

E-mail : [sales1@pharmachine.in](mailto:sales1@pharmachine.in)

WEBSITE : [www.pharmachine.in](http://www.pharmachine.in)

## MAXIMUM ALLOWABLE LOAD ON PUNCHES

Tablet Size (mm)	Compression force depending on type of cavity (In Metric Tons)		
	Flat Faced Shallow concave	Standard concave	Deep Concave Double Radius Flat Bevel Bevel Concave
4	1.0	0.6	0.4
5	1.6	1.0	0.6
6	2.3	1.4	0.9
7	3.1	1.9	1.2
8	4.0	2.5	1.5
9	5.1	3.2	1.9
10	6.3	3.9	2.4
11	7.6	4.8	2.9
12	9.0	5.7	3.4
13	10.6	6.6	4.0
14	12.3	7.7	4.6
15	14.1	8.8	5.3
16	16.1	10.1	6.0
17	18.2	11.4	6.8
18	20.4	12.7	7.6
19	22.7	14.2	8.5
20	25.1	15.7	9.4
25	39.3	24.5	14.7

All values in Metric Tones

- For Capsule / Oval / Odd Shape, consider the minimum cross section as the tablet size. For example in 19 x 8 mm Capsule, consider width 8 mm as reference size.
- For conversion of Metric Ton to Kilo-Newton : 1 Metric ton = 9.808 KN

This Chart is a general guideline and can be used to prevent damage to punches. It can be used to derive the ideal figure of tonnage required practically.