RTP 9® Tablet Press User Manual

We don’t just sell machines—
we provide service.

Copyright Notice

Important Safety Information

READ THIS BEFORE OPERATING MACHINE

Intended Use

The intended use of this machine is to press dry raw materials into tablet form.
Potential misuse of this machine includes:

- Applying too much force to the powder.
- Trying to fill the Die with powder by hand.
- Inserting Tooling that is too big for the machine.
- Not properly mounting the machine.
- Using powders that could explode under pressure.
- Using wet or damp material.

Personal Protection

For personal protection while transporting the RTP 9®, abide by these actions:

- Use an engine hoist to lift the machine.
- Wear steel toe boots to prevent foot injury.
- Wear heavy duty grip gloves to ensure firm grasp on machine.
- Wear back support belt to prevent injury if needed.

For personal protection while operating the RTP 9®, abide by these actions:

- Avoid wearing loose jewelry to prevent machine entanglement.
- Contain long hair to prevent machine entanglement.
- Wear safety goggles.
- Wear disposable latex/rubber gloves.
- Wear a hairnet (food grade products only).
- Wear a beard net if needed (food grade products only).

General Hazards

In the case of an emergency during operation, immediately push the Emergency Stop button or turn the Emergency Shut-Off Switch.

- Be aware of risk of entanglement and pinch point due to moving parts.
- Do not operate in a wet environment or with wet hands due to risk of electrical shock or burn.
- Do not operate if any wires are damaged, pinched, or frayed due to risk of electrical shock or burn.
- Keep out of reach of children.
- Keep fingers away from all moving parts.
- Ensure that machine is secure with anti-vibration feet on the workspace floor.
- Inspect machine before use.
- Check that nuts and bolts are suitably tightened.
- Use this machine only for its intended use as described in this manual.
- Do not modify the machine in any way.
- Turn off and unplug the machine before conducting cleaning and maintenance.

Important Safety Information

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Symbols

WARNING

This signals potential risk for personal injury.

WARNING

This signals potential risk for electrical shock.

CAUTION

This signals potential risk for damage to the machine or other parts.

Modes for Stopping

In the case of an emergency during automatic operation, immediately unplug the RTP 9® and/or push the Emergency Stop button or turn the Emergency Shut-Off switch:

Prop. 65 Statement for CA Residents

Based on LFA's current level of knowledge of our machines, the RTP 9® does not require a Proposition 65 warning label.

Warning for Explosive Material

This machine is not explosion proof. LFA recommends that you test your materials' explosivity before running them through this machine. If your materials are indeed explosive, do not use them with this machine.

Important Safety Information

READ THIS BEFORE OPERATING MACHINE

Installation and Safety Assessment

Due to the nature and design of this machine and its intended use in an industrial environment, it is important that before use it is installed in a cage with a mode of stopping on the outside of the cage. LFA Machines has decided that we can not possibly foresee all of the environments or situations in which this machine could be used or installed and therefore have determined that the end user must install the machine in a way that is appropriate and safe for its use.

Once the machine has been installed, it is critical that you conduct a safety assessment to ensure that it complies with all local and industry accepted safety regulations.

If you require guidance on the installation of the machine or conducting a safety assessment, please contact LFA Machines.

This machine is sold as an Unfinished Machine under the Machinery Directive (2006/42/EC) Article 13.

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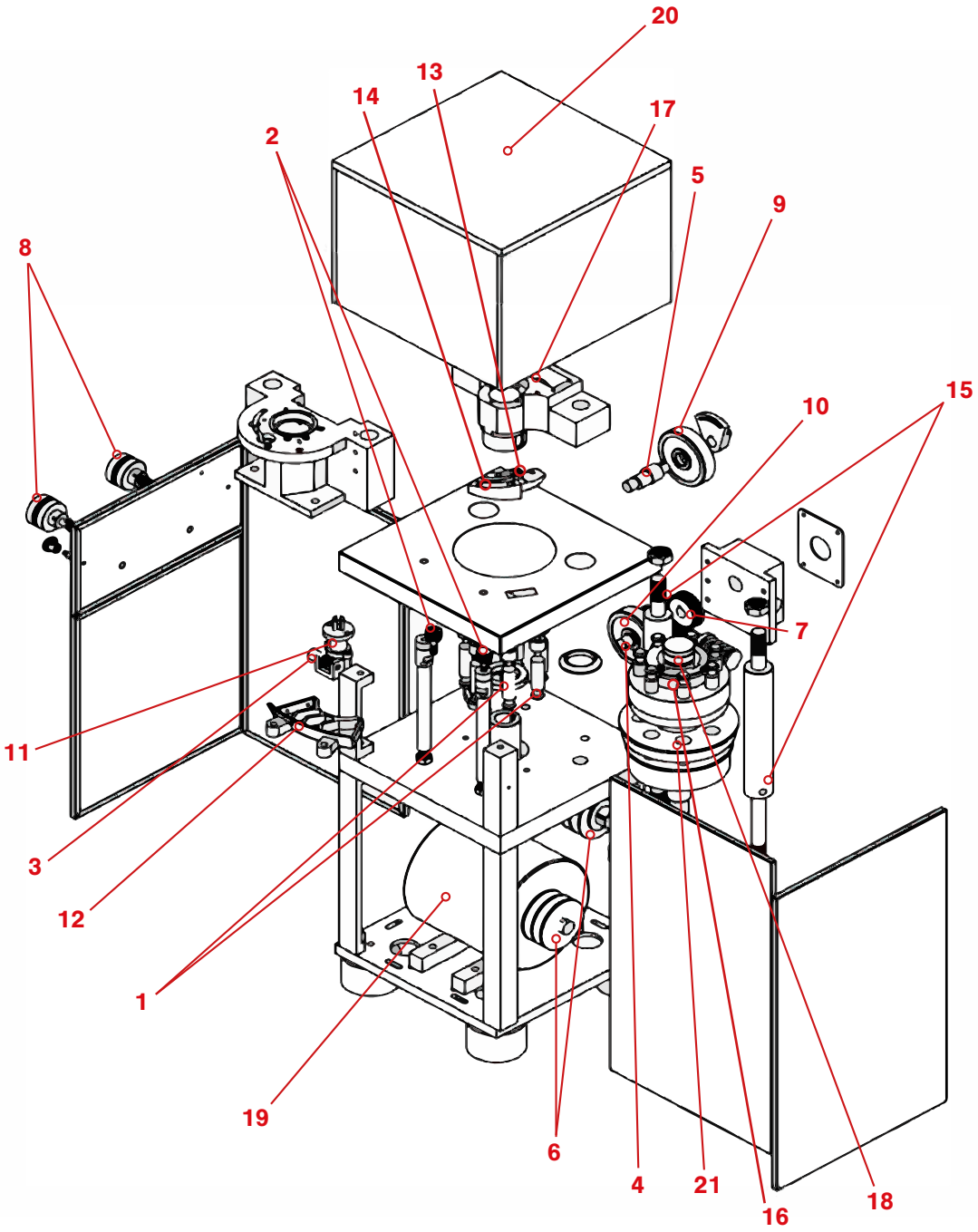
RTP 9® Components

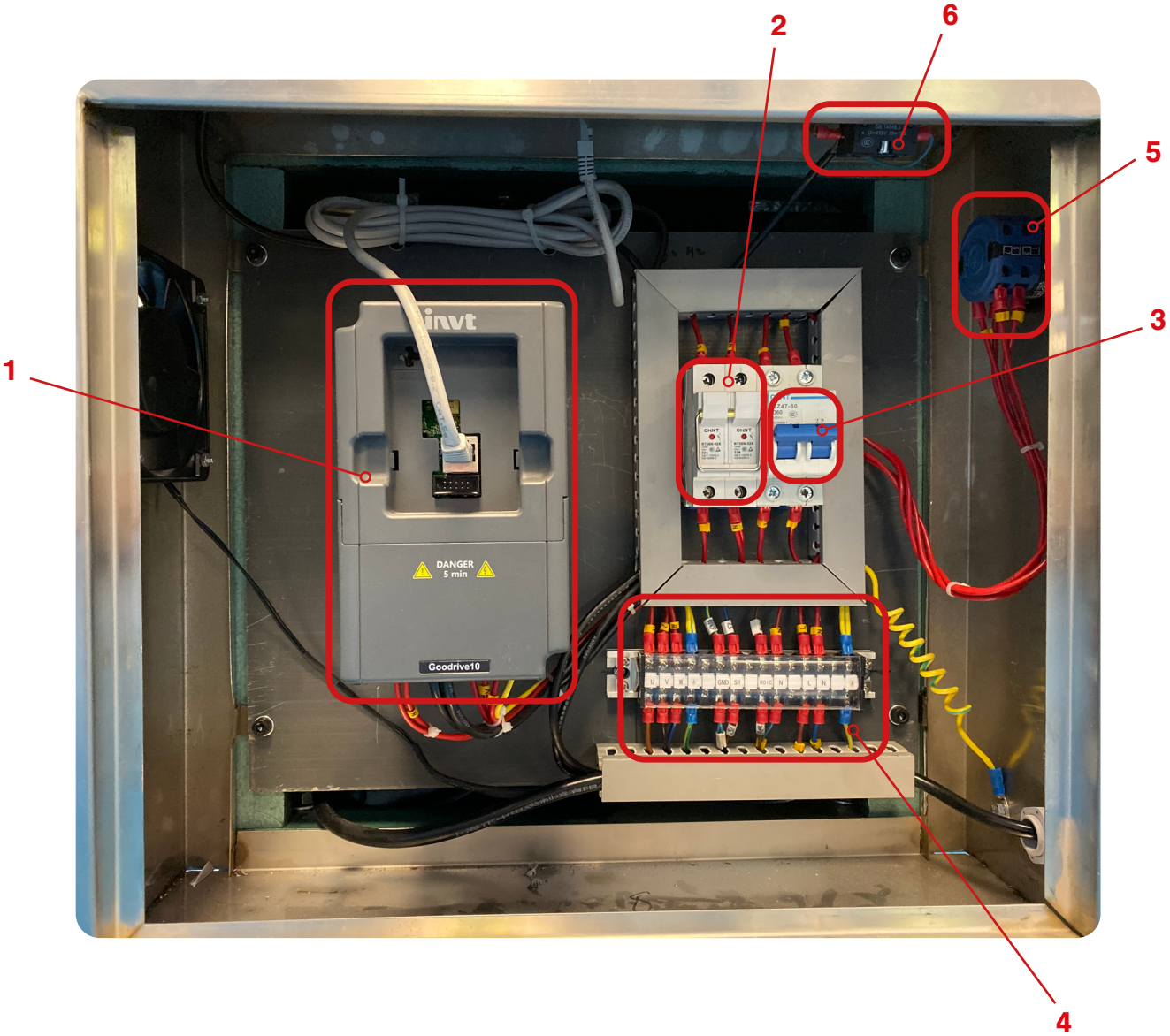


1. Lower Punches
2. Fill Tray Thumb Bolts
3. Fill Cam Adjustment Worm Gear
4. Lower Roller Cam Shaft
5. Upper Roller Cam Shaft
6. Drive Belt Pulley
7. Pressure Adjustment Cog
8. Pressure and Fill Depth Knobs
9. Upper Roller Cam
10. Lower Roller Cam
11. Fill Cam Adjustment Assembly
12. Fill Tray
13. Fill Cam
14. Ejection Cam
15. Upper Support Columns
16. Upper Tracking
17. Upper Roller Cam Housing
18. Main Cam Shaft
19. Motor
20. Perspex Casing
21. Turret

RTP 9® Electrical Components

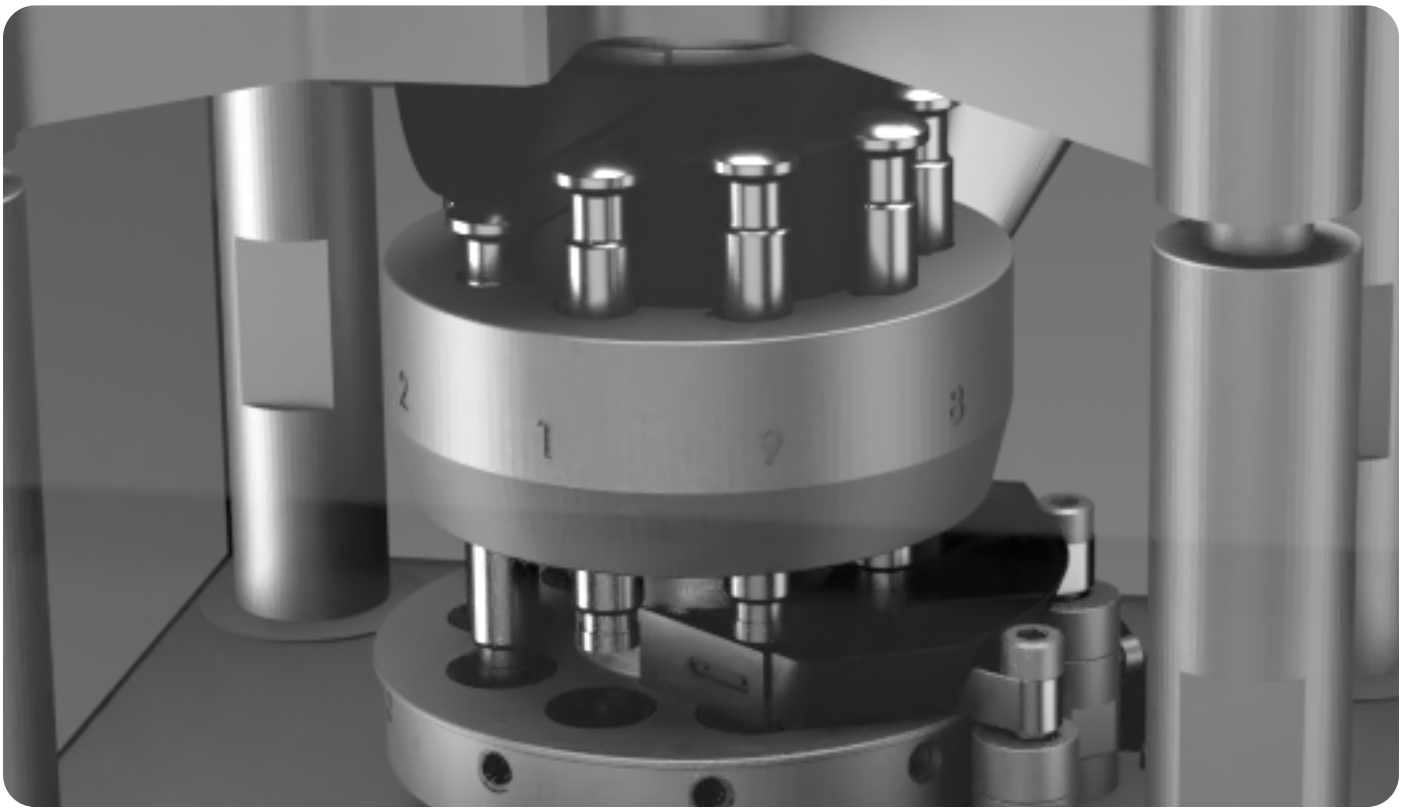
WARNING

Only qualified electricians should work with these controls.



1. The variable frequency drive (for motor speed)
2. Fuses
3. Breaker
4. Terminal block
5. Emergency stop
6. Power isolator switch

Preface



The RTP 9® is a rotary tablet press that can efficiently produce a high volume of quality tablets. With its nine Tooling heads and powerful motor, the RTP 9® has the ability to make up to 16,200 tablets an hour with a maximum of 40 kN of pressure. Rather than manually adjusting nuts and cogs, the RTP 9®'s advanced features include a convenient control console to manage tablet thickness, fill depth, and production speed. Particularly popular in the pharmaceutical, chemical, food, and electronic industries, the RTP 9® has been designed for research and development and medium-sized production with an emphasis on safety and ease of use.

The purpose of this document is to support your understanding of the RTP 9®'s components, features, functions, and design. With this manual, you will be able to successfully operate and maintain your RTP 9® machine.

The user manual's content includes:

- Important safety information
- RTP 9® installation instructions
- Description of the RTP 9®'s operation
- RTP 9® maintenance information
- Appendix with supplemental information

Training

RTP 9® training is essential for the machine's successful operation and your personal safety. There are several methods to prepare you for working with the RTP 9®.

On-Site/Off-Site Training

LFA technicians can travel and train you at your own facility with your own machines. LFA also offers free training at our UK, USA, and Taiwan facilities for all our customers and their teams. For more information, go to https://www.lfatabletpresses.com/services

Training via Video Chat/Phone

Using an online video chat system, an LFA technician can interact face-to-face with you and assist with your understanding of the machine. Or, if you prefer, LFA can provide training via phone for all customers who call the office. To set up a training, call or email your local LFA office:

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LFA Articles

LFA writes informative articles about tablet presses, which includes instructions, procedures, and guides.

To access the articles, go to https://www.lfatabletpresses.com/articles

LFA Videos

LFA has created several videos involving the RTP 9® and other tablet presses.

To access the videos, go to https://www.lfatabletpresses.com/videos or https://www.youtube.com/user/TabletPilPress

Installation

Tools and Materials Needed

Before you install and operate the RTP 9®, it is best to have the following tools and materials on hand for general operation and maintenance:

- Engine hoist or lift
- Lifting strap
- Hammer
- Crowbar
- Rubber mallet
- Metric wrench set
- Socket set
- Circlip pliers
- Pliers/grippers
- Flathead screwdriver
- Set of metric Allen keys with ball ends
- Long wire pipe cleaner
- Cleaner (e.g. Member's Mark Commercial Lemon Disinfectant)
- Sanitizer (e.g. Member's Mark Commercial Sanitizer)
- Lubricant (NSF approved type for food grade products)
- Grease gun
- Toothbrush
- Cleaning brush set
- Plastic sheet or something similar to cover machine
- Safety goggles
- Hairnet and/or beard net (food grade products only)
- Sterile shoe covers (food grade products only)

The Appropriate Workstation for the Machine

The floor on which the machine is to be placed must support the RTP 9®'s 260 kg (about 573 lbs) weight. The static floor loading limit is 0.8 kN/m2.

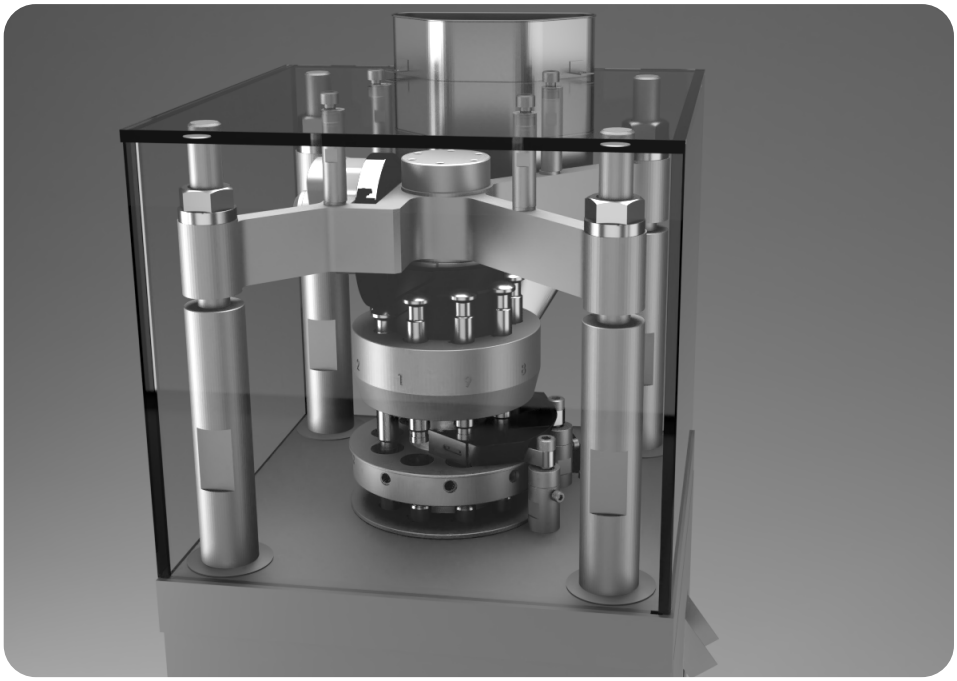
The machine's motor requires a single-phase power supply of 240 V or 110 V. Ensure to position the
machine near an appropriate electrical plug

Environmental Conditions

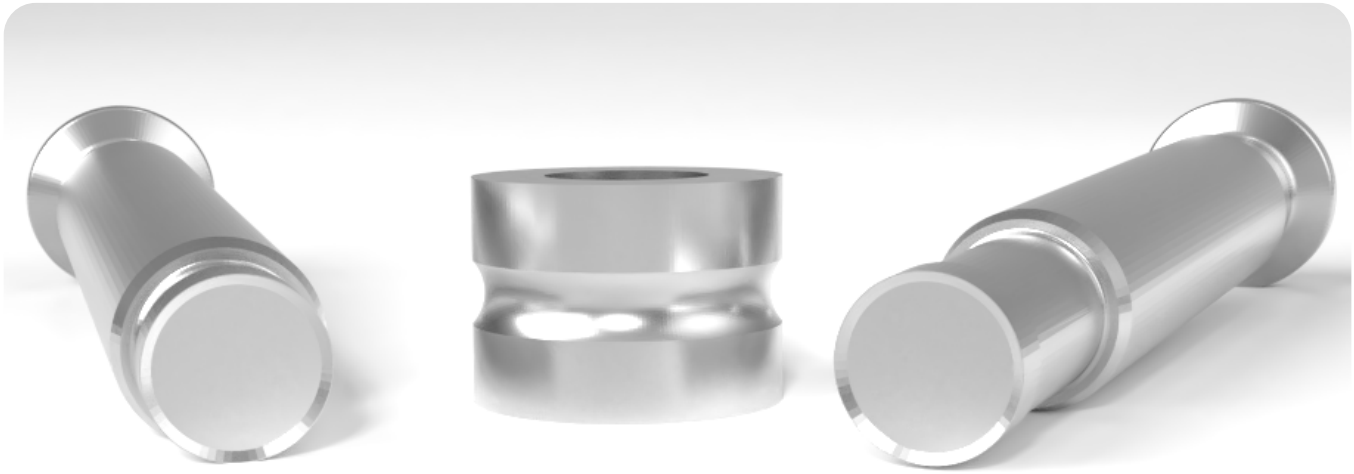
It is important that the environment in which you operate and store the RTP 9® has the appropriate temperature and relative humidity levels. These two environmental factors can potentially cause the machine to rust and/or cause the tablets to have a lower quality. The table below shows the acceptable temperature and relative humidity levels:

Machine	Temperature		Humidity
RTP 9®	°C	°F	45-65% RH
	18-24	64-75	

The shipping crate will contain the following:
1. The assembled RTP 9®



2. The Tooling (already installed)



3. Power Transformer (for 110 V countries only)

4. Toolkit including:

- Die Installation Bar
- Die Removal Bar
- Grease guns
- Panel door keys
- Socket set
- Crosshead screwdriver
- Flathead screwdriver
- Wrenches
- Allen key set

Unpacking the RTP 9®

Tools Needed

- Flathead screwdriver
- Hammer
- Wrench set

Instructions

1. Pry open each of the clips on the shipping container with a flathead screwdriver.

1.1 Note: Hammer the clips even further down to aid in removing the shipping container from the base.

2. Lift the top of the shipping container from its base, which is bolted to the RTP 9®.
3. Remove the plastic wrapping and set the Power Transformer and Toolkit aside.

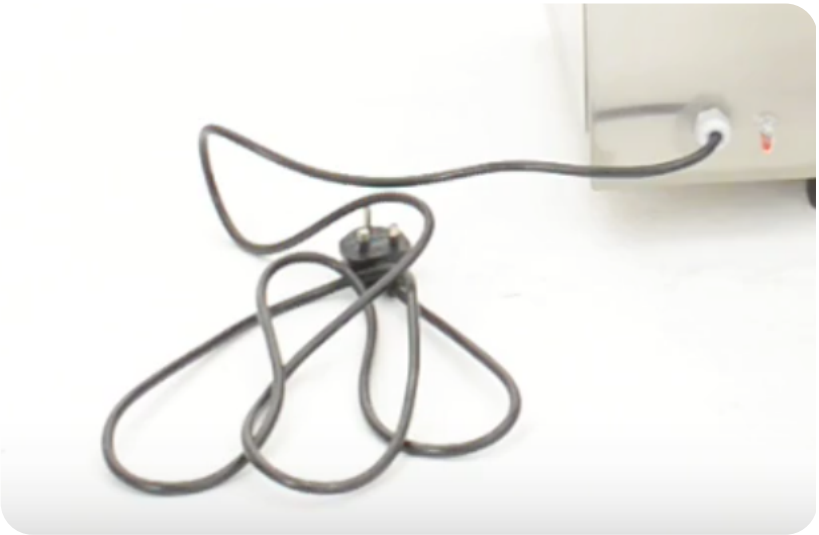
3.1 Note: Save the wrapping for future transport and/or storage.

4. Open the left-hand and right-hand panel doors to remove the nuts and bolts from the shipping container's base with a wrench.

4.1 Note: Keep the nuts, bolts, and the shipping container’s base in case you need to move or relocate the RTP 9®.

Assembly

The RTP 9® comes fully assembled. If you have a 110 V outlet, simply connect the RTP 9®'s electrical plug into the Power Transformer's outlet. After that, plug the Power Transformer into the power supply.



The RTP 9® also comes with anti-vibration pads underneath its base's four corners. The anti-vibration pads not only absorb noise and vibrations, but also reduce the machine's movement.

READ BEFORE INSTALLATION:
Depending on local health and safety laws, the RTP 9® may be required to be installed in a cage. A risk assessment is required to be conducted before installation and operation of the machine.

LFA Machines is able to advise on this. Please contact us for more information:

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Positioning the RTP 9®

WARNING: To prevent personal injury, wear steel toe boots and heavy duty grip gloves while transporting the RTP 9®.

Because of its 260 kg (around 573 lbs) weight, LFA does NOT recommend carrying the machine manually but rather with an engine hoist. At least two people should be involved (one operating the engine hoist and one stabilizing the machine) in removing the machine from the shipping container and placing it in the workspace.

Moving the RTP 9® with an Engine Hoist

Tools Needed

- Set of metric Allen keys with ball ends
- Engine hoist
- Lifting straps
- Heavy duty grip gloves
- Steel toe boots

Instructions

1. Loosen the Hopper's screws with an Allen key and remove it from the Perspex Casing.
2. Remove the screws on the Perspex Casing with an Allen key and remove it and the Hopper.
3. Remove all the panel doors.
4. Remove the Handle.
5. Feed the lifting straps through the four Upper Support Columns and around the Turret.
6. Bring together the lifting straps above the RTP 9® and into the engine hoist's lifting hook.
7. Carefully raise the RTP 9® with an engine hoist and guide it to your desired location.

    7.1 Note: Remember to secure the Perspex Casing, Hopper, and panel doors back onto the RTP 9®.

In accordance with Article 13 of the European Directive 2006/42/EC, LFA Machines sells the RTP 9® as a partly finished machine, and it is meant to be installed into and function as a part in a production line.

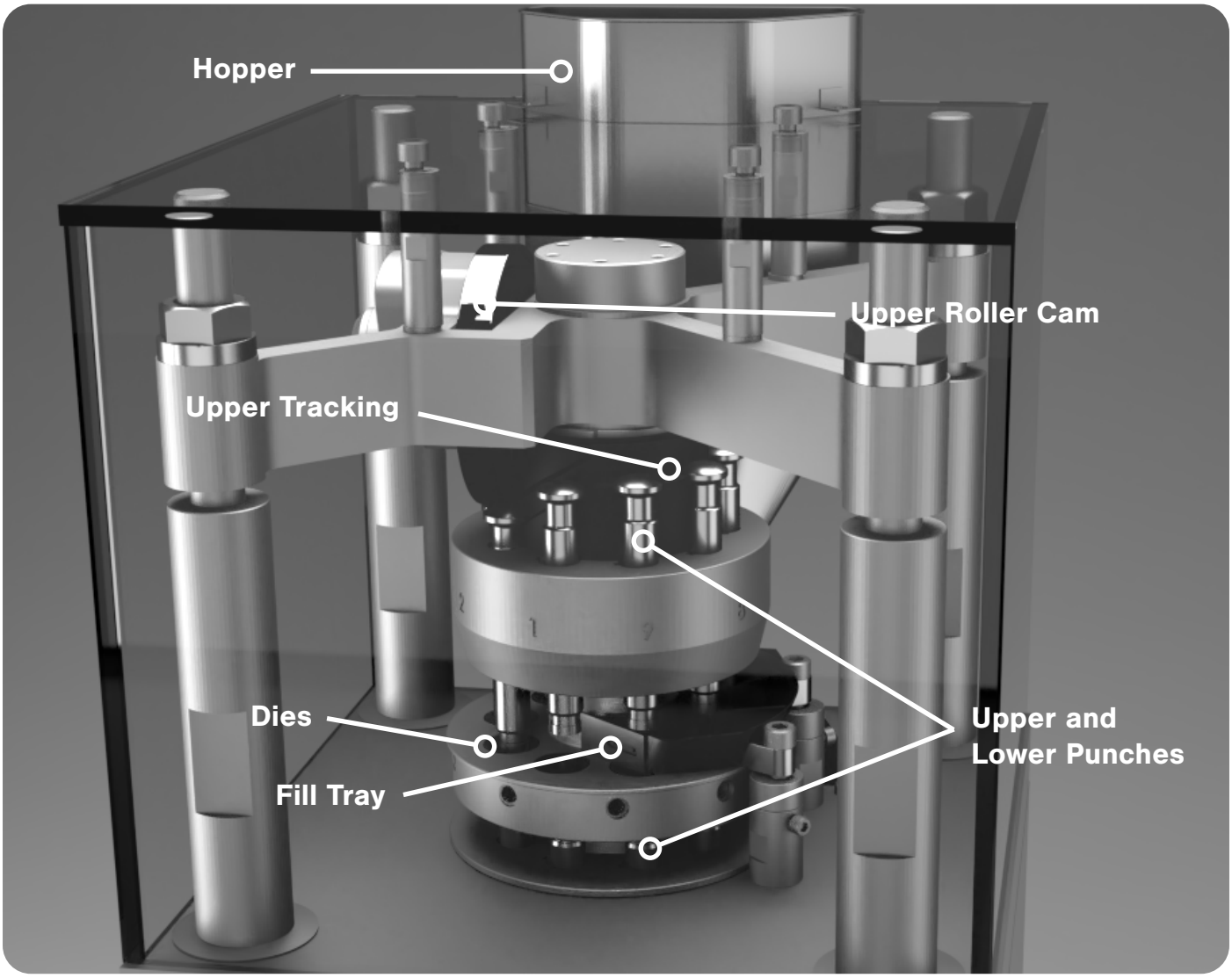
After the installation of this machine, the following measures need to be taken:

- **Shields must be installed in order to cover moving parts, those being in particular the Turret, Upper Punches, and Hopper.**
- **An emergency stop/emergency lockout/isolator switch must be installed on the outside of the machine.**
- **A risk assessment must be conducted on the entire production line.**

If you require guidance on the installation of the machine or conducting a safety assessment, please contact LFA Machines.

Controls

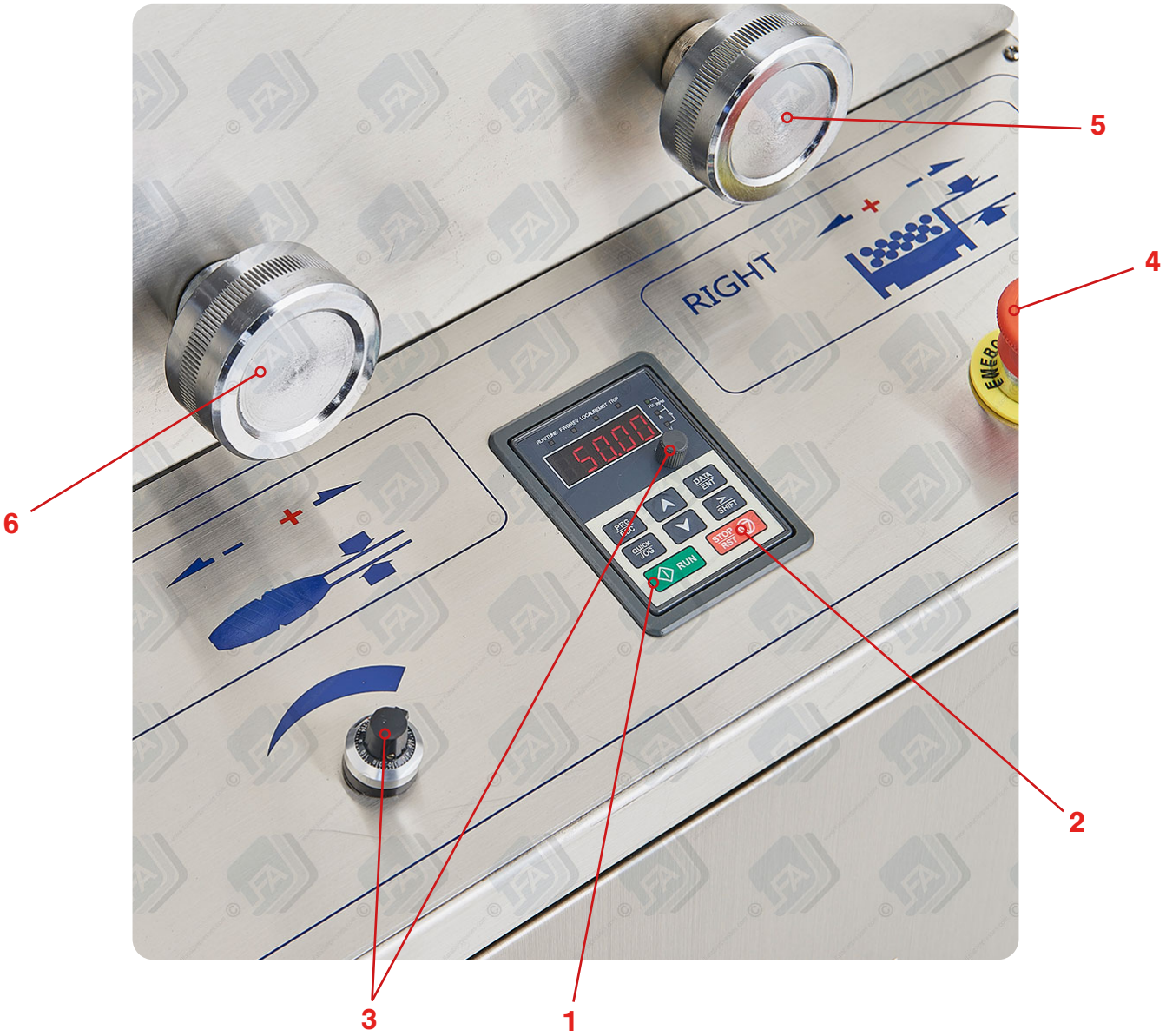
Basic Components



A description of the principal components follows:

- The **Hopper** holds the dry materials that will be compressed.
- The **Fill Tray** distributes the dry materials into the Die bores and pushes tablets into the Ejection Tray.
- The **Dies** define the size and shape of the powder.
- The **Upper Punches** and **Lower Punches** compress the materials within the Dies.
- The **Turret** houses the Tooling.
- The **Upper Tracking** and **Lower Tracking** guide the Tooling.
- The **Upper Roller Cam** and **Lower Roller Cam** compress the Upper Punches and Lower Punches to create the tablet.

