







MAXIMUM ALLOWABLE LOAD ON PUNCHES

Tablet Size (mm)	Compression force depending on type of cavity (In Metric Tones)		
	Flat Faced 	Standard concave 	Deep Concave  Double Radius  Flat Bevel  Bevel Concave 
4	1.0	0.6	0.4
5	1.6	1.0	0.6
6	2.3	1.4	0.9
7	3.1	1.9	1.2
8	4.0	2.5	1.5
9	5.1	3.2	1.9
10	6.3	3.9	2.4
11	7.6	4.8	2.9
12	9.0	5.7	3.4
13	10.6	6.6	4.0
14	12.3	7.7	4.6
15	14.1	8.8	5.3
16	16.1	10.1	6.0
17	18.2	11.4	6.8
18	20.4	12.7	7.6
19	22.7	14.2	8.5
20	25.1	15.7	9.4
25	39.3	24.5	14.7

All values in Metric Tones

- For Capsule / Oval / Odd shape, consider the minimum cross section as the tablet size. For example in 19 x 8 mm Capsule, consider width 8 mm as reference size.
- For conversion of Metric Ton to Kilo-Newton : 1 Metric ton = 9.808 KN
- This chart is a general guideline and can be used to prevent damage to punches. It can be used to derive the ideal figure of tonnage required practically.