DIE PUNCH INSPECTION KIT :

Tooling, after prolonged usages are likely to give rise to any of the following problems :

- Excessive weight variation.
- Tablet thickness / hardness variation
- Excessive powder seepage, collar formation
- Punch running tight in die. Bending of small punch tips.
- If care is not taken in due time, these problems can cause costly breakdown. To co-relate these specific problems with the inconsistencies in the tooling, the following parameters need to be checked with help of this kit.
- Working height uniformity of all punches.
- Punch tip to die bore clearance.
- Punch tip to body concentricity
- This Kit can also check Cup Depth & other parameters like Punch Diameters, Die O.D., Die Height etc.

PROBLEM	CHECK	METHOD
Tablet weight, thickness and hardness variation	Inconsistent lower punches cause weight variation while upper punches cause thickness & hardness variation. Working height inconsistency can be checked by keeping the punch in upwards position The dial tip should be placed at the deepest point in cavity. Deviation in the dial reading between punches is difference in working height.	
Tablet center thickness variation	The total height of punch can be checked by keeping the punch in inverted position, supported in punch holding bush & comparing it with the standard height gauge. Depth of cavity is the difference between the total height & working height of the punch.	
Punch tip running tight / rubbing against the die bore	Punch body to tip concentricity by rotating the punch on a magnetic Vee block as shown.	
Dies are either too loose or too tight in the die-pocket	Die O.D. uniformity comparing with standard die O.D. block.	
Die protrudes from the die pocket	Check the height of one die using a micrometer. If height is ok, place this die under the dial and set the dial to '0' Replace this die with other die. Displacement in the dial is difference in the height. You can also check height uniformity by moving the die under dial.	
Powder Seepage / Collar Formation	Die bore accuracy with the help of Go / NoGo plug gauge.	
Punch tight in Turret / Die	Punch body & tip diameter with the Micrometer.	
Tablet does not match drawing	Check radius of concave tablets using the radius gauge	

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ITEM	SPECIFICATION	APPLICATION	DESCRIPTION
Dial Gauge Comparator Stand	Suitable to accommodate punch height	To hold the dial gauge while inspecting various parameters.	
Micrometer	Range = 0.25mm Least Count = 0.01 mm	To check outsider dimensions : Punch O.D., Punch Tip Dia, Die Height	
Punch Holding Bush	1 for 'B' Type 1 for 'D' Type	To hold the punch while inspecting the total & working height	
Punch Height Gauge	Standard = 5.260'' = 133.6 mm	Master piece to set the dial for Punch Height	
Die O.D. Block	'D' Type = 38.10 mm 'B' Type = 30.16 mm 'BB' Type = 24.00 mm	Maser piece to set the dial for Die O.D.	
Magnetic Vee Block	Suitable to accommodate punch & die	To hold the punch while checking punch body to tip concentricity	
Round Die Go-Nogo Plug Gauge	6 Nos. – as per requirement	To check the die bore size	
Magnifying Glass	Scale = 4X	To observe the punch tip cavity and die bore finish	
Die Pocket Cleaner	Suitable for D/B/ BB die	For Cleaning the die pockets in the turret	
Radius Gauge	1-7, 7.5-15, 15.5-25 mm	To check the radius of curvature of tablet	
Die Inserter Jig	Suitable for D/B/BB die	Used for installing the dies in turret.	

Note : Images Shown here are illustrative. As the design & manufacturing of Machines are subject to improvement, the product supplied will be as per our Techno-Commercial offer.