Control Console



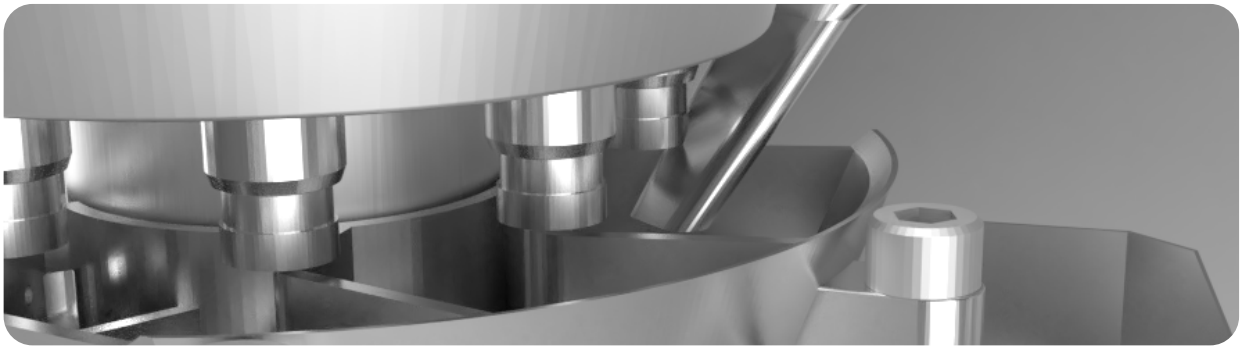
1. Starts machine.
2. Stops machine and resets variable frequency driver.
3. Controls production speed.
4. Cuts off machine in emergency.
5. Adjusts fill depth.
6. Adjusts punch pressure.

RTP 9® Process

The basic mechanism of the RTP 9® involves filling the Tooling (Dies, Upper Punches, and Lower Punches) with powder, compressing the powder, and ejecting the tablets.

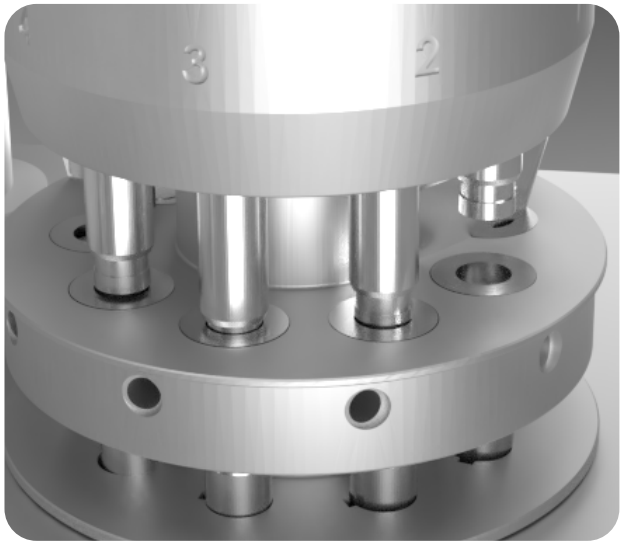
Filling the Tooling with Powder

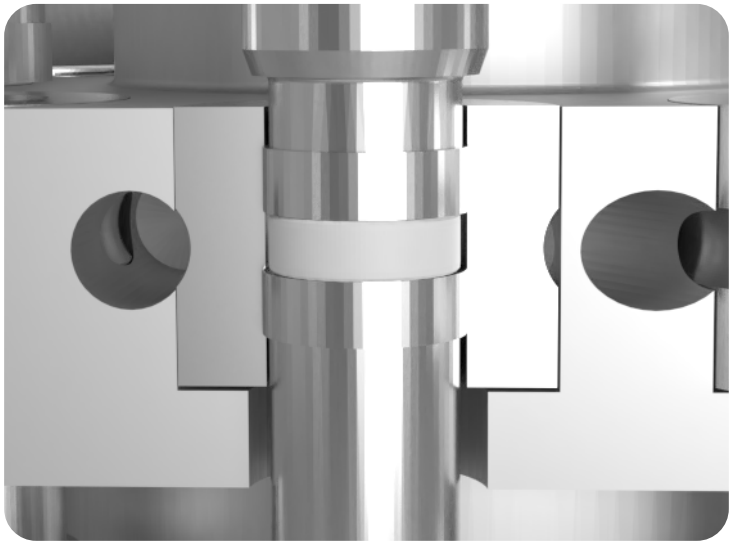
The dry materials are poured into the Hopper, which funnels the powder into the Fill Tray. As the machine operates, the Turret moves, which causes the Upper Punches to withdraw from the Dies. During this process, powder is moved by the Turret and is guided into the Die bores by the Fill Tray.



Compressing the Powder

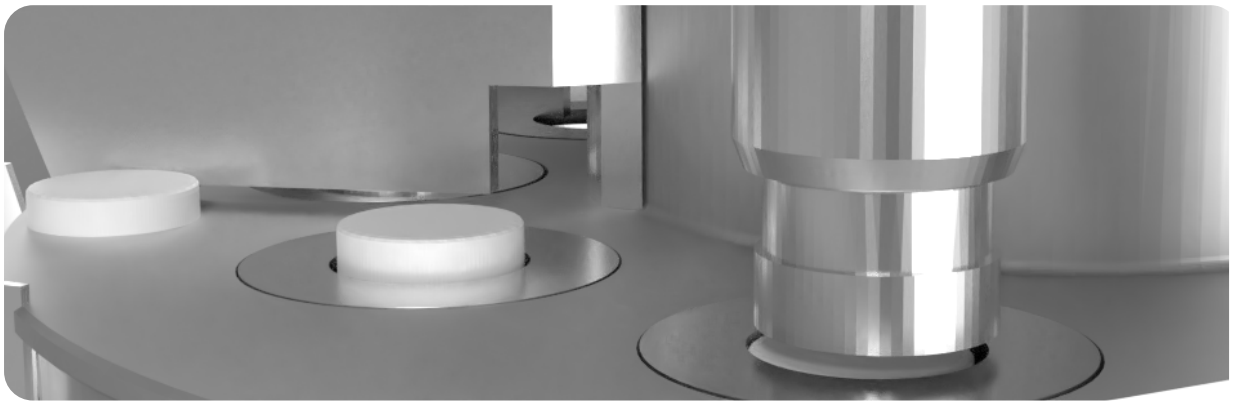
After the Die bore is filled with powder, the Upper Punches are driven into the Dies. The Upper and Lower Punches then compress the powder under high pressure.





Ejecting the Tablet

After both punches compress the powder into a tablet, the Upper Tooling is withdrawn and the tablet is then pushed out of the Die bore by the Lower Punch. Once the tablet has been ejected out of the Die bore, it is slid out of the way by the Fill Tray's Take-Off Blade to prepare for the next tablet compression.



How to Create Tablets with the RTP 9®

Tools and Materials Needed

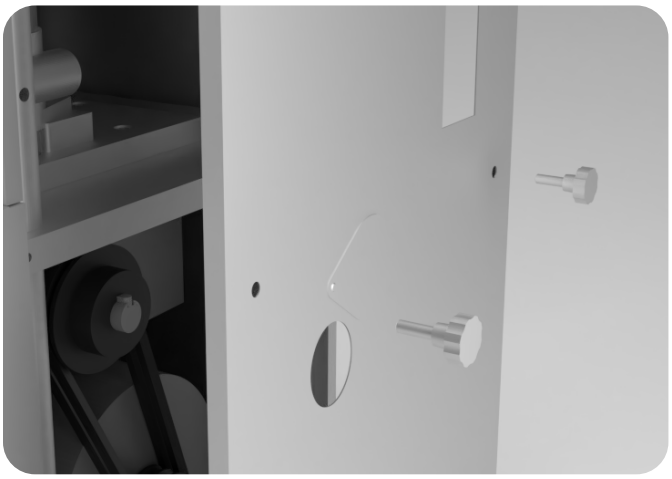
- Raw material formulation
- Fully assembled RTP 9® with Hopper
- Safety goggles
- Disposable latex/rubber gloves (for food grade products and to protect hands from grease)
- Hairnet and/or beard net (food grade products only)
- Sterile shoe covers (food grade products only)

WARNING: To prevent any potential personal injury, unplug the RTP 9® from the electrical outlet.

Instructions

Note: Wear latex/rubber gloves (and appropriate food grade attire if applicable) during this process.

1. Open the rear side panel door.
2. Fix the Handle onto the Drive Belt Pulley's socket.



3. Turn the Handle manually for one full Turret rotation in the direction indicated by the arrow to ensure proper machine operation.
4. Pour the dry materials into the Hopper.
    4.1 Note: Manually press a tablet to avoid the chance of jamming the machine.
5. Remove the Handle and reinsert the panel door.
6. Plug in the RTP 9® to an electrical outlet.
    6.1 Note: For 110 V outlet, plug in the Power Transformer and flip its switch.
7. Press the green RUN button to start the machine.
8. Press the red STOP button to stop the machine.

Settings and Adjustment

The RTP 9®s settings can be adjusted. Tuning the machine can help with changing the tablets' characteristics. To watch a video of tuning an RTP 9®, go to https://www.lfatabletpresses.com/rtp-9-tuning-your-press

Fill Depth

At times, a tablet will be too light or too heavy, and its weight must change. This simple adjustment determines the tablet's weight.

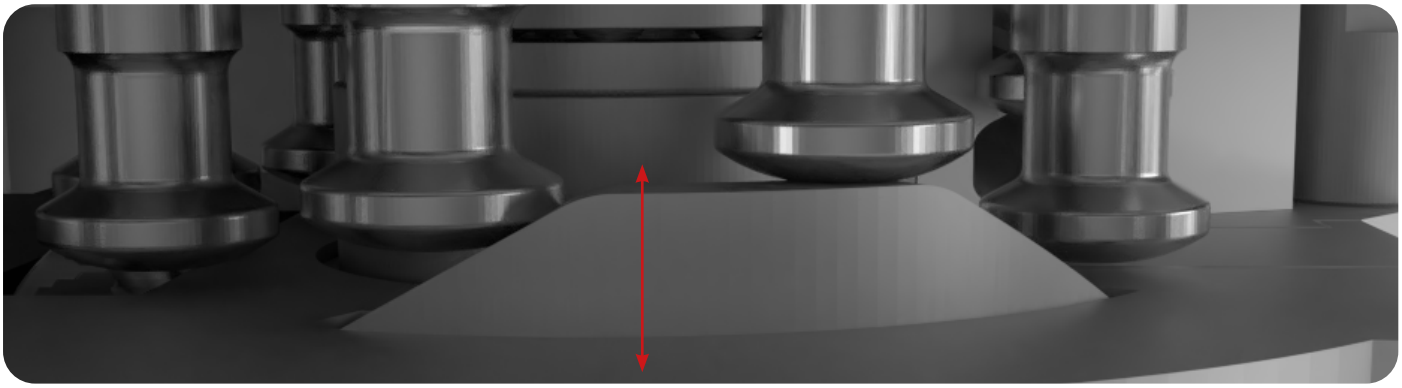
Tools and Materials Needed

- Disposable latex/rubber gloves (for food grade products and to protect hands from grease)
- Hairnet and/or beard net (food grade products only)
- Sterile shoe covers (food grade products only)

Instructions

Note: Wear latex/rubber gloves (and appropriate food grade attire if applicable) during this process.

1. Produce test tablets to determine how the machine should be adjusted.
2. Rotate the right-hand knob on the console to change the fill depth.
    2.1 Note: To increase the weight rotate the knob counterclockwise (this lowers the Dosing Cam). To decrease the weight rotate the knob clockwise (this raises the Dosing Cam).
    2.2 Note: It may take several rotations of the knob to make the fill depth adjustment.



Powder Flow from Hopper

If you find that there is excess powder waste due to overflow, the Hopper will need to be adjusted.

Tools and Materials Needed

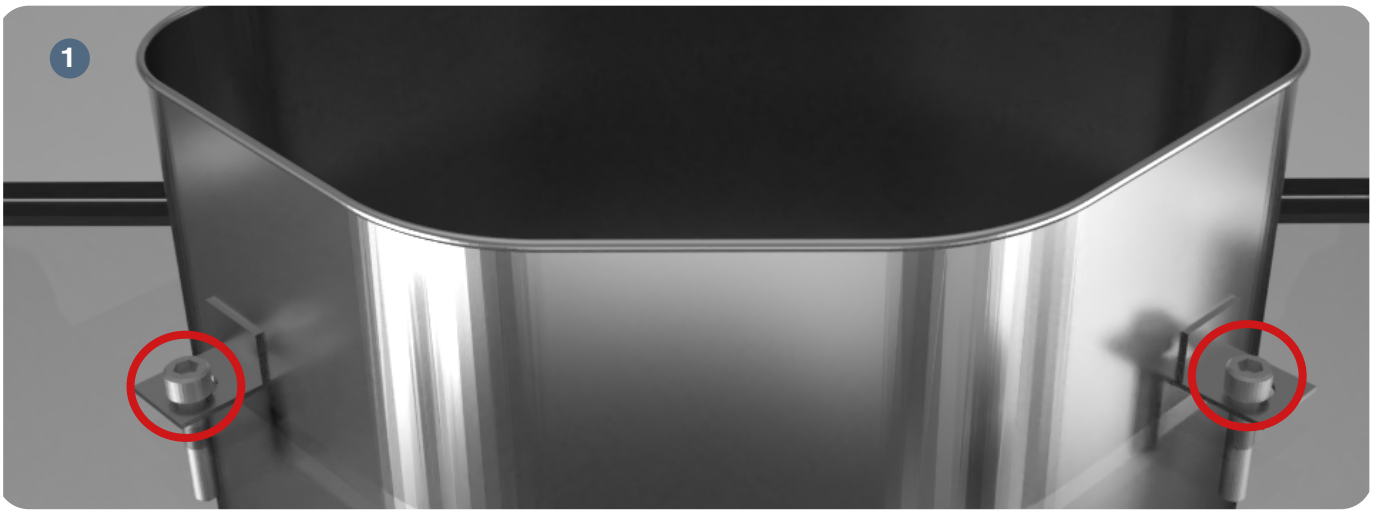
- Set of metric Allen keys
- Disposable latex/rubber gloves (for food grade products and to protect hands from grease)
- Hairnet and/or beard net (food grade products only)
- Sterile shoe covers (food grade products only)

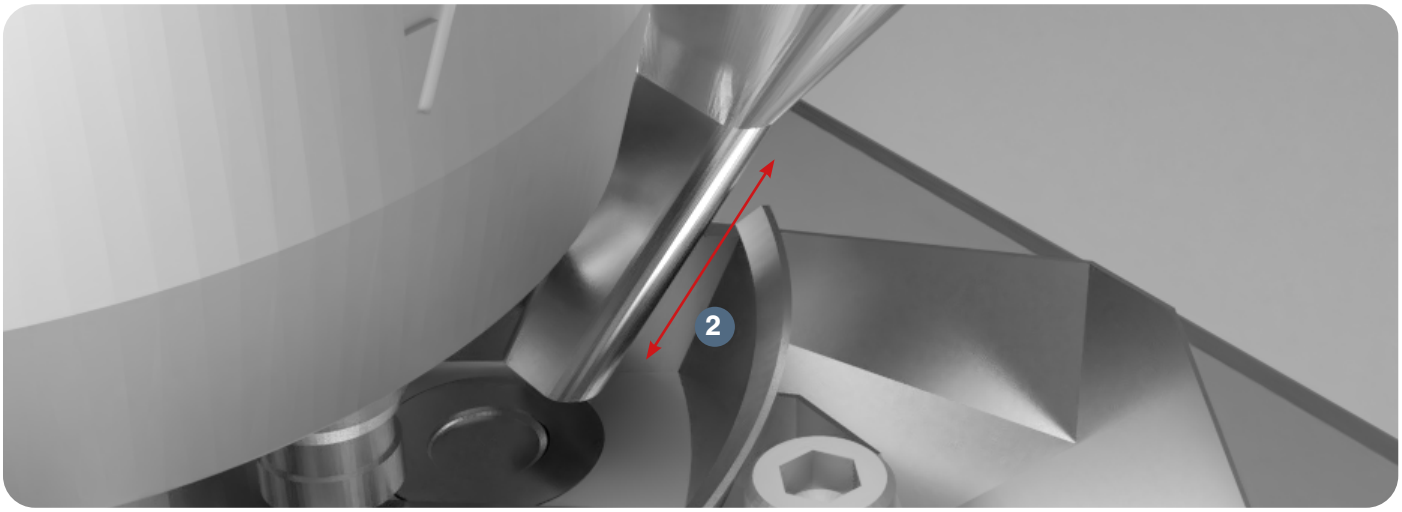
WARNING: To prevent any potential personal injury, unplug the RTP 9® from the electrical outlet.

Instructions

Note: Wear latex/rubber gloves (and appropriate food grade attire if applicable) during this process.

1. Adjust both of the Hopper screw bolts by hand and raise/lower the Hopper to the desired position inside the Fill Tray's gate.
    1.1 Note: The lower and closer the Hopper is to the Die table, the less flow there will be.
2. Tighten the bolts by hand to secure the Hopper into the desired place.





Fill Tray Height

The size of granules in your powder can affect how smoothly dry materials are moved through the Fill Tray, which can affect how much powder is wasted. Sometimes this requires the Fill Tray's height to be adjusted.

To watch a video of Fill Tray calibration, go to https://www.lfatabletpresses.com/rtp-9-adjusting-feed-frame

Tools and Materials Needed

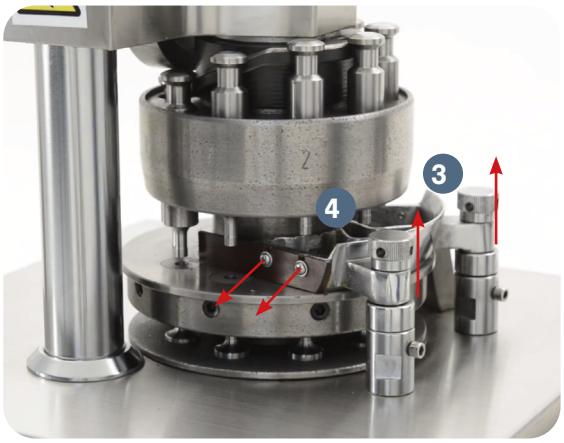
- Set of metric Allen keys
- Feeler gauge
- Disposable latex/rubber gloves (for food grade products and to protect hands from grease)
- Hairnet and/or beard net (food grade products only)
- Sterile shoe covers (food grade products only)

WARNING: To prevent any potential personal injury, unplug the RTP 9® from the electrical outlet.

Instructions

Note: Wear latex/rubber gloves (and appropriate food grade attire if applicable) during this process.

1. Loosen the Hopper's screws with an Allen key and remove it from the Perspex Casing.
2. Open up the Perspex Casing's door to gain access to the Fill Tray.
3. Loosen the Fill Tray Thumb Bolts with an Allen key or by hand and remove them.
4. Loosen the Fill Tray Scraper and Take-Off Blade with a crosshead screwdriver.



5. Run a feeler gauge between the Fill Tray and the Turret to determine the adjustment.
    5.1 Note: Start at 0.15 mm and raise appropriately if there is no powder waste/damage to the Fill Tray. If there is waste, lower it.
6. Adjust the Fill Tray Height Adjusters accordingly and tighten their bolts.
7. Resecure the Fill Tray Scraper and Take-Off Blade with a crosshead screwdriver.
    7.1 Note: Make sure that they are flush against the Turret.
8. Tighten the Fill Tray Thumb Bolts by hand or with an Allen key.
9. Reinsert the Hopper into the Perspex Case and secure its screws with an Allen key.

Tablet Thickness

Sometimes you will need to adjust the tablets' thickness so that the pressure relative to the fill is high, which results in creating a solid tablet.

Tools and Materials Needed

- Disposable latex/rubber gloves (for food grade products and to protect hands from grease)
- Hairnet and/or beard net (food grade products only)
- Sterile shoe covers (food grade products only)

Instructions

Note: Wear latex/rubber gloves (and appropriate food grade attire if applicable) during this process.

1. Produce test tablets to determine how the machine should be adjusted.
2. Rotate the left-hand knob on the console to change the punch pressure.
    2.1 Note: To make tablets thinner, rotate the knob counterclockwise (increase punch pressure). To make tablets thicker, rotate the knob clockwise (decrease punch pressure).
    2.2 Note: The pressure adjustment knob can be sensitive. Make adjustments in small increments.

CAUTION: If the punch pressure is increased too much, the machine will sustain a lot of damage even though the machine will automatically cut off. Simply decrease the punch pressure to its limit to get the machine running again.

Upper Punch Penetration

If the tablet needs to be around 1 mm thicker or thinner, you can adjust the Upper Roller Cam.

Watch a video of upper punch penetration adjustment at https://www.lfatabletpresses.com/rtp-9-upper-roller-adjustment

Tools and Materials Needed

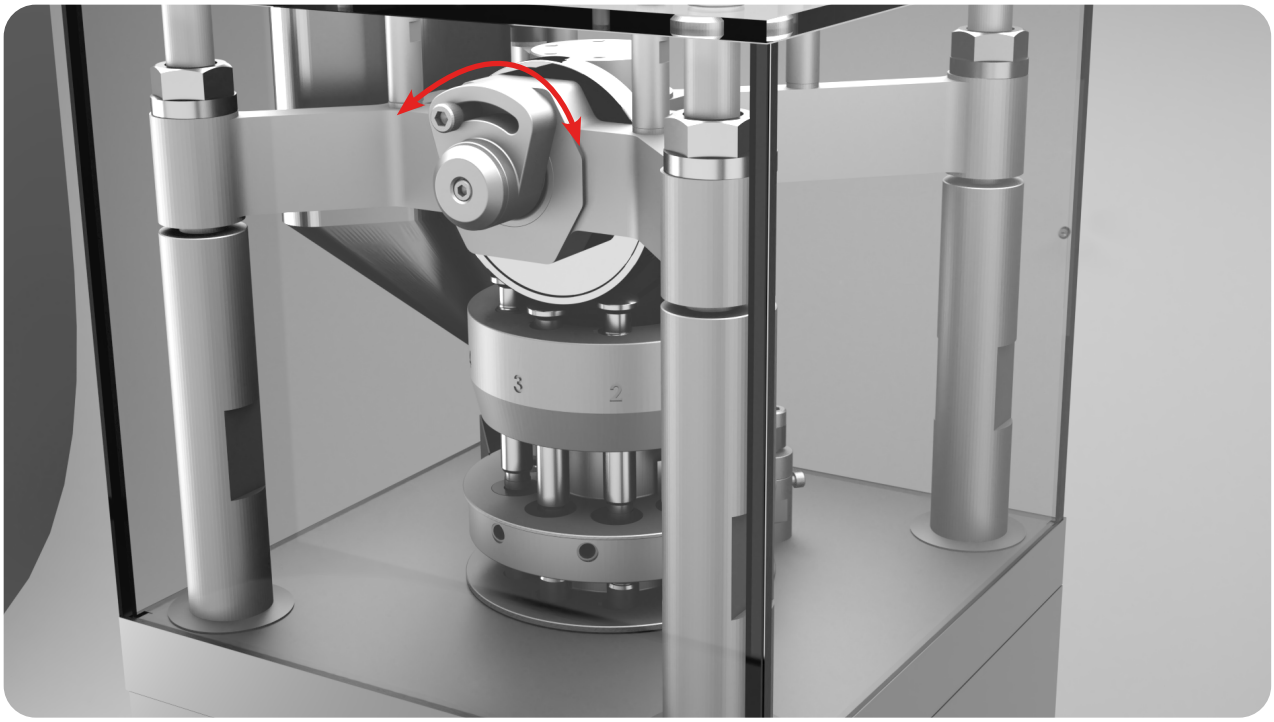
- Set of metric Allen keys
- Disposable latex/rubber gloves (for food grade products and to protect hands from grease)
- Hairnet and/or beard net (food grade products only)
- Sterile shoe covers (food grade products only)

WARNING: To prevent any potential personal injury, unplug the RTP 9® from the electrical outlet.

Instructions

Note: Wear latex/rubber gloves (and appropriate food grade attire if applicable) during this process.

1. Open the Perspex Casing's front door to gain access to the Upper Roller Cam Pressure Adjuster.
2. Loosen the Upper Roller Cam Pressure Adjuster's bolt with an Allen key.
3. Move the Upper Roller Cam Housing Adjuster to increase or decrease the Upper Punch's penetration.
    3.1 Note: To increase, move clockwise. To decrease, move counterclockwise.
4. Resecure the Upper Roller Cam Pressure Adjuster's bolt with an Allen key.



Maintenance

To ensure that the RTP 9® will have a long operational life, maintenance is essential. This section includes methods for replacing parts, troubleshooting solutions, and how often to grease and clean your machines to keep its performance optimal.

General Maintenance Prescriptions

- Use the maintenance checklist (found in the Appendix) before, during, and after machine operation.
- Make sure all grease points are maintained and regularly lubricated.
- Use an appropriate amount of lubricant. Excess grease can drip into the tablets as they are formed.
- Before reassembling the machine after cleaning, make sure that the parts are dried and oiled.
- Constantly check for any loose nuts and/or screws before, during, and after machine operation.
- After each run, place the Tooling in an airtight container and cover in lubricant.

Lubrication

Regularly greasing your machine is vital to prolonging its operational life. Parts that are not greased properly can make the machine seize up and cause major problems later. LFA recommends maintaining a lubrication schedule for your RTP 9®, which can be found in this section.

Tools and Materials Needed

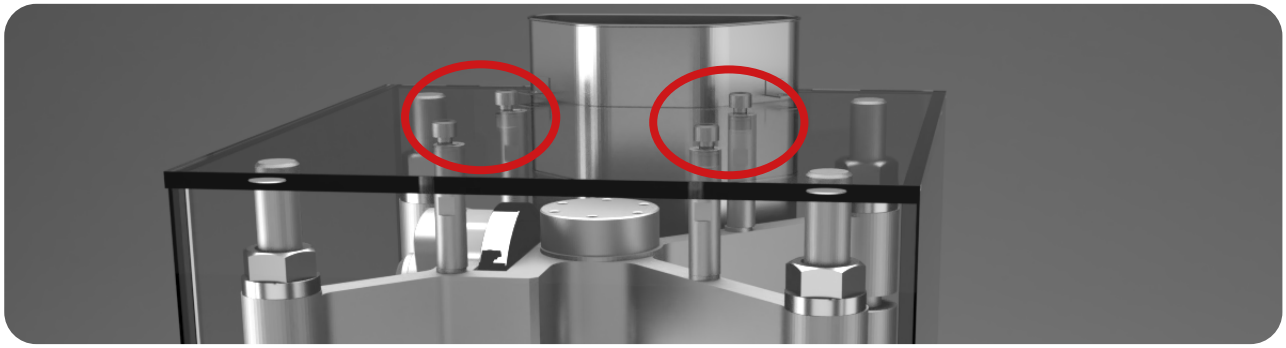
- Grease gun
- RTP 9® Toolkit (comes with machine)
- NLGI Grade 1 and Grade 2 grease
- SAE 10 oil
- Set of metric Allen keys with ball ends
- Disposable latex/rubber gloves (for food grade products and to protect hands from grease)
- Hairnet and/or beard net (food grade products only)
- Sterile shoe covers (food grade products only)

WARNING: To prevent any potential personal injury, unplug the RTP 9® from the electrical outlet.

Instructions

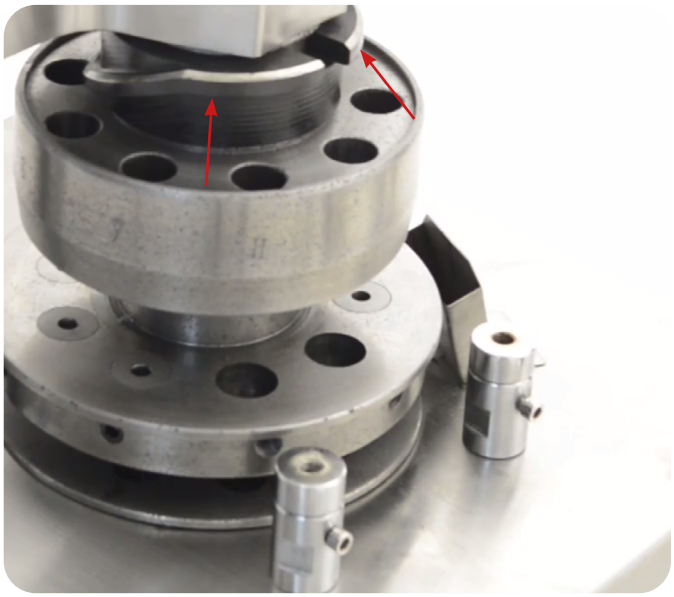
Note: Wear latex/rubber gloves (and appropriate food grade attire if applicable) during this process.

1. Remove the Perspex Case and the Hopper with an Allen key.

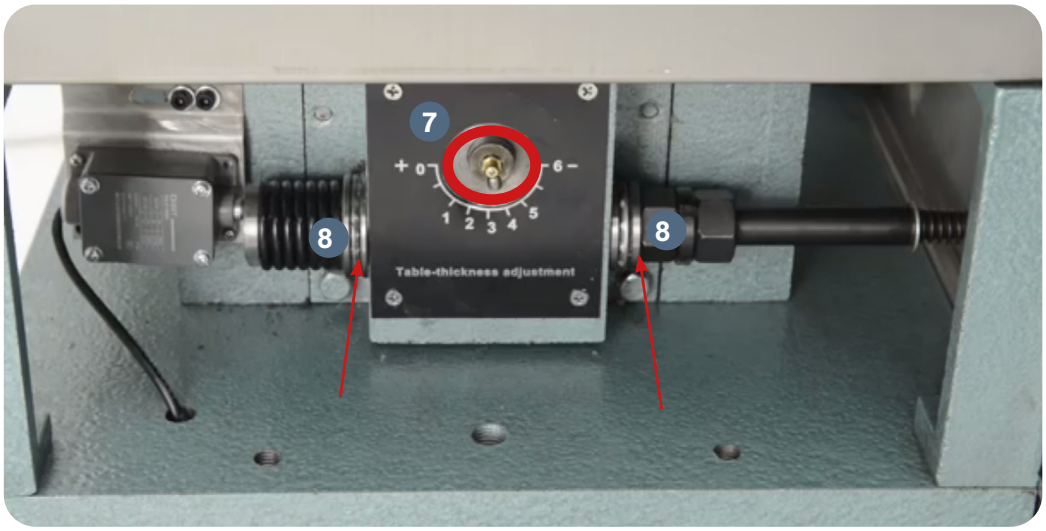


2. Remove the Upper Punches and Lower Punches.
    2.1 For additional assistance, please refer to the Tooling removal instructions on page 34.
3. Lubricate the heads of the Upper Punches and Lower Punches with NLGI Grade 1 grease.
4. Lubricate the barrels of the Upper Punches and Lower Punches with SAE 10 oil.

