometimes sprayed onto the filler leaves, while paper is used to create the band placed around each cigar

MANUFACTURING

CULTIVATION



CURING



FERMENTATION



MANUFACTURING



STRIPPING



ROLLING



WRAPPING

MANUFACTURING

- The **Cigar Manufacturing Process:**
- **Step 1: Cultivation of Tobacco**
- Tobacco plants are carefully pruned to ensure their leaves grow to the correct size. Plants that produce leaves for the outer wrappers of cigars are usually covered to protect the leaves from the sun

MANUFACTURING

➤ **Step 2: Curing**

- In this step in the **cigar manufacturing** process, the tobacco leaves are harvested and cured to create the cigar's characteristic aroma. After harvesting, the tobacco leaves must be cured in order to develop their characteristic aroma

MANUFACTURING

- **Step 3: Fermenting**
- Once cured, the tobacco leaves are sorted by size and colour
- The leaves are tied into bundles called ***hands*** of 10 or 15 leaves each and stored in boxes called ***hogsheads*** for a period ranging from six months to five years

MANUFACTURING

- **Step 4: Stripping**
- In this step the main vein of the filler leaves are removed. This step can be completed by hand or by machine

MANUFACTURING

- **Step 4: Stripping**
- The stripped leaves are wrapped in bales and stored for further fermentation
- Just before the leaves are ready for manufacture into cigars, they are steamed to restore lost humidity, and sorted again

MANUFACTURING

- **Step 5: Rolling**
- Whether the rolling is done by hand or by machine the filler must be packed evenly for the cigar to ensure that it burns smoothly

MANUFACTURING

- **Step 6: Wrapping**
- Wrapping is the most difficult step in the **cigar manufacturing** process. The partially completed cigar is taken out of the mold, placed in on the wrapper leaf and cut

MANUFACTURING

- Today, most cigars are made by machine. Throughout each step of the manufacturing process, each cigar is inspected to ensure that it is of the highest quality
- Whether made by machine or by hand, **cigar manufacturing** is an art unto itself

CLASSIFICATION

- **Types of cigars**
- **Long filler cigars** (wet cigars) are generally hand made, large and at the top end of the price range.
- They are made with whole leaves, laid parallel to each other and wrapped with a tobacco leaf.

CLASSIFICATION

- **Long filler cigars.....**
- They are usually from countries with a warm and very humid climate, such as Cuba or the Dominican Republic
- They need to be stored in a humidor at around 20 degrees Celsius and 70 per cent humidity to avoid drying out

CLASSIFICATION

- **Short filler cigars** (dry European cigars) are generally machine made and consist of a large variety of cut tobacco strands

CLASSIFICATION

- This allows the manufacturer to blend a variety of tobaccos for flavor and, as they have a low degree of humidity, they do not need special storage
- Under normal climatic and handling conditions, their shelf life is virtually unlimited

CLASSIFICATION BY COLOR

Color

Description

**Double
Claro**

very light, slightly greenish; achieved by picking leaves before maturity and drying quickly, the color coming from retained green chlorophyll; formerly popular, now rare

Claro

very light tan or yellowish. Indicative of shade-grown tobacco

Colorado

medium brown, includes Natural and

Claro

English Market Selection

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CLASSIFICATION BY COLOR

Color	Description
Colorado	Distinctive reddish-brown (also called Rosado or Corojo)
Colorado Maduro	darker brown; often associated with African wrapper from Cameroon, and Honduran or Nicaraguan grown wrapper from Cuban seed.
Maduro	Very dark brown or black; primarily grown in Connecticut, Mexico, Nicaragua and Brazil.
Oscuro	Very black, (also called Double Maduro), often oily in appearance; has become more popular in the 2000s



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Classification by Size

Term	Length in “	Width in 64 th of “	Metric length	Metric width
Rothschild	4 + ½	48	11 cm	19 mm
Robusto	4 + 7/8	50	11 cm	20 mm
Small Panatela	5	33	13 cm	13 mm
Petit Corona	5 + 1/8	42	13 cm	17 mm
Carlota	5 + 5/8	35	14 cm	14 mm
Corona	5 + ½	42	14 cm	17 mm
Corona Gorda	5 + 7/8	46	14 cm	18 mm

