I Holland: Die Alignment

Shaped and Multi hole Die Alignment Tool

Benefits of using a Die Alignment Tool

The Die Alignment Tool is used to accurately locate and align a multi or shaped die into the die table. Traditionally the upper punch has been used to perform this operation, however this is not recommended because the clearance between the punch tips and the die bores will allow for misalignment. Using the upper punch may also result in damage to the punch tip edges. The Die Alignment Tool has much less clearance, hence a tighter fit in the die, resulting in a more accurate positioning of the die bore relative to the punch tips.

Incorrect alignment of the tooling during setting will lead to tightness and binding between the punch tips and die bores during operation causing wear and galling to the tooling, the press cams and punch guides. Use of the Die Alignment Tool will speed up the tool setting procedure reducing the tablet press downtime.

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1: Ensure the tablet press and tooling are clean and free from damage.

2: Carefully insert the Die alignment Tool into the upper punch guides.

3: Select a die and locate on to the tip of the alignment tool and position over the die pocket.

4: Gently push the die down into the die pocket, continue to push and gently tap the die until fully seated.

5: When positioning the die it is advisable to twist the Alignment Tool in the direction that compensates for the rotational forces of the press turret, this will remove any clearance between the key in the Alignment Tool and the keyway in the upper punch guide.

6: Once the die is fully seated, nip up the die locking screws and remove the Alignment Tool. At this point the die locking screws may be fully tightened to the recommended torque setting.

7: To check that the die has not twisted out of alignment, re-insert the Alignment Tool ensuring a smooth fit between the tip and the die bore. If there is any interference loosen the die locking screw and repeat the above procedure. Once satisfied with the fit, repeat this procedure for all dies.

8: When all the dies are set, carefully load all upper and lower punches.

A comprehensive tooling setting procedure is available on request.