5. Lubricate the Upper Tracking with NLGI Grade 1 grease.

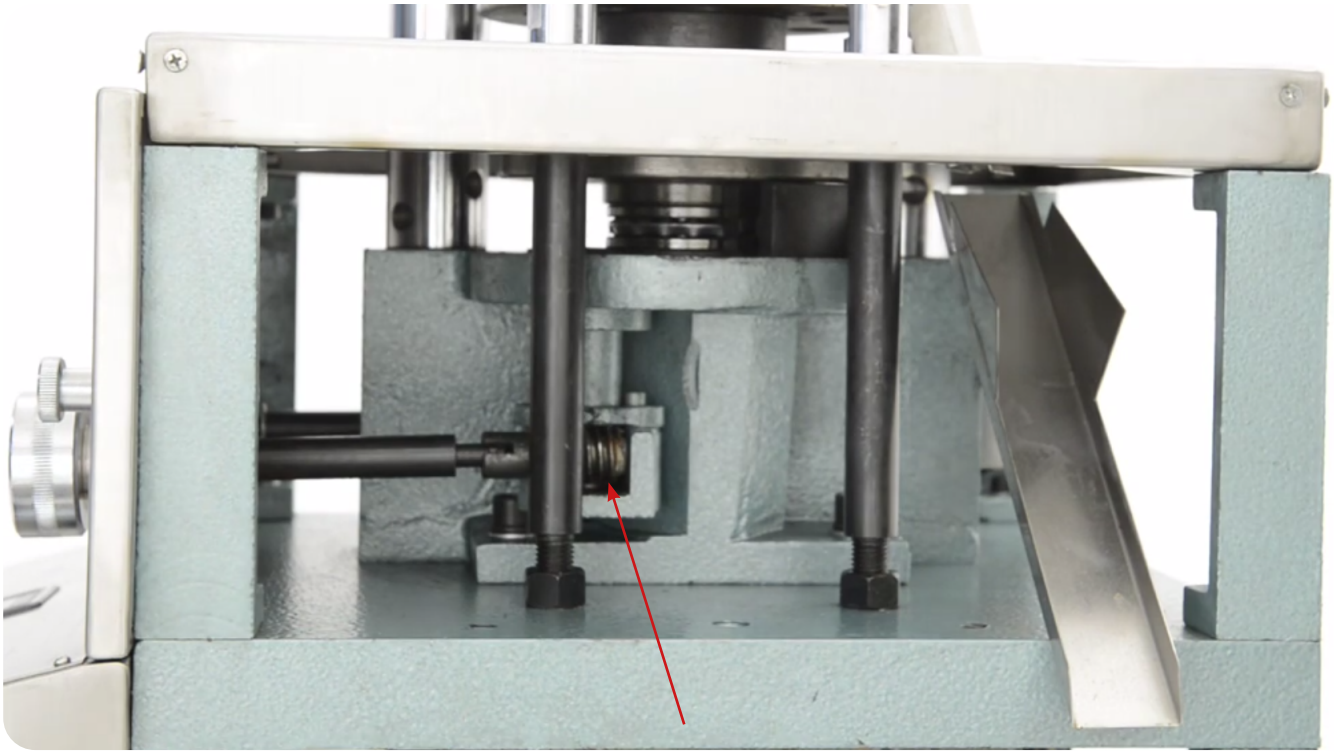


6. Open the left-hand side panel door.
7. Lubricate the Lower Roller Cam Shaft's grease nipple with NLGI Grade 2 grease.
8. Lubricate the Pressure Adjustment Gears with NLGI Grade 2 grease.



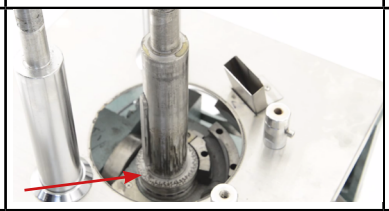
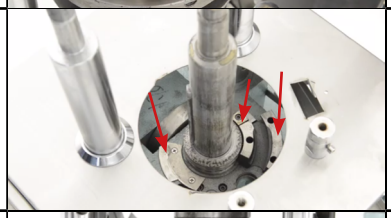
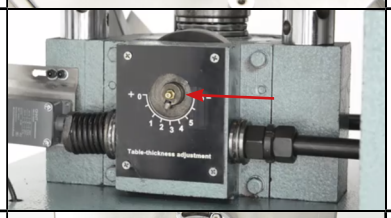
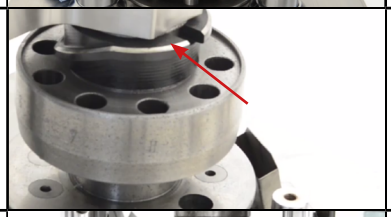
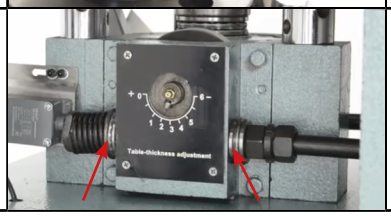
9. Lubricate the Upper Roller Cam Shaft's grease nipple with NLGI Grade 2 grease.

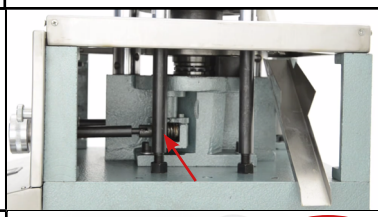
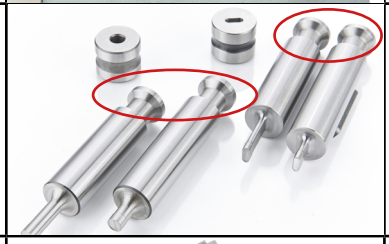
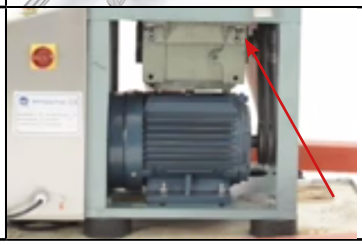
10. Open the right-hand side panel door.
11. Lubricate the Fill Adjustment Gear with NLGI Grade 2 grease.



Lubrication Schedule

LFA recommends the following RTP 9® parts to be lubricated according to the following frequency:

Part	Location	Image	Frequency	Type of Lubricant
Drive Shaft Bearings	Ball bearings at the bottom of the Main Drive Shaft		Inspect after every 3 months or 100,000 tablets and apply if dry. If old, gritty grease is present, clean before lubricating.	NLGI Grade 2
Turret Bearings	Ball bearings inside the center of the Turret		Inspect after every 3 months or 100,000 tablets and apply if dry If old, gritty grease is present, clean before lubricating.	NLGI Grade 2
Lower Tracking	Inside the Main Drive Shaft's bore and the Ejection Cam, Fill Cam, and Dosing Cam		Inspect after every 3 months or 100,000 tablets and apply if dry If old, gritty grease is present, clean before lubricating.	NLGI Grade 2
Grease Nipple on Lower Roller Cam Shaft	On left side of RTP 9® (open panel door)		Apply after every 100,000 tablets.	NLGI Grade 2
Grease Nipple on Upper Roller Cam Shaft	On the back of the Upper Roller Cam Housing		Apply after every 100,000 tablets.	NLGI Grade 2
Upper Tracking	Tracking on Turret that guides the Upper Punches		Apply when dry before beginning batch.	NLGI Grade 1
Pressure Adjustment Gears	Gears on both sides of Lower Cam Roller's housing (open left-hand side panel door)		Inspect after every 3 months or 100,000 tablets and apply if dry. If old, gritty grease is present, clean before lubricating.	NLGI Grade 2

Part	Location	Image	Frequency	Type of Lubricant
Fill Adjustment Gear	Gear on Fill Adjustment shaft (open right-hand side panel door)		Inspect after every 3 months or 100,000 tablets and apply if dry If old, gritty grease is present, clean before lubricating.	NLGI Grade 2
Tooling Heads	Heads of Upper Punches and Lower Punches		Inspect and apply when dry.	NLGI Grade 1
Tooling	Airtight container		Cover and store in oil after cleaning.	Mineral Oil
Tooling Barrels	The main shaft of the Upper Punches and Lower Punches		Lubricate every time Tooling is installed in the press.	SAE 10
Gearbox	On top of Gearbox through the shaft's bore		Visually inspect and apply when needed.	460 Grade Worm Gear Oil

Dismantling for Repair and Replacement

Eventually due to wear and tear, some parts of the RTP 9® will need to be removed for repair and replacement. To prevent any delays in your tablet production, it is best practice to keep extra parts just in case.

To buy an RTP 9® part replacement, simply go to
https://www.lfatabletpresses.com/products/pill-press-machine-spare-parts/rtp-9-parts

Warranty
To access LFA's warranty policy, go to https://www.lfatabletpresses.com/warranty
If your part is eligible for warranty, have your part's serial number on hand and please contact LFA:

UK
Phone
+44 01869 250234
Email
support.uk@lfamachines.com

USA
Phone
+1 (682) 312-0309
Email
support.usa@lfamachines.com

Taiwan
Phone
+886 422031790
Email
support.asia@lfamachines.com

WARNING: To prevent any potential personal injury, ALWAYS unplug the RTP 9® from the electrical outlet when replacing parts.

Wear Parts and Causes of Damage

Wear Part	Cause of Damage
Tooling	The Tooling can become chipped or broken. Lead times for a new set of Tooling can take as long as 6-8 weeks, so LFA recommends having a spare set or two.
Fill Tray	On the RTP 9®, the Fill Tray spreads the powder over the Die Table and into the Die bores. It is formed from cast brass with chrome plating and is designed to wear. It protects the Turret/Die Table and the Tooling. If this part is damaged by a Die sitting above the Die Table, it is possible to refinish it using a flat stone, some oil, and 3000 grit sandpaper. Eventually when the "gates" underneath are so small that powder is unable to pass through smoothly, or if there is a catastrophic failure, this part will need to be replaced.
Fill Tray Scraper and Take-Off Blade	The Feeder Tray Scraper is used to take off the excess powder from the Die Table after the Dosing Cam has forced out the powder. The Take-Off Blade is used to aid in tablet ejection. These parts can become damaged if a Die is protruding from the Die Table or if a Lower Punch jumps up from the Dosing Cam. To reduce waste, these parts will need to be replaced if damaged.
Ejection Cam	The Ejection Cam ejects the tablets at the correct moment in the Turret's cycle. This part is not able to be tuned and is fixed in place. Over time this part can wear, and the tablet's ejection point can get lower until they are not ejecting correctly from the Die bores. The three main causes of this are: 1) tight Lower Punches due to buildup of excess fines in powder, 2) high ejection forces that are caused by sticky powders clinging to the Die bore's wall, and 3) powder that mixes with oil/grease, which creates a sandpaper effect on the Ejection Cam.
Fill Cam	The Fill Cam pulls down the Lower Punches to fill the Die bores with powder. This part is built from brass and is designed to wear to protect the Tooling and the press. The main causes of a worn Fill Cam are: 1) tight Lower Punches due to buildup of excess fines in powder, 2) use of incorrect Tooling with the wrong head profile, and 3) powder that mixes with oil/grease, which creates a sandpaper effect on the Fill Cam.
Dosing Cam	The Dosing Cam is used to calibrate the press to produce the desired tablet weight. This is done by pushing excess powder out of the Die bore after it has been filled. The main causes of a worn Dosing Cam are: 1) Tight Lower Punches due to buildup of excess fines in powder, 2) use of incorrect Tooling with the wrong head profile, and 3) powder that mixes with oil/grease, which creates a sandpaper effect on the Dosing Cam.
Upper/Lower Roller Cam	The Roller Cams apply all the pressure onto the Tooling. If these become worn, it can cause damage to the tops of the Tooling and affect tablet hardness and consistency. This is predominantly caused by general wear and, in some cases, excess punch pressure being applied.

Tooling

If you want to change the shape and diameter of the tablet, or if any of the Upper Punches, Lower Punches, and/or Dies you currently have are damaged, it is necessary to change the Tooling.
To buy new Tooling from LFA, simply go to https://www.lfatabletpresses.com/products/tablet-press-tooling

To watch a video of an RTP 9® Tooling change, go to https://www.lfatabletpresses.com/rtp-9-tooling-change

Tools and Materials Needed

- Set of metric Allen keys with ball ends
- Tooling (Upper Punches, Dies, and Lower Punches)
- RTP 9® Toolkit (comes with machine)
- Lubricant (NSF approved for food grade products)
- Heavy rubber mallet
- Disposable latex/rubber gloves (for food grade products and to protect hands from grease)
- Hairnet and/or beard net (food grade products only)
- Sterile shoe covers (food grade products only)

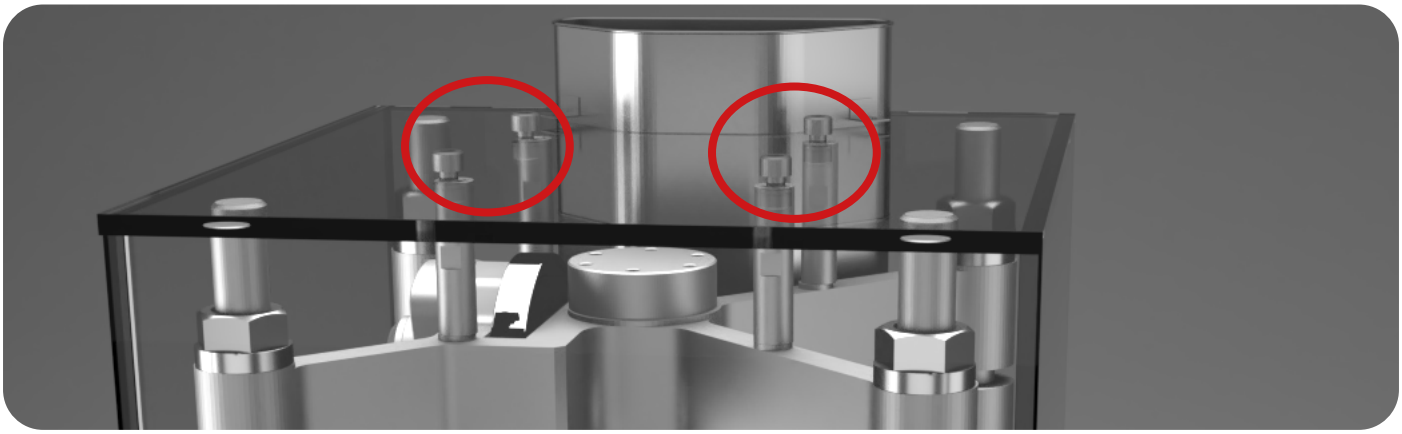
WARNING: To prevent any potential personal injury, ALWAYS unplug the RTP 9® from the electrical outlet when replacing parts.

Instructions

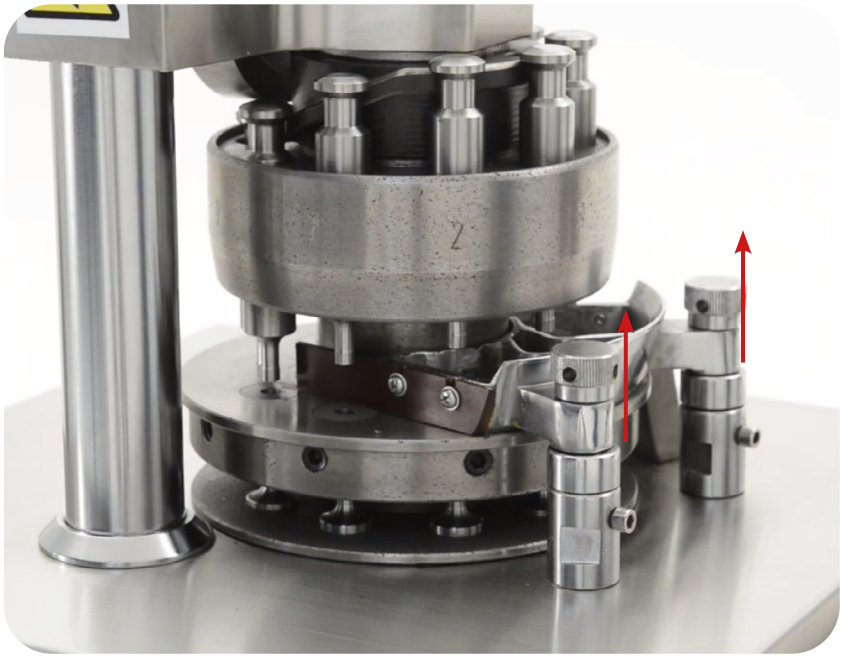
Note: Wear latex/rubber gloves (and appropriate food grade attire if applicable) during this process.

Remove the Old Tooling

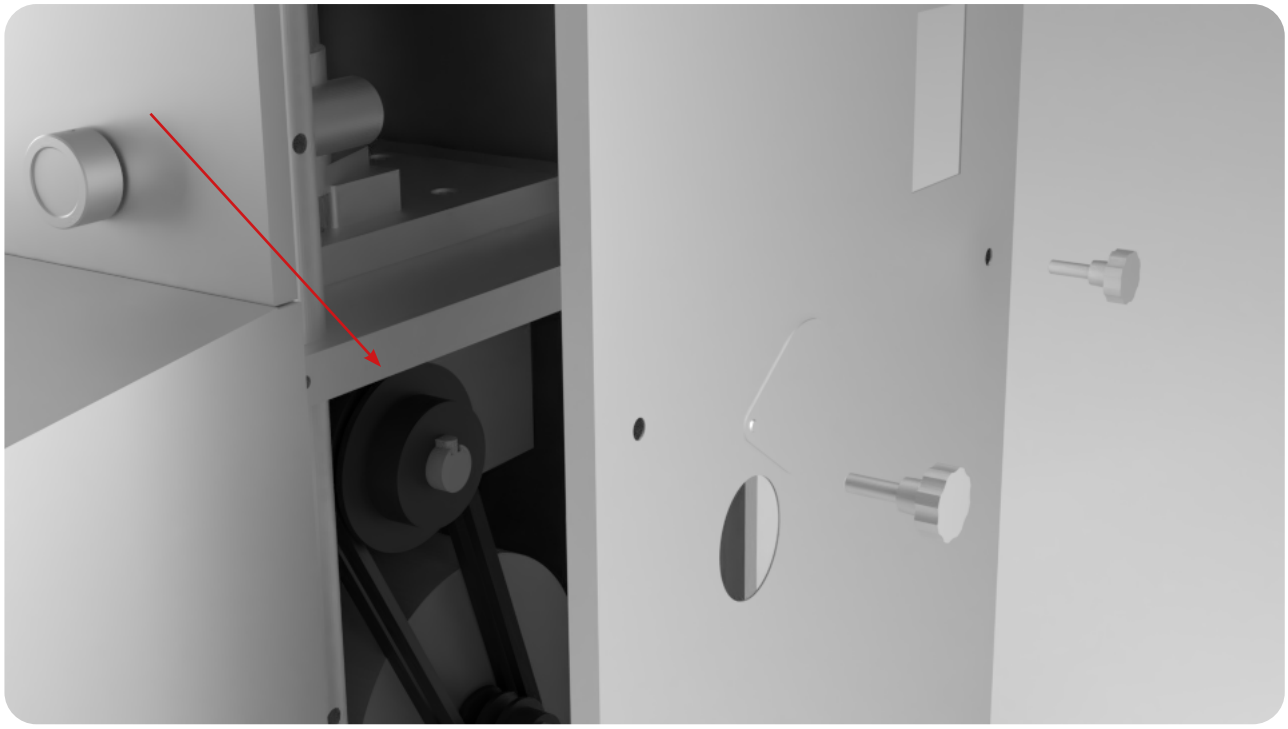
1. Loosen the Hopper's screws with an Allen key and remove it from the Perspex Casing.
2. Remove the screws on the Perspex Casing with an Allen key and take it off.



3. Loosen the Fill Tray's Thumb Bolts with an Allen key and remove them by hand.

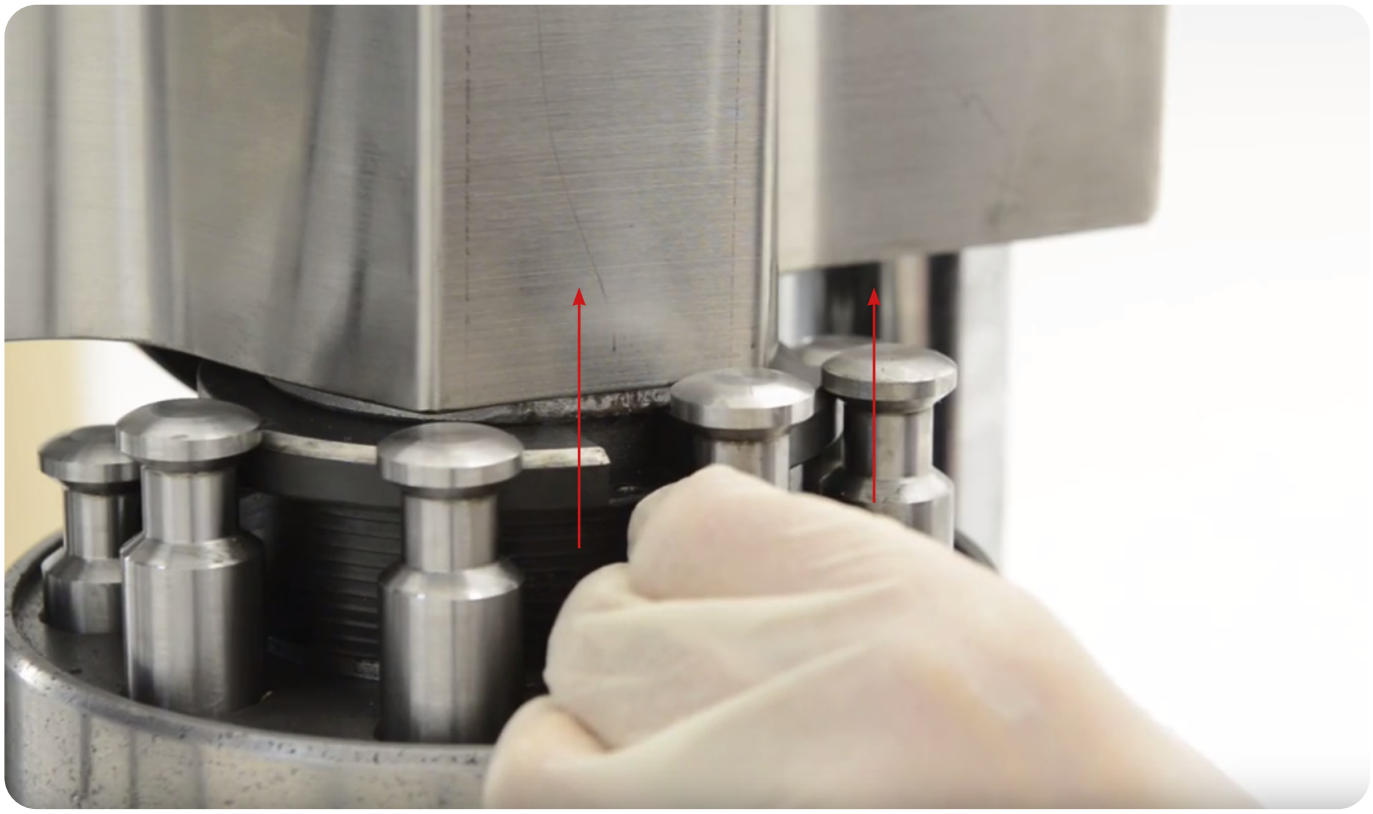


4. Remove the Fill Tray from the Turret.
5. Remove the rear side panel door.
6. Insert the Handle onto the Drive Belt Pulley socket.

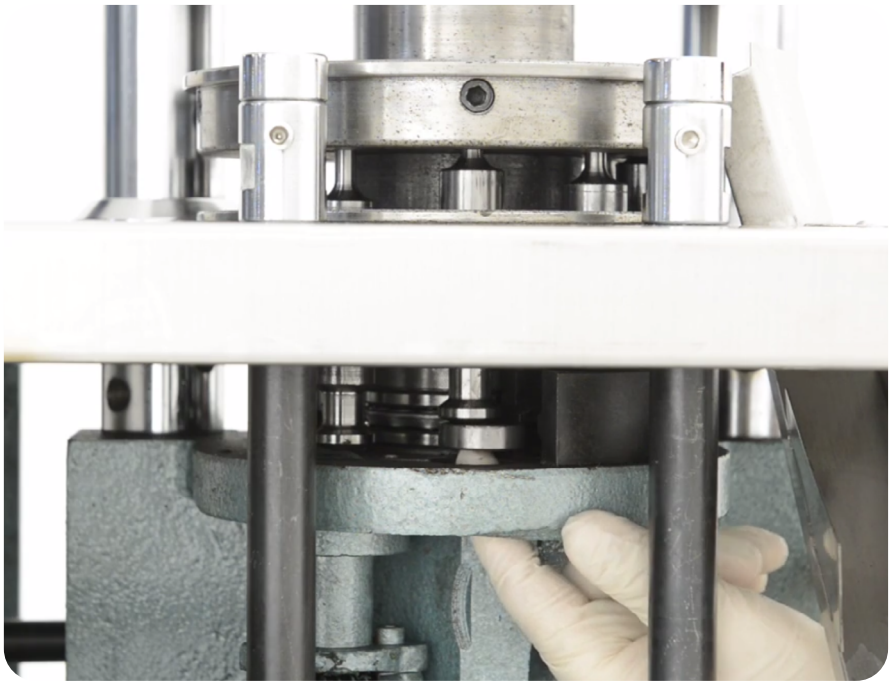


7. Remove the Upper Tracking Key with an Allen key.

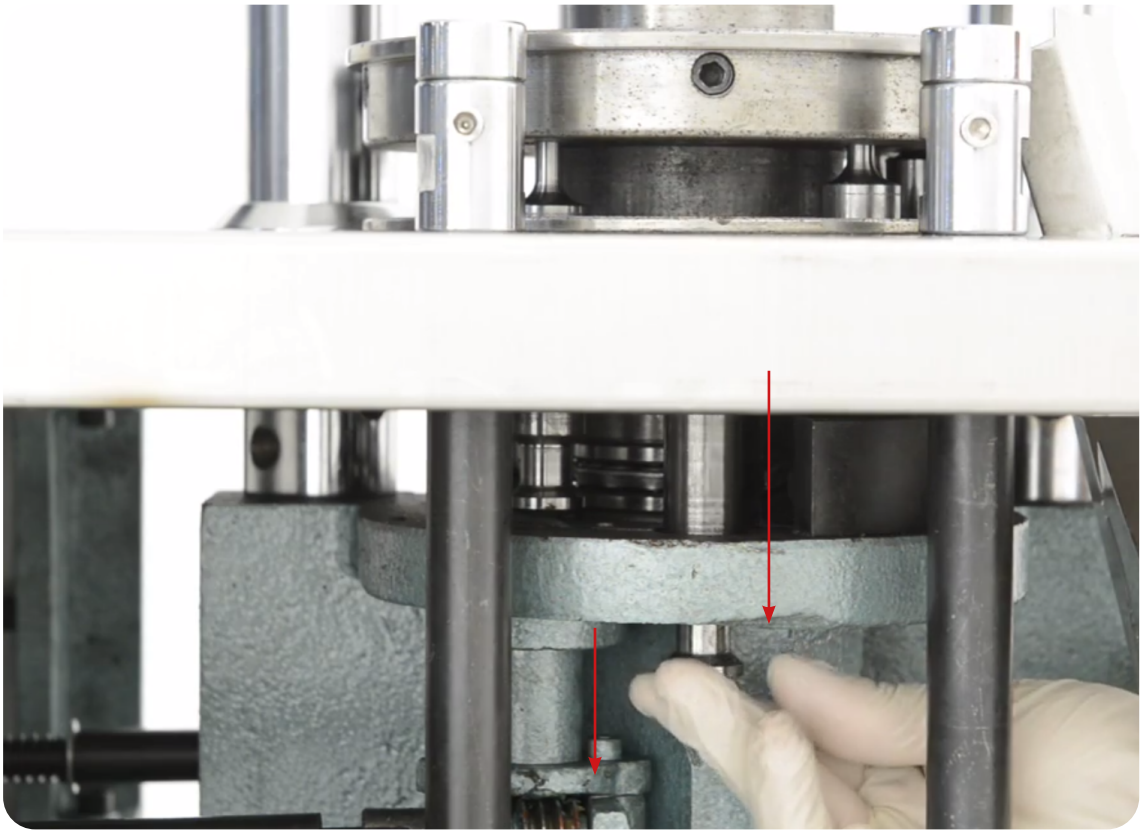
8. Rotate the Handle until an Upper Punch is where the Upper Tracking Key was previously.
9. Pull the Upper Punch upwards to remove it from the Turret.



10. Repeat steps 8-9 until all Upper Punches are removed.
11. Push up the Lower Punch Insertion Disc underneath the Lower Punches and remove it from the RTP 9®.

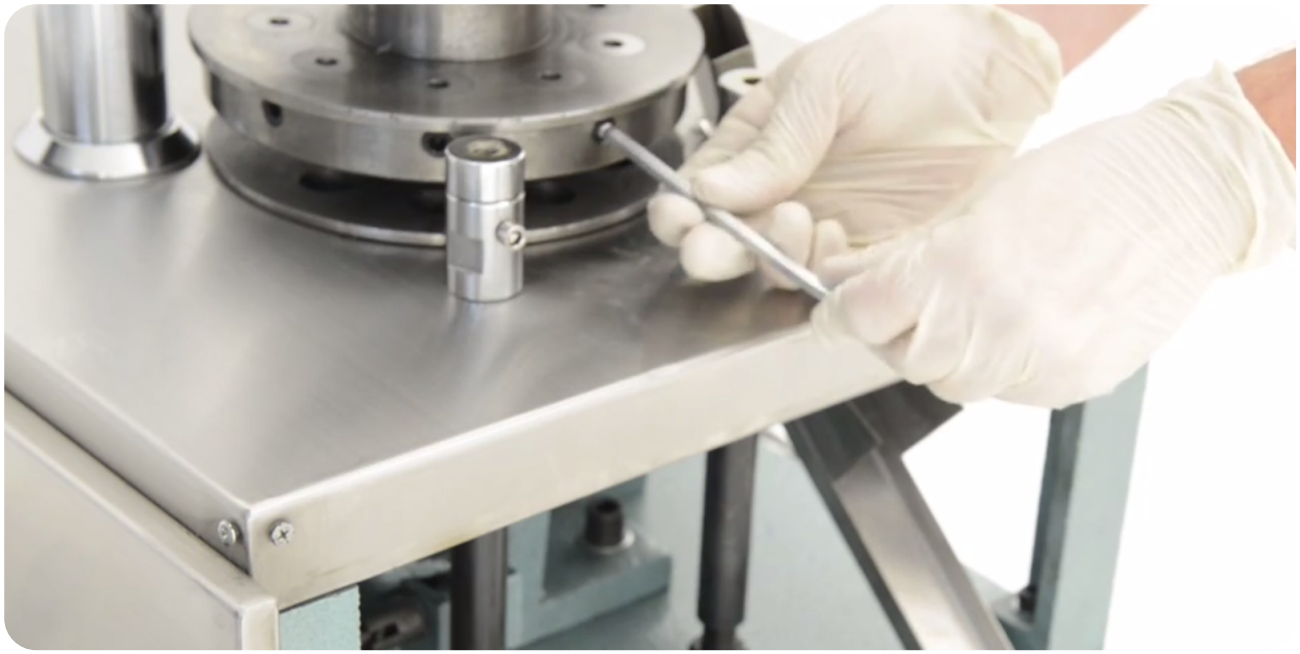


12. Rotate the Handle until a Lower Punch is aligned with where the Lower Punch Insertion Disc was previously.
13. Gently pull on the Lower Punch's head through the hole.
    13.1 Note: Be sure to have a firm hold on the Lower Punch so that it does not fall and become damaged.



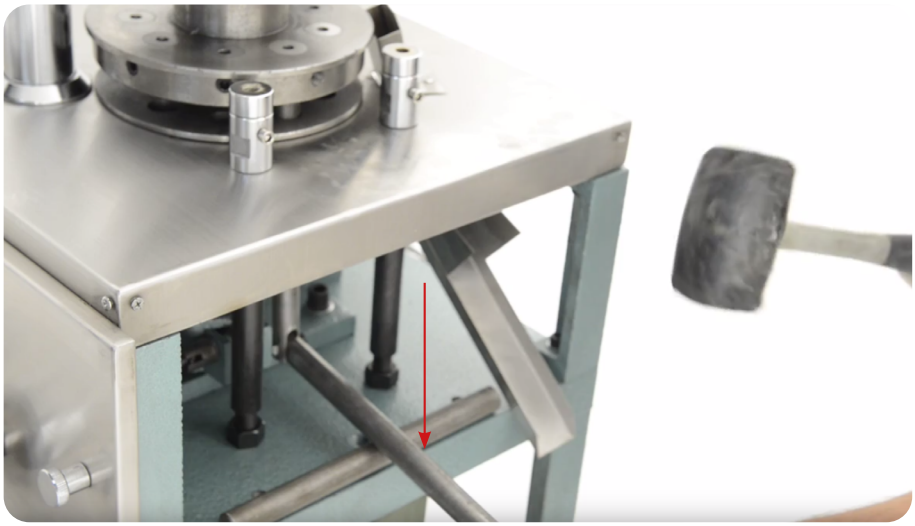
14. Repeat steps 12-13 until all Lower Punches are removed.

15. Rotate the Handle until a Die is aligned with where the Lower Punch Insertion Disc was previously.
16. Remove Die's set screw with an Allen key.



17. Hold the smaller part of the Die Removal Bar up through the hole where the Lower Punch Insertion Disc was previously and into the Turret.
18. Lift up the smaller part under the Die and insert the rest of the Die Removal Bar onto it.
19. Place the Die Installation Bar below the Die Removal Bar to act as a support.

