

BS ISO 18084:2011



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Press tools for tablets — Punches and dies

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National foreword

This British Standard is the UK implementation of ISO 18084:2011. It supersedes BS ISO 18084:2005 which is withdrawn.

The UK participation in its preparation was entrusted to Technical Committee MTE/12, Tools for pressing and moulding.

A list of organizations represented on this committee can be obtained on request to its secretary.

This publication does not purport to include all the necessary provisions of a contract. Users are responsible for its correct application.

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Compliance with a British Standard cannot confer immunity from legal obligations.

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Amendments issued since publication

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INTERNATIONAL STANDARD

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Second edition
2011-09-15

Press tools for tablets — Punches and dies

Outillage de presse pour comprimés — Poinçons et matrices



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ISO copyright office
Case postale 56 • CH-1211 Geneva 20
Tel. + 41 22 749 01 11
Fax + 41 22 749 09 47
E-mail copyright@iso.org
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Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

International Standards are drafted in accordance with the rules given in the ISO/IEC Directives, Part 2.

The main task of technical committees is to prepare International Standards. Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights.

ISO 18084 was prepared by Technical Committee ISO/TC 29, *Small tools*, Subcommittee SC 8, *Tools for pressing and moulding*.

This second edition cancels and replaces the first edition (ISO 18084:2005), of which it constitutes a minor revision. In particular, key item 5 and key item 34 of Figure 1 and detail X of Figure 7 have been corrected.

Press tools for tablets — Punches and dies

1 Scope

This International Standard specifies the main dimensions, tolerances and characteristics of punches and dies for all kinds of tablets.

This International Standard deals with measures which are relevant for the interchangeability of the press punches between the different tableting machines of various manufacturers.

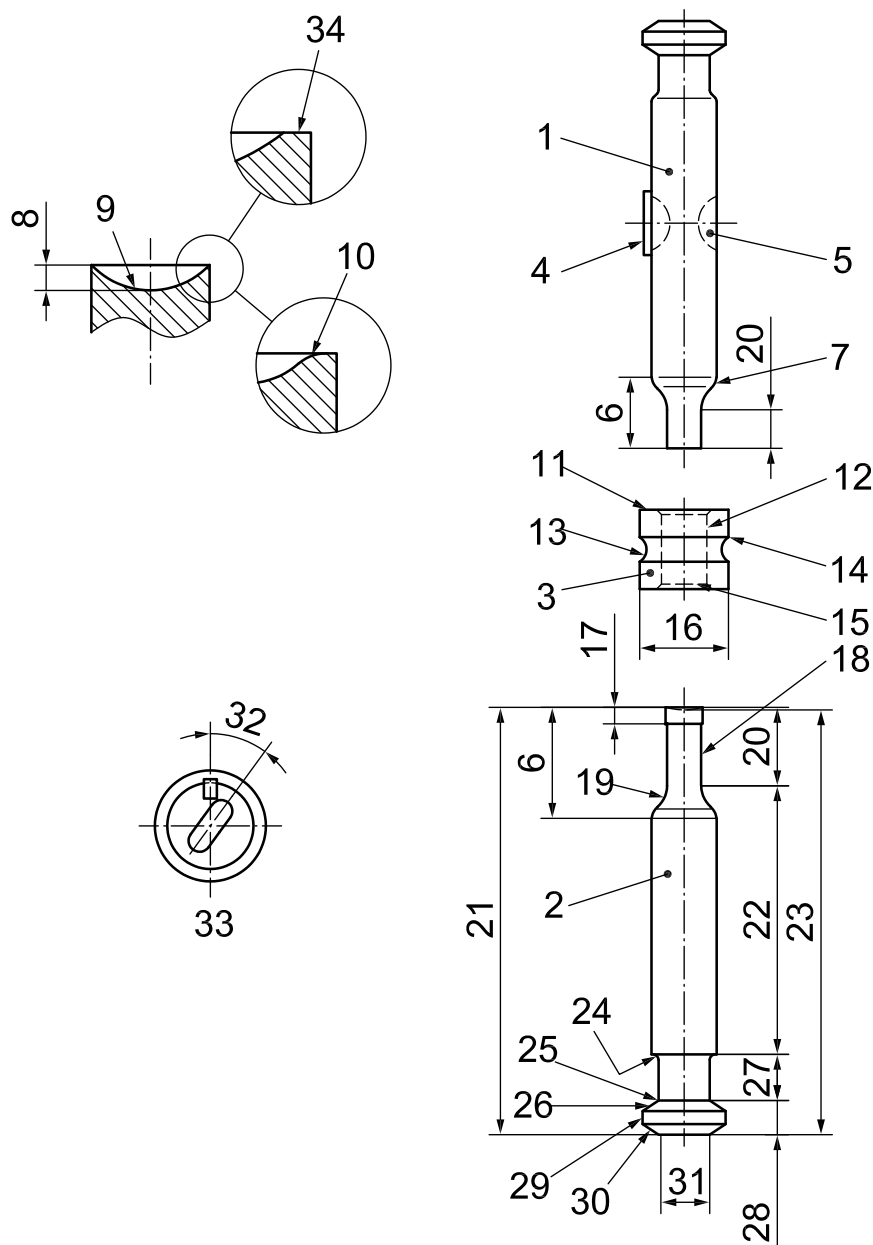
2 Normative references

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 2768-1, *General tolerances — Part 1: Tolerances for linear and angular dimensions without individual tolerance indications*

3 Nomenclature

See Figures 1 and 2.



Key

1 upper punch	13 die groove	25 neck-to-head radius
2 lower punch	14 protection radius or shoulder	26 inside head angle
3 die	15 chamfer or radius	27 neck under head
4 key	16 outer diameter	28 head
5 keyway	17 tip straight	29 head outer diameter
6 stem (tip to full barrel)	18 relief	30 outside head angle
7 barrel-to-stem chamfer	19 barrel-to-stem radius	31 head flat
8 cup depth	20 working length of the tip	32 key orientation angle
9 tip face	21 overall length	33 upper punch face key position
10 blended land	22 barrel	34 land
11 face	23 working length	
12 bore	24 barrel-to-neck radius	

Figure 1 — Punch and die terminology