Durability, Productivity, Longevity.
This chart explains the principles of the tabletting cycle and key considerations for tablet tooling.

The tabletting process is very demanding. Delicate punch tips have to withstand many forces such as high cyclic loading, high speed frictional forces and aggressive granules.

**Tablet Terminology**
- Shaped Tablets
- Round Tablets

**Typical Tablet Shapes**
- Flat Faced
- Bevel and Convex
- Multi-Tip
- Standard on
- Optional on

**Punch & Die Terminology**
- Upper Punch
- Die Segment
- Punch Tip/Bonded Cap
- Die Head

**PharmaGrade® Steel Properties**

<table>
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<th>Diameter (mm)</th>
<th>0</th>
<th>10</th>
<th>20</th>
<th>30</th>
<th>40</th>
<th>50</th>
<th>60</th>
<th>70</th>
<th>80</th>
<th>90</th>
<th>100</th>
<th>110</th>
<th>120</th>
<th>130</th>
<th>140</th>
</tr>
</thead>
<tbody>
<tr>
<td>Load (kN)</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
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<td></td>
<td></td>
<td></td>
<td>10</td>
<td>20</td>
<td>30</td>
<td>40</td>
<td>50</td>
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</tbody>
</table>

**PharmaCote® tool coatings**

- Overcomes Common Tooling Problems with PharmaCote® Treatments and Coatings.

**Punch Tip Pressure Guide**