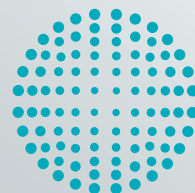




efficiency **i**

# The new i Series

Next-generation tablet production



**FETTE**  
**COMPACTING**  
be efficient



# “Digital ready”: The next level of efficiency

**The i Series from Fette Compacting has stood for ultra-efficient and flexible tablet production for decades. The new i Series now offers even more possibilities thanks to numerous innovations. Clean, system compatible and “digital-ready” – from the dust-tight equipment to the connection to the “Pharmaceutical Production 4.0”. The i Series is the next-generation of tablet production.**

## **Technological platform**

Fette Compacting has collaborated with its customers to develop the new generation as a technological platform on which the electronic and mechanical components are based. The special feature is that the components of relevance for validation remain largely unchanged. Accordingly, the i Series retains all features which make it so valuable for customers. In combination with the machine, efficiency<sup>i</sup> means that the user continues to retain everything that makes his production so successful today – but with even greater efficiency and more possibilities.

## **F10i – flexible single rotary tablet press**

The F10i is the first machine in the new i Series: an efficient single rotary tablet press for small batches. Producers can swiftly adapt the tablet press to various requirements, with or without containment. Flexibility and versatility are ensured by a handling arm in particular which supports the operator when changing the turrets, and a mechanical manual turret clamping system. This makes the F10i perfectly equipped for future production requirements.

## **F20i: Maximum flexibility and efficiency**

With an output of 475,000 tablets per hour and Pmax<sup>®</sup> technology, the F20i is the allrounder of the new i generation. It is suitable for a wide range of products and batch sizes and thus enables maximum flexibility in production. Numerous innovations such as an innovative tablet discharge and an optimized turret change system simplify handling and make the F20i the most efficient tablet press in its performance class.

## **F30i – high-performance double rotary tablet press with extremely fast sampling of the first layer**

The F30i is the double rotary press in the new i Series. Producers can adapt the tableting press swiftly to various requirements and equip it with a suitable containment package if necessary. Designed for the production of large batches, the F30i provides maximum output of up to 1.6 million tablets per hour.



F10i



F20i



F30i



# efficiency **i**



**FETTE**  
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The most important features of  
the new iSeries at a glance:

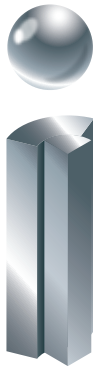


## Innovative

**Containment Guard –**  
dust-tight system design

**RFID operator login**

**TRI.EASY** Multi-flexible  
dust-tight tablet chute



## Integrative

**Cross-generation**  
system compatibility

**SmartInterface**  
by Fette Compacting

**New HMI software Visual 8**

**Uniform interface for**  
process equipment



## Intuitive

**Fast and intuitive**  
cleaning

**HMI software**  
with operating support

**Assistance systems**  
for easy operation



## Intelligent

**SmartInterface**  
by Fette Compacting

**location-independent machine**  
monitoring

**Process and**  
production reliability  
thanks to RFID

**Recipe-specific,**  
reproducible  
hardware settings

# F10i – Innovative







## Clean production: from dust-tight to containment

Containment is becoming a core issue for production due to the increased use of new pharmaceuticals, including Active Pharmaceutical Ingredients (API). "Dust-tight" will become the minimum standard for pharmaceutical machines for the foreseeable future. The F10i already features consistent dust-tight design even in its most standard version. For all users who require containment, the Containment Guard-option provides a suitable solution.



### Containment Guard\* – dust-tight system design

#### 50% less shrouding parts, with a reduction of 70% surfaces to be cleaned

Most efficient and fastest cleaning ever

Savings in costs due to significantly shorter cleaning cycles and machine is ready for production in far less time.

Cleaning effort associated with production areas is considerably reduced by dust-tight connecting elements between the machine and process equipment

Maximum operator protection

#### TRI.EASY – High-performance, multi-format tablet chute with dust-tight design

Wide range of applications from mini-tabs to effervescent tablets

#### Extremely compact machine with small switching cabinet

Also suitable for small rooms

\* The containment package is required for active substances

### RFID operator login

#### Operator login by using RFID technology

Easy access for faster processes and machine operation

Time savings as no manual entries are required

#### Maximum security in the management of the operators

Login for operating and service technicians for various tasks

#### Various operating authorizations can be defined

21 CFR Part 11 compliant



### TRI.EASY Multi-flexible dust-tight tablet chute

#### Compact housing

Efficient cleaning of components

#### Safe and extremely fast sorting of bad tablets and sample tablets

Optimal, fast switching processes without tablets being jammed or destroyed

#### Poka Yoke principle and geometrical similarity of components

Fail-safe, easy and fast assembly and dismantling

#### LED status display of track positions

Operating mode is apparent at all times

#### Safety-oriented track drive system with e-drives and end-position damping

Reliable switching processes with end-position confirmation



# F20i – Innovative







### Clean production: from dust-tight to containment

Containment is becoming a core issue for production due to the increased use of new pharmaceuticals, including Active Pharmaceutical Ingredients (API). "Dust-tight" will become the minimum standard for pharmaceutical machines for the foreseeable future. The F20i already features consistent dust-tight design even in its most standard version. For all users who require containment, the Containment Guard-option provides a suitable solution.



