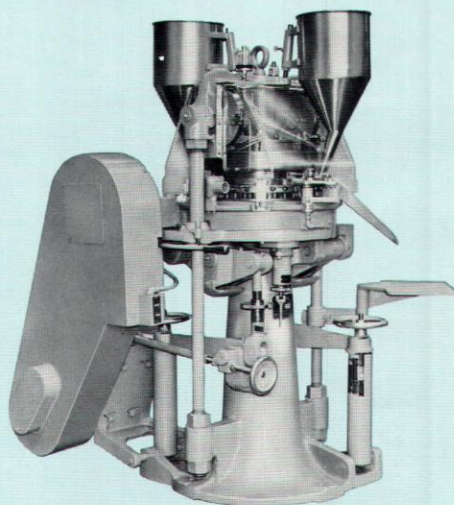


STOKES® Series Model 513 Rotary Tablet Presses

Two Models available: Model 513-2, 45 station • • produces up to 4200 tpm, and 7/16" diameter maximum;
 Model 513-3, 35 station • • produces up to 3260 tpm, and 5/8" diameter maximum.

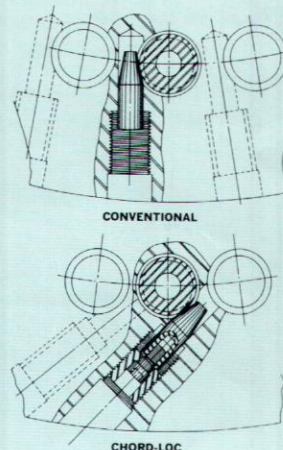
OUTSTANDING FEATURES

- **Chord-Loc die arrangement.** Patented design permits the use of more tooling stations in a given size head. This extra capability extends, over a conventional design, both filling time and the time that material is under compression, regardless of tablet output speed. Also provided is a more continuous material flow, which can result in consistently better tablet weight uniformity.
- **Controls** — Conveniently located weight, pressure and speed adjustments can be made while equipment is in operation.
- **Pin-type transit-level tunnel feeder.** Funnels material directly over die cavity. Coupled with pins, this action improves filling of the dies for accurate tablet weight. Unit is complete with adjustable flow control for optimum accuracy of tablet weight. No moving parts to wear out. Level adjustment provides for precise positioning.
- **Clutch** — Low effort multiple disc clutch with manual interlock provides smooth transmission of power and prevents accidental start-up of press.
- **Three-Piece rotary head.** Die table section is made of steel plate for maximum strength and long life, and is ground and polished to assure better quality tablets.
- **Hardened steel worm and replaceable bronze head gear.** Give smooth, trouble-free and quiet transmission of power under the most adverse operating conditions.
- **Guarding** — See thru full upper head guard. Permits viewing the press operation yet allows for fine tuning of material flow while press is in operation.
- **Heavy Duty Bearing Support Drive** — Promote long life, low maintenance. Withstand sustained high speed and heavy tableting load conditions without generating high temperatures, thus reducing the possibility of thermal damage to materials being tableted.
- **Variable Speed Drive** — Makes possible continuous operation even under severe conditions; provides a wide choice of operating speeds for effective tableting of a broad range of materials.
- **Dust Suction Nozzles** — One at each compression station above and below the table. Result: cleaner operation and punch sockets, and smoother punch operation.
- **Punch Control** — Maintains upper punch on a level plane thru Dwell Cam system.



OPTIONAL FEATURES

- **Keywayed punch sockets.** Insure proper tool alignment when tablets of irregular shape are produced.
- **Lower punch support system.** Gives positive control of lower punch during entire cycle to improve tablet weight uniformity.
- **Light pressure indicating system.** Protects small and delicate shape tooling more effectively.
- **Tachometer** — Electric unit accurately indicates rate of production in tablets per minute.
- **Adjustable upper pressure rolls.** Permit tablets to be formed at various elevations in the die. This extends die life and often eliminates the tendency of tablets to cap and laminate. Convenient hand-wheel. Control with entrance indicator.
- **Shallow fill cams.** Make operation cleaner through less scrape-off and reduced attrition of granular materials. Shortens punch stroke for higher tableting speeds, increasing punch and die life, particularly with abrasive materials. Make possible satisfactory tableting of sticky, hygroscopic, and troublesome materials.



Series 513 rotary tableting presses utilize a unique Stokes Chord-Loc die arrangement. Drawings illustrate conventional and Chord-Loc methods of mounting and locking dies.

SPECIFICATIONS — Stokes Series 513 Chord-Loc® Rotary Tableting Presses

	Model 513-2	Model 513-3
Maximum production rates (tpm)	4200	3260
Number of tool sets	45	35
Maximum tablet diameter (in.)	7/16	5/8
Fill depth, adjustable range (in.)	0-1 1/16	0-1 1/16
Operating pressure (tons):		
Maximum	4	4
With standard release spring	1 1/2-4	1 1/2-4
With light release spring	0-1 1/2	0-1 1/2
Upper punch entrance (in.)	1/4	1/4
Upper punch stroke (in.)	1 1/4	1 1/4
Lower punch stroke (in.)	3/4	3/4
Lower roll adjustment (in.)	3/32-1/2	3/32-1/2
Pressure roll:		
Diameter (in.)	8	8
Face width (in.)	1	1
Dust collection nozzles and connections:		
Number	2	2
Size, NPT (in.)	1 1/4	1 1/4
Recommended dust collection capacity, 3" H ₂ O S.P. @ each nozzle (cfm)	50	50
Hopper capacity, each (cu. in.)	850	850
DRIVE		
Electrical service (volts, cycles, phase)	230 or 460/60/3	230 or 460/60/3
Motor:		
Hp	3	3
Rpm	1800	1800
Variable speed pulley drive (3:1 range)	S.E.	S.E.
Speed range (tpm)	1400/4200	1085/3260
Start-stop control circuit	S.E.	S.E.
T.E.F.C. motor	S.E.	S.E.
DIMENSIONS AND WEIGHTS		
Overall height (in.)	64	64
Floor to bottom of discharge chute (in.)	31	31
Width (in.)	36	36
Depth (in.)	34	34
Net weight (lb.)	2000	2000
Shipping weight (lb.)	2350	2350
Boxed for export (cu. ft.)	77	77

• **Punches and dies** are an important part of any tableting operation. They must be designed and manufactured to maximize output of perfect tablets. Stokes Punch and Die Department is staffed by experts in pharmaceutical tablet making, including tooling specialists, designers, artists, and a team of competent Metallurgical Engineers. The cumulative experience of these specialists contributes to optimum efficiency in every new design as well as to constant improvement in existing models.



TOOLS - NOMINAL

	Model 513-2	Model 513-3
Punch length (in.)		
Upper	5/4	5/4
Lower	5/4	5/4
Punch diameter (in.) ..		
Upper	3/4	3/4
Lower	3/4	3/4
Die diameter (in.)945	1.187
Die depth (in.)	7/8	7/8

SPECIFICATIONS SUBJECT TO CHANGE WITHOUT NOTICE

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