

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.

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 tablets 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 bevel-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

## 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

# Tableting Specifications Manual

**Yihong Qiu, Yisheng Chen, Geoff G.Z.  
Zhang, Lirong Liu, William Porter**

## **Tableting Specifications Manual:**

Tableting Specification Manual American Pharmacists Association,2006 This is the most comprehensive guide about the design of and specifications for tablet tooling the design of tablets and the appropriate compression forces for various types of tooling The manual provides detailed explanations and supporting illustrations for inspection and maintenance of tooling Two troubleshooting charts identify common tablet production problems and their remedies Tableting Specification Manual AMERICAN PHARMACISTS ASSOCIATION.,2025-08 The Tableting Specification Manual TSM is the pharmaceutical industry's guide for tablet tooling specifications in North America In addition to tooling specifications TSM includes information on terminology tablet manufacturing know how tablet design tool steels tool interchangeability maintenance and troubleshooting The contributions come from a team of volunteers each possessing years of experience and valuable knowledge with a willingness to share Tablet press tooling tablet presses and the tablet making industry continue accelerating rapidly Advances in machining technologies to manufacture tooling and tablet press components for optimized performance have paved the way for improved tablet making capabilities Other advancements in areas such as tablet simulator technology provide greater insight into controlling tablet attributes with increased understanding The culmination of this is improved product development greater scalability more predictable performance and continually improving tablet quality This new 8th edition provides a resource for tablet manufacturing professionals unlike anything else It is essential to remember that while this text governs tooling standards for North America it also serves as a guide for supporting tablet manufacture The best way to use TSM is to fully understand your current capabilities and improve and enhance those needs Our guidance is to work with the tooling suppliers and the tablet press Original Equipment Manufacturers OEMs They are a resource that can help your team utilize this guide to enhance performance and improve quality

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