20. Tap the end of the Die Removal Bar with a rubber mallet until the Die pops up from the Turret.

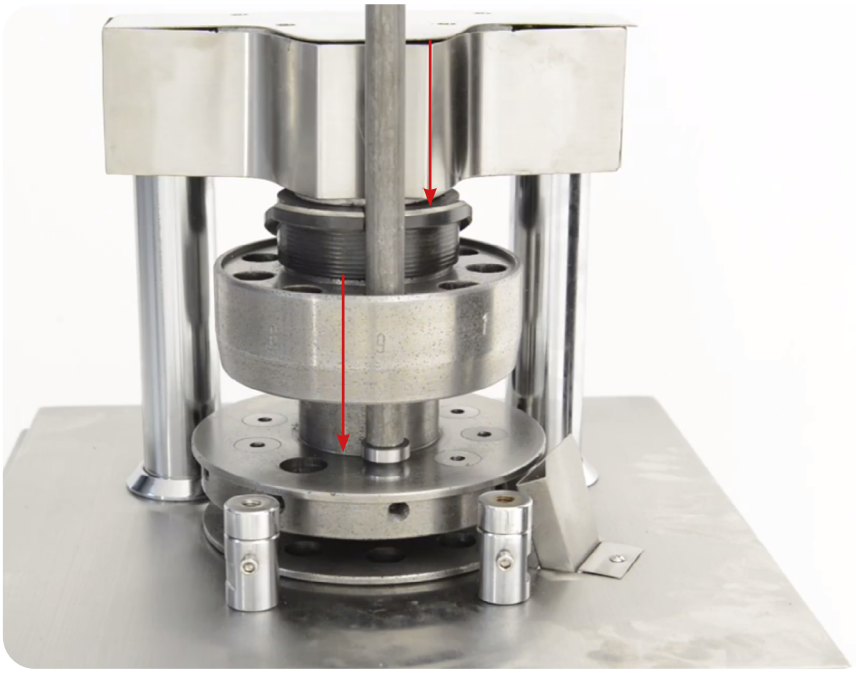


21. Repeat steps 15-20 until all Dies are removed.

Note: To help ensure that the Dies are inserted correctly, LFA recommends using an Insertion Ring. You can order the Die Seat Cleaner and Insertion Ring on our website at https://www.lfatabletpresses.com/die-seat-cleaner-insertion-ring

Replace the Tooling

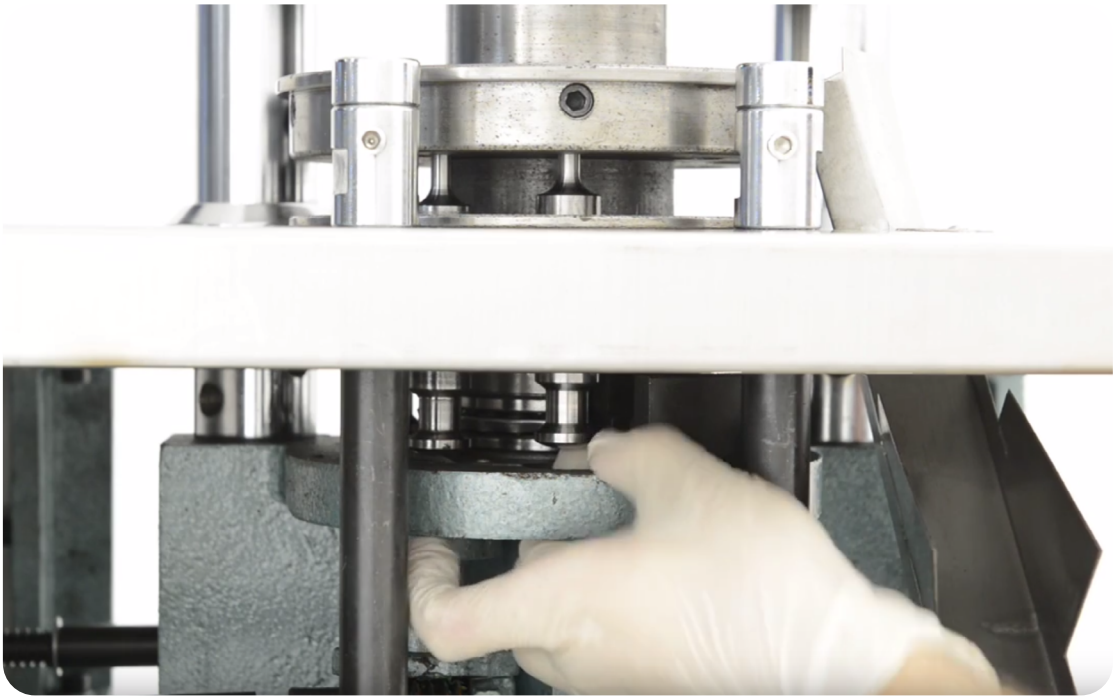
22. Position the new Die on the Turret.
    22.1 Note: Place a bit of grease around the new Die's sides to make insertion easier.
23. Insert the Die Installation Bar through the Upper Punch's hole and over the new Die.
24. Tap the Die Installation Bar with a rubber mallet until the new Die is inserted into the Turret.
    24.1 Note: Make sure that the new Die is flush with the Turret.



25. Reinsert the Die's set screw in the Turret and tighten with an Allen key.
    25.1 Note: The Die's set screw are to be tensioned at 16 lbs/ft.
26. Rotate the Handle until the next new Die can be inserted.
27. Repeat steps 22-26 until all the new Dies are secured in the Turret.

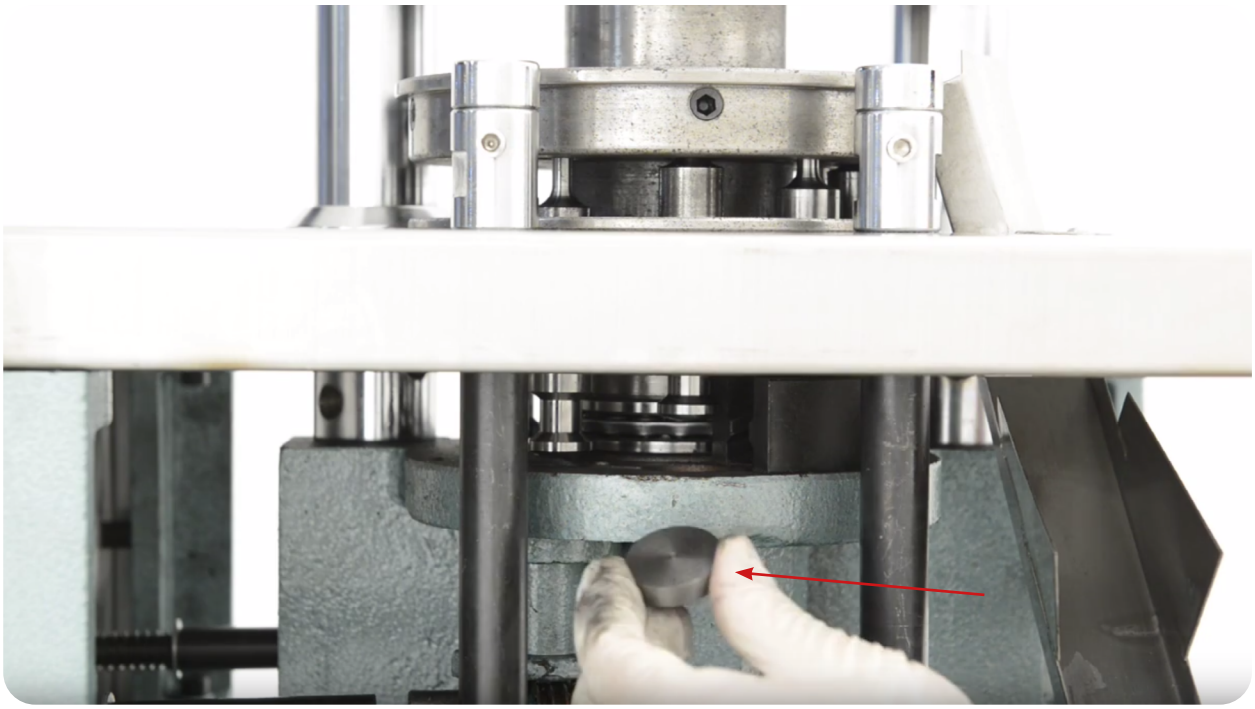
28. Insert a new Lower Punch up through the Lower Punch Insertion Disc's hole and into the new Die's bore.

28.1 Note: Lubricate the barrel of the Lower Punch.

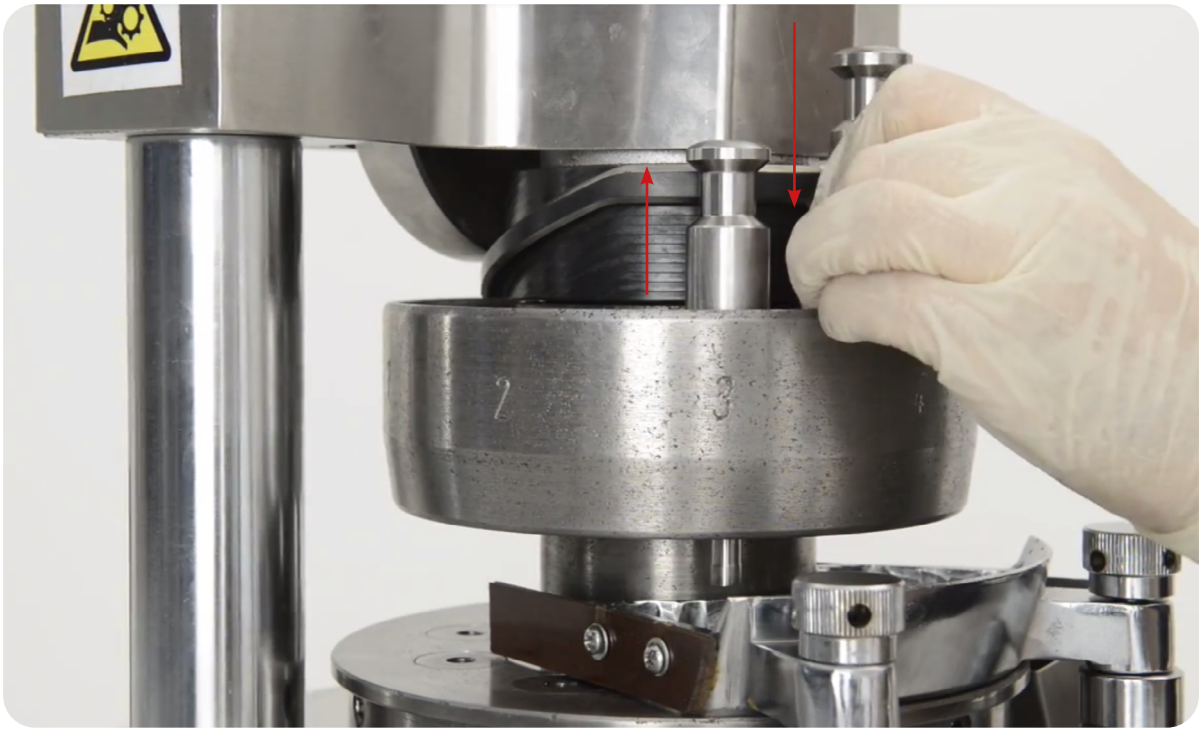


29. Place the new Lower Punch's head on the Lower Tracking.
30. Rotate the Handle until the next new Lower Punch can be inserted.
31. Repeat steps 28-30 until all the new Lower Punches are inserted into the Turret.
32. Reinsert the Lower Punch Insertion Disc with the beveled side facing up.

32.1 Note: Manually turn the RTP 9® Turret for a couple of rotations to ensure that the new Lower Punches are situated correctly.

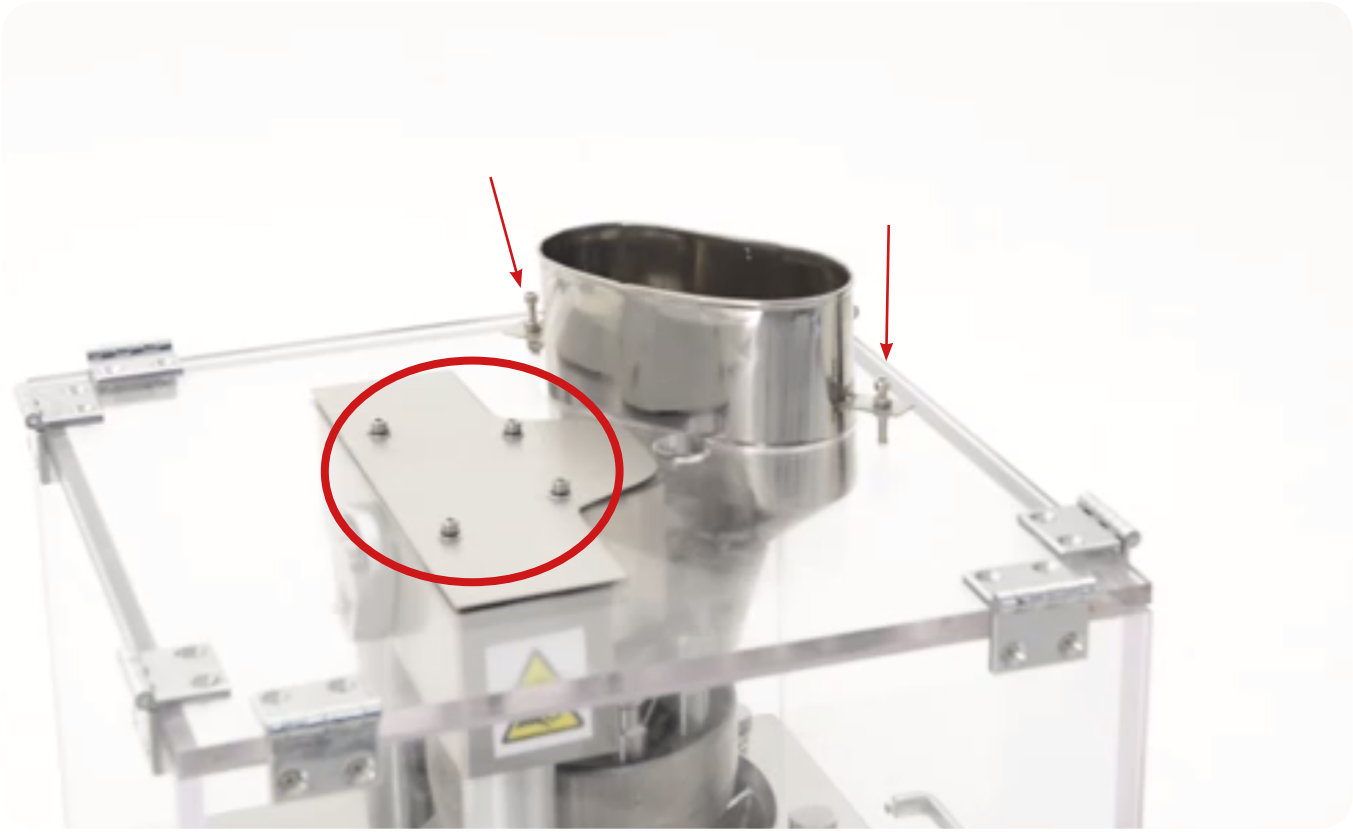


33. Insert a new Upper Punch through the top of the Turret.
    33.1 Note: Lubricate the barrel of the Upper Punch.
34. Place the new Upper Punch's head on the Upper Tracking.
    34.1 Note: Be sure that the new Upper Punch's head is above the Upper Tracking to prevent damage.



35. Rotate the Handle until the next new Upper Punch can be inserted.
36. Repeat steps 33-35 until all the new Upper Punches are inserted into the Turret.
    36.1 Note: Manually turn the RTP 9® Turret for a couple of rotations to ensure that the new Upper Punches are situated correctly.
37. Resecure the Upper Tracking Key with an Allen key.

38. Remove the Handle from the Drive Belt Pulley.
39. Place the Fill Tray back on the Turret.
    39.1 Note: Please refer to the Fill Tray Height adjustment instructions on page 22 for calibration.
40. Tighten the Fill Tray Thumb Bolts back onto the Fill Tray and RTP 9® by hand and/or with an Allen key.
41. Resecure the Perspex Casing and the Hopper with an Allen key.



Fill Tray

The Fill Tray helps channel the dry materials into the Die bores and also pushes the tablets out of the way and into the Ejection Tray. This part is designed to wear to avoid damaging the Tooling and/or Turret, so it may need to be replaced. These instructions also apply to Fill Tray Scraper/ Take-Off Blade removal and replacement.

Tools and Materials Needed

- Set of metric Allen keys with ball ends
- Crosshead screwdriver
- New Fill Tray part
- Disposable latex/rubber gloves (for food grade products and to protect hands from grease)
- Hairnet and/or beard net (food grade products only)
- Sterile shoe covers (food grade products only)

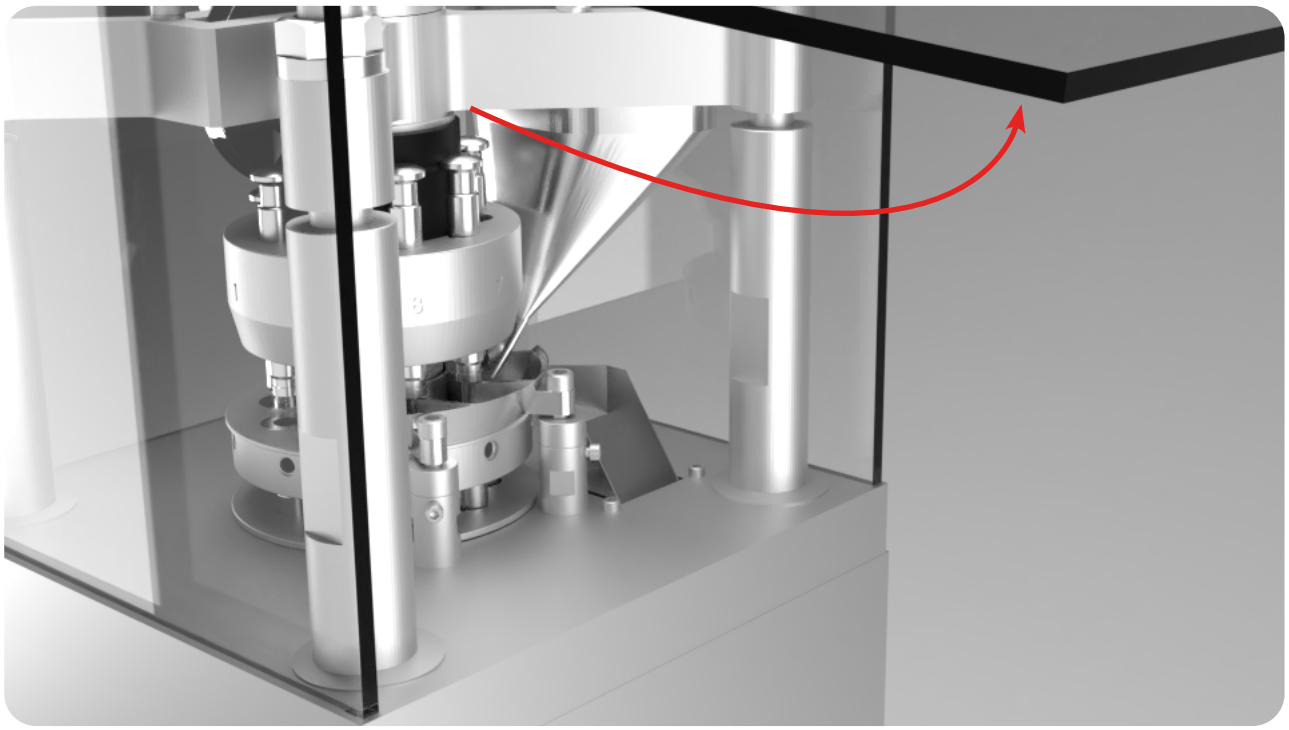
WARNING: To prevent any potential personal injury, ALWAYS unplug the RTP 9® from the electrical outlet when replacing parts.

Instructions

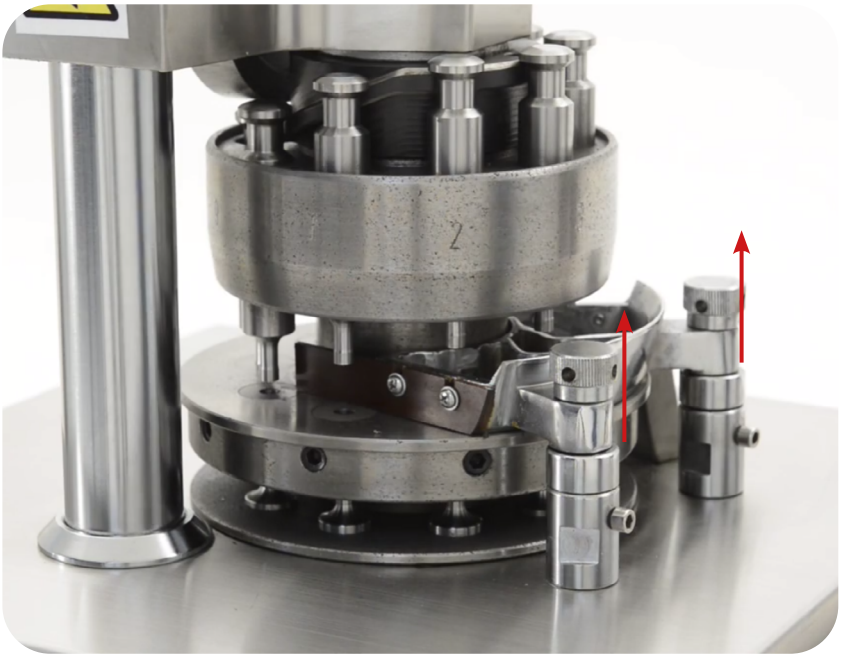
Note: Wear latex/rubber gloves (and appropriate food grade attire if applicable) during this process.

Remove the Fill Tray

1. Open up the Perspex Casing's door to gain access to the Fill Tray.
2. Loosen the Hopper's screws with an Allen key and remove it from the Perspex Casing.



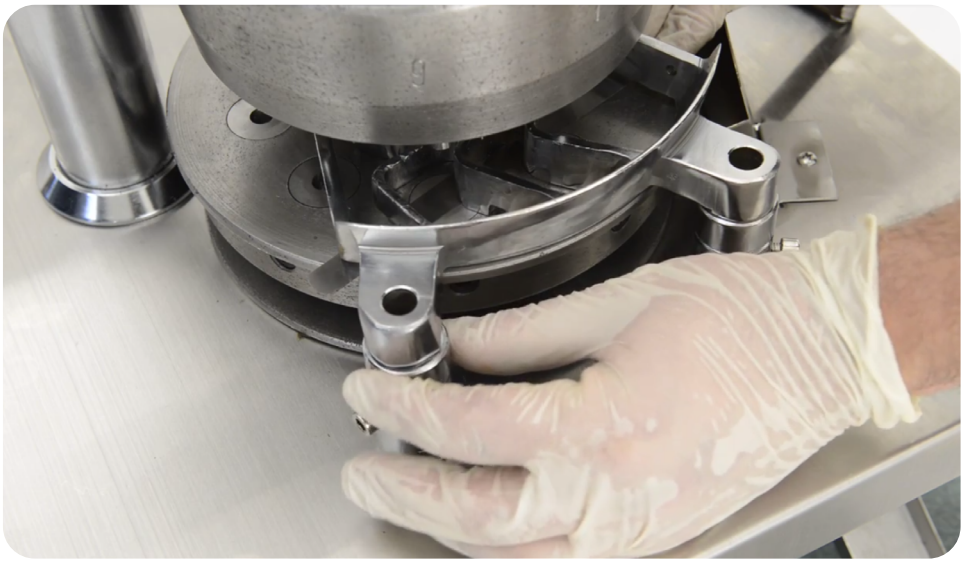
3. Loosen the Fill Tray Thumb Bolts with an Allen key or by hand and remove them.



4. Take off the Fill Tray from the Turret.
5. Remove the Fill Tray Scraper and Take-Off Blade from the Fill Tray with a crosshead screwdriver.

Replace the Fill Tray

6. Loosely attach the Fill Tray Scraper and Take-Off Blade on the new Fill Tray with a crosshead screwdriver.
7. Place the new Fill Tray on the Turret and align it with the Fill Tray Height Adjusters' holes.



8. Screw in the Fill Tray Thumb Bolts through the Fill Tray and Fill Tray Height Adjusters.
    8.1 Note: Please refer to the Fill Tray Height adjustment instructions on page 24 for calibration.
9. Tighten the Fill Tray Scraper and Take-Off Blade with a crosshead screwdriver.
    9.1 Note: It is important to make sure that the Fill Tray Scraper blade is firmly up against the Die Table of the Turret. To do this, push down on the top of the blade while tightening the screws that hold it in place. The Take-Off Blade needs to not be touching the Die Table and should be mounted approximately 1/3 of the height of the tablet from the surface of the Die Table.
10. Shut the Perspex Casing door.
11. Resecure the Hopper to the Perspex Casing with an Allen key.
    11.1 Note: Be sure the Hopper's end is situated in the Fill Tray's largest section and to the far-most right.

Upper Tracking

The Upper Tracking guides the Upper Punches' movement throughout the machine's operation. To see a video of this process, go to https://www.lfatabletpresses.com/rtp-9-upper-tracking-change

Tools and Materials Needed

- Set of metric Allen keys with ball ends
- Socket wrench from RTP 9® Toolkit (36 mm)
- New Upper Tracking part
- Disposable latex/rubber gloves (for food grade products and to protect hands from grease)
- Hairnet and/or beard net (food grade products only)
- Sterile shoe covers (food grade products only)

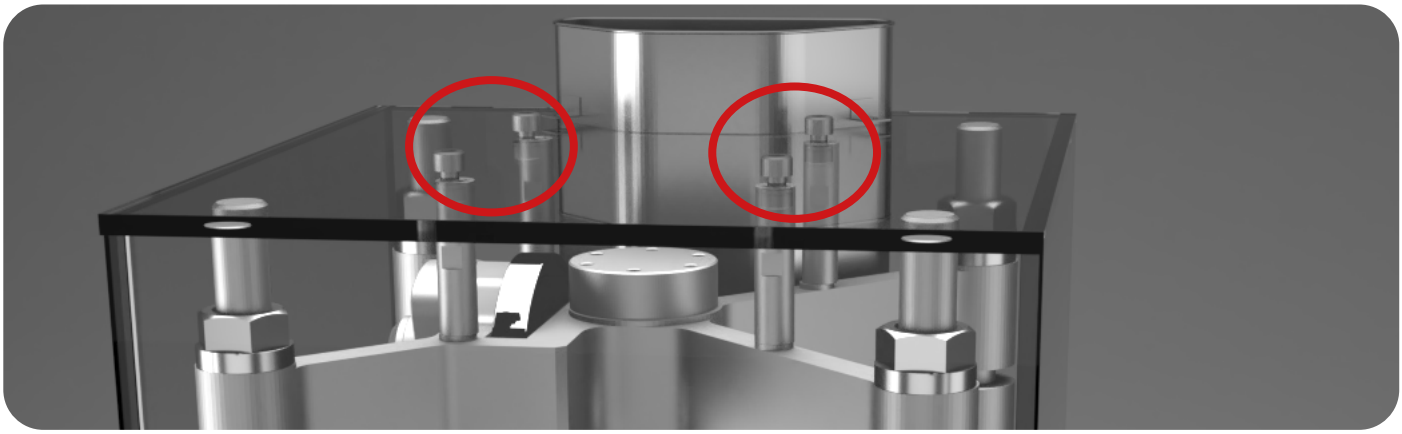
WARNING: To prevent any potential personal injury, ALWAYS unplug the RTP 9® from the electrical outlet when replacing parts.

Instructions

Note: Wear latex/rubber gloves (and appropriate food grade attire if applicable) during this process.

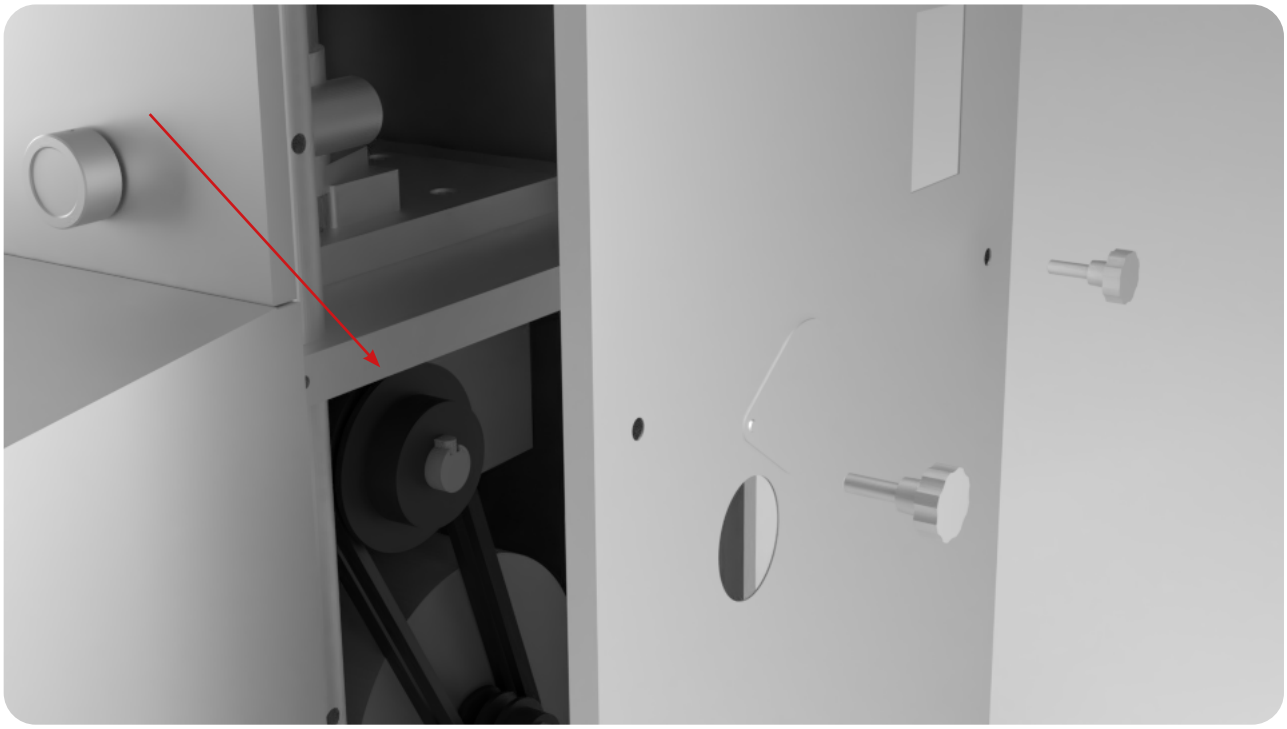
Remove the Upper Tracking

1. Loosen the Hopper's screws with an Allen key and remove it from the Perspex Casing.
2. Remove the screws on the Perspex Casing with an Allen key and take it off.



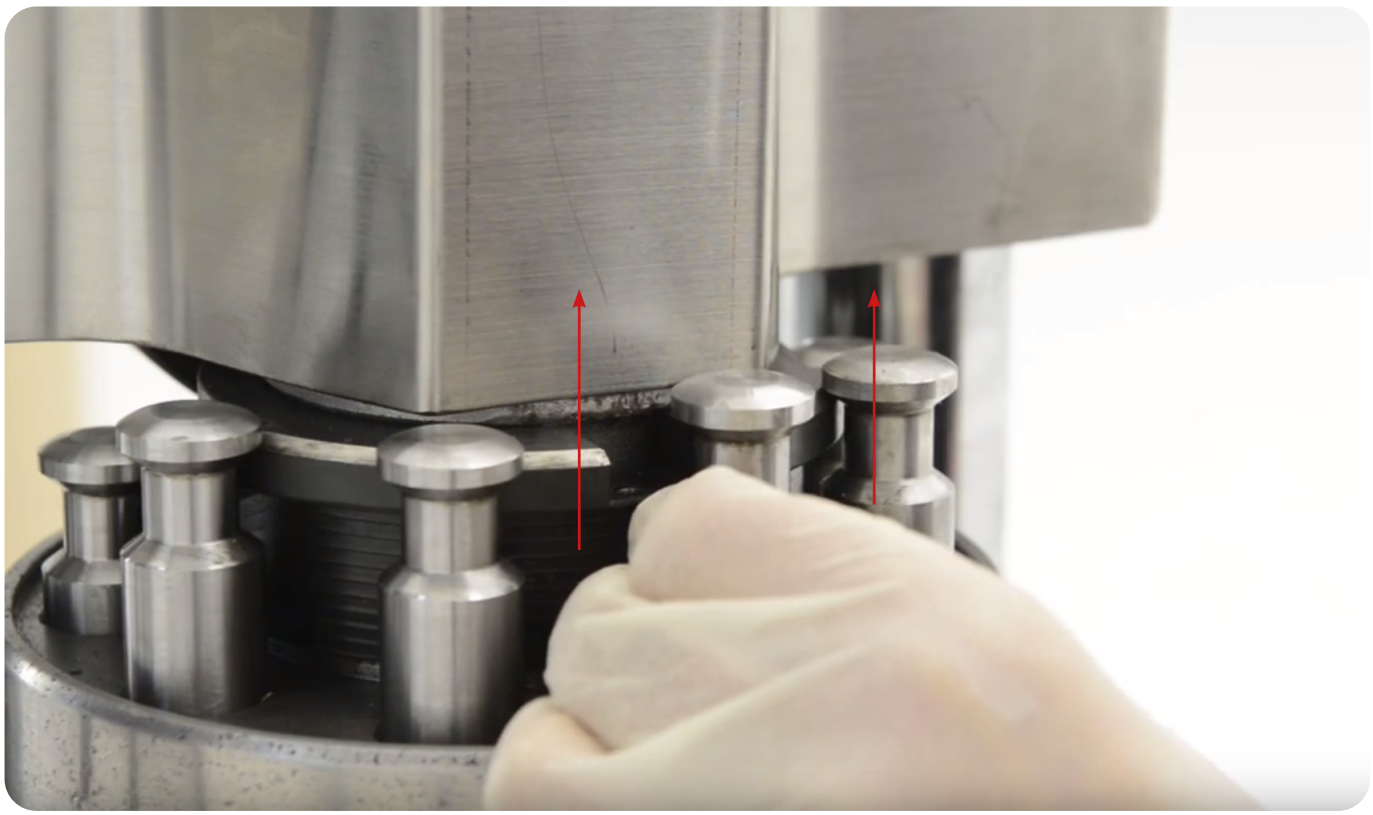
3. Loosen the Fill Tray's Thumb Bolts with an Allen key and remove them by hand.

4. Remove the Fill Tray from the Turret.
5. Remove the rear side panel door and insert the Handle onto the Drive Belt Pulley socket.



