



ADAMUS SA

## Compression tooling unpacking, cleaning and storing.

1. Prepare a clean and safe storage area or stand / container.
2. Remember that the standard steel used for compression tooling is not corrosion-resistant unless tools have been ordered as made from steels with higher chromium content.
3. Be aware that the human sweat can have the corrosive nature so the tooling must not be touch by bare hands. Always use the cotton or rubber gloves in any stage of compression tooling handling.
4. Carefully remove the punches and dies from the transportation box or other packaging, piece by piece, wipe each one with a clean, dry cotton cloth to remove the preservative oil and place in a special tray or container. The tools must be separated from each other to prevent the contact between them. Be extremely careful of the delicate edges of the punches and dies. They can be damage very easily even by the light contact with any surface or object.
5. Clean the tooling, preferably in an ultrasonic cleaner. Watch out for the edges. Use the special holders for punches and basket for dies. The cleaning agent must contain corrosion inhibitors. It is absolutely crucial to wipe and dry tools immediately after washing, ideally in a stream of warm, dry air. Special attention should be paid to drying the holes in the dies and the tips area on the punches.
6. Place the tools in transportation container or tray for further handling.
7. If tooling has to be installed in the tablet press, pass them to assembly area.
8. If tooling should be stored, cover their surfaces with preservative oil. All surfaces must be dry before applying the oil. The oil must not be contaminated with water. The humidity of the storage room should not be higher than 60% and there should not be large temperature jumps in the room with the dew point passing. In addition, care should be taken during cleaning works in the storage room (cleaning the floor, washing windows, walls, etc.), to not allow to get drops of cleaning agents on the surface of the tools

### Warnings.

Tools that are free of preservatives should be protected against:

a) condensation of water vapor from the air. The cooling of tools (below the dew point) and placing them in moist air causes condensation of water vapor on the surface. This may cause corrosive spots, especially in the presence of residual powder or granules.

b) accidental spatter of water and / or chemical components, including those in pressed powders and granules.