COMPONENTS / PURPOSE

Components

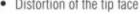
- High speed motor with 2000+ RPM
- · Felt Bobs: Dome / Conical-Flat
- · Nylon Brushes: Cup / Wheel
- · Cavity Shining Paste
- Diamond Paste

- · Revive the original cavity finish and not to remove
- · 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 y proul

Polishing Technique

- · Keep flat surface of cavity in contact with flat end of
- · 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



Pharmachine INDIA