6. Remove the Upper Tracking Key with an Allen key.

7. Rotate the Handle until an Upper Punch is where the Upper Tracking Key was previously.
8. Pull the Upper Punch upwards to remove it from the Turret.



9. Repeat steps 7-8 until all Upper Punches are removed.

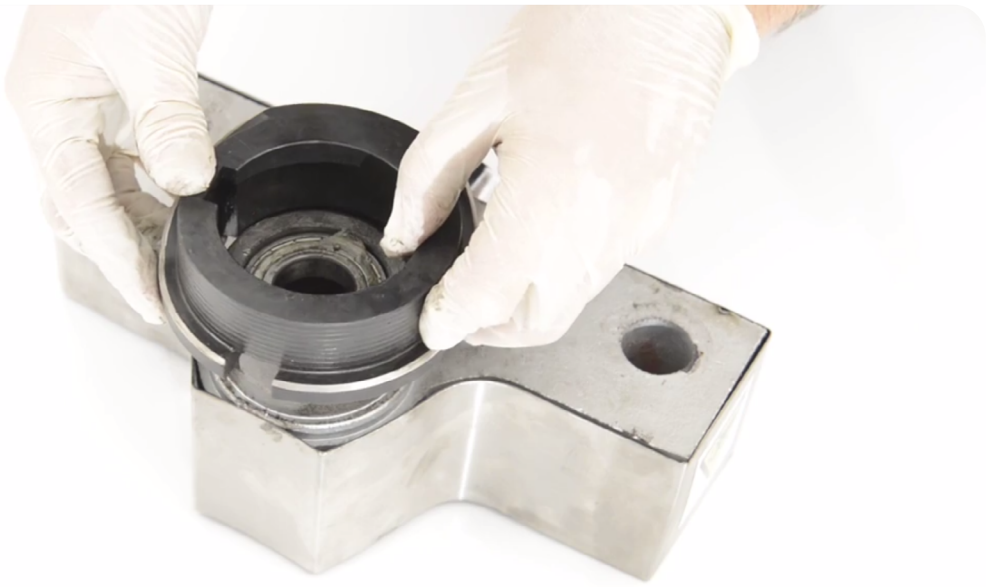
10. Remove the large nuts in the Upper Roller Cam Housing with a socket wrench.

11. Pull up the Upper Roller Cam Housing from the Turret.
    11.1 Note: Be sure to keep a hold of the Upper Tracking to prevent it from falling.

12. Pull the Upper Tracking from the Upper Roller Cam Housing.

Replace the Upper Tracking

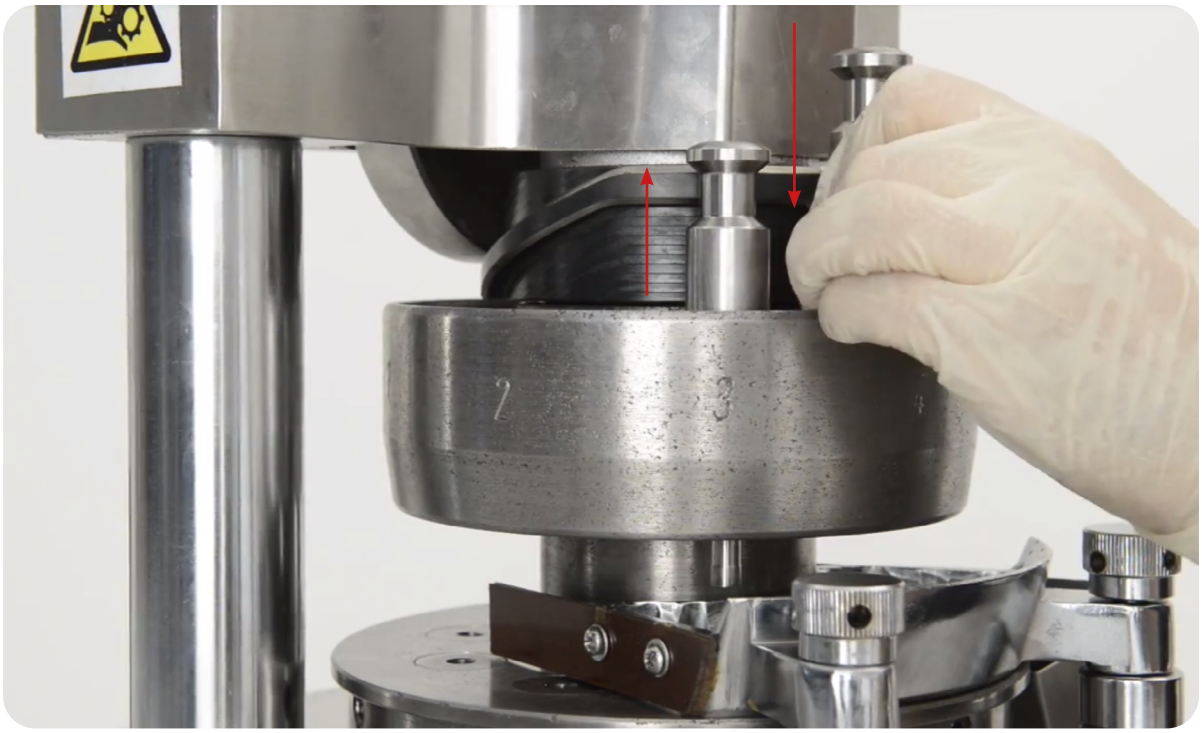
13. Place the new Upper Tracking onto the Upper Roller Cam Housing.



14. Reinsert the Upper Roller Cam Housing and the new Upper Tracking onto the RTP 9® and tighten its nuts with a socket wrench.

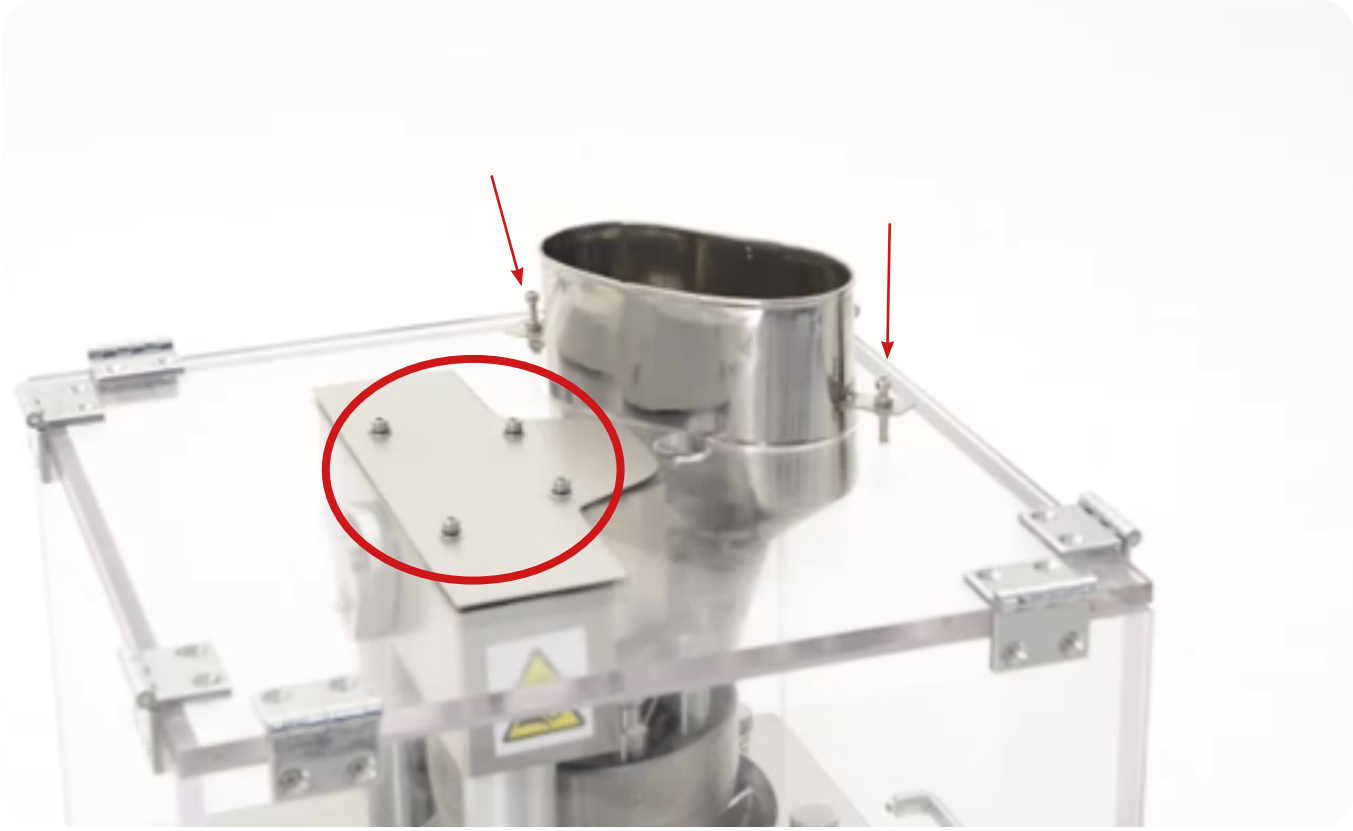
14.1 Note: The correct tension for these nuts is 70-90 Nm.

15. Insert an Upper Punch through the top of the Turret.
16. Place the Upper Punch's head on the new Upper Tracking.
    16.1 Note: Be sure that the Upper Punch's head is above the new Upper Tracking to prevent damage.



17. Rotate the Handle until the next Upper Punch can be inserted.
18. Repeat steps 15-17 until all the Upper Punches are inserted into the Turret.
19. Resecure the Upper Tracking Key with an Allen key.
    19.1 Note: Manually turn the RTP 9® Turret for a couple of rotations to ensure that the Upper Punches are situated correctly.

20. Remove the Handle from the Drive Belt Pulley.
21. Place the Fill Tray back on the Turret.
    21.1 Note: Please refer to the Fill Tray Height adjustment instructions on page 22 for calibration.
22. Tighten the Fill Tray Thumb Bolts back onto the Fill Tray and RTP 9® by hand and/or with an Allen key.
23. Resecure the bolts on the Perspex Casing with an Allen key.
24. Resecure the Hopper to the Perspex Casing with an Allen key.



Upper Roller Cam

The Upper Roller Cam compresses the Upper Punches to make tablets. These instructions also apply to replacing the Upper Roller Cam Shaft.

Watch a video to see what a worn Upper Roller Cam looks like at https://www.lfatabletpresses.com/rtp-9-inspecting-roller-cams

Watch a video of Upper Roller Cam removal and replacement at https://www.lfatabletpresses.com/rtp9-upper-roller-cam-change-1

Tools and Materials Needed

- Set of metric Allen keys with ball ends
- Socket wrench from RTP 9® Toolkit (36 mm)
- New Upper Roller Cam part
- Disposable latex/rubber gloves (for food grade products and to protect hands from grease)
- Hairnet and/or beard net (food grade products only)
- Sterile shoe covers (food grade products only)

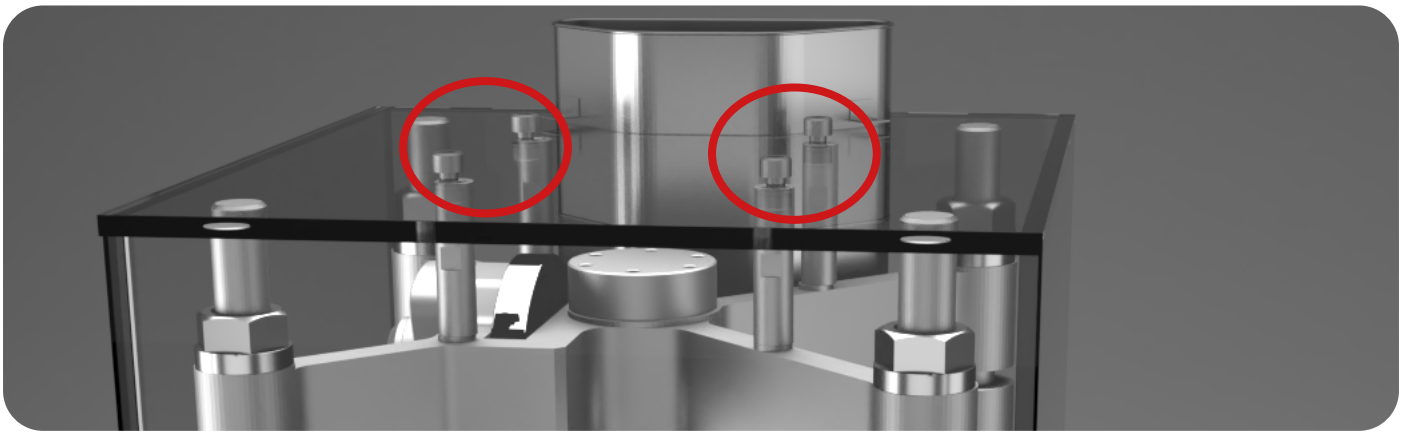
WARNING: To prevent any potential personal injury, ALWAYS unplug the RTP 9® from the electrical outlet when replacing parts.

Instructions

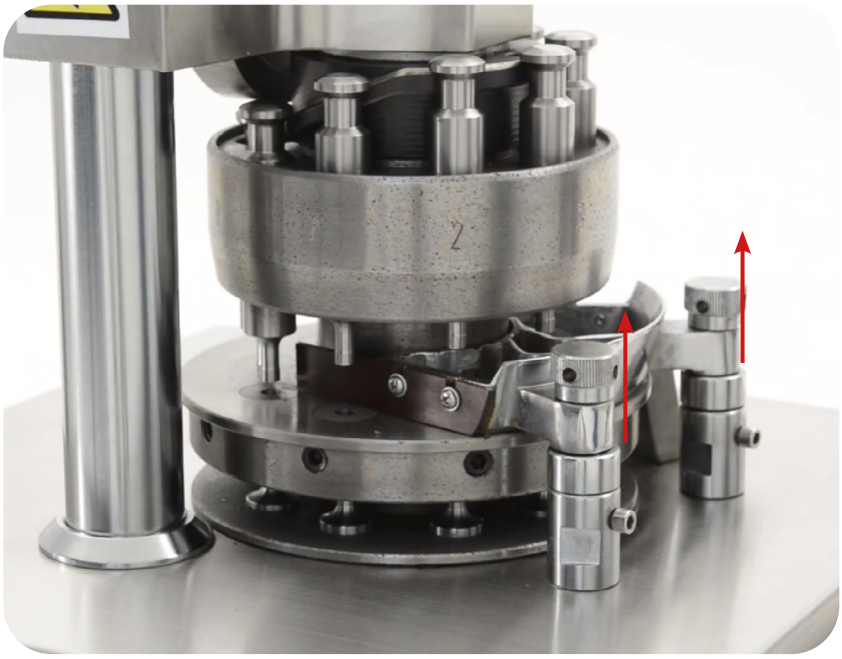
Note: Wear latex/rubber gloves (and appropriate food grade attire if applicable) during this process.

Remove the Upper Roller Cam

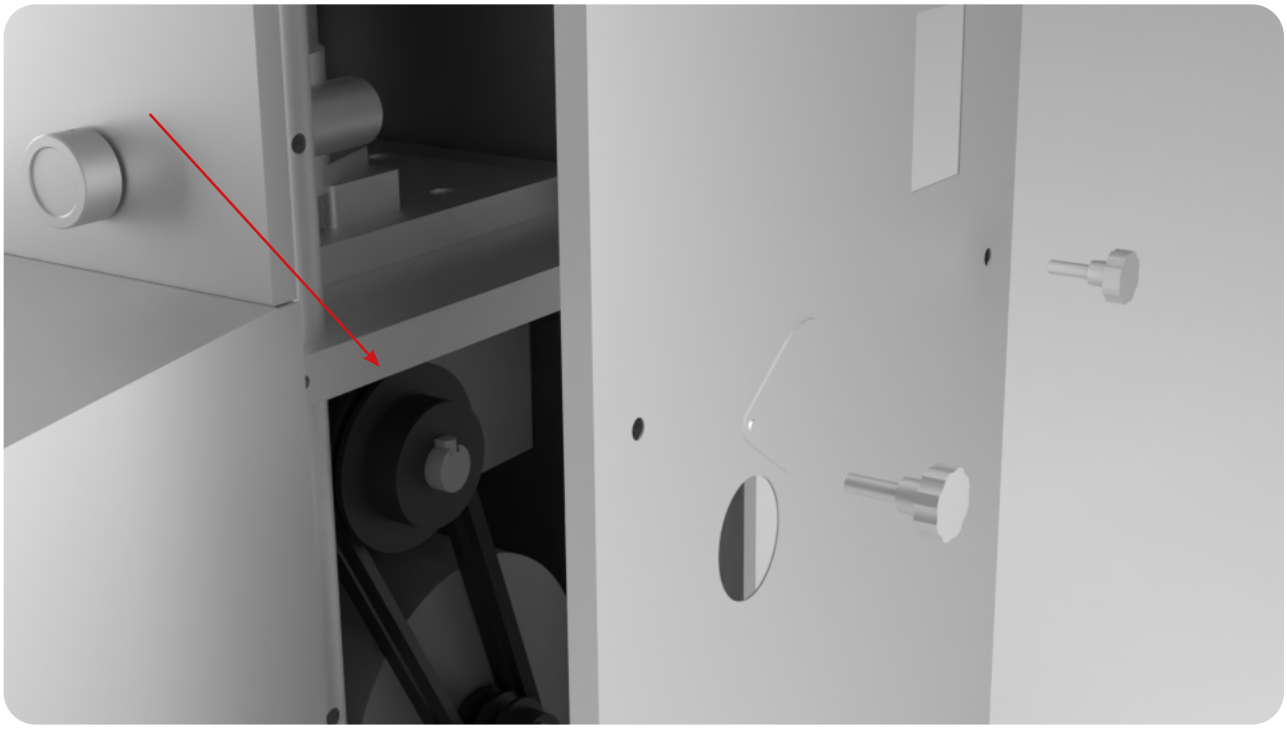
1. Loosen the Hopper's screws with an Allen key and remove it from the Perspex Casing.
2. Remove the screws on the Perspex Casing with an Allen key and take it off.



3. Loosen the Fill Tray's Thumb Bolts with an Allen key and remove them by hand.

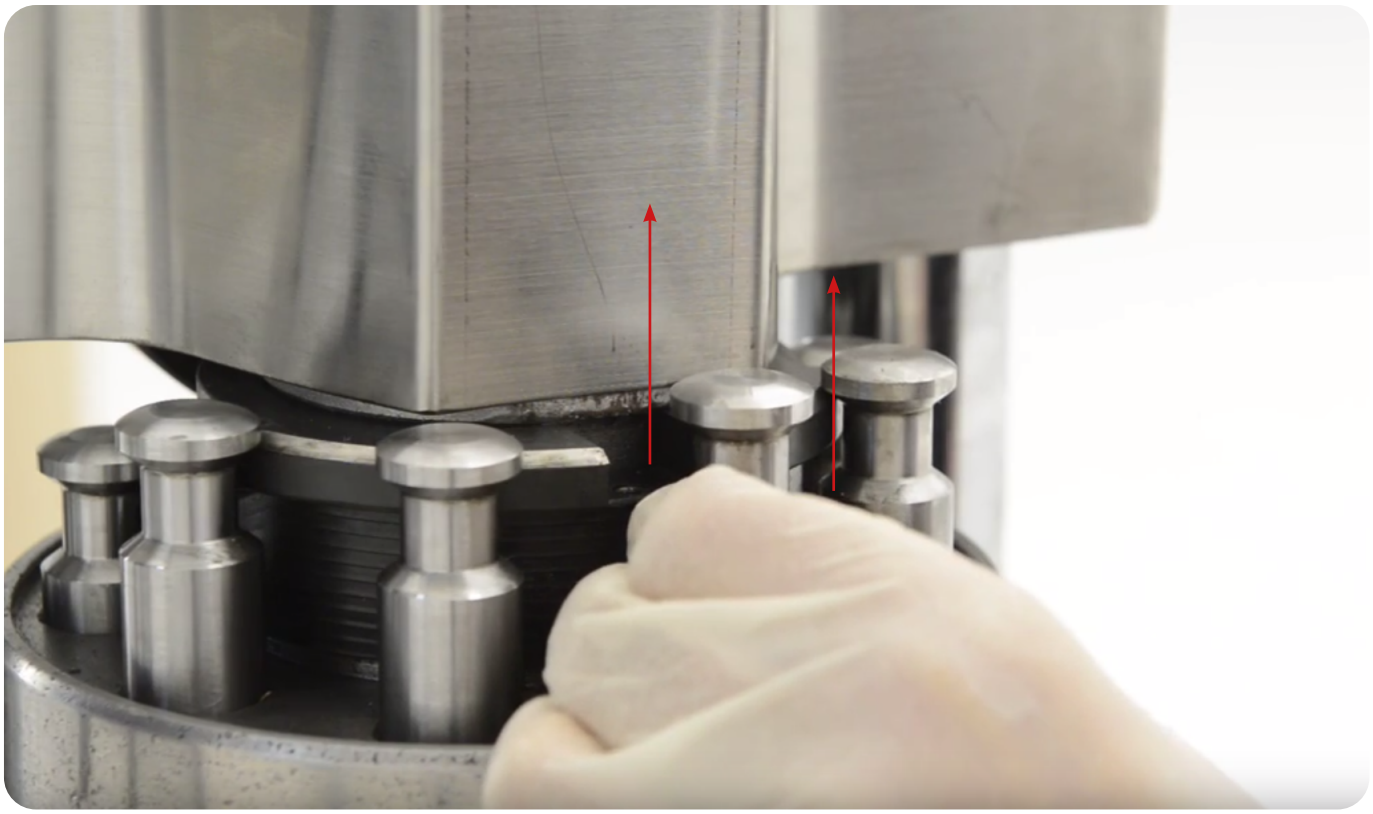


4. Remove the Fill Tray from the Turret.
5. Remove the rear side panel door and insert the Handle onto the Drive Belt Pulley socket.



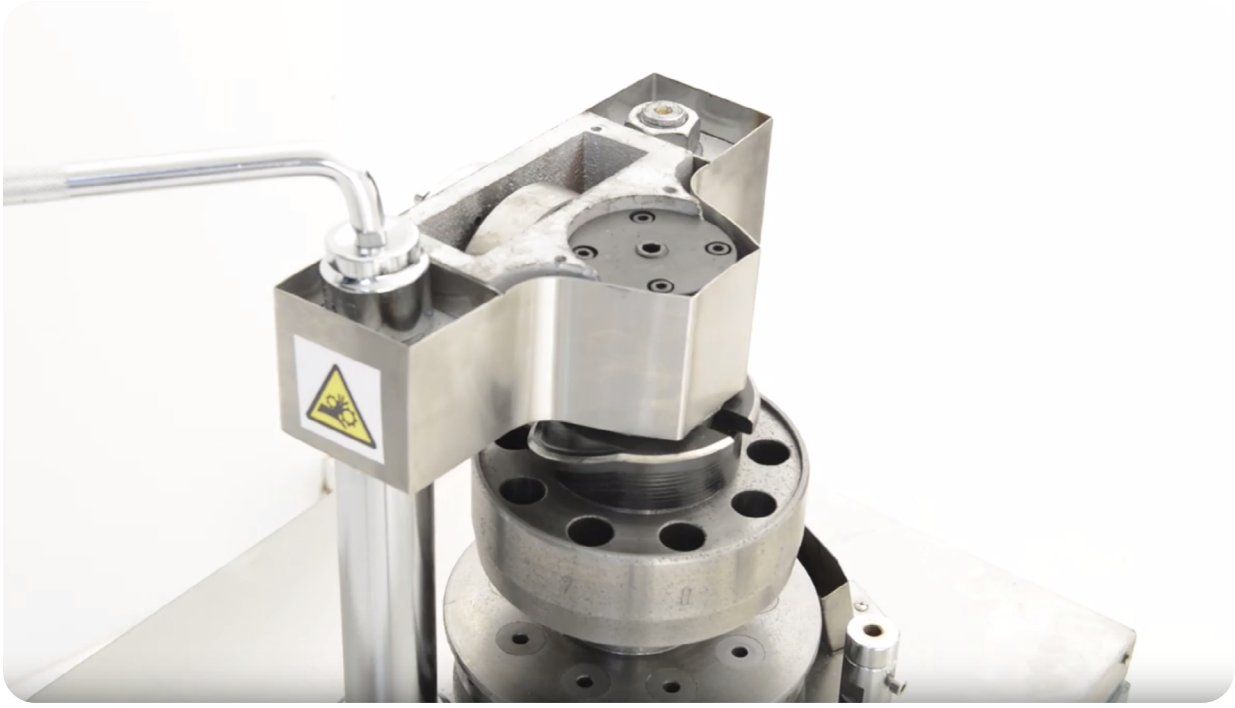
6. Remove the Upper Tracking Key with an Allen key.

7. Rotate the Handle until an Upper Punch is where the Upper Tracking Key was previously.
8. Pull the Upper Punch upwards to remove it from the Turret.



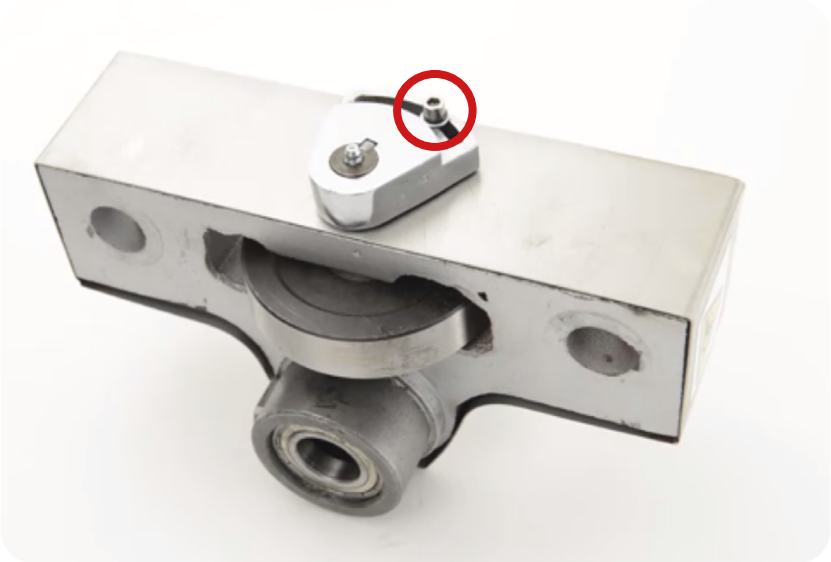
9. Repeat steps 7-8 until all Upper Punches are removed.

10. Remove the large nuts in the Upper Roller Cam Housing with a socket wrench.

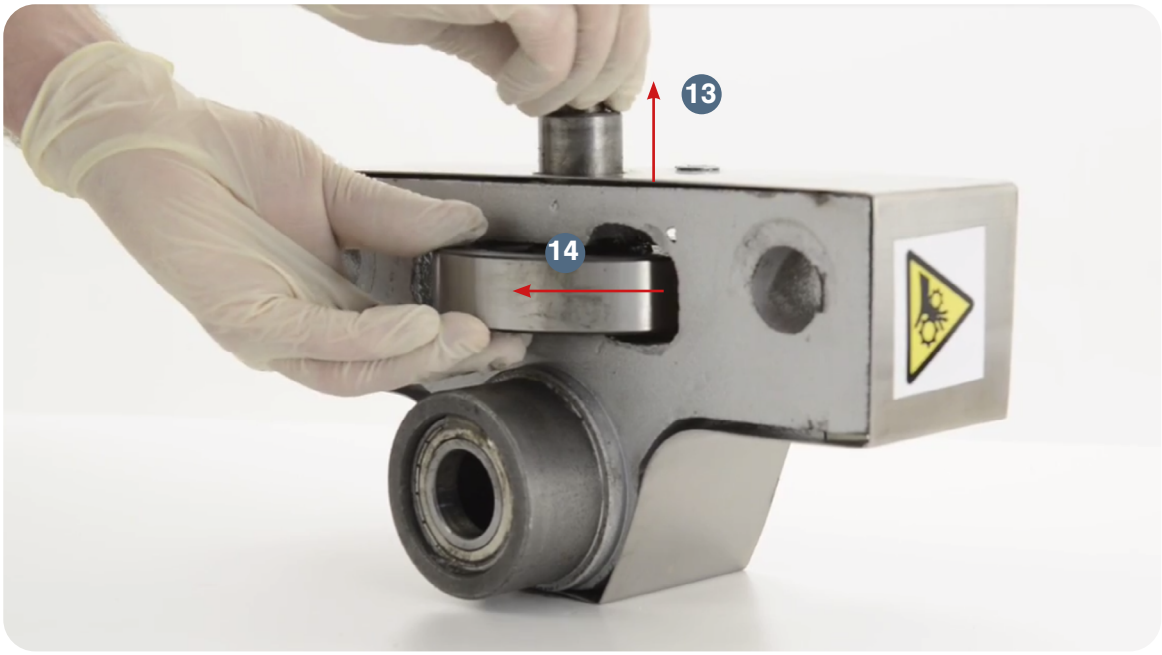


11. Pull up the Upper Roller Cam Housing from the Turret.
    11.1 Note: Be sure to keep a hold of the Upper Tracking to prevent it from falling.

12. Remove the Upper Roller Cam Pressure Adjuster with an Allen key.



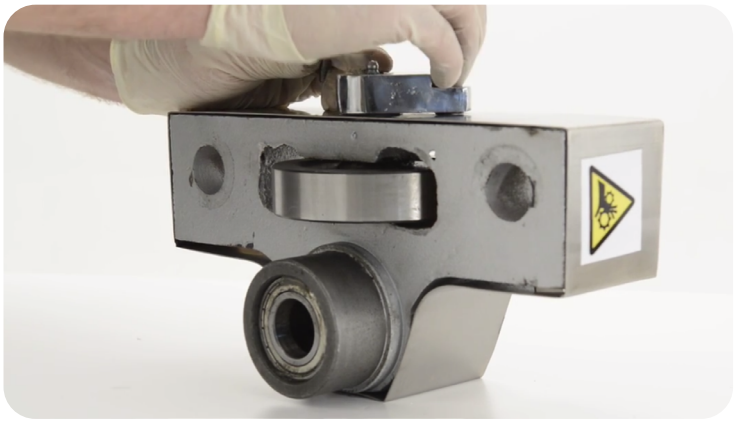
13. Pull out the Upper Roller Cam Shaft from the Upper Roller Cam.
14. Remove the Upper Roller Cam from the Upper Roller Cam Housing.



Replace the Upper Roller Cam

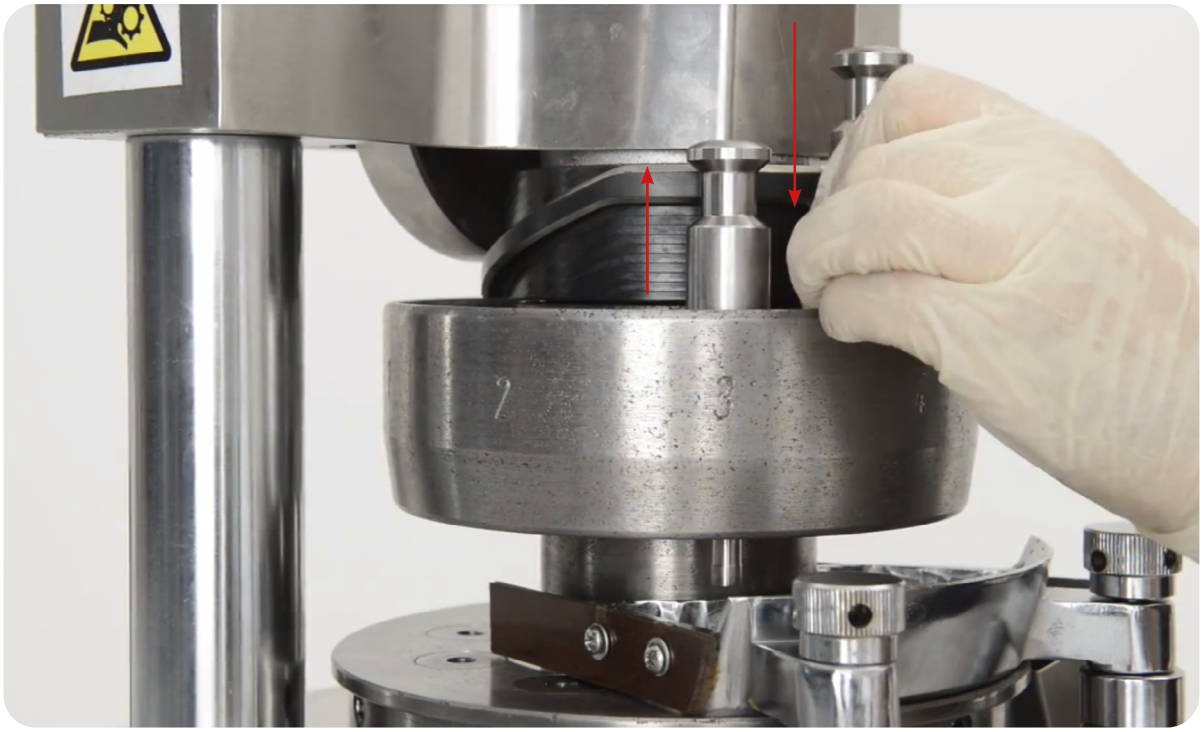
15. Insert the new Upper Roller Cam into the Upper Roller Cam Housing.
16. Insert the Upper Roller Cam Shaft into the new Upper Roller Cam and Upper Roller Cam Housing.
    16.1 Note: Ensure that the Upper Roller Cam Shaft's keyed section is facing the Upper Roller Cam Pressure Adjuster's bolt hole.

