

IPR PACII CONTROL...



The Allen Bradley ControlLogix PLC is mounted inside a stainless steel cabinet.

Software Included:

CFR Part 11 Compliant PAC Software

Windows 2000 Operating System

Borland's Interbase (A secure SQL Database for Record Storage and Data Logging)

Intellution Human Machine Interface (HMI) Software

Hardware Included:

Allen Bradley ControlLogix PLC

Allen Bradley High Speed I/O Controller

Industrial Touch Screen Computer

Stepper Motor(s)

Stepper Controller(s)

LVDT & Demodulator

Portable Stainless Steel Cabinet

Encoder Assembly

Analog Devices 3B Strain Gage Input Modules and backplane

Analog Devices 3B LVDT Input Module

Proximity Sensors and Bracket on Press

Power Supply

All Cabling Between Cabinet and Press

Harting Connectors for cables on press

Tablet Press Shutdown Components

INDUSTRIAL PHARMACEUTICAL
RESOURCES, INC.

1241 Hardt Circle
Bartlett, IL 60103

IPR's PACII Tablet Press Control System is designed to provide automatic weight control and reject capability on any rotary tablet press. Utilizing Allen Bradley ControlLogix PLC technology and Intellution iFix HMI Software, IPR meets rigid industry standards for compliance, ease of use, reliability, and performance. Key features include:



Main Compression Trend Analysis Screen graphically displays average compression force, target force set point, weight adjust limits, tablet reject limits, turret rpm, tablets produced, tablets scrapped, product, and lot number.

Individual Tool Pressure Screen graphically displays individual punch peak forces, target force set point, weight adjust limits, tablet reject limits, turret rpm, tablets produced, tablets scrapped, product, and lot number.

Product Recipe Screen includes tablet weight specifications, press shutdown specifications, feeder speed, turret speed, overload tonnage setting, and revision history.

Press Recipe Screen includes calibration, missing punches, number of feeders, number of stations, control method, press name, and revision history.

Automatic Setup Screen automatically determines a target force set point, adjust limits, and reject limits per product. This feature not only saves time but also validates the reject limits!

Weight Feedback is available via weight scale or automatic weight, hardness, and thickness tester.

Hardness Tester Interface to record tablet hardness and shutdown tablet press for out of specification tablets.

Global Status Menu on each force screen to display date, time, product name, press name, current lot, tablets made, tablets scrapped, TPM, rpm, and operator's name.

Global Buttons on every screen for easy navigation. The operator is always just one button click away from getting back to the main screen!

Lot Reports to display total production, efficiency, total rejects, events, tablet force over time, and other useful summary information.

Overall Equipment Efficiency Report & Graphs to display and record machine use metrics.

Matching Our Objectives To Yours...

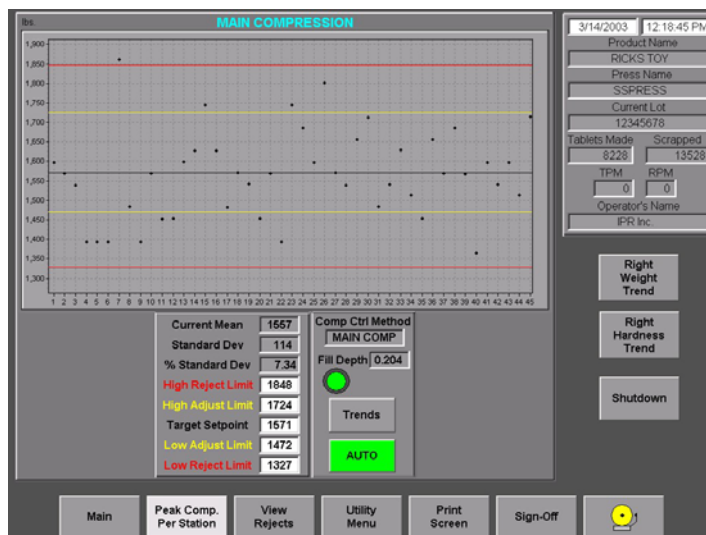


PROVIDES PEACE OF MIND

TOP TEN REASONS TO CHOOSE PACII

1. PEACE OF MIND
KNOWING THE
BIGGEST VARIABLE
IN YOUR COMPRES-
SION PROCESS IS
ELIMINATED.....
SUBJECTIVE DECISION
MAKING
2. PACII QUALITY &
EASE OF USE
3. COMPETENCY OF
IPR'S EXPERIENCED
TABLET MECHANICS
AND ENGINEERS
4. YOU CAN TRUST AND
COUNT ON IPR TO DO
THE RIGHT THING
5. SUPERIOR HIGH SPEED
TECHNOLOGY THAT
ENABLES MEASUR-
ABLE PERFORMANCE
OF WEIGHT CONTROL
AND TABLET REJECT
6. IPR'S REPUTATION
FOR PROVIDING OUT-
STANDING SERVICE
AND SUPPORT
7. THE PACII'S OPEN
TECHNOLOGY USING
PLC LOGIC
8. FLEXIBILITY OF A
SYSTEM CONFIGURED
FOR YOUR OPERA-
TION
9. HONESTY AND
SINCERITY OF IPR'S
ENTIRE GROUP OF
HARD WORKING
EMPLOYEES
10. TRUST IN IPR!

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The PACII Peak Compression Screen is pictured above. This useful screen enables tablet press operators to view individual station peak forces, view force, weight and hardness trends, and view Standard Deviation and % Standard Deviation. Navigation to other screens is easily done by simply touching a desired button at the bottom of the screen.

Additional PACII System Options Include:

- * Machine Control Software For Turret, Feeder, Lubrication, and Overload Sub Systems
- * Motorization of Tablet Thickness & Punch Penetration
- * VFD Upgrade
- * Low Hopper Sensor
- * Lubrication System Upgrade
- * Weight Scale and Hardness Tester
- * Air Blast Tablet Reject Mechanism
- * Single Piece Tablet Discharge Chute
- * Conversion To Corporate Database Standards (i.e. Sequel Server or Oracle)
- * Turret with Stainless Steel Die Table (Note: Increased # of stations on B & D Turrets is available.)



Matching Our Objectives To Yours...