### Containment Guard\* – dust-tight system design

#### Optimized cleaning

71 % fewer trim parts, resulting in 74 % fewer surfaces to be cleaned

Most efficient and fastest cleaning ever

Maximum operator protection thanks to minimal Exposure to active ingredients

Dust-tight connections between machine and process equipment for low cleaning effort

Savings in costs due to significantly shorter cleaning cycles

Easy cleaning for faster operational readiness of the machine

**TRI.EASY – High-performance, multi-format tablet chute with dust-tight design**  
Wide range of applications from mini-tabs to effervescent tablets

**External control cabinet with energy monitoring system IP54 certified**  
Possibility of remote machine shutdown

\* The containment package is required for active substances

### RFID operator login

#### Operator login by using RFID technology

Easy access for faster processes and machine operation

Time saving due to automatic operator login

#### Maximum security in the management of the operators

Login for operating and service technicians for various tasks

#### Various operating authorizations can be defined

21 CFR Part 11 compliant



### TRI.EASY Multi-flexible dust-tight tablet chute

#### Compact housing

Efficient cleaning of components

#### Safe and extremely fast sorting of bad tablets and sample tablets

Optimal, fast switching processes without tablets being jammed or destroyed

#### Poka Yoke principle and geometrical similarity of components

Fail-safe, easy and fast assembly and dismantling

#### LED status display of track positions

Operating mode is apparent at all times

#### Track drive system with e-drives and end-position damping

Reliable switching processes with end-position confirmation



# F30i – Innovative



## Clean production: from dust-tight to containment

Containment is becoming a core issue for production due to the increased use of new pharmaceuticals, including Active Pharmaceutical Ingredients (API). "Dust-tight" will become the minimum standard for pharmaceutical machines for the foreseeable future. The F30i already features consistent dust-tight design even in its most standard version. For all users who require containment, the Containment Guard-option provides a suitable solution.



### Containment Guard\* – dust-tight system design

#### 71% less shrouding parts, with a reduction of 74% surfaces to be cleaned

Most efficient and fastest cleaning ever

Savings in costs due to significantly shorter cleaning cycles and machine is ready for production in far less time.

Cleaning effort associated with production areas is considerably reduced by dust-tight connecting elements between the machine and process equipment

Maximum operator protection

### TRI.EASY – High-performance, multi-format tablet chute with dust-tight design

Wide range of applications from mini-tabs to effervescent tablets

### External control cabinet with energy monitoring system

Possibility of remote machine shutdown

\* The containment package is required for active substances

### RFID operator login

#### Operator login by using RFID technology

Easy access for faster processes and machine operation

Time savings as no manual entries are required

#### Maximum security in the management of the operators

Login for operating and service technicians for various tasks

#### Various operating authorizations can be defined

21 CFR Part 11 compliant



### TRI.EASY Multi-flexible dust-tight tablet chute

#### Compact housing

Efficient cleaning of components

#### Safe and extremely fast sorting of bad tablets and sample tablets

Optimal, fast switching processes without tablets being jammed or destroyed

#### Poka Yoke principle and geometrical similarity of components

Fail-safe, easy and fast assembly and dismantling

#### LED status display of track positions

Operating mode is apparent at all times

#### Safety-oriented track drive system with e-drives and end-position damping

Reliable switching processes with end-position confirmation



# i Series – Integrative





### System-compatible set-up to IoT and MES

For several years, the i Series has been distinguished by its cross-generation system compatibility. Practically all products with contact to the system assemblies remain unchanged despite its innovative design. Thanks to the possibility of system integration, the new tablet press can be perfectly integrated in existing production environments. The new i Series also features technical connectivity for state-of-the-art production environments, up to "Pharmaceutical production 4.0".



### SmartInterface by Fette Compacting

#### Machine real-time monitoring

24/7 access to data, documentation and machine real-time monitoring by mobile devices (tablet, smartphone, PC etc.)

Digital value-added function for easier handling and process acceleration

Key performance indicator (KPI) dashboard

Individual and simultaneous monitoring of various parameters

Identical look and feel of the SmartInterface and user interface (Human-Machine Interface, HMI)

Display of changed process parameters compared to standard settings

Easy storage of non-executable documents (e.g. SOPs in PDFs, JPGs etc.) on the machine via mobile device

Instructions / messages can be sent to the machine-HMI

Automatic detection of process equipment certified by Fette Compacting

### Cross-generation system compatibility

#### A smart interface for the unified process equipment via Ethernet connection

Automation in one hand and control of all process devices

Easy monitoring and steering of process equipment

#### Standard interface for the process equipment

Fast and easy machine set-up for production

UL/CSA-conformant design available as an option





i Series – Intuitive



F10i



F20i



F30i

### Easy handling with tactile HMI and wizard

An ultra-modern human machine interface (HMI) supports the user in the form of intuitive control, monitoring and documentation of the machine and process-equipment via a terminal with tactile feedback. At the software level, an assistant for workflows (workflow operation wizard) provides support in the safe and error-free implementation of standard operating procedures (SOPs). Intuitive handling of the new i Series also includes extremely simplified cleaning processes.

