

die bore for the metering of volume, compression of granulation, and ejection of the tablet

Tip Straight: The area of the tip length that extends from the end of the tip to the tip relief.

Die Terminology

Die: A tool that serves as the mold in which the product is compressed to form the desired peripheral (outer) size and shape of a tablet.

Die, Lined (Insert): A die fitted with an insert made from a much harder, more wear-resistant material, such as tungsten carbide or a ceramic.

Die, Tapered: A die in which the size of the bore gradually increases from the point of compaction of the granulation to the chamfer of the bore.

Die Bore: The cavity within the die where the tablet is compressed. The cavity's shape and size determine the same for the tablet.

Die Chamfer: Entry angle on the die bore edge.

Die Groove: The groove around the outer periphery of the center of the die, which allows the die to be fixed in the tablet press.

Die Height: The overall height of the die, which is compatible with the height of the die sockets in the tablet press.

Die O.D.: The outside diameter of the die, which is compatible with the diameter of the die sockets in the tablet press.

Die Protection Radius: The undercut area between the die groove and O.D.

Tablet Manufacturing

Producing a tablet with a unique design often increases a product's recognition among consumers. Although tablets can be produced in a variety of shapes and sizes, limitations as to their configuration do exist. The limiting factors are usually related to characteristics of the tooling and the press used to produce the tablets. Some categories of tablets are easier to manufacture and comprise the majority of tablets on store shelves.

Tablet Categories

Definitions of tablet terminology are based on the geometric properties of the most common tablet

shapes; therefore, these definitions are placed in Section 3, "Tablet Design." For the scope of this section, tablets are broadly categorized as either "rounds" or "shapes." Figures 22–25 in Section 3 are cross-referenced in the following text to illustrate examples of the tablet categories.

Round Tablets

Round tablets include primarily convex and flat-faced tablets (see Figure 22, page 52). Frequently, industry people use the term *concave* to describe both the concave surface of a punch cup and the surface of the tablet produced. Technically, the punch cup is usually a concavity and therefore produces a tablet with a convex surface; however, convex cups that produce concave tablets do exist.

Convex tablets can be further categorized according to their cup depth. Figure 23 (page 54) shows convex tablets with shallow, standard, deep, extra-deep, and modified-ball cup depths. Flat-faced tablets can be further categorized as flat-faced plain, flat-faced beveled-edged, and flat-faced radius-edged (see Figure 25, page 56).

Shaped Tablets

Tablets that have geometric configurations other than those listed for rounds are referred to as shapes (see Figure 25). Figure 24 (page 55) uses three common geometric configurations to illustrate the terminology for shaped tablets. To produce a tablet with a particular configuration, the tablet shape is reproduced in the tooling used to manufacture the tablets. Before the method of reproduction can be discussed, a thorough understanding of tablet tooling is required.

Modern Tablet Tooling

The function of tablet tooling is to produce tablets with predetermined physical characteristics, such as shape, thickness, weight, and hardness. To achieve this, the die cavity, or bore, is filled with a granulation or powder to a depth that is determined by the position of the lower punch. The lower punch's position determines the amount of granulation used in each tablet. The upper punch tip is then guided into the bore and force is applied to the punch heads, thereby compressing the material into a tablet. The tablet's shape is determined by the configuration of the die bore and the punch tips. The tablet's thickness and hardness are determined by

Tableting Specifications Manual

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