17. Reinsert the Upper Roller Cam Pressure Adjuster onto the Upper Roller Cam Shaft and tighten its bolt with an Allen key.



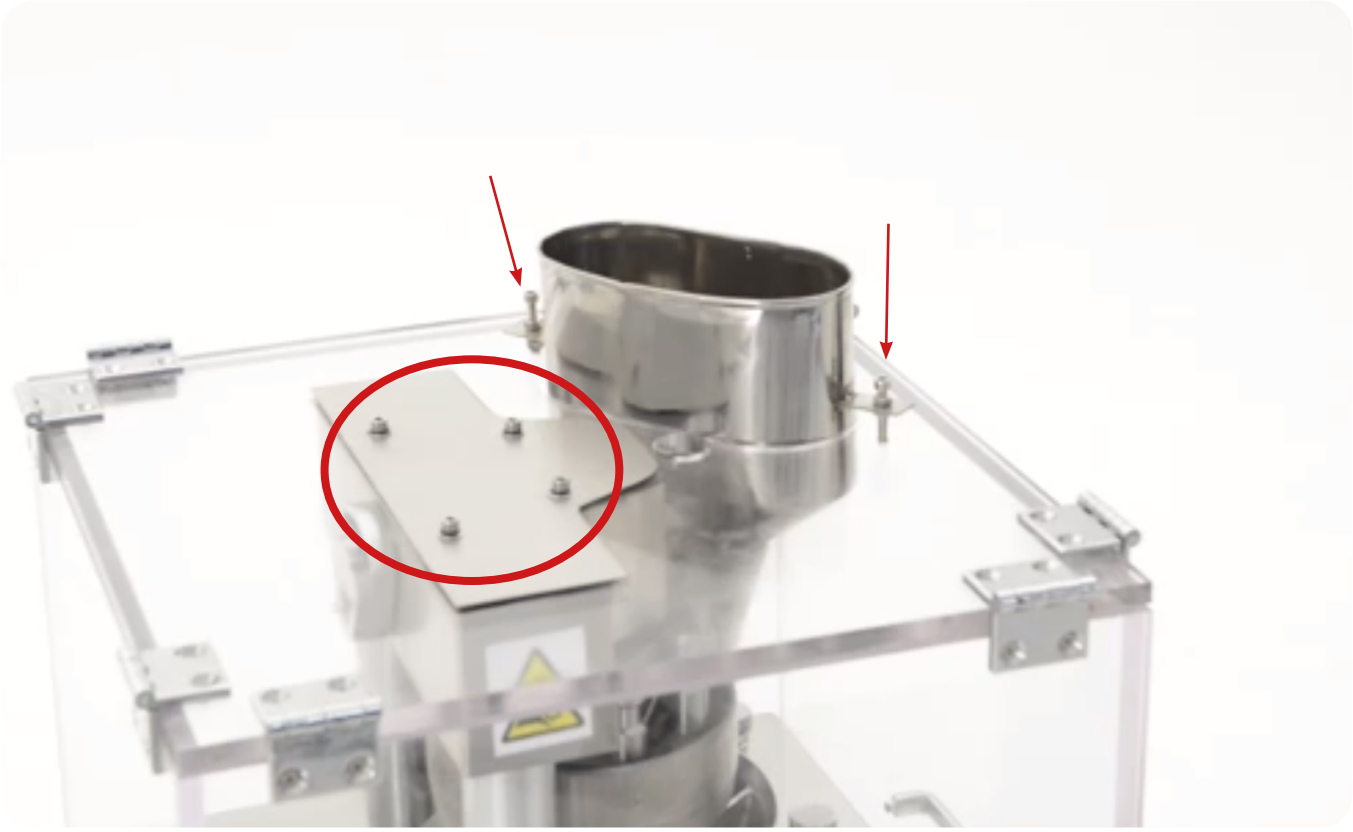
18. Reinsert the Upper Roller Cam Housing onto the RTP 9® and tighten the nuts with a socket wrench.
    18.1 Note: The correct tension for these nuts is 70-90 Nm.

19. Insert an Upper Punch through the top of the Turret.
20. Place the Upper Punch's head on the Upper Tracking.
    20.1 Note: Be sure that the Upper Punch's head is above the Upper Tracking to prevent damage.



21. Rotate the Handle until the next Upper Punch can be inserted.
22. Repeat steps 19-21 until all the Upper Punches are inserted into the Turret.
23. Resecure the Upper Tracking Key with an Allen key.
    23.1 Note: Manually turn the RTP 9® Turret for a couple of rotations to ensure that the Upper Punches are situated correctly.

24. Remove the Handle from the Drive Belt Pulley.
25. Place the Fill Tray back on the Turret.
    25.1 Note: Please refer to the Fill Tray Height adjustment instructions on page 22 for calibration.
26. Tighten the Fill Tray Thumb Bolts back onto the Fill Tray and RTP 9® by hand and/or with an Allen key.
29. Resecure the bolts on the Perspex Casing with an Allen key.
30. Resecure the Hopper to the Perspex Casing with an Allen key.



Lower Tracking

The Lower Tracking (the Fill Cam, Ejection Cam, and Dosing Cam) guides the Lower Punches' movement throughout the machine's operation. To watch a video of what worn a Lower Tracking cams looks like, go to https://www.lfatabletpresses.com/rtp-9-inspecting-lower-cams

Tools and Materials Needed

- Set of metric Allen keys with ball ends
- Crosshead screwdriver
- Socket wrench (36 mm) from RTP 9® Toolkit
- Disposable latex/rubber gloves (for food grade products and to protect hands from grease)
- Hairnet and/or beard net (food grade products only)
- Sterile shoe covers (food grade products only)

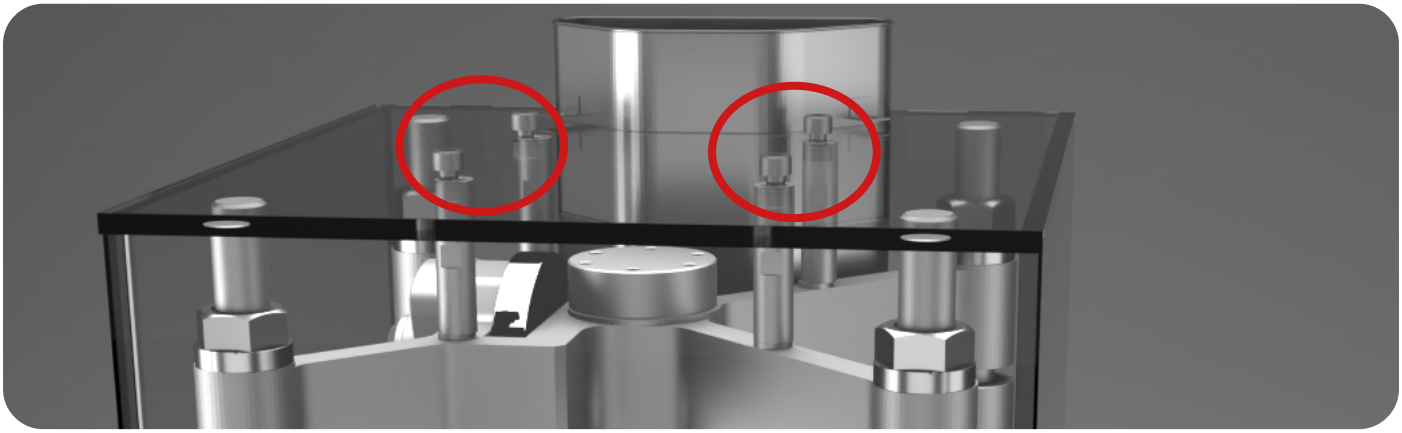
WARNING: To prevent any potential personal injury, ALWAYS unplug the RTP 9® from the electrical outlet when replacing parts.

Instructions

Note: Wear latex/rubber gloves (and appropriate food grade attire if applicable) during this process.

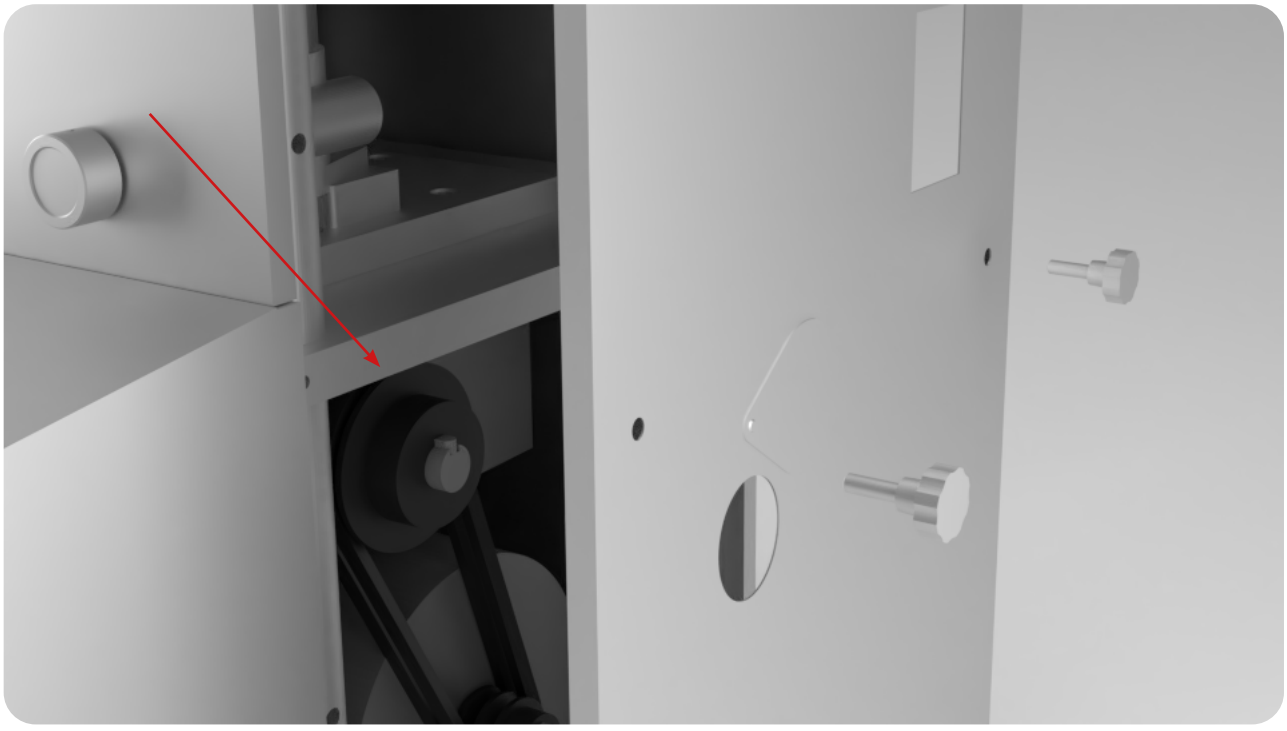
Remove the Lower Tracking

1. Loosen the Hopper's screws with an Allen key and remove it from the Perspex Casing.
2. Remove the screws on the Perspex Casing with an Allen key and take it off.



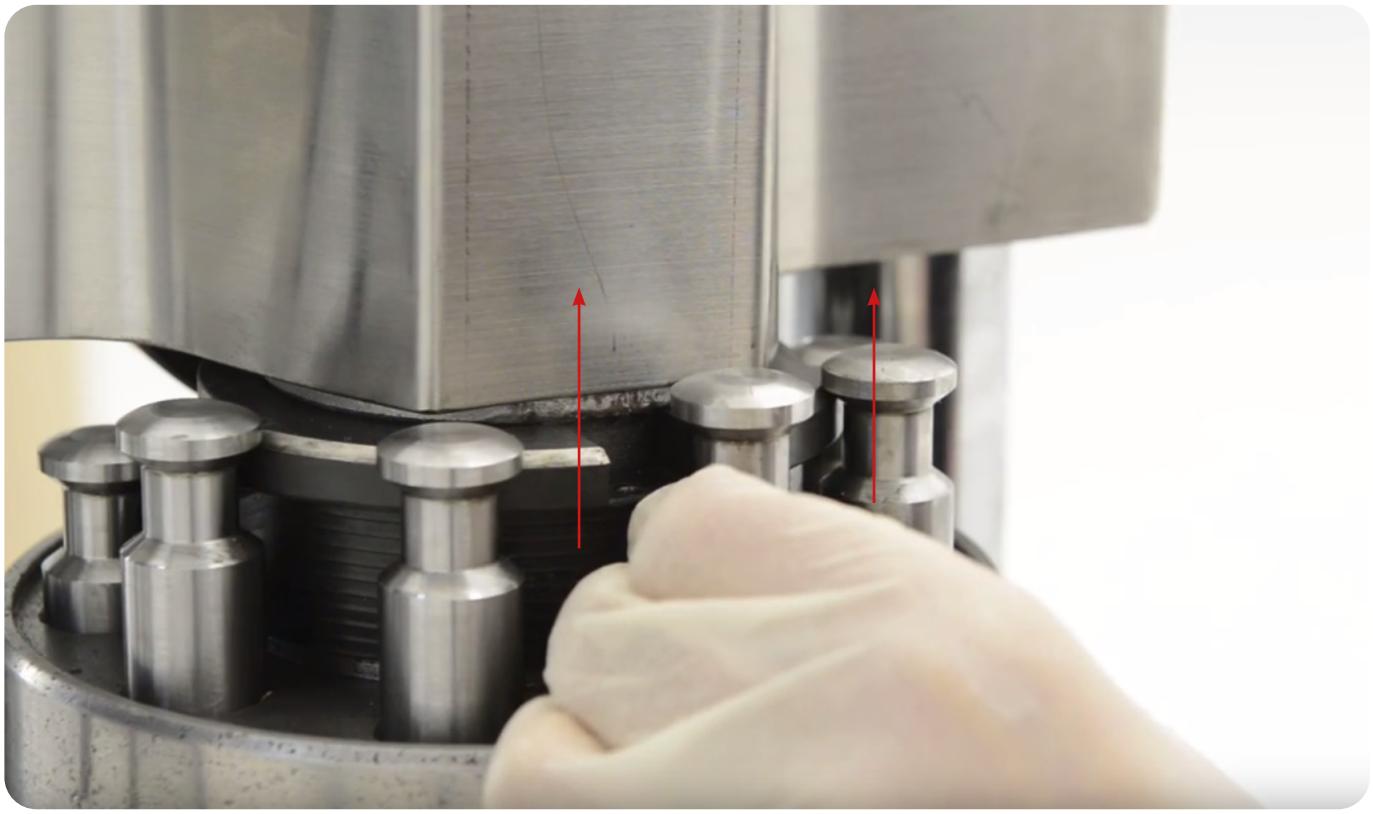
3. Loosen the Fill Tray's Thumb Bolts with an Allen key and remove them by hand.

4. Remove the Fill Tray from the Turret.
5. Remove the rear side panel door and insert the Handle onto the Drive Belt Pulley socket.

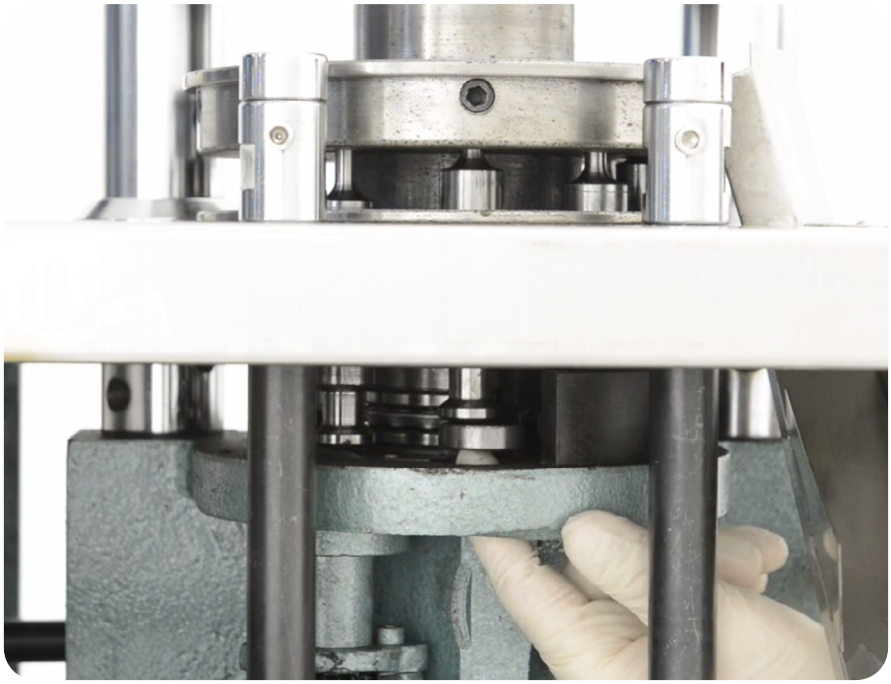


6. Remove the Upper Tracking Key with an Allen key.

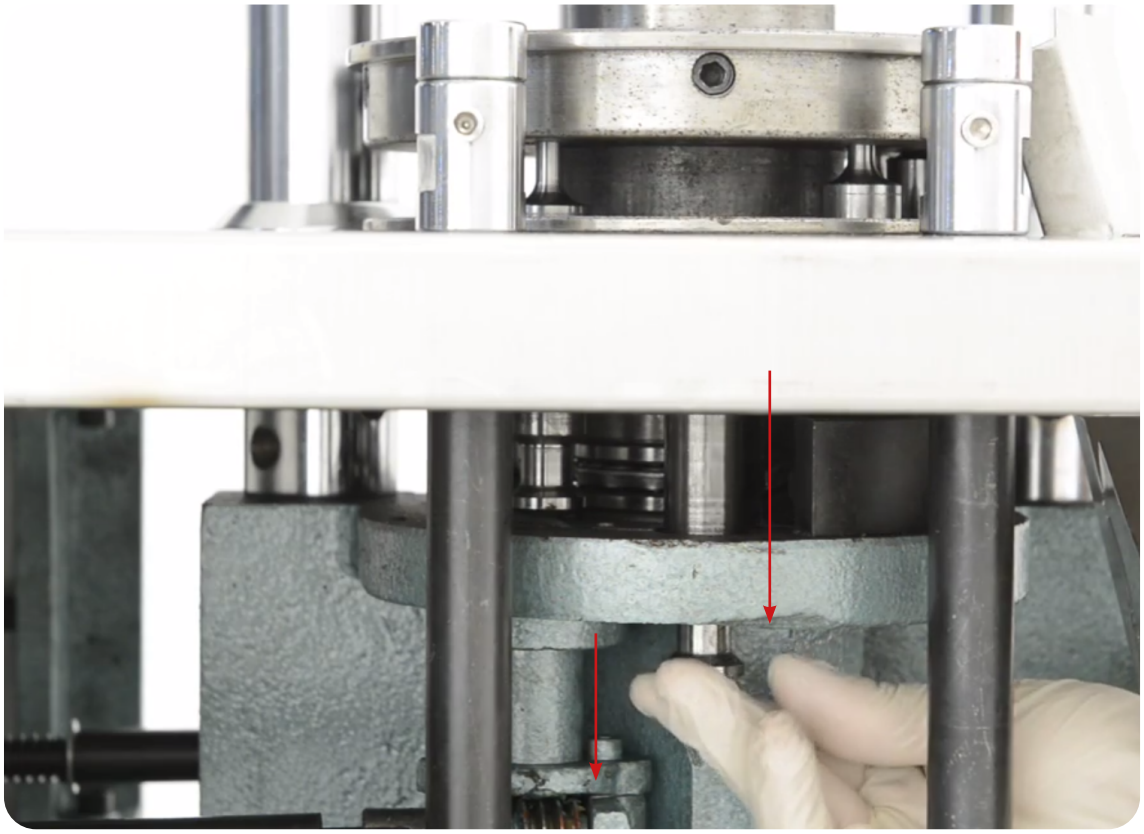
7. Rotate the Handle until an Upper Punch is where the Upper Tracking Key was previously.
8. Pull the Upper Punch upwards to remove it from the Turret.



9. Repeat steps 7-8 until all Upper Punches are removed.
10. Push up the Lower Punch Insertion Disc underneath the Lower Punches and remove it from the RTP 9®.
11. Remove the right-hand panel door.



12. Rotate the Handle until a Lower Punch is aligned with where the Lower Punch Insertion Disc was previously.
13. Gently pull on the Lower Punch's head through the hole.
    13.1 Note: Be sure to have a firm hold on the Lower Punch so that it does not fall and become damaged.

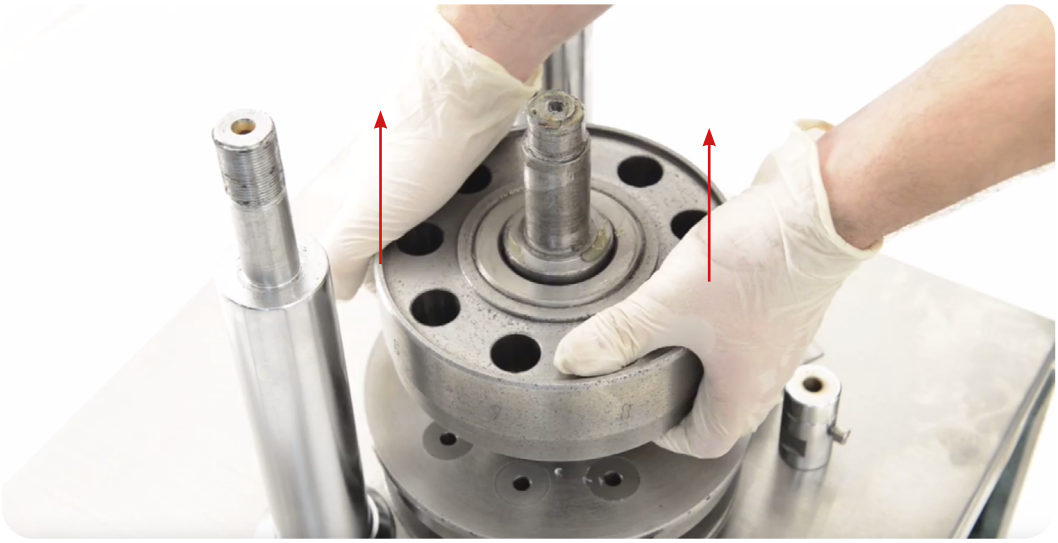


14. Repeat steps 12-13 until all Lower Punches are removed.

15. Remove the large nuts in the Upper Roller Cam Housing with a socket wrench.

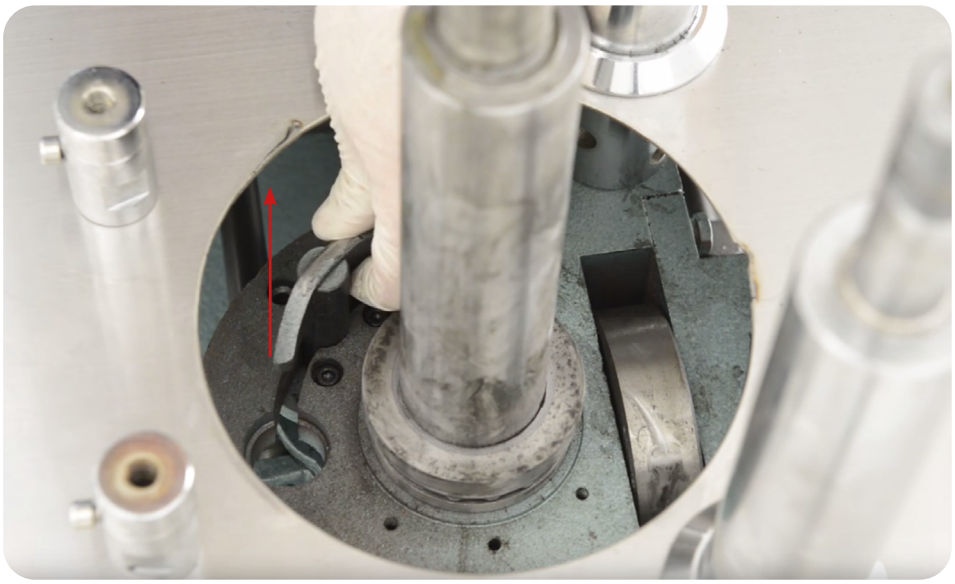
16. Pull up the Upper Roller Cam Housing from the Turret.
    16.1 Note: Be sure to keep a hold of the Upper Tracking to prevent it from falling.

17. Pull up the Turret and set it aside.



18. Remove the Ejection Cam and the Fill Cam with an Allen key.
19. Turn the Fill Depth Knob clockwise to raise the Dosing Cam.

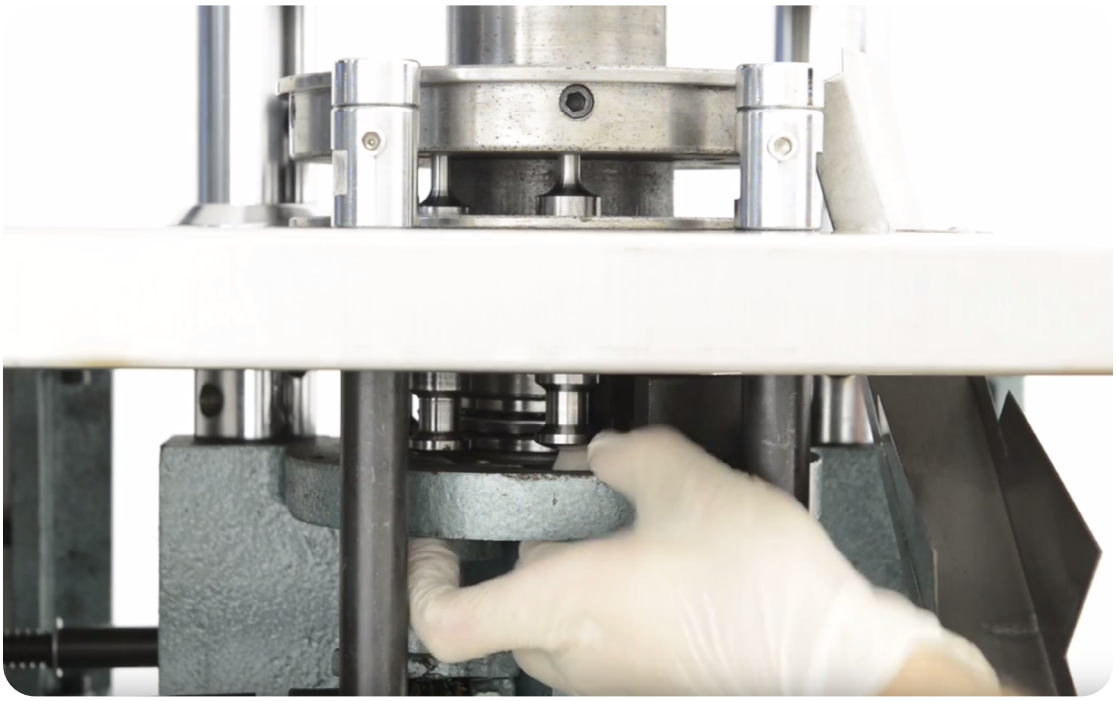
20. Pull up the Dosing Cam from the RTP 9®.



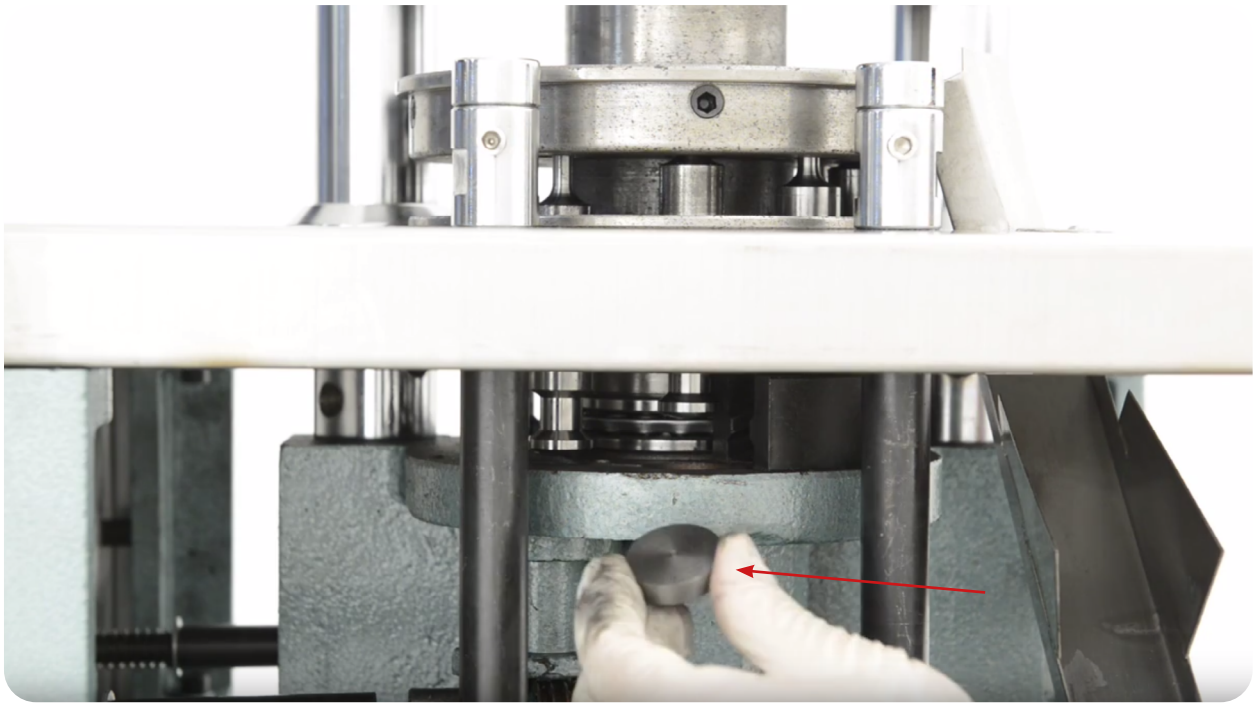
Replace the Lower Tracking

21. Secure the new Lower Tracking components with an Allen key and a crosshead screwdriver.
22. Reinsert the Turret over the Main Drive Shaft.
23. Reinsert the Upper Cam Housing and tighten its screws with a socket wrench.
    23.1 Note: The correct tension for these nuts is 70-90 Nm.

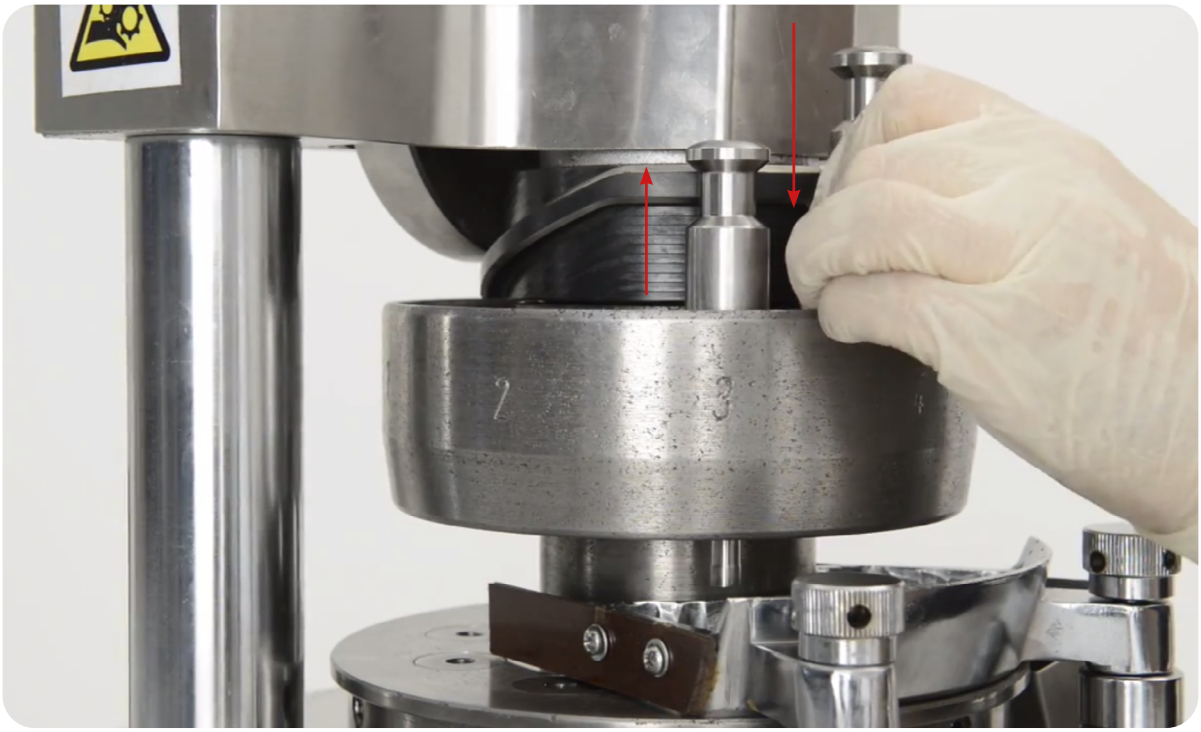
24. Insert a Lower Punch up through the Lower Punch Insertion Disc's hole and into the Die's bore.



25. Place the Lower Punch's head on the Lower Tracking.
26. Rotate the Handle until the next Lower Punch can be inserted.
27. Repeat steps 24-26 until all the Lower Punches are inserted into the Turret.
28. Reinsert the Lower Punch Insertion Disc with the beveled side facing up.
    28.1 Note: Manually turn the RTP 9®'s Turret for a couple of rotations to ensure that the Lower Punches are situated correctly.

