

DOMED AND FLAT PUNCH HEADS

TROUBLESHOOTING TOOLING SERIES



HEAD STYLES DOMED & FLAT

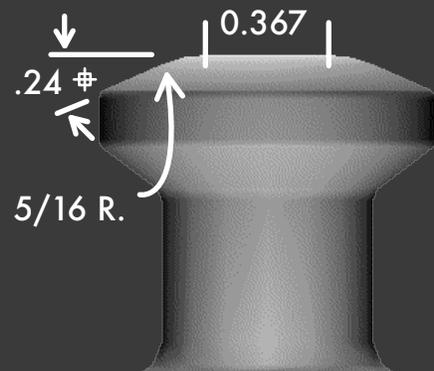
Head Flat Implications

The domed or flat area on the top of the punch is also "Critical Geometry". This controls several aspects of the finished product.

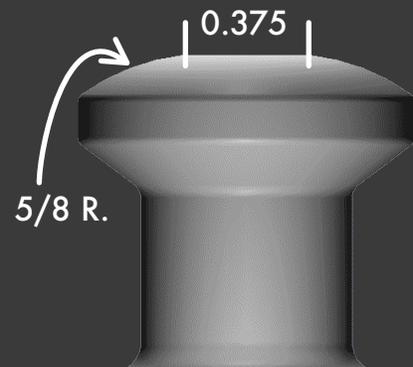
1. The length of the tool is measured from this surface, therefore if the punches wear, the lengths will not be consistent causing inconsistent thickness, weight and hardness of tablets.
2. Any wear to the punch flat is directly transferred to other contacted components. Pressure Rolls and ejection cams are damaged from punch head wear.
3. Punch heads receive the most abuse in the tableting cycle. If allowed to wear to extremes, metal fragments from punch heads and all related components can be detected in the compressed product.

"B-TYPE" HEAD FLATS

Standard TSM Head



Domed TSM Head

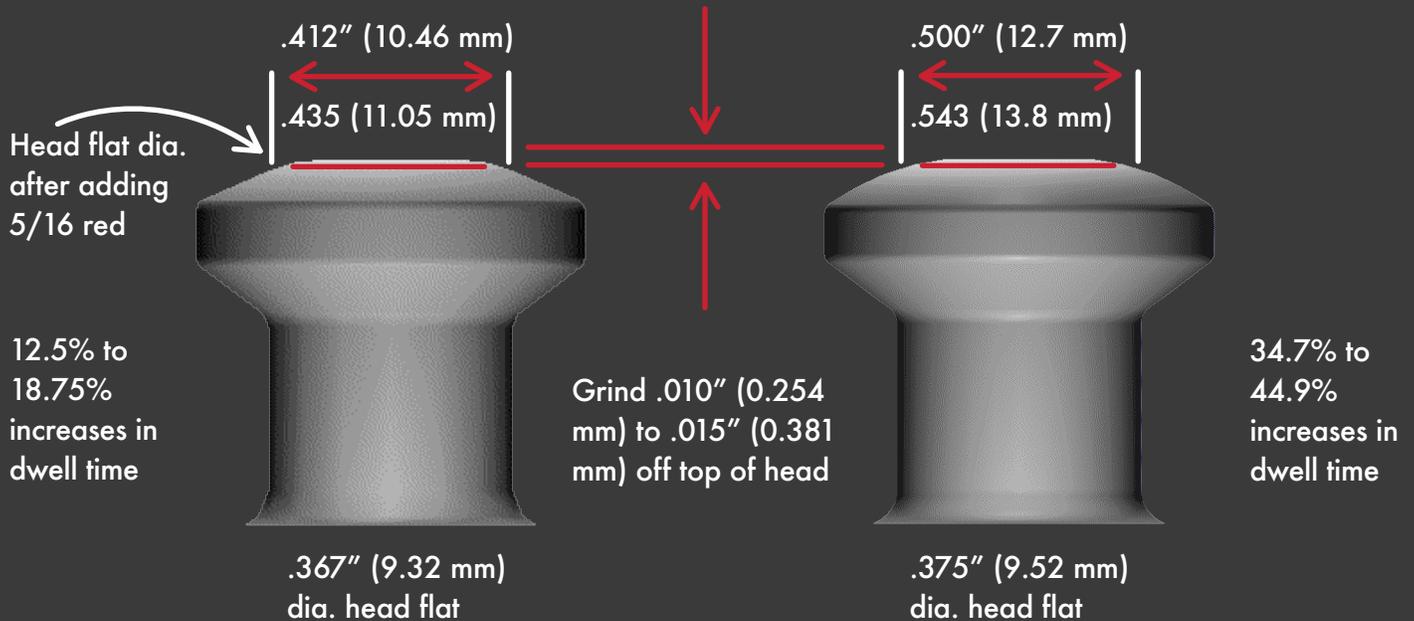




ENHANCED DWELL-TIME

Standard TSM Head

Domed TSM Head



Grind .010 or .015 off head to increase head flat diameter, & standardize working length to the TSM standard +/- .001, or +/- .0005 tolerance to control weight & density.