### Fast and intuitive cleaning

#### Optimized design of the components

Intelligent cable management significantly reduces cleaning efforts, and simplifies handling

### HMI software with operating support

#### New 19" "Touch Only" machine operation

Country-specific keyboard layouts possible

#### Unique tactile feedback

Touch-sensitive keys for start-, stop and special functions with feedback for easy operability

#### Ultra-vision screen display

For maximum contrast even in poor lighting conditions

#### Microsoft Windows embedded operating system

Future-tight operating system

#### SQL server database

Real-time intelligence

### Assistance systems for easy operation

#### Fette Compacting visual 8 software with wizard functions

Easy and fast operation of the tablet press even for inexperienced operators

#### Self-explanatory assistance systems for example Checkmaster

#### Assistance systems

Recipe assistant for fast creation of new recipes

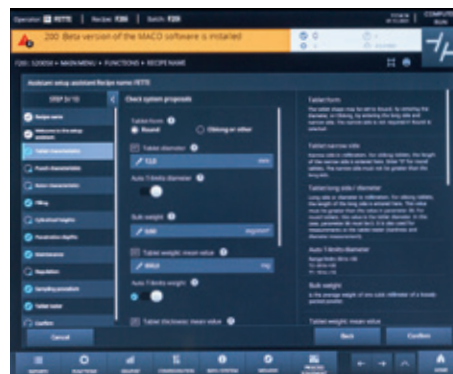
Control loop assistant

SOP Designer

#### HMI operation

Intuitive operation thanks to self-explanatory pictograms and symbols

#### Operating errors are practically eliminated



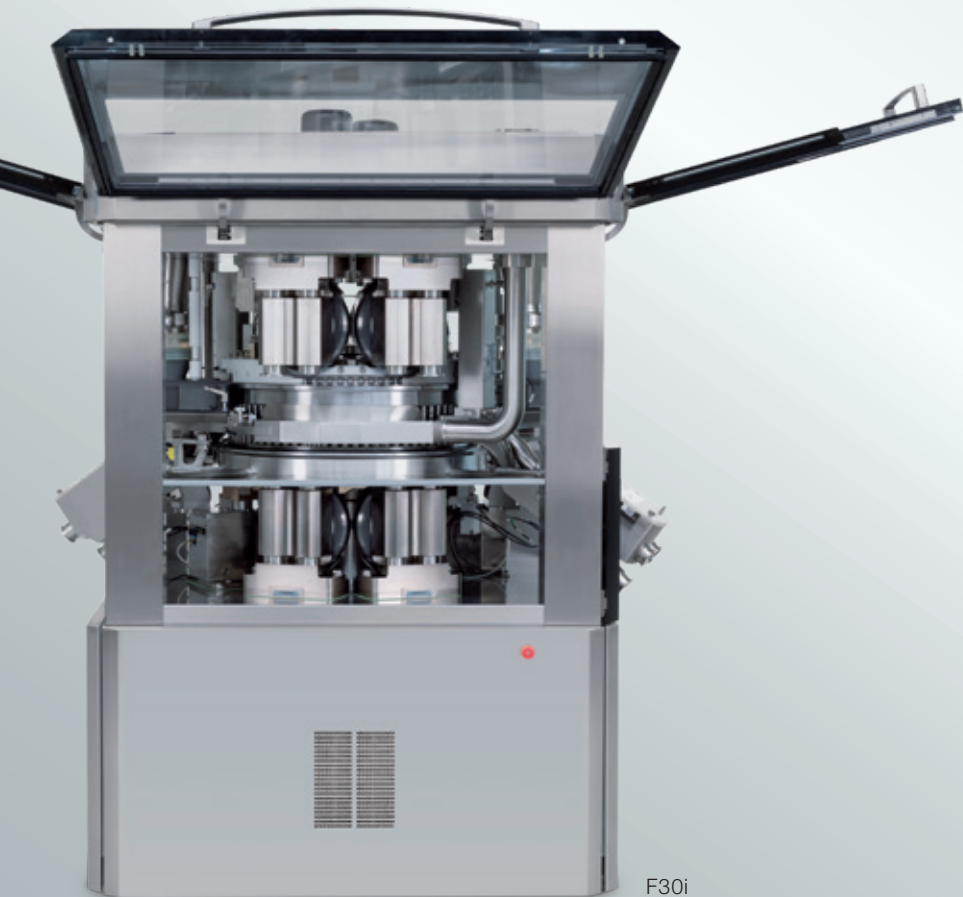
i Series – Intelligent



F10i



F20i



F30i



### Optimized processes with SmartInterface and RFID

The path to intelligent production in the future is paved in particular by the new SmartInterface offered by Fette Compacting. This key component is a server-based, real-time monitoring app enabling the user to supervise his production via mobile end devices. Users can download batch logs at any time and are always on top of the production parameters. In order to further improve process reliability and avoid set-up errors, the i Generation also features an RFID option.