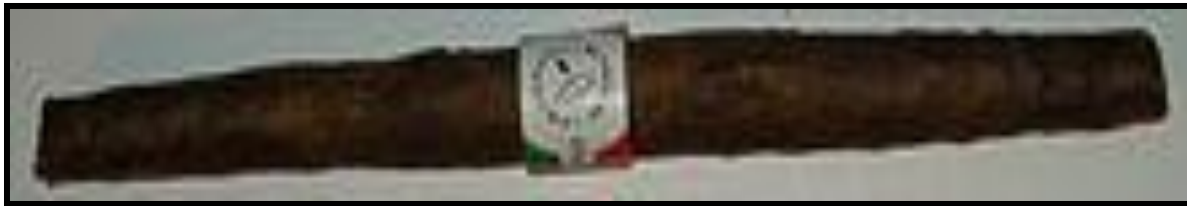
Classification by Size

Panatela	6	38	15 cm	15 mm
Toro	6	50	15 cm	20 mm
Corona Grande	6 + 1/8	42	16 cm	17 mm
Lonsdale	6 + 1/2	42	17 cm	17 mm
Churchill	7	47-50	18 cm	19– 20 mm
Double Corona	7 + 5/8	49	19 cm	19 mm
Presidente	8	50	20 cm	20 mm
Gran Corona	9 + 1/4	47	23 cm	19 mm

Double Toro/Gordo **6** **60** **15 cm** **24 mm**

Classification by Shape

Shape	Description
Torpedo	Like a parejo except that the cap is pointed.
Pyramid	Has a broad foot and evenly narrows to a pointed cap.
Perfecto	Narrow at both ends and bulged in the middle.
Presidente/Dia dema	shaped like a parejo but considered a figurado because of its enormous size and occasional closed foot akin to a perfecto.
Culebras	Three long, pointed cigars braided together.
Tuscanian	A long, tough, slim cigar thicker in the middle and tapered at the ends, with a very strong aroma. It is also known as a cheroot.



Tuscanian

Parejo

Torpedo

Pyramid

Perfecto

Presidente

HOW TO JUDGE A GOOD CIGAR

- Should see reputation of the company and not attractive packing
- Old cigars (can see spots on cigars)

HOW TO JUDGE A GOOD CIGAR

➤ Color of the ash

- Ash should be dark grayish (dark ash – strong cigar & white ash – mild cigar)
- Ash should not fall itself. The longer it stays the better its quality is
- Should not make cracking sounds, if it makes the cigar is of poor quality

SMOKING

- To smoke a cigar, a smoker cuts it, lights it, then puts the unlit end into the mouth and draws smoke into the mouth
- Some smokers inhale the smoke into the lungs, particularly with '*little cigars*', but this is uncommon otherwise
- A smoker may swirl the smoke around in the mouth before exhaling it

CUTTING

- Although some cigars are cut on both ends, or twirled at both ends, the vast majority come with one straight cut end and one end in a "cap"

CUTTING

- Most quality handmade cigars, regardless of shape, will have a cap which is one or more small pieces of a wrapper pasted on to one end of the cigar with either a natural tobacco paste or with a mixture of flour and water

CUTTING

- The cap end of a cigar must be cut off for the cigar to be smoked properly
- It is the rounded end without the tobacco exposed, and this is the end one should always cut
- If the cap is cut jaggedly or without care, the end of the cigar will not burn evenly and smoke able tobacco will be lost

CUTTING

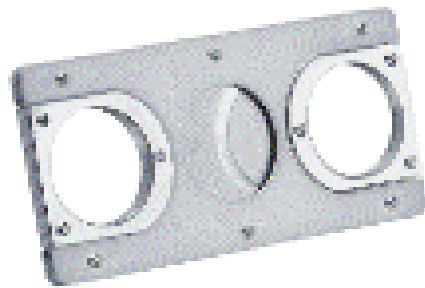
- Smoking a cigar from the wrong end may result in a bad experience



- There are three basic types of cigar cutters:
 - Guillotine (straight cut)
 - Punch cut
 - V-cut (a.k.a. notch cut, cat's eye, wedge cut, English cut)
 - Scissor cutter