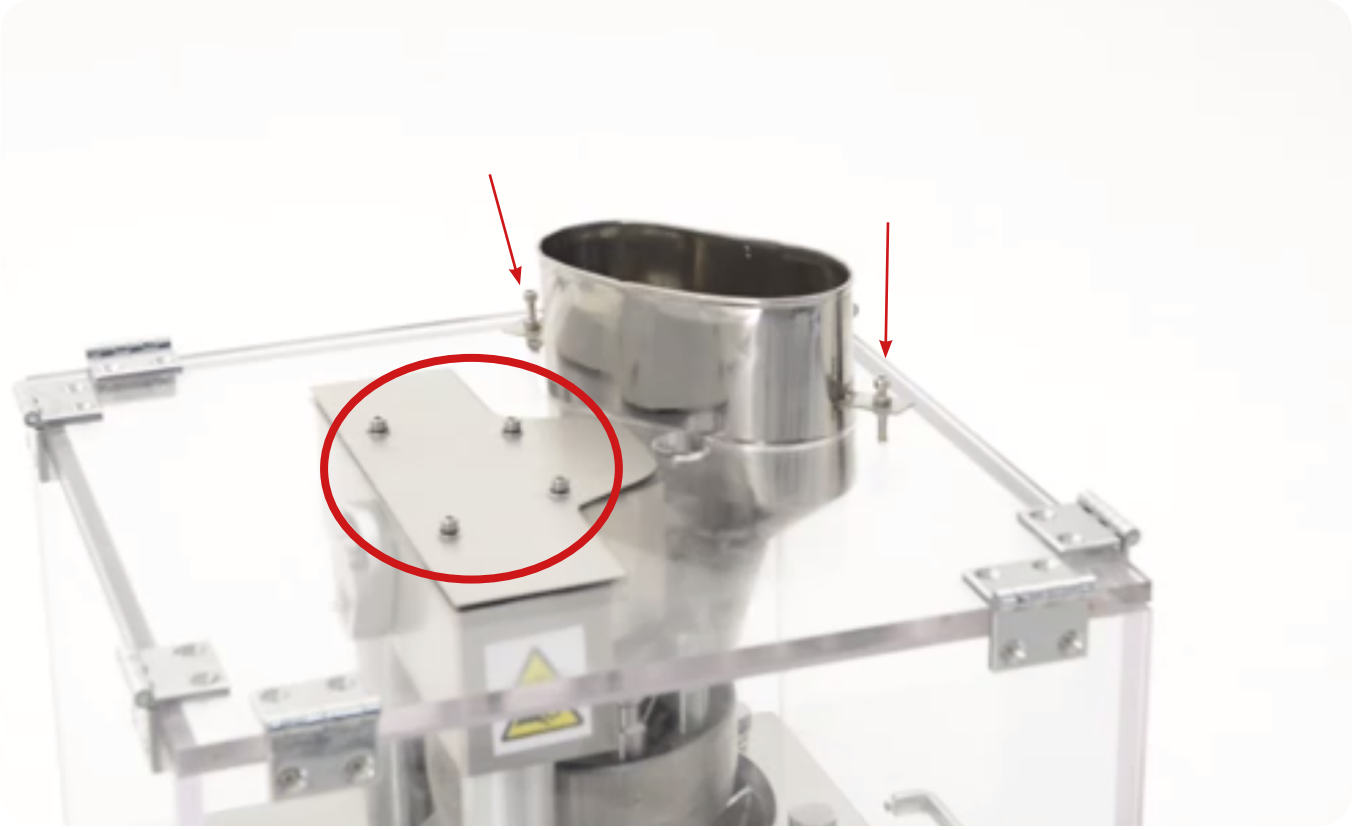


29. Insert an Upper Punch through the top of the Turret.
30. Place the Upper Punch's head on the Upper Tracking.
    30.1 Note: Be sure that the Upper Punch's head is above the Upper Tracking to prevent damage.



31. Rotate the Handle until the next Upper Punch can be inserted.
32. Repeat steps 29-31 until all the Upper Punches are inserted into the Turret.
33. Resecure the Upper Tracking Key with an Allen key.
    33.1 Note: Manually turn the RTP 9®'s Turret for a couple of full rotations to ensure that the Upper Punches are situated correctly.

34. Remove the Handle from the Drive Belt Pulley.
35. Close the panel door.
36. Place the Fill Tray back on the Turret.
    36.1 Note: Please refer to the Fill Tray Height adjustment instructions on page 22 for calibration.
37. Tighten the Fill Tray Thumb Bolts back onto the Fill Tray and RTP 9® by hand and/or with an Allen key.
38. Resecure the bolts on the Perspex Casing with an Allen key.
39. Resecure the Hopper to the Perspex Casing with an Allen key.



Lower Roller Cam

The Lower Roller Cam compresses the Lower Punches to make tablets. These instructions also apply to replacing the Lower Roller Cam Shaft.

To watch a video of what a worn Lower Roller Cam looks like, go to https://www.lfatabletpresses.com/rtp-9-inspecting-roller-cams

Tools and Materials Needed

- Set of metric Allen keys with ball ends
- Socket wrench set
- New Lower Roller Cam part
- Disposable latex/rubber gloves (for food grade products and to protect hands from grease)
- Hairnet and/or beard net (food grade products only)
- Sterile shoe covers (food grade products only)

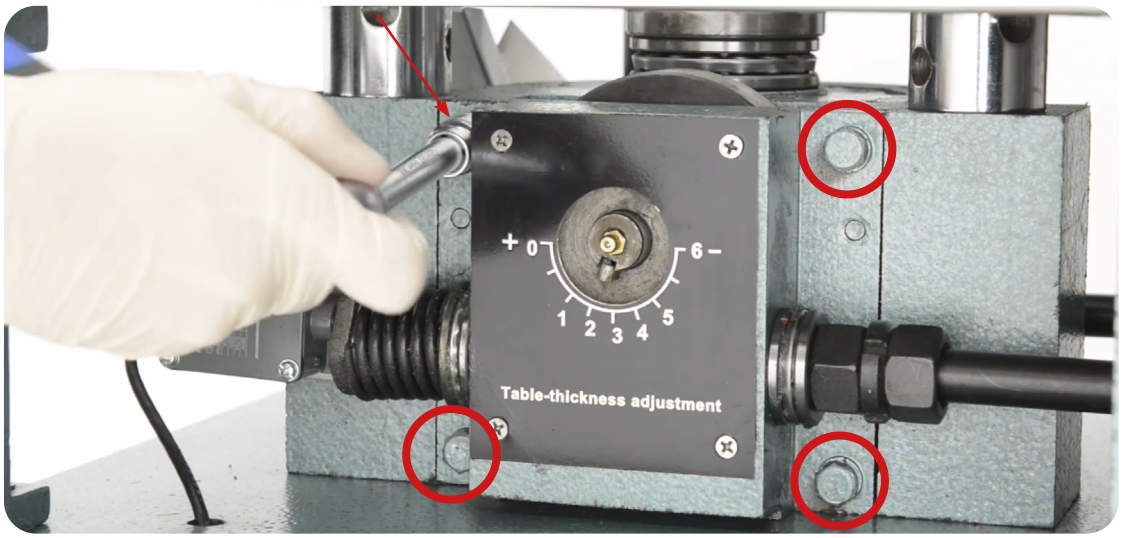
WARNING: To prevent any potential personal injury, ALWAYS unplug the RTP 9® from the electrical outlet when replacing parts.

Instructions

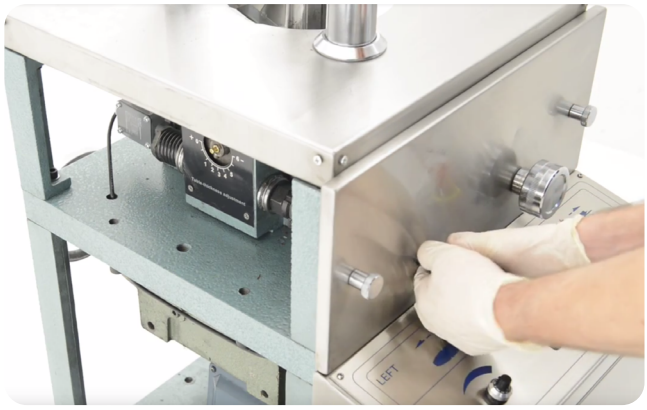
Note: Wear latex/rubber gloves (and appropriate food grade attire if applicable) during this process.

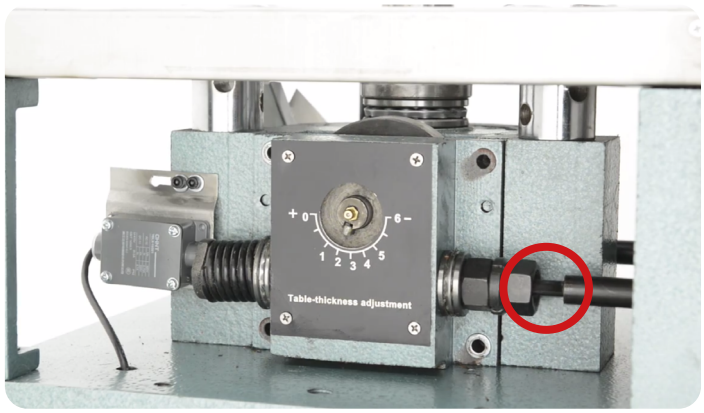
Remove the Lower Roller Cam

1. Remove the left-hand side panel door.
2. Remove the four bolts that hold the Lower Roller Cam with a socket wrench.



3. Pull on the Fill Depth Knob until it disengages from the RTP 9®.

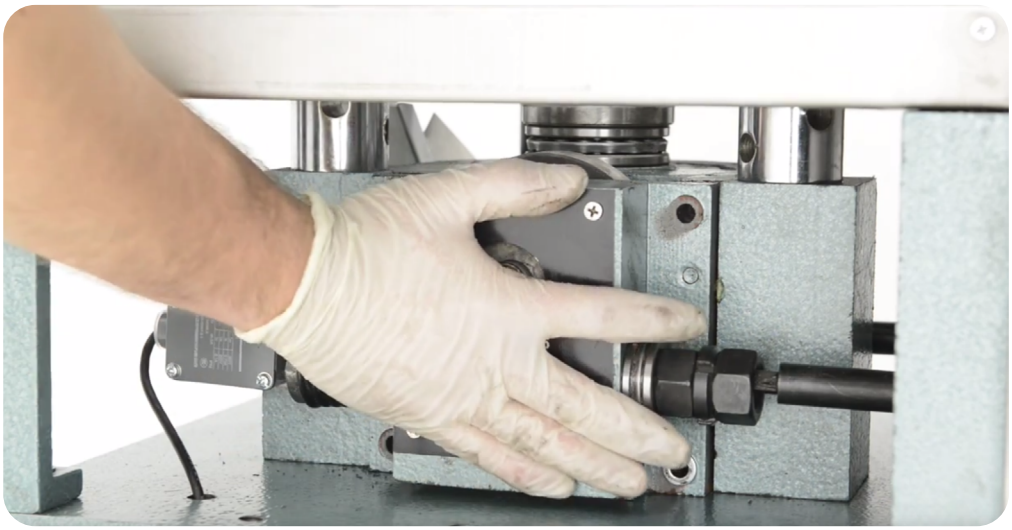




4. Pull out the Lower Roller Cam's housing by hand.
5. Remove the Lower Roller Cam from the Lower Roller Cam Shaft.
    5.1 Note: For Lower Roller Cam Shaft removal, use a small crowbar to disengage it from the Lower Roller Cam's housing.

Replace the Lower Roller Cam

6. Insert the new Lower Roller Cam onto the Lower Roller Cam Shaft.
7. Reinsert the Pressure Knob into the correct position.
8. Place the new Lower Roller Cam's housing back onto the RTP 9®.
    8.1 Note: Ensure that everything is in the correct position before fully tightening the bolts.



9. Tighten the bolts that hold the Lower Roller Cam's housing with a socket wrench.
    9.1 Note: The tightening torque for each bolt should be 10 Nm.
10. Place the Handle on the Drive Belt Pulley and manually rotate it once to ensure everything is operating properly.
11. Remove the Handle and lock the left-hand side panel door.

Troubleshooting

Sometimes unavoidable issues will occur while operating the RTP 9®. Fortunately, there are several methods to remedy these issues.

Common Machine/Part Issues

Symptom	Possible Cause	Possible Solution
Machine freezes or locks up	Grease point areas are dry.	Regularly oil and grease all the Grease Nipples and high friction areas.
	There is excess pressure.	Rotate the Pressure Knob on the left-hand side of machine counterclockwise.
	There is caking of powder in the machine.	Take apart the Turret and Tooling and clean.
Knocking sounds coming from machine	There is excess pressure.	Rotate the Pressure Knob on the left-hand side of the machine counterclockwise.
	The V Belts are loose.	Adjust the Motor's nuts to tighten the V Belts.
	Parts may be loose.	Check the machine's parts and tighten as necessary.
	The Gearbox needs oil.	Check the Gearbox's oil gauge and lubricate as necessary.
Heavy resistance during production	The high friction areas are either unclean, locked, worn out, or not greased properly.	Apply grease to the Grease Nipple points and all high friction areas and/or clean the machine.
Excess machine vibration	The V Belts are worn.	Replace the V Belts.
	The machine has no anti-vibration pads or they are worn.	Place new anti-vibration pads on the bottom of the machine.
	Parts may be loose.	Check the machine's parts and tighten as necessary.
Excess powder waste	The dry materials are moving too fast.	Lower the rotation speed.
	The Fill Tray is too high or unleveled.	Adjust the Fill Tray, Fill Tray Scraper, and Take-Off Blade accordingly.
	There is a gap between the Turret and the Machine Base.	Apply NLGI Grade 4 grease to the gap between the Turret and Machine Base.

Symptom	Possible Cause	Possible Solution
Inability to compact materials to tablet form	The Fill Tray is blocked and not enough materials are flowing out.	Check the Fill Tray for a potential clog.
	There is not enough pressure.	Rotate the Pressure Knob on the left-hand side of the machine clockwise.
	The Tooling is damaged.	Remove and replace the Tooling (all Upper Punches, Lower Punches, and Dies)
	There are flowing issues with the mix.	If the machine is able to make tablets with LFA's Firmapress®, then the problem is your mix. Adjust your formulation. If still an issue, contact LFA for support.
Powder sticks to the Upper Punches	There is damage to the Tooling or the Tooling's design is causing sticking.	Remove and replace the Tooling (all Upper Punches, Lower Punches, and Dies).
	There are issues with the mix.	Adjust your formulation. If still an issue, contact LFA for support.
Powder sticks to the Lower Punches	There are issues with the mix.	Adjust your formulation. If still an issue, contact LFA for support.

Common Tablet Issues

Symptom	Possible Cause	Possible Solution
Double tablets	Previous tablet did not eject correctly.	Remove the double tablet manually from the Die bore.
	Excess granular materials were placed in the Die, which prevented the ejection of the existing tablet.	Clean the Tooling to remove any excess granular materials and make sure that it is clean and completely dry.
Cracked or broken tablets	There are problems with the formulation of the granules and ingredients.	If the machine is able to make tablets with LFA's Firmapress®, then the problem is your mix. Adjust your formulation. If still an issue, contact LFA for support.
	The Fill Tray is not feeding enough material to be pressed in tablet form.	Adjust the Fill Tray, Fill Tray Scraper, and Take-Off Blade accordingly.
	There is excess pressure.	Please read our article on Capping at https://www.lfatabletpresses.com/articles/tablet-capping
Inconsistent tablet weight	There are flowing issues with the mix.	If the machine is able to make tablets with LFA's Firmapress®, then the problem is your mix. Adjust your formulation. If still an issue, contact LFA for support.
Soft tablets	There is too little punch pressure.	Rotate the Pressure Knob on the left side of the machine clockwise.
	There are flowing issues with the mix.	If the machine is able to make tablets with LFA's Firmapress®, then the problem is your mix. Adjust your formulation. If still an issue, contact LFA for support.
Uneven tablets	The Tooling is worn out.	Check the ingredients of your formula before you replace the Tooling.
Broken tablets during ejection	The Ejection Cam is dirty.	Take off the Turret and inspect Ejection Cam and clean if necessary.
	The Ejection Cam is worn.	Replace the Ejection Cam.

De-Jamming the RTP 9®

Some reasons why an RTP 9® might jam are:

- The fill depth is set too low and the pressure is set too high. At its highest punch pressure force, the machine will automatically cut off.
- There is a build up of powder sticking to the Tooling.

Tools and Materials Needed

- Set of metric Allen keys with ball ends
- Disposable latex/rubber gloves (for food grade products and to protect hands from grease)
- Hairnet and/or beard net (food grade products only)
- Sterile shoe covers (food grade products only)

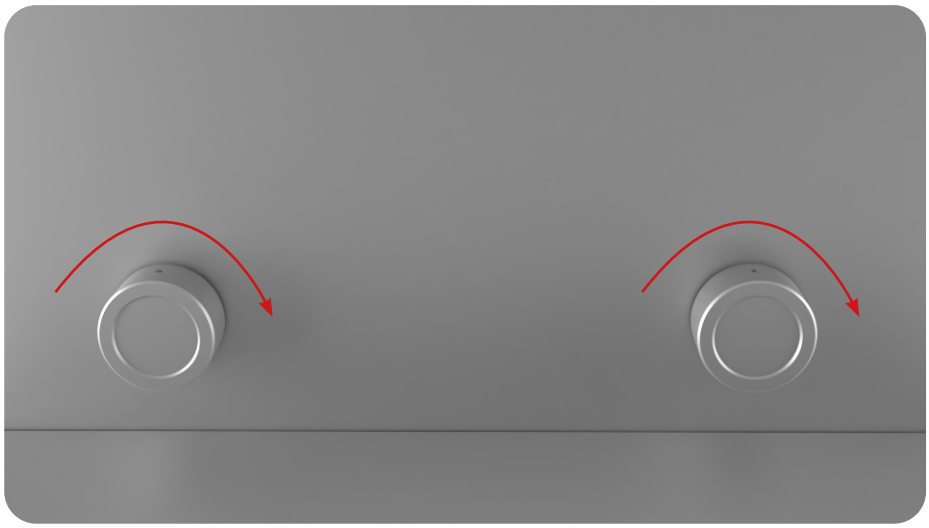
WARNING: To prevent any potential personal injury, ALWAYS unplug the RTP 9® before de-jamming it.

Instructions

Note: Wear latex/rubber gloves (and appropriate food grade attire if applicable) during this process.

Method 1: Lower the Punch Pressure

1. Remove all the excess powder.
2. Rotate the left-hand knob on the console clockwise to its limit.
3. Rotate the right-hand knob on the console clockwise to its limit.
4. Insert the Handle into the Drive Belt Pulley socket.
5. Turn the Handle until the machine turns over.



Cleaning

During the RTP 9®'s operation, excess powder will find its way into parts of the machine, particularly on the Tooling, Fill Tray, Turret, Upper Tracking, and Lower Tracking. It is important to clean the RTP 9® thoroughly to prevent rusting and cross contamination.

LFA recommends that the machine be cleaned after each operation.

Tools and Materials Needed

- Cleaning brush
- Bagless vacuum
- Long wire pipe cleaner
- Toothbrush
- Cleaner (e.g. Member's Mark Commercial Lemon Fresh Disinfectant)
- Sanitizer (e.g. Member's Mark Commercial Sanitizer)
- Set of metric Allen keys with ball ends
- Socket wrench (36 mm) from RTP 9® Toolkit
- Die Installation Bar from RTP 9® Toolkit
- Die Removal Bar from RTP 9® Toolkit
- Disposable latex/rubber gloves
- Bowl of warm soapy water (nothing abrasive)
- 3 clean cloths
- Potable water
- Hairnet and/or beard net (food grade products only)
- Sterile shoe covers (food grade products only)

WARNING: To prevent any potential personal injury, ALWAYS unplug the RTP 9® from the electrical outlet when replacing parts.

Instructions

Note: Wear latex/rubber gloves (and appropriate food grade attire if applicable) during this process.

Remove Parts

1. Remove the Hopper, the Perspex Casing, the Fill Tray, the Tooling, and the Turret.
    1.1 Note: Please refer to the repair Lower Tracking instructions on page 60 for further assistance.
2. Remove the left-hand, right-hand, and rear side panel doors.
3. Use a brush to bring powder debris out from hard to reach places.
4. Vacuum the top section of the RTP 9®.
    4.1 Note: Ensure that you vacuum inside the top panel where the Turret is positioned.
5. Vacuum the entire areas inside the steel side panel door encasement.
    5.1 Note: Be sure to vacuum both levels and all corners of the RTP 9® base.

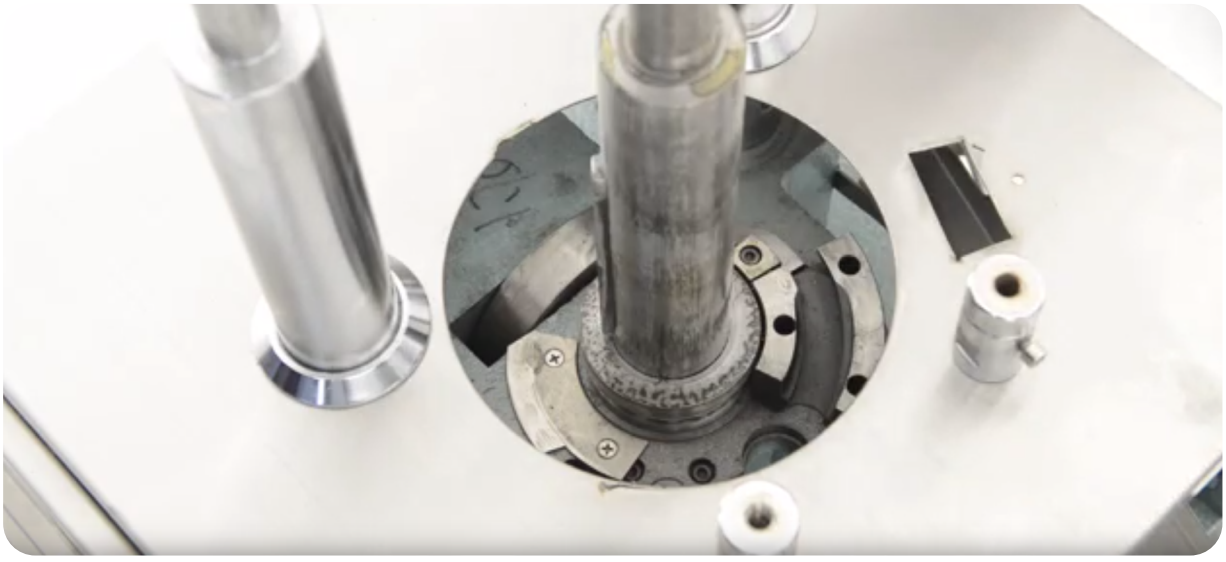
Note: Before washing the Turret and Die bores, LFA recommends using our Die Seat Cleaner. You can order the Die Seat Cleaner and Insertion Ring on our website at https://www.lfatabletpresses.com/die-seat-cleaner-insertion-ring

Clean the Parts

6. Take one of the parts removed from the machine and bring it to the bowl of soapy water.
    6.1 Note: To ensure that all dirt and debris are removed, wash one part at a time.
7. Take a clean cloth and carefully wash the part thoroughly.
    7.1 Note: Use the toothbrush for difficult-to-remove debris. When cleaning tooling, use non-abrasive cleaning equipment such as a soft pipe cleaner and soft cloth.
8. Dry part immediately after it is cleaned and rinsed.
9. Sanitize part with a clean cloth.
10. Lubricate part.
11. Repeat steps 6-10 for each remaining part until they are all clean.

Clean the Base

12. Spray the RTP 9® base with the cleaner, particularly in the Tooling's location.
13. Rinse the cleaner off with potable water.
14. Sanitize the RTP base with a clean cloth.



Cleaning Schedule Matrix

Part	Frequency							
	After installing machine	After every use	Before every use	In between products that present a cross contamination risk	Weekly	Monthly	Before placing In storage	After removing from storage
Tooling	Remove from machine	Remove from machine	Install into machine	Remove from machine	N/A	N/A	Remove from machine	Install into machine
Hopper	Remove from machine	Remove from machine	Install into machine	Remove from machine	N/A	N/A	Remove from machine	Install into machine
Perspex Casing	Clean on machine	Clean on machine	Clean on machine	Clean on machine	N/A	N/A	Clean on machine	Clean on machine
Turret and surrounding area	Clean in machine	Clean in machine	Clean in machine	Clean in machine	N/A	N/A	Clean in machine	Clean in machine
Fill Tray and surrounding area	Remove from machine	Remove from machine	Install into machine	Remove from machine	N/A	N/A	Remove from machine	Remove from machine
Upper Cam Housing (Upper Roller Cam)	Clean in machine	Clean in machine	Clean in machine	Clean in machine	Clean in machine	Remove from machine	Clean in machine	Clean in machine
Upper Tracking	Clean in machine	Clean in machine	Clean in machine	Clean in machine	Clean in machine	Remove from machine	Clean in machine	Clean in machine
Lower Cam Housing (Lower Roller Cam)	Clean in machine	Clean in machine	Clean in machine	Clean in machine	Clean in machine	Remove from machine	Clean in machine	Clean in machine
Lower Tracking	Remove from machine	Clean in machine	Clean in machine	Clean in machine	Clean in machine	Remove from machine	Clean in machine	Remove from machine
Motor	Clean in machine	Clean in machine	Clean in machine	Clean in machine	Clean in machine	Remove from machine	Clean in machine	Clean in machine
Gearbox	Clean in machine	Clean in machine	Clean in machine	Clean in machine	Clean in machine	Remove from machine	Clean in machine	Clean in machine
Drive Belt Pulleys	Clean in machine	Clean in machine	Clean in machine	Clean in machine	Clean in machine	Remove from machine	Clean in machine	Clean in machine
Exterior	Clean on machine	Clean on machine	Clean on machine	Clean on machine	Clean on machine	Remove from machine	Clean on machine	Clean on machine
Ejection Tray	Remove from machine	Remove from machine	Install into machine	Remove from machine	N/A	N/A	Remove from machine	Remove from machine

Cleaning Level Key
Level 1 - Remove powder
Level 2 - Dry clean with cloth
Level 3 - Dry clean and re-lubricate if specified in lubrication schedule
Level 4 - Wet clean and re-lubricate if specified in lubrication schedule
Remove from machine - Take part out of machine and clean if required. Store it correctly or install back into machine.
Install into machine - Install part into the machine and make sure that it has been cleaned. If needed, lubricate to the level required.
Clean on/in machine - Clean the part while in the machine and do not remove it. Make sure that all contact surfaces are clean to the level required.

This cleaning matrix is intended as a guide only and is not an exhaustive list. All cleaning schedules will need to be adapted to the industry and product, following industry regulations and the material safety data sheets that come with specific products. Please check with your Food Safety Manager/Department, Quality Control Manager/Department, or other relevant internal departments at your company before using.

Storing the RTP 9®

After its thorough cleaning, the RTP 9® needs to be stored in the proper conditions. It is important to store it in an environment in which the machine is safe from rusting. The RTP 9®'s high traction areas and the Tooling need to be lubricated separately before you store them.

Tools and Materials Needed

- Plastic wrapping to cover machine
- Airtight container for Upper Punches, Lower Punches, and Dies (if in storage for more than a week)
- Grease gun
- Lubricant/grease (NSF approved lubricant if machine has a high chance of contact with the food or drug product)
- Disposable latex/rubber gloves (for food grade products and to protect hands from lubricant)
- Hairnet and/or beard net (food grade products only)
- Sterile shoe covers (food grade products only)

Instructions

Note: Wear latex/rubber gloves (and appropriate food grade attire if applicable) during this process.

Lubricating the Tooling

If you are not using the machine for more than a week, store the Tooling in a container and cover it with lubricant to prevent rust formation. If not, simply lubricate each part of the Tooling, particularly the heads and barrels of the Upper and Lower Punches, and reinsert it back into the machine.

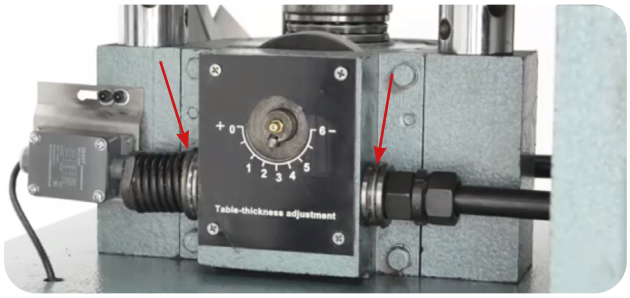
LFA's Rotary Tooling Case provides storage and is perfect for transport and protection. Order at https://www.lfatabletpresses.com/rotary-tooling-case

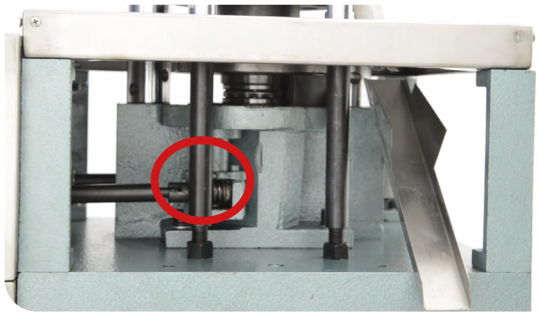
Lubricating the Grease Points and High-Traction Parts

1. Open the left and right side panel doors.
2. Remove the Hopper and Perspex Casing with an Allen key.
3. Lubricate the Lower Cam Roller Shaft's grease nipple with a grease gun.

4. Lubricate the Upper Roller Cam Shaft's grease nipple with a grease gun.

5. Rub grease on both Pressure Adjustment Gears.
6. Rub grease on the Fill Adjustment Gear.





Environmental Conditions

It is important that the environment in which you store the RTP 9® has the appropriate temperature and relative humidity levels. These two environmental factors can potentially cause the machine to rust and/or cause the tablets to have a lower quality. The table below shows the acceptable temperature and relative humidity levels:

Machine	Temperature		Humidity
RTP 9®	°C	°F	45-65% RH
	18-24	64-75	

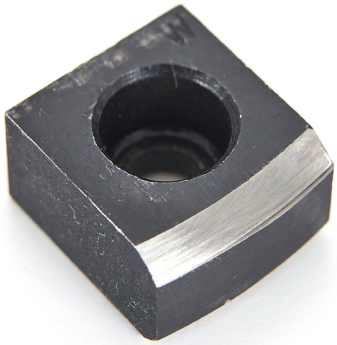
Appendix

Glossary

Term	Definition
API/Active Pharmaceutical Ingredient	Any substance or mixture of substances used that is an active ingredient in the drug product.
Binding agent	See excipient.
Die	The part of the Tooling that makes up the hole in which the powder is compressed and shaped into a tablet.
Die bore	The cavity inside the middle of the Die.
Die face	The very top flat surface of the Die.
Ejection height	The height at which the Lower Punch is lifted to for a tablet's ejection from the machine.
Excipient	An inactive substance that serves as the vehicle or medium for a drug or other API.
Fill depth	The amount of space that the powder can flow into in the Die.
Formulation	Powder mix of the excipient and the API that is compressed to make tablets.
Granular material	See Formulation.
Kilonewton (kN)	The force to accelerate a mass of 1 kg at a constant 1 m per second. The RTP range's pressure is measured in this unit.
Punches	The Upper Punch and Lower Punch have concave endings in the shape of the desired tablet. When the punches meet, they compress the powder between.
Punch pressure	The adjustable amount of force that is used to press tablets.
RTP	LFA trademarked term for rotary tablet press.
Tooling	Enables a tablet press to form tablets. It consists of Dies, Upper Punches, and Lower Punches.