### Process and production safety through RFID

#### **TRI.EASY RFID filling cam query**

Automatic detection of filling cams which match the product

Increase of efficiency and user-friendliness as well as simplification of the operation by fast and fail-safe adjustment of the machine

#### **TRI.EASY RFID-monitored air sorting with air curtains**

Reproducible and correct settings for all products

Coding element monitoring and display in the event of incorrect installation of mechanical parts

Extensive time savings thanks to Poka Yoke principle

Cost savings through fast and easy efficient set-up of the machine

Process stability

#### **TRI.EASY turret**

Self-identification of the most important turret parameters

### Recipe-specific and reproducible hardware settings

#### **All pneumatic settings can be made with scales from a central operator panel**

Process reliability and fail-safe handling

Faster set-up and reduced set-up times

Scale values can be saved in the recipe

#### **Fill-O-Matic height adjustment with scale rings**

Easier handling of components

Optimized settings independent of operator

Error avoidance through fail-safe adjustment

Reduced product loss and improved yields thanks to optimal and consistently reproducible settings

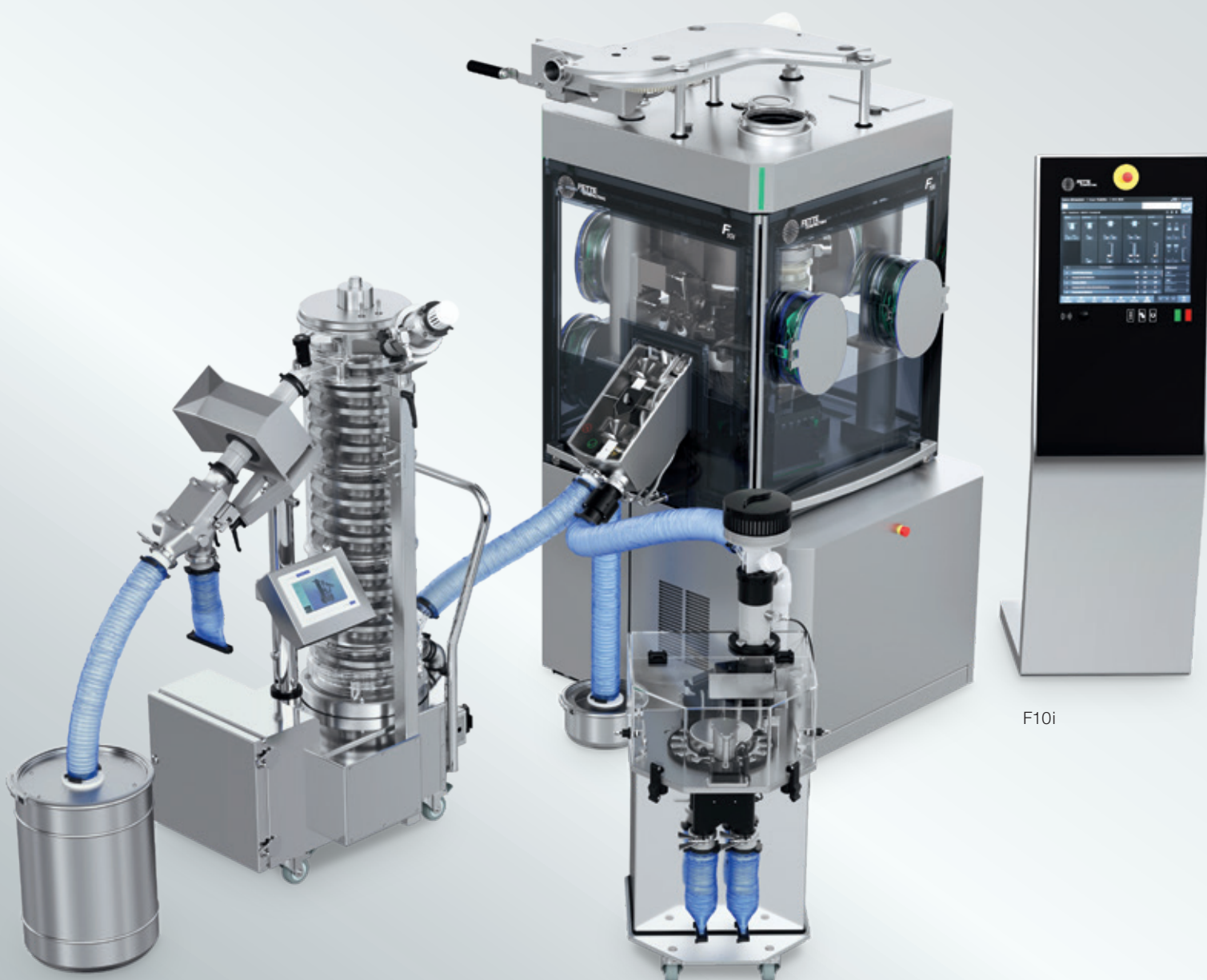
Increased machine availability through saved settings in the recipe







