

POLISHING GUIDE

COMPONENTS / PURPOSE

Components

- High speed motor with 2000+ RPM
- Felt Bobs: Dome / Conical-Flat
- Nylon Brushes: Cup / Wheel
- Cavity Shining Paste
- Diamond Paste

Purpose

- Revive the original cavity finish and not to remove metal
- Reduce sticking & picking problem
- Get better tablet finish

ERRORS / DO'S AND DON'TS

Common Errors

- Rounding of outside diameter of tip
- Rounding of the edges of tip face
- Distortion of embossed details
- Distortion of the tip face



Do's and Don'ts

- Always rest arm on the table while polishing for stability and better control
- Don't use Diamond Paste for regular polishing
- Never apply pressure
- Polish in outward motion



PLAIN F.F.B.E. PUNCHES

Felt bob to be used

- Use conical-flat type felt bob

Polishing Technique

- Apply punch face to the end of rotating bob.
- Keep flat surface of punch face parallel with the flat end of bob
- Move punch from side to side across the bob face
- Do not apply pressure on bevel edge as this would damage the edge



PLAIN CONCAVE PUNCHES

Felt bob to be used

- Use dome-type felt bob

Polishing Technique

- Apply punch face to the end of rotating bob.
- Move the punch from side to side pivoting away from the bob face



EMBOSSED F.F.B.E. PUNCHES

Nylon brush to be used

- Use cup type nylon brush

Polishing Technique

- Keep flat surface of cavity in contact with flat end of the brush
- Move punch from side to side across brush face
- Hold punch at 45 degrees and polish entire cavity
- Do not flatten brush against cavity as this would damage the embossing



EMBOSSED CONCAVE PUNCHES

Nylon brush to be used

- Use wheel type nylon brush

Polishing Technique

- Hold punch at 90 degrees to the brush
- Move the punch laterally from side to side. Rotate the punch 90 degree and repeat lateral motion.
- Brush bristles should move from inside the cup to the outside edge
- Do not flatten brush against cavity



For more information please visit 'Tool Doctor' on our website.



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