

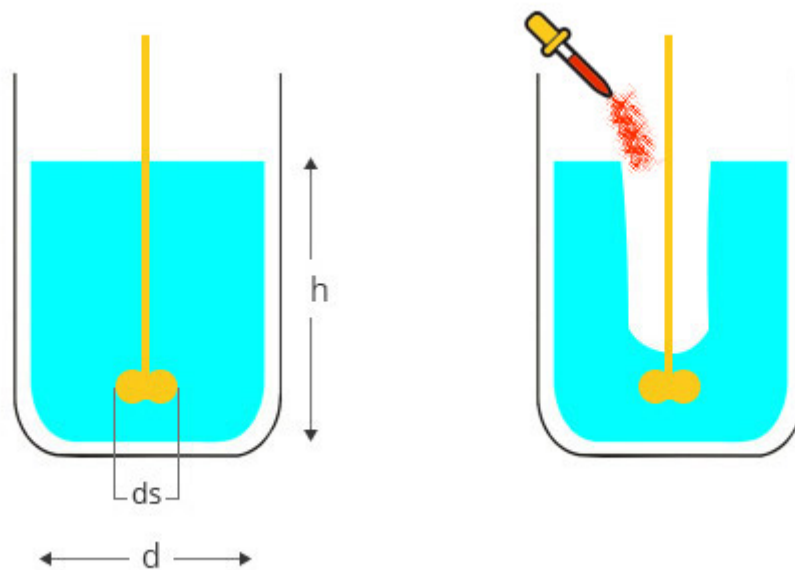
Recommended Solvent System and Reconstitution Level

Purified water at up to 35% w/w solids

Equipment / Accessories

Variable-speed mechanical stirrer

Mixing Vessel



Calculation of InstacoatTM4G and solvent quantities

Determine the quantities of InstacoatTM 4G (35% w/w solids) and water required, based on the quantity of tablets to be coated and the target coating weight gain. e.g.: For coating 1.0 kg of tablets to 3% wt. gain, weigh 3 g Instacoat and 61.3 gm purified water at room temperature (includes 10% overage for losses).

Reconstitution Process

Add the weighed quantity of water to a mixing vessel.

Using a mechanical stirrer, stir the purified water to form a vortex.

Add required quantity of Instacoat™ 4G to the centre of the liquid vortex in a slow steady stream, avoiding clumping while maintaining a vortex. Once the entire quantity of Instacoat has been added, reduce the stirrer speed to eliminate the vortex. (Fig. 2) Continue mixing for 45 minutes.

Recommended Process Conditions

	Side-vented (fully perforated) pans	Conventional (non perforated) pans	Continuous Coaters
Pan diameter (inch)	24-60	12	24-30
Tablet load (kg)	10-350	0.5-1.0	150-430 static
Tablet throughput (kg/hr)	N/A	N/A	500-635
Weight gain (%)	2.5-3.0		
Number of guns	1-6	1-2	14-22
Liquid nozzle diameter (mm)	1.0-1.2		
Atomising air pressure (bar)	3.0-4.0		
Pattern air pressure	Set to achieve maximum uniform bed coverage		
Tablet bed temperature (°C)*	42-46		

Inlet air temperature (°C)	Set to achieve required bed temperature & process time
Suspension spray rate (g/min)	Set to achieve required bed temperature
Exhaust air volume	To maintain slight negative pressure in pan
Pan speed	To achieve steady tablet flow through spray zone

*Tablet bed temperature offers the most effective way of controlling the coating process. Where this measurement is unavailable, exhaust temperature may be substituted. However, the relationship between the two measurements is complex and depends on several factors such as pan load, pan depression, pan design and airflow rate. Indicated exhaust temperature may be above or below the true bed temperature. It is recommended that the relationship between the two measurements is calibrated.

Typical Constituents

PVA; Plasticiser; Titanium Dioxide; Edible Pigments, Anti-Tack & Adhesion Enhancing agents.