# CONTAINMENT GUARD



F10i

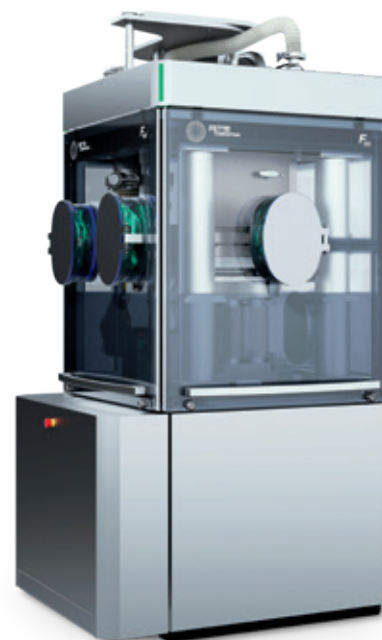


### Perfect containment for large production volumes and active substances

Maximum operator safety is the essential feature of the containment system offered by Fette Compacting. This imperative safety can only be achieved by appropriate technological solutions and largely automated manufacturing.

The tableting process is fully automated in the machines of the new i Series. Containment is continuous – from filling the machine to the removal of tablets. In the event of a machine stop, glove ports in the window flaps allow manual access from all sides without any interruption to containment.

The Fette Compacting containment system has been optimized with maximum operating and system safety in mind. All glove ports and window flaps are integrated in the safety control system where they are also monitored. An RTP (Rapid Transfer Port) permits the input and output of material, tools, and punches. The possibility of maloperation is practically excluded.



F10i

#### Cleaning-optimized press room

Reduced dust exposure thanks to optimized press room design

No dust outside the machine

All parameters can be set from the HMI

Tablet chute and press room have a dust-tight design

#### New window flaps

Manual and fail-safe locking of window flaps

Maximum safety provided by operator-level monitoring

Access to containment controls for authorized users only

Logging of all operator entries and log changes

Sensor for monitoring the underpressure

Display of the switchable extraction plant

Switchable between extraction system in the machine and extraction hose

Acoustic and visual safety information in the event of a leak

Rapid Transfer Port (RTP) for entering and exiting materials into and out of the containment system

#### Glove ports

Safety sensor in each glove port

Ergonomic design

Possibility of changing punches and/or filling cams under containment conditions

#### No dust released during manufacturing or preparation for cleaning or interaction under containment conditions possible without interrupting containment

No special protective suits necessary during production

Savings in time and money

#### No contact with active products

Operators protected from impurities and contamination

#### Dust-tight press room within the machine

Safe manufacturing environment

#### Fail-safe machine operation and control

Maximum operator safety during the entire production process, reduced costs during operation

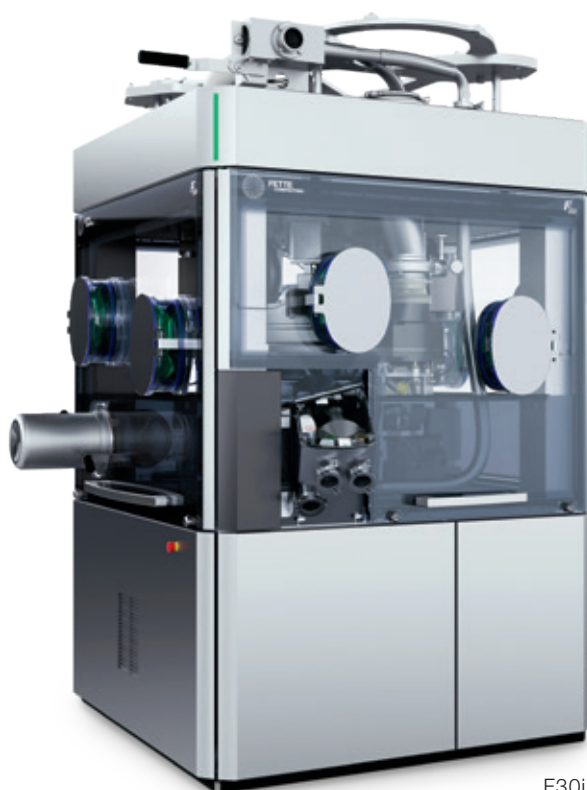




F20i

### **Containment Guard i Generation**

The Containment Guard marks the efficiency of the comprehensive solutions offered by containment tableting systems. The technical basis is formed by a modular system based on the FE and i Series offered by Fette Compacting. Apart from tablet presses, this also includes the process and safety equipment as well as services and consulting specially tailored to containment requirements.