TYPES OF CIGAR CUTTERS

Single/ Double cutters



Bullet Punch Cutter



TYPES OF CIGAR CUTTERS

**“V” Shaped
Cutter**



**Scissor type
Cutter**



LIGHTING

- The "head" of the cigar is usually the end closest to the 'cigar band'
- The opposite end of the cigar is called the "foot"
- The band identifies the type of the cigar and may be removed or left on

LIGHTING

- The smoker cuts the **cap** from the **head** of the cigar and ignites the foot of the cigar
- The smoker draws smoke from the head of the cigar with the mouth and lips, usually not inhaling into the lungs

LIGHTING

- When lighting, the cigar should be rotated to achieve an even burn and the air should be slowly drawn with gentle puffs
- Cigars can be lit with the use of butane-filled lighters
- Butane is colorless, odorless and burns clean with very little, if any, flavor

LIGHTING

- It is not recommended to use fluid-filled lighters and paper matches since they can influence the taste
- Another option is **wooden** matches
- They are not treated and soaked with sulfur and thus the smoke is not affected with chemicals

LIGHTING

- Cigars packaged in metal tubes will typically include a thin wrapping of cedar
- This may be used to light the cigar, eliminating the problem of lighters or matches affecting the taste

FLAVOR

- Each brand and type of cigar tastes different. While the wrapper does not entirely determine the flavor of the cigar, darker wrappers tend to produce a sweetness, while lighter wrappers usually have a "drier" taste

FLAVOR

- Some words used to describe cigar flavor and texture include; spicy, peppery (red or black), sweet, harsh, burnt, green, earthy, woody, cocoa, roasted, aged, nutty, creamy, cedar, oak, chewy, fruity, and leathery

HUMIDOR

- The level of humidity in which cigars are kept greatly varies their taste
- It is believed that a cigar's flavor best evolves when stored at a relative humidity of approximately 68-74% and a temperature of 64° F

HUMIDOR

- An ideal rate of humidity allows an even burning of the cigar, on the contrary, dry cigars become fragile and burn faster while damp cigars burn unevenly and take on a heavy acidic flavor

HUMIDOR

- Humidors together with their humidifiers are then used to serve this purpose
- A Humidor's interior lining is basically constructed with three types of wood which are:
 - Spanish cedar
 - American (or Canadian) red cedar
 - Honduran mahogany



HUMIDOR

- Most humidors come with a plastic or metal case with a sponge that works as the humidifier, although most recent versions come on polymer acrylic

HUMIDOR

- The latter must be filled only with distilled water, and the former may use a solution of propylene glycol and distilled water as well
- Humidors may get contaminated with bacteria and to avoid such contamination they should be replaced every two years

HUMIDOR

- Humidors also come with hygrometers which are analog or digital
- There are three systems of analog hygrometers: analog hygrometers with a metal spring, analog natural hair hygrometers, and analog synthetic hair hygrometers

HUMIDOR

A Humidor



A Hygrometer



CIGAR ACCESSORIES

- **Cigar Lighters** – These are butane filled lighters usually attached with a cutter
- **Cigar tubes** - Cigar tubes are useful to carry small amounts of cigars, normally one or five. The latter tube would be called 5-finger tube and the former 1-finger tube. They are usually made from stainless steel

CIGAR ACCESSORIES

- **Cigar holders** - Cigar holders are also known as cigar stands and they are useful to keep the cigars out of ashtrays. Also, cigar holders may refer to a tube in which the cigar is held while smoked. These are mostly used by women, and rarely by men

CIGAR ACCESSORIES



Cigar Lighter



Cigar Tube



Cigar Holder

HEALTH EFFECTS

- Like other forms of tobacco use, cigar smoking poses a significant health risk depending on dosage: risks are greater for those who inhale more when they smoke, smoke more cigars, or smoke them longer

HEALTH EFFECTS

- The risk of dying from any cause is statistically greater for cigar smokers than for people who have never smoked, with the risk higher for smokers less than 65 years old, and with risk for moderate and deep inhalers reaching levels similar to cigarette
- Health risks are nicotine addiction, tooth loss, and many types of cancer, including cancers of the mouth, throat, and esophagus

BRANDS

- Balmoral
- Bolivar
- Cohiba
- El Rey del Mundo
- Hoyo de Monterrey
- Montecristo

BRANDS

- Punch
- Romeo y Julieta
- San Cristobal de la Habana
- Sancho Panza
- Vegas Robaina
- H. Uppman

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THANK YOU

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