

Coating Parameters – Isopropyl Alcohol/Methylene Chloride Solvent Solution

Opadry®, complete film coating system, is a one-step product combining polymer, plasticizer and pigment, as required, in a dry concentrate. It provides excellent film forming capabilities including sharp logo definition, high tensile strength and excellent adhesion properties

The coating parameters listed in the table below are based on Colorcon data. Individual product and machine functions should be taken into account and conditions altered as required.

Pan Type		Fully Perforated Side Vented Coating Pan				Conventional Pan
Pan Diameter	cm	38.1	60.96	121.92	152.4	40.64
	in	15	24	48	60	16
Solution Preparation						
Solvent		IPA/MC **	IPA/MC **	IPA/MC **	IPA/MC **	IPA/MC **
Solids Content	% w/w	8	8	8	8	8
Run Objectives						
Theoretical Weight Gain	% w/w	3	3	3	3	3
Tablet Charge	kg	1.5 - 3.0	12 - 15	120 - 160	320 - 350	3
Gun Configuration						
Example Spray Gun	Type	Walther Pilot	Walther Pilot	Walther Pilot	Walther Pilot	Walther Pilot
Number of Guns	guns	1	1 - 2	3 - 4	5 - 6	1
Nozzle Diameter	mm	1	1	1.2	1.5	1
	in	0.04	0.04	0.05	0.06	0.04
Gun to Bed Distance	cm	8	15	22	27	8
	in	3.15	5.91	8.66	10.63	3.15
Gun to Gun Distance	cm		15	15	15	
	in	0	5.9055	5.9055	5.9055	0
Atomizing Air Pressure	bar	1.2	2	3.5	4.5	1.2
	psi	17.06	28.44	49.77	63.99	17.06
Pattern Air Pressure	bar	1.5	2.5	2.5	2.5	1.5
	psi	21.33	35.56	35.56	35.56	21.33
Process Parameters						
Drying Air Volume	cu.m/hr	250 - 290	424 - 470	2300 - 3060	5440 - 6630	140
	cu.ft/min	147 - 175	250 - 275	1350 - 1800	3200 - 3900	82.40
Pan Speed	rpm*	22	14	8	6	25
Pre-warm tablet Bed	°C	40 - 44	40 - 44	40 - 44	40 - 44	40 - 44
	°F	100.44 - 110.49	100.44 - 110.49	100.44 - 110.49	100.44 - 110.49	100.44 - 110.49
Inlet Air Temperature	°C	45	45	45	45	45
	°F	113.00	113.00	113.00	113.00	113.00
Tablet Bed Temperature	°C	33 - 38	33 - 38	33 - 38	33 - 38	33 - 38
	°F	82.86 - 95.42	82.86 - 95.42	82.86 - 95.42	82.86 - 95.42	82.86 - 95.42
Spray Rate	g/min	25 - 35	75 - 95	250 - 300	475 - 525	20 - 28
Approximate Coating Times	min	16 - 45	47 - 75	150 - 240	229 - 276	40 - 56

*Pan speed should be set so that even mixing of the bed occurs.

This will be influenced by tablet size, shape, friability and baffle type in the pan.

** isopropyl alcohol/methylene chloride mixture ratio can be 50:50 or 60:40 or 70:30

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