F30i

# Technical Data – F10i

| Die (D) / Segments (S)         |                   | D   | D  | D                                       | D                              |
|--------------------------------|-------------------|---|--|---|--------------------------------|
| Number of punch stations       |                   | 32  | 30                                       | 24                                      | 20                             |
| Punch type                     |                   | EU19<br>EU19 FS®<br>TSM19<br>BBS  | EU19<br>EU19 FS®<br>FS19®<br>TSM19<br>BB | EU19<br>EU19 FS®<br>FS19®<br>TSM19<br>B | EU1"<br>EU1"-441<br>TSM1"<br>D |
| Tablet output units/hour       | min.              | 48,000  | 45,000                                   | 36,000                                  | 30,000                         |
|                                | max.              | 230,400   | 216,000                                  | 172,800                                 | 120,000                        |
| Max. compression force 1*      | kN                | 80  | 80                                       | 80                                      | 80                             |
| Max. compression force 2*      | kN                | 80  | 80                                       | 80                                      | 80                             |
| Max. tablet diameter           | mm                | 11  | 13                                       | 18                                      | 25                             |
| Max. filling depth**           | mm                | 18  | 18                                       | 18                                      | 18                             |
| Pitch circle diameter          | mm                | 280   | 280                                      | 280                                     | 280                            |
| Turret rotation speed min.     | min <sup>-1</sup> | 25  | 25                                       | 25                                      | 25                             |
| Turret rotation speed max.     | min <sup>-1</sup> | 120   | 120                                      | 120                                     | 100                            |
| Die diameter                   | mm                | 22  | 24                                       | 30.16                                   | 38.1                           |
| Die-/segment height            | mm                | 22.225  | 22.225                                   | 22.225                                  | 23.8                           |
| Punch shaft diameter           | mm                | 19  | 19                                       | 19                                      | 25.35                          |
| Punch length Upper/lower punch | mm                | 133.6 (133.35)  | 133.6 (133.35)                           | 133.6 (133.35)                          | 133.6 (133.35)                 |
| Upper punch insertion depth    | mm                | 1 – 4   | 1 – 4                                    | 1 – 4                                   | 1 – 4                          |
| Dimensions L x W x H           | mm                | 925 x 1,112 x 1,875 ***   |  |   |                                |
| Weight                         | kg                | Tablet press approx. 2,100 kg ****, Operating terminal 90 kg              |  |   |                                |
| Electrical supply parameters   |                   | Operating voltage 400 – 480 V, frequency 50/60 Hz, power consumption 9 kW |  |   |                                |

Theoretical values or technical limits: These can vary in practice, according to product and application.  
Tablet thickness is a size dependent on product and can strongly vary.  
\* limited by punch properties  
\*\* special filling depth available on request  
\*\*\* dimensions may vary depending on option  
\*\*\*\* weight may vary depending on option

| S       | S                                  | S              | S        |
|---------|------------------------------------|----------------|----------|
| 45      | 30                                 | 24             | 21       |
| FS12®   | EU19<br>EU19 FS®<br>FS19®<br>TSM19 | EU1"<br>TSM1"  | EU1"-441 |
| 67,500  | 45,000                             | 36,000         | 31,500   |
| 324,000 | 216,000                            | 144,000        | 126,000  |
| 34      | 80                                 | 80             | 80       |
| 34      | 80                                 | 80             | 80       |
| 11      | 18                                 | 25             | 25       |
| 20      | 20                                 | 20             | 20       |
| 280     | 280                                | 280            | 280      |
| 25      | 25                                 | 25             | 25       |
| 120     | 120                                | 100            | 100      |
| –       | –                                  | –              | –        |
| 25      | 25                                 | 25             | 25       |
| 12      | 19                                 | 25.35          | 25.35    |
| 133.6   | 133.6 (133.35)                     | 133.6 (133.35) | 133.6    |
| 1–4     | 1–4                                | 1–4            | 1–4      |



# Technical Data – F20i

| Die (D) / Segments (S)         |                   | D  | D  | D                                       | D                                  |
|--------------------------------|-------------------|--|--|---|------------------------------------|
| Number of punch stations       |                   | 47   | 43                                       | 36                                      | 30                                 |
| Punch type                     |                   | FS19®<br>EU19 FS®<br>EU19<br><br>BBS   | FS19®<br>EU19 FS®<br>EU19<br>TSM19<br>BB | FS19®<br>EU19 FS®<br>EU19<br>TSM19<br>B | EU1"<br>EU1"-441<br>TSM1"<br><br>D |
| Tablet output units/hour       | min.              | 42,300   | 38,700                                   | 32,400                                  | 27,000                             |
|                                | max.              | 338,400  | 309,600                                  | 259,200                                 | 180,000                            |
| Max. compression force 1*      | kN                | 100  | 100                                      | 100                                     | 100                                |
| Max. compression force 2*      | kN                | 100  | 100                                      | 100                                     | 100                                |
| Max. tablet diameter           | mm                | 11   | 13                                       | 18                                      | 25                                 |
| Max. filling depth             | mm                | 18   | 18                                       | 18                                      | 22                                 |
| Pitch circle diameter          | mm                | 410  | 410                                      | 410                                     | 410                                |
| Turret rotation speed min.     | min <sup>-1</sup> | 15   | 15                                       | 15                                      | 15                                 |
|                                | max.              | 120  | 120                                      | 120                                     | 100                                |
| Die diameter                   | mm                | 22   | 24                                       | 30,16                                   | 38,1                               |
| Die-/segment height            | mm                | 22.225   | 22.225                                   | 22.225                                  | 23.8                               |
| Punch shaft diameter           | mm                | 19   | 19                                       | 19                                      | 25.35                              |
| Punch length Upper/lower punch | mm                | 133.6  | 133.6 (133.35)                           | 133.6 (133.35)                          | 133.6 (133.35)                     |
| Upper punch insertion depth    | mm                | 1 – 4  | 1 – 4                                    | 1 – 4                                   | 1 – 4                              |
| Dimensions L × W × H           | mm                | 1,220 × 1,220 × 2,022  |  |   |                                    |
| Weight                         |                   | Tablet press 3,300 – 3,500 kg, operating terminal 90 kg, switch cabinet 270 kg |  |   |                                    |
| Electrical supply parameters   |                   | Operating voltage 400 – 480 V, frequency 50/60 Hz, power consumption 13,2 kW   |  |   |                                    |

