

## Coating Parameters

Nutraficient®, food supplement coatings are one-step film coating products available in clear, white and pigmented formulations. Developed specifically for food supplements, they provide excellent film forming capabilities including 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			
Pan Diameter	cm	38.1	60.96	122	152.4
	in	15	24	48	60
<b>Solution Preparation</b>					
Solvent		Purified Water	Purified Water	Purified Water	Purified Water
Solids Content	% w/w	12	12	12	12
<b>Run Objectives</b>					
Theoretical Weight Gain	% w/w	3	3	3	3
Tablet Charge	kg	1.5	15	120	280
<b>Gun Configuration</b>					
Example Spray Gun	Type	Schlick 930-33/7-1 S22	Schlick 930-33/7-1 S23	Manesty	Manesty
Number of Guns	guns	1	2	3	5
Nozzle Diameter	mm	1.2	1.2	1.2	1.2
	in	0.05	0.05	0.05	0.05
Gun to Bed Distance	cm	15	15	30	30
	in	6	6	12	12
Gun to Gun Distance	cm		15	15	15
	in		6	6	6
Atomizing Air Pressure	bar	1.5	2.5	3	2.5
	psi	21	35	43	35
Pattern Air Pressure	bar	1.5	2.5	3	2.5
	psi	21	35	43	35
<b>Process Parameters</b>					
Drying Air Volume	cu.m/hr	250	500	2200	6500
	cu.ft/min	147	294	1295	3826
Pan Speed	rpm*	20	15	7	3.5
Pre-warm tablet Bed	°C	46-48	46-48	47	46-48
	°F	115-118	115-118	117	115-118
Inlet Air Temperature	°C	60	65	65	65
	°F	140	149	149	149
Tablet Bed Temperature	°C	38	37	40	39
	°F	100	99	104	102
Spray Rate	g/min	12	70	300	500
Approximate Coating Times	min	34	59	110	154
*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.					

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