

TABLET PROBLEMS

WEIGHT VARIATION

Tooling Related

- Lower Punch [LP] working height inconsistent
- Improper clearance in Lower Punch tip & die bore.

Press Related

- Lower Punch jammed
- Lower Punch jumping - Use anti-turning plug
- Dozer assembly worn / not set correctly
- Improper hopper setting

Formulation Related

- Granules not flowing freely

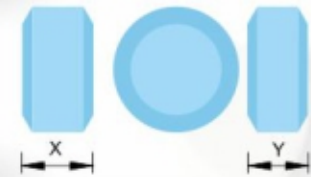


THICKNESS VARIATION

- Check all points mentioned in Weight variation
- ### Tooling Related

- Upper Punch [UP] working height inconsistent
- ### Press / Operation Related

- Pressure roller jumping or jammed
- Roller pin worn out



CAPPING

Tooling Related

- Air entrapment - Use taper dies
- Die ring formation

Press Related

- Wrong ejection setting – Set takeoff bar and Lower Punch to top face of die
- Air entrapment - Compress higher in die, Reduce speed

Formulation Related

- Use pre-compressed granules
- Weak granulation - Increase binder



STICKING & PICKING

Tooling Related

- Poor finish on punch cavity
- Embossing has picking prone zones - Redesign embossing

Formulation Related

- Sticky formulation - Try hard chrome plating
- Moisture content high in granules
- Lubricant content low in granules
- Room humidity high



BLACK PARTICLES

Tooling Related

- Punch tip binding to die.

Press Related

- Over lubrication - Use dust cups
- Rubbing of feeder components



DOUBLE IMPRESSION

Tooling Related

- Upper Punch rotates during compression - Use punches with key

Press Related

- Lower Punch rotates during compression - Adjust anti-turning plugs



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