Description of RTP 9® Parts

Upper Tracking Key
The Upper Tracking Key keeps the Tooling on the Upper Tracking. In order to change the Upper Punches, this part must be removed. Order at https://www.lfatabletpresses.com/rtp-9-upper-tracking-key



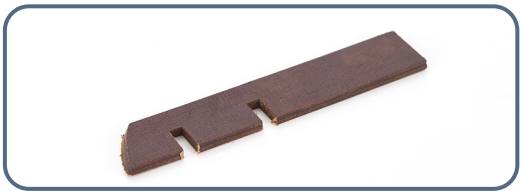
Lower Punch Insertion Disc
The Lower Insertion Disc can be removed to take out/insert the Lower Punches from/into the Turret. Order at https://www.lfatabletpresses.com/rtp-9-lower-punch-insertion-disc

Tooling
The Tooling consists of the Dies, the Upper Punches, and the Lower Punches. They all work as a set and compress the powder into tablets. Order at https://www.lfatabletpresses.com/products/tablet-press-tooling

Fill Tray Height Adjusters
The Fill Tray Height Adjusters move the Fill Tray's position in proximity to the Turret, which affects powder flow. Order at https://www.lfatabletpresses.com/rtp-9-feeder-tray-height-adjusters

Fill Tray Scraper and Take-Off Blade

The Fill Tray Scraper (nonmetal) helps keep the powder flowing into the Dies' bores, and the Take-Off Blade (metal) aids in tablet ejection. Order at https://www.lfatabletpresses.com/rtp-9-feeder-tray-scrapers or https://www.lfatabletpresses.com/take-off-blade-rtp-9

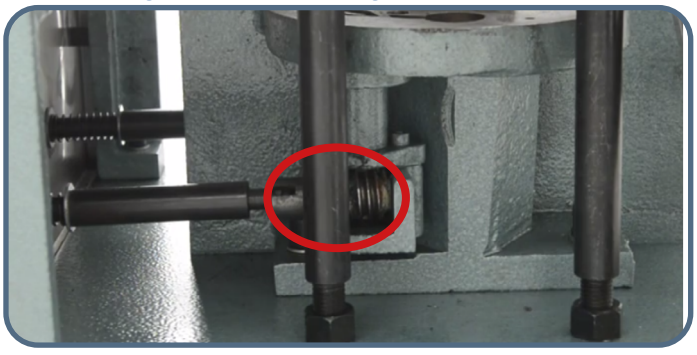


Lower Tracking

The Lower Tracking consists of three components: the Ejection Cam, the Fill Cam, and the Dosing Cam. These all guide and move the Lower Punches. Order at https://www.lfatabletpresses.com/lower-tracking-kit-rtp-9

Dosing Cam Assembly Cog

Whenever the Fill Depth Knob is turned, the weight of the tablets is increased or decreased. Order at https://www.lfatabletpresses.com/rtp-9-lower-filling-adjustment-cog

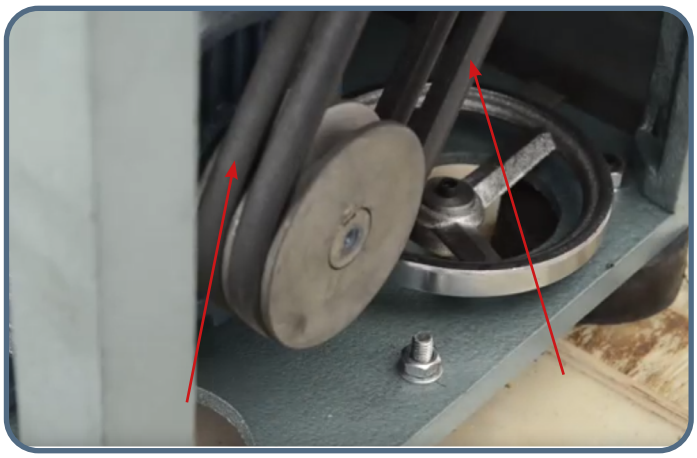


Fill Tray Thumb Bolts

The Fill Tray Thumb Bolts secure the Fill Tray onto the Turret. Order at https://www.lfatabletpresses.com/rtp-9-feeder-tray-thumb-bolts

V Belts

The V Belts connect to the Gearbox and the Motor through the Drive Belt Pulleys. They aid in initiating the machine's operation. Order at https://www.lfatabletpresses.com/rtp-9-drive-belts

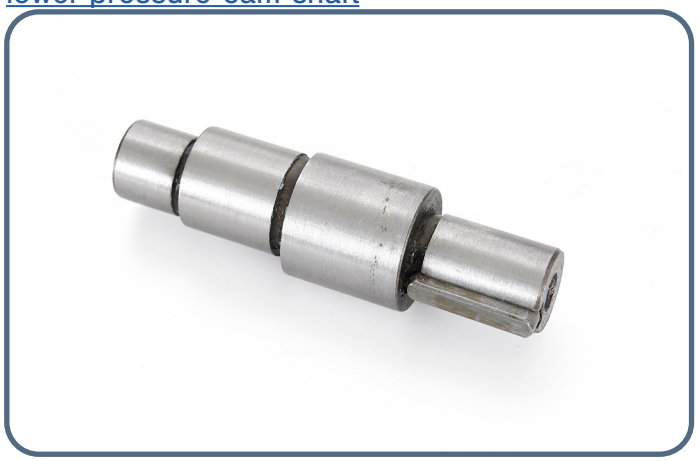


Lower Roller Cam

The Lower Roller Cam determines the Lower Punch's position within the Die bore during compression. Order at https://www.lfatabletpresses.com/rtp-9-fill-cam

Lower Roller Cam Shaft

The Lower Roller Cam Shaft connects the Lower Roller Cam to the Lower Roller Cam Housing. Order at https://www.lfatabletpresses.com/rtp-9-lower-pressure-cam-shaft

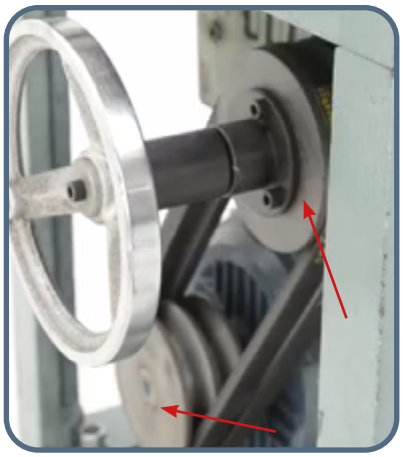


Upper Roller Cam Shaft

The Upper Roller Cam Shaft connects the Upper Roller Cam to the Upper Roller Cam Housing. Order at https://www.lfatabletpresses.com/rtp-9-lower-pressure-cam-shaft

Drive Belt Pulleys

The Drive Belt Pulleys (2) are fixed onto the Motor and the Gearbox. They hold the V Belts, which initiate the RTP 9®'s operation. Order at https://www.lfatabletpresses.com/rtp-9-drive-belt-pulley



Upper Roller Cam

The Upper Roller Cam determines the Upper Punch's position within the Die bore during compression. Order at https://www.lfatabletpresses.com/rtp-9-upper-pressure-cam

Handle

The Handle can be attached to the Gearbox and is used to manually operate the RTP 9®. Order at https://www.lfatabletpresses.com/rtp-9-hand-wheel

Pressure Adjustment Cog

Whenever the Pressure Knob is turned, the Pressure Adjustment Cog moves the Lower Roller Cam to increase or decrease pressure. Order at https://www.lfatabletpresses.com/rtp-9-pressure-adujment-cog

Fill Depth Shaft

The Fill Depth Shaft fits into the Dosing Cam Assembly Cog and is turned by the Fill Depth Knob. Order at https://www.lfatabletpresses.com/rtp-9-fill-depth-shafts

Pressure Knob and Fill Depth Knob

These knobs are used to adjust the pressure and the fill depth. They are located at the front of the control console. Order at https://www.lfatabletpresses.com/rtp-9-pressure-fill-depth-knob

Fill Tray

The Fill Tray helps channel the dry materials into the Dies' bores and also pushes the tablets out of the way and into the Ejection Tray. Order at https://www.lfatabletpresses.com/rtp-9-feed-tray

Pressure Adjustment Shaft

The Pressure Adjustment Shaft fits into the Pressure Adjustment Cog and is turned by the Pressure Knob. Order at https://www.lfatabletpresses.com/rtp-9-pressure-adjustment-shafts

Hopper

The Hopper contains the powder and allows it to flow onto the Fill Tray and into the Dies' bores. Order at https://www.lfatabletpresses.com/rtp-9-hopper

Upper Tracking

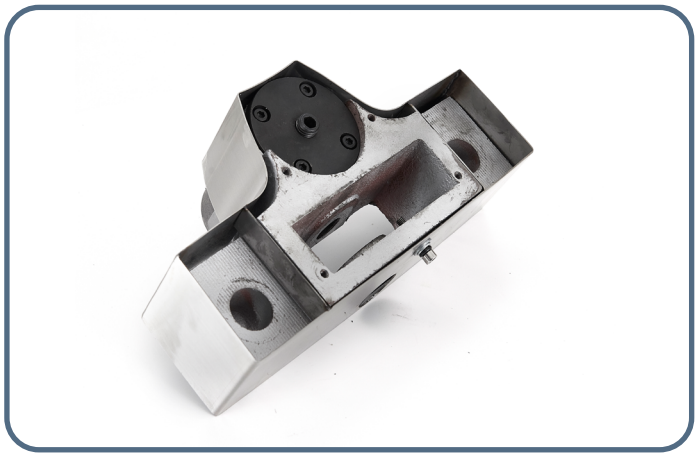
The Upper Tracking holds the Upper Punches and guides their movement through the Turret. Order at https://www.lfatabletpresses.com/rtp-9-upper-tracking

Upper Support Columns

The Upper Support Columns (2) hold up the Upper Roller Cam Housing. Order at https://www.lfatabletpresses.com/rtp-9-upper-support-column

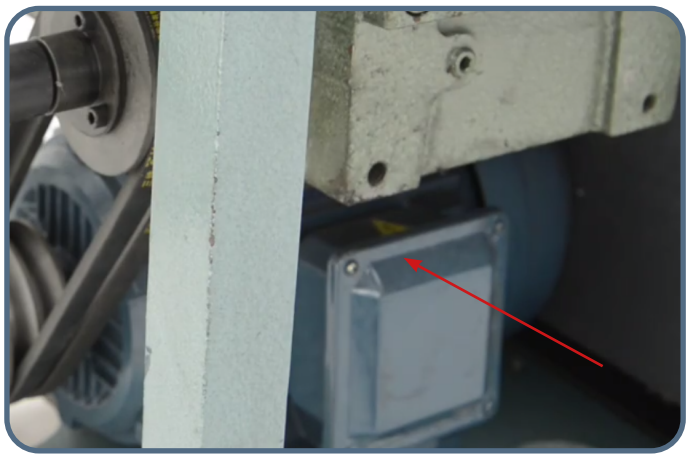
Upper Roller Cam Housing

The Upper Roller Cam Housing contains the Upper Roller Cam, the Upper Support Columns, and the Main Cam Shaft. Order at https://www.lfatabletpresses.com/rtp-9-upper-pressure-cam-housing



Motor

The Motor electrically powers the RTP 9® and is located under the Gearbox. Order at https://www.lfatabletpresses.com/rtp-9-motor

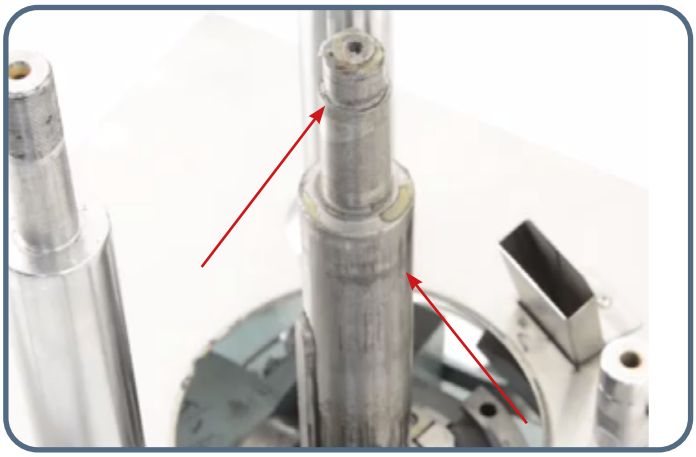


Upper Support Nuts

The Upper Support Nuts are fixed onto the Upper Support Columns. Order at https://www.lfatabletpresses.com/rtp-9-upper-support-nut

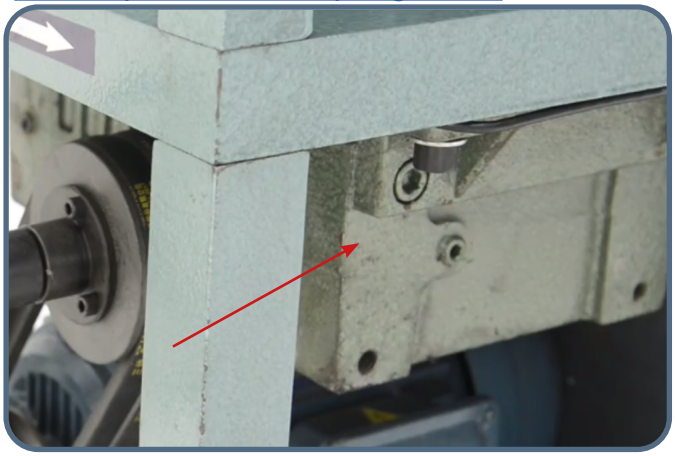
Main Cam Shaft

The Main Cam Shaft sits inside the Upper Roller Cam Housing and the Turret. It is a major driving force in the RTP 9®'s operation. Order at https://www.lfatabletpresses.com/rtp-9-main-cam-shaft



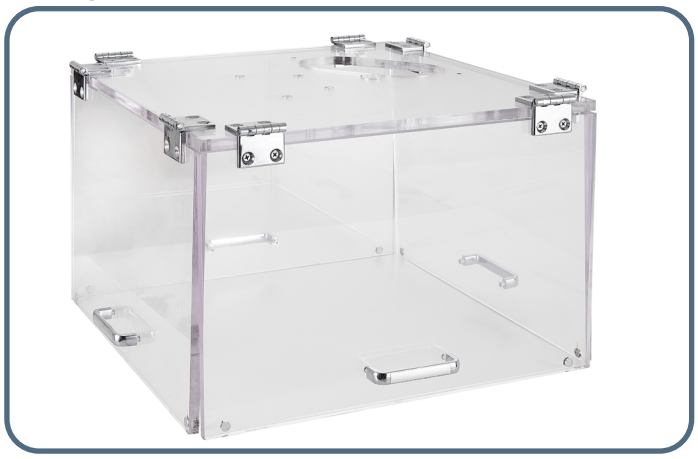
Gearbox

The Gearbox is driven by the Motor to initiate the RTP 9®'s operation. Order at https://www.lfatabletpresses.com/rtp-9-gearbox



Perspex Casing

The Perspex Casing covers the upper section of the RTP 9® to prevent cross-contamination and personal injury (Handles not included). Order at https://www.lfatabletpresses.com/rtp-9-perspex-casing



Perspex Casing Handle

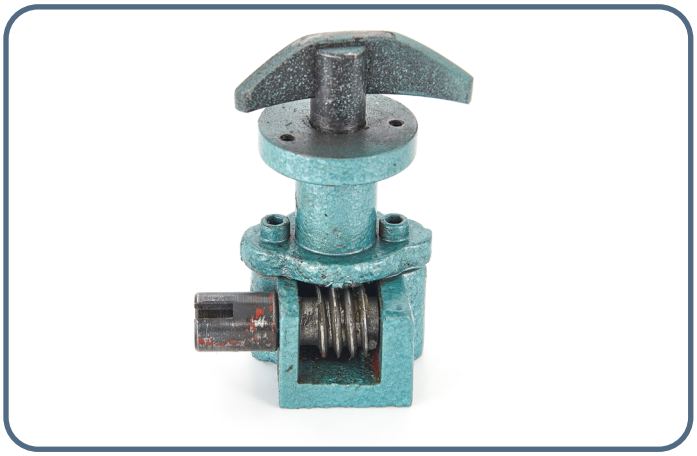
The Perspex Casing Handle (1) is used to open the Perspex Casing without completely removing it. Order at https://www.lfatabletpresses.com/rtp-9-perspex-casing-handle

Turret

The Turret houses the Tooling as well as the Main Cam Shaft and the Fill Tray. Order at https://www.lfatabletpresses.com/rtp-9-turret

Dosing Cam Assembly

The Dosing Cam Assembly holds the Dosing Cam and moves it for adjustments. Order at https://www.lfatabletpresses.com/rtp-9-dosing-cam



Material of Contact Parts

Contact Part	Material
Turret	Cast iron 250
Ejection Tray	SUS304
Hopper	SUS304
Tooling (Upper Punches, Lower Punches, and Dies)	User specified
Fill Tray	Tin bronze QSN-6-3
Fill Tray Scraper and Take-Off Blade	Bakelite and copper coat Zn

Technical Specifications

Tooling Specification	RTP Tooling
Number of dies	9
Production capacity	16,200/hr
Max diameter of tablet	12 mm (round) 14 mm (irregular)
Max fill depth	15 mm
Thickness of tablet	6 mm
Max pressure	40 kN
Number of filling stations	1
Double layered tablet	No
Kilowatts	1.5 kW
Volts	240 V (110 V on request)
Amps	13 A
Overall size	1029 mm x 470 mm x 665 mm
Dimensions with suggested working clearance	1929 mm x 1370 mm x 1565 mm
Weight	260 kg (573 lbs)
Floor loading (static)	0.8 kN/m2
Correct belt tension (new)	290.25 N
Correct belt tension (run-in)	193.5 N

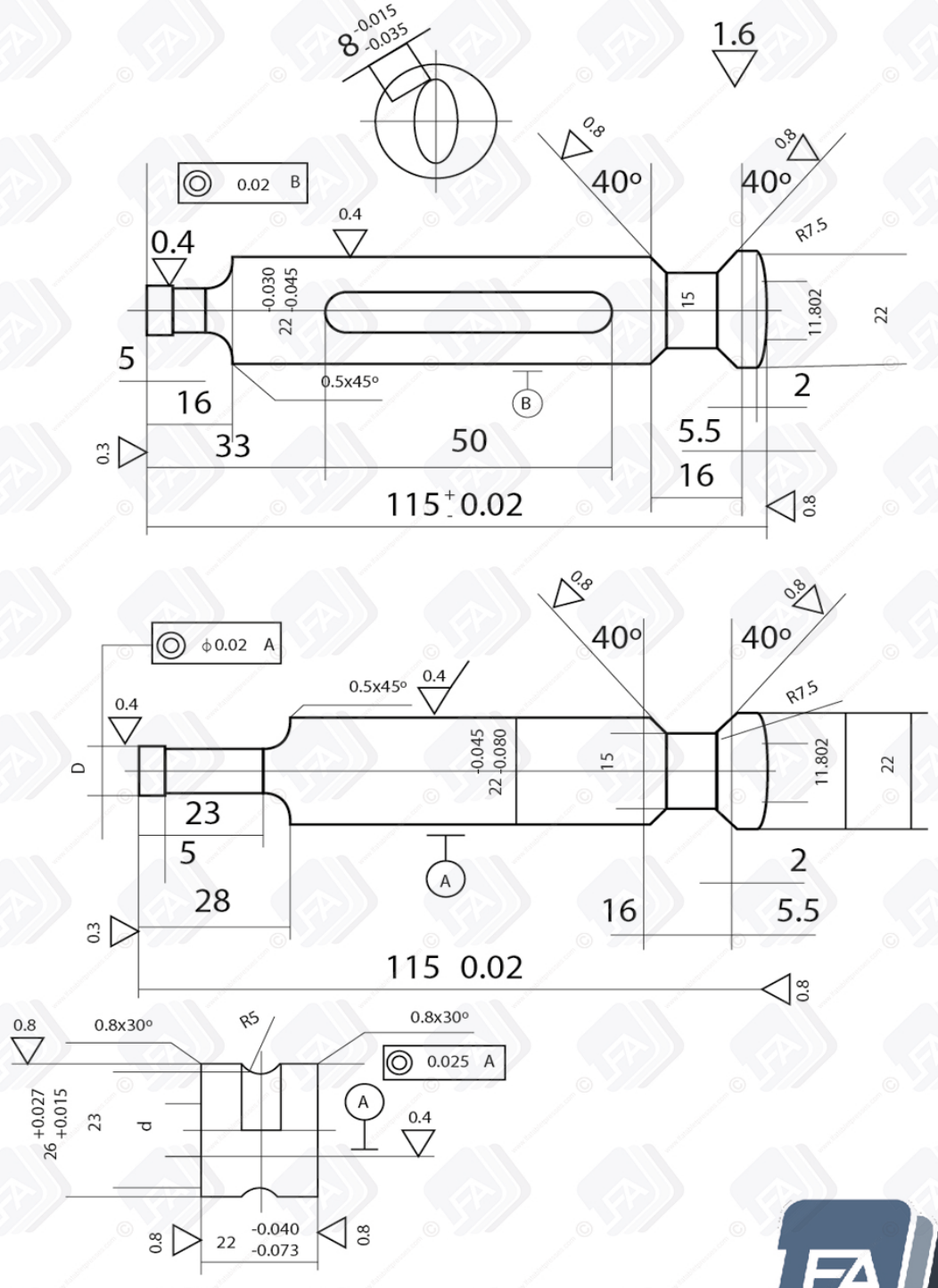
Maintenance Checklist

Before Operation	
☐	Visually inspect the tablet press and the parts.
☐	Ensure all locking nuts are tight.
☐	Visually inspect Grease Nipples and regrease where necessary.
☐	Manually rotate the machine without powders to ensure that it is not jammed
☐	Ensure Handle is removed from the Drive Belt Pulley socket.
☐	Ensure Perspex Casing securely encloses the upper portion of machine.
☐	Visually inspect electrical wires for any damage.
During Operation	
☐	Tune the tablet press until the tablet size and weight are correct
☐	Listen for irregular knocking or clicking sounds. If heard, stop operation, release the pressure by rotating the Pressure Knob on the left-hand side of the machine clockwise a few times, and lubricate the machine.
☐	Watch for buildup of powder in front of the Fill Tray. If occurring, either (a) make mix more granular, (b) check the Fill Tray for damage, (c) clear the buildup, or (d) adjust the Fill Tray and/or Hopper.
☐	Occasionally check the Motor's temperature. If it starts to overheat, turn off the machine, let it cool down, and grease it to ensure smooth operation.
☐	Ensure that the Hopper does not run out of powder.
☐	Weigh five or ten sample tablets to ensure the desired weights, tablet height, and hardness are being met.
☐	Check to see that the Emergency Stop properly works.
After Operation	
☐	Unplug machine and remove all excess powder with a bagless vacuum.
☐	Remove the Perspex Casing, Hopper, Fill Tray, Tooling, Upper Roller Cam Housing, and Turret and clean the inside of the tablet press.
☐	Wipe down the other surfaces with a damp cloth.
☐	Apply a layer of NSF approved grease to the entire tablet press.
☐	Lubricate all Grease Nipples.
☐	Store Tooling in an airtight box with a small amount of grease.

Diagrams

RTP 9® Tooling Dimensions

RTP Standard Tooling Dimensions



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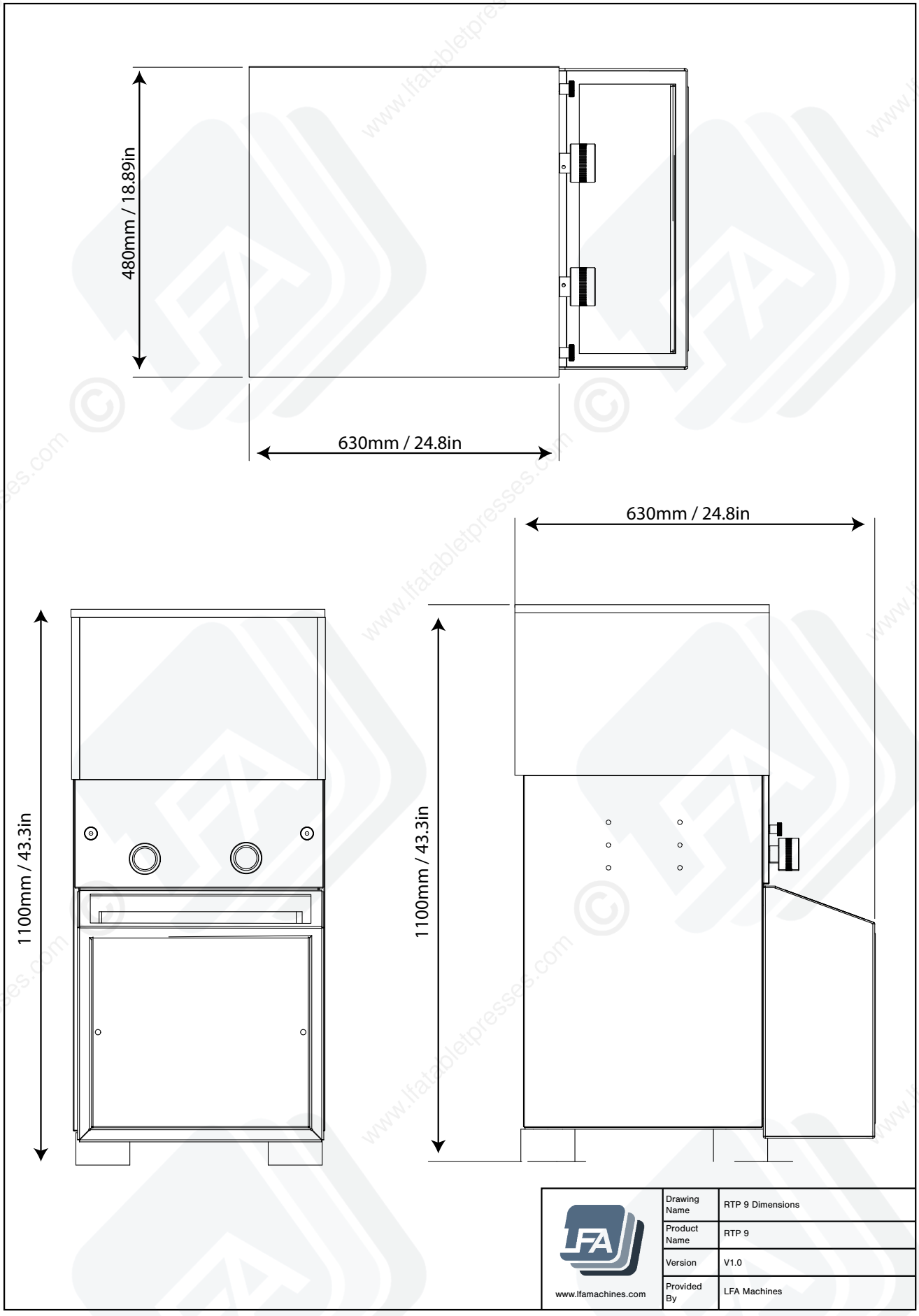
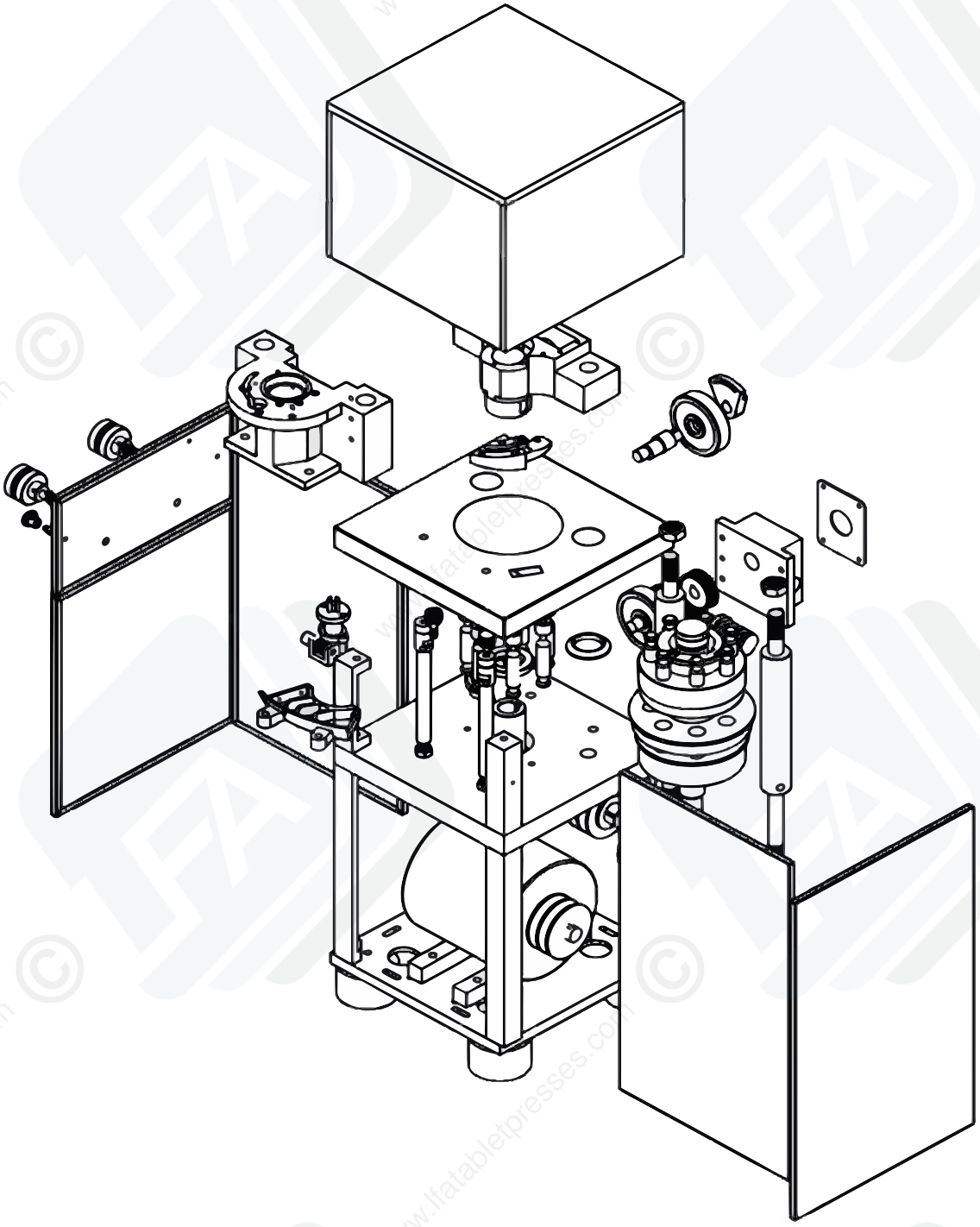
RTP 9® Dimensions

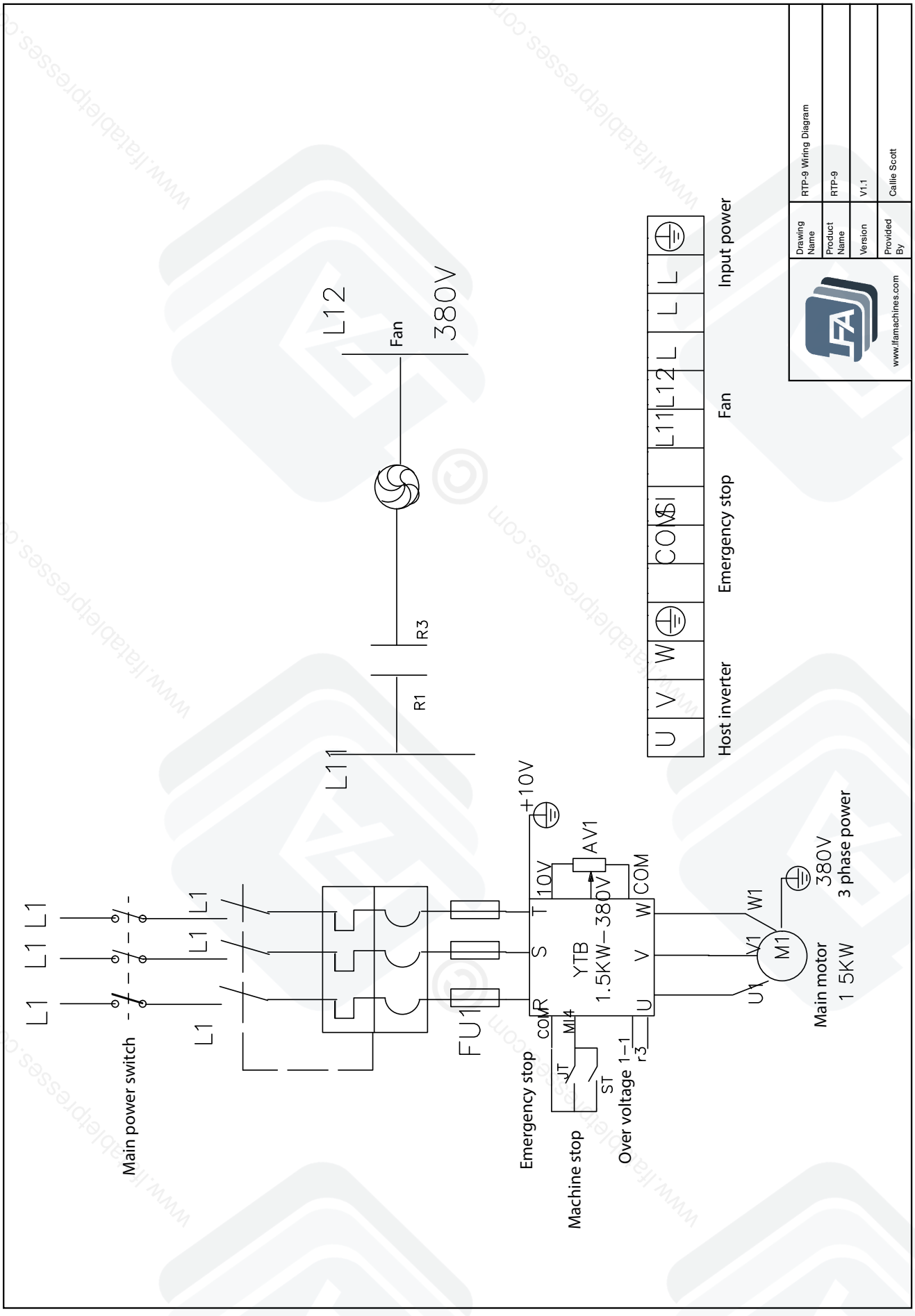


RTP 9® Exploding Diagram



www.lfamachines.com	Drawing Name	RTP 9 Explosive Diagram
	Product Name	RTP 9
	Version	V1.0
	Provided By	LFA Machines

RTP 9® Wiring Diagram



Resources

Helpful Links

Warranty
For information regarding the warranty policy of the RTP 9® and other LFA products, please visit https://www.lfatabletpresses.com/warranty

LFA Website
In order to aid you in your tablet production, LFA Machines maintains a website that offers a breadth of useful information about the RTP 9® and other tablet presses. You have access to online tools such as the Tablet Mix Calculator to help you in your formulation production and our regularly published articles that cover a whole range of topics about tablet presses and tablet production.

Visit the LFA homepage at https://www.lfatabletpresses.com

To create a free member's account, follow this link: https://www.lfatabletpresses.com/customer/account/create

LFA Machines YouTube Channel
Our YouTube videos provide you an opportunity to see demonstrations of how to use our tablet presses, common troubleshooting tips, and other LFA products such as capsule fillers and mixers. We regularly upload videos to give you a visual aid that will hopefully support you in your tablet production efforts. To watch our videos, visit https://www.youtube.com/channel/UCwtbcwja77ai7vX2o34FUkQ

LFA Machines Social Media
Social media is a great way to keep yourself updated on new developments and exciting things happening at LFA Machines. The list below contains our current social media pages:

Twitter: @lfatabletpress
Instagram: @lfatabletpresses
Facebook: https://www.facebook.com/lfatabletpresses
LinkedIn: https://www.linkedin.com/company/lfa-machines-oxford-ltd/

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