Theoretical values or technical limits: These can vary in practice, according to product and application.  
Tablet thickness is a size dependent on product and can strongly vary.  
\* limited by punch properties

|  | S       | S                                  | S              | S        |
|--|---------|------------------------------------|----------------|----------|
|  | 66      | 45                                 | 36             | 33       |
|  | FS12®   | FS19®<br>EU19 FS®<br>EU19<br>TSM19 | EU1"<br>TSM1"  | EU1"-441 |
|  | 59,400  | 40,500                             | 32,400         | 29,700   |
|  | 475,200 | 324,000                            | 216,000        | 198,000  |
|  | 34      | 100                                | 100            | 100      |
|  | 34      | 100                                | 100            | 100      |
|  | 11      | 18                                 | 25             | 25       |
|  | 20      | 20                                 | 20             | 20       |
|  | 410     | 410                                | 410            | 410      |
|  | 15      | 15                                 | 15             | 15       |
|  | 120     | 120                                | 100            | 100      |
|  | –       | –                                  | –              | –        |
|  | 25      | 25                                 | 25             | 25       |
|  | 12      | 19                                 | 25.35          | 25.35    |
|  | 133.6   | 133.6 (133.35)                     | 133.6 (133.35) | 133.6    |
|  | 1–4     | 1–4                                | 1–4            | 1–4      |
|  |         |                                    |                |          |
|  |         |                                    |                |          |

# Technical Data – F30i

| Die (D) / Segments (S)         |                   | D  | D  | D                                       | D                              |
|--------------------------------|-------------------|--|--|---|--------------------------------|
| Number of punch stations       |                   | 79   | 73                                       | 61                                      | 49                             |
| Punch type                     |                   | FS19®<br>EU19 FS®<br>EU19<br>BBS   | FS19®<br>EU19 FS®<br>EU19<br>TSM19<br>BB | FS19®<br>EU19 FS®<br>EU19<br>TSM19<br>B | EU1"<br>EU1"-441<br>TSM1"<br>D |
| Tablet output units/h          | min.              | 142,200  | 131,400                                  | 109,800                                 | 88,200                         |
|                                | max.              | 1,137,600  | 1,051,200                                | 878,400                                 | 470,400                        |
| Max. compression force 1*      | kN                | 100  | 100                                      | 100                                     | 100                            |
| Max. compression force 2*      | kN                | 100  | 100                                      | 100                                     | 100                            |
| Max. compression force 3*      | kN                | 100  | 100                                      | 100                                     | 100                            |
| Max. compression force 4*      | kN                | 100  | 100                                      | 100                                     | 100                            |
| Max. tablet diameter           | mm                | 11   | 13                                       | 18                                      | 25                             |
| Max. filling depth**           | mm                | 18   | 18                                       | 18                                      | 18                             |
| Pitch circle diameter          | mm                | 680  | 680                                      | 680                                     | 680                            |
| Turret rotation speed min.     | min <sup>-1</sup> | 15   | 15                                       | 15                                      | 15                             |
|                                | max.              | 120  | 120                                      | 120                                     | 80                             |
| Die diameter                   | mm                | 22   | 24                                       | 30.16                                   | 38.1                           |
| Die-/segment height            | mm                | 22.225   | 22.225                                   | 22.225                                  | 23.8                           |
| Punch shaft diameter           | mm                | 19   | 19                                       | 19                                      | 25.35                          |
| Punch length Upper/lower punch | mm                | 133.6  | 133.6 (133.35)                           | 133.6 (133.35)                          | 133.6 (133.35)                 |
| Upper punch insertion depth    | mm                | 1 – 4 (8***)   | 1 – 4 (8***)                             | 1 – 4 (8***)                            | 1 – 4 (8***)                   |
| Dimensions                     | mm                | 1,394 × 1,394 × 2,030  |  |   |                                |
| Weight                         |                   | Tablet press 4,600 kg, operating terminal 90 kg, switch cabinet 350 kg     |  |   |                                |
| Electrical supply parameters   |                   | Operating voltage 400 – 480 V, frequency 50/60 Hz, power consumption 17 kW |  |   |                                |

Theoretical values or technical limits: These can vary in practice, according to product and application.  
Tablet thickness is a size dependent on product and can strongly vary.

\* limited by punch properties

\*\* special filling depth available on request

\*\*\* bi-layer-operation



| S              | S                                  | S                         |
|----------------|------------------------------------|---------------------------|
| 110            | 75                                 | 55                        |
| FS12®          | FS19®<br>EU19 FS®<br>EU19<br>TSM19 | EU1"<br>EU1"-441<br>TSM1" |
| 396,000        | 135,000                            | 99,000                    |
| 1,584,000      | 1,080,000                          | 528,000                   |
| 34             | 100                                | 100                       |
| 34             | 100                                | 100                       |
| 34             | 100                                | 100                       |
| 34             | 100                                | 100                       |
| 11             | 18                                 | 25                        |
| 20             | 20                                 | 20                        |
| 680            | 680                                | 680                       |
| 15             | 15                                 | 15                        |
| 120            | 120                                | 80                        |
| –              | –                                  | –                         |
| 25             | 25                                 | 25                        |
| 12             | 19                                 | 25.35                     |
| 133.6 (133.35) | 133.6 (133.35)                     | 133.6 (133.35)            |
| 1–4 (8***)     | 1–4 (8***)                         | 1–4 (8***)                |

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**Fette Compacting GmbH**

Grabauer Strasse 24  
21493 Schwarzenbek, Germany  
Phone +49 4151 12-0  
Fax +49 4151 3797  
tablet@fette-compacting.com

**Fette Compacting America, Inc.**

400 Forge Way  
Rockaway N.J. 07866, USA  
Phone +1 973 5868722  
Fax +1 973 5860450  
sales@fetteamerica.com

**Fette Compacting America Latina Ltda.**

Av. Cambacica, 1200 módulo 10  
Parque Imperador  
CEP 13097-160  
Campinas / SP, Brazil  
Phone / Fax +55 19 37969910  
contato@fette-compacting.com.br

**Fette Compacting Mexico, SA de CV**

Adolfo Prieto No. 1638  
Colonia Del Valle Sur  
03100 Mexico, DF, Mexico  
Phone +52 55 40000653  
tablet@fette-compacting.com

**Fette Compacting (China) Co., Ltd.**

No. 9 Shengtong Road,  
Moling Sub-District,  
Jiangning Development Zone,  
211111 Nanjing  
Jiangsu Province, P.R.C., China  
Phone +86 25 52121818  
Fax +86 25 52129951  
fcn@fette-compacting.com

**Fette Compacting Machinery India Private Limited**

A - 406 /407, 4th floor, Atrium 215,  
Next to Hotel Courtyard Marriott,  
Near J. B. Nagar Metro station,  
Andheri – Kurla Road, J. B. Nagar,  
Andheri (East)  
400 093 Mumbai, India  
Phone +91 83 26750355  
sales.in@fette-compacting.com

Competence Centre  
Plot No S 115, Phase III B  
Verna Industrial Estate  
Verna, Goa 403 722, India  
Phone +91 83 26750355

**Fette Compacting Asia Pacific Pte Ltd.**

107 Eunos Avenue 3, #01-01  
Singapore 409837, Singapore  
Phone +65 659 25654  
Fax +65 654 71939  
infoasiapacific@fette-compacting.com

**Fette Compacting Ibérica SL**

Avenida Labradores, 1  
2ª Planta, Oficina 3  
28760 Tres Cantos, Spain  
Phone +34 91 8039689  
Fax +34 91 3483052  
fcib@fette-compacting.com

**Fette Compacting France**

1, Rue du Centre  
93160 Noisy Le Grand, France  
Phone +33 155 812121  
Fax +33 155 812120  
fcf@fette-compacting.com

**Fette Compacting Belgium BVBA**

Schaliënhoeverdreef 1b  
2800 Mechelen, Belgium  
Phone +32 15 684260  
Fax +32 15 684269  
fcbe@fette-compacting.com

**EuroPharma Machinery Ltd**

Unit 12 Highview  
Bordon, Hampshire, GU35 0AX  
United Kingdom  
Phone +44 1420 473344  
Fax +44 1420 488030  
admin@europharma.co.uk

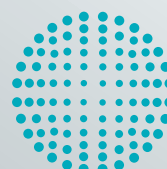
**Fette Compacting Middle East FZE**

Jebel Ali Free Zone, Jafza  
Lobby 14, Office 308, Dubai  
United Arab Emirates  
Phone +971 4 8808226  
dubai@fette-compacting.com

**Fette Compacting North-West Africa**

Tour d'Affaire Nord, Centre Commercial  
Bab Ezzouar – Regus 4ème Etg.  
16000 Algiers, Algeria  
Phone +213 770 117 007  
fcnwa@fette-compacting.com

[www.fette-compacting.com](http://www.fette-compacting.com)



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