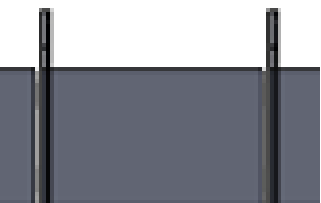
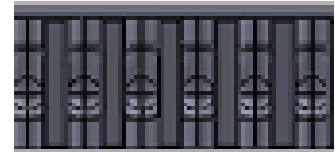


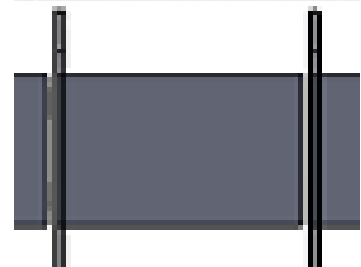
## Slat Counter Set up Strategies:

### Terminology:

- Slats: the plastic bars having cavities to pick up tablets for filling.
  - 72 Slats are required on the machine.
- Dividers: separate the tablets that drop from the slat into each “Division”.
  - Groups of tablets that enter each funnel.
- Funnel: Controls the group of tablets as they enter into each bottle.
  - For large counts a funnel may collect tablets from 2 or more divisions.

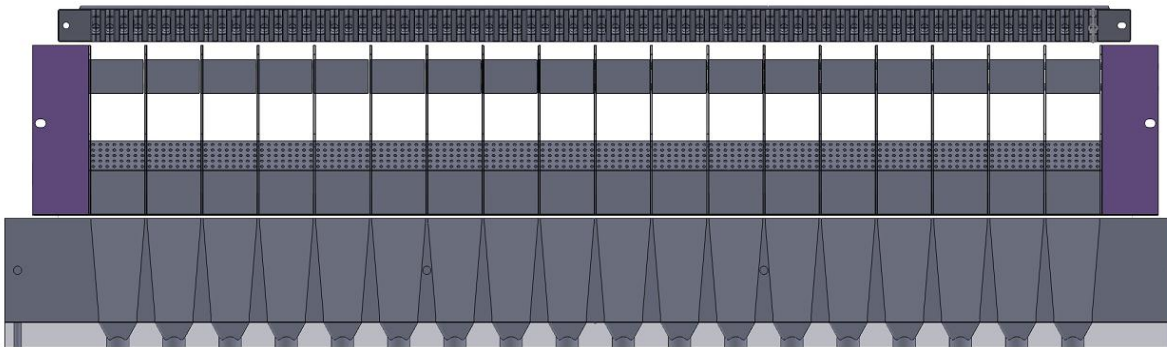


4 Drop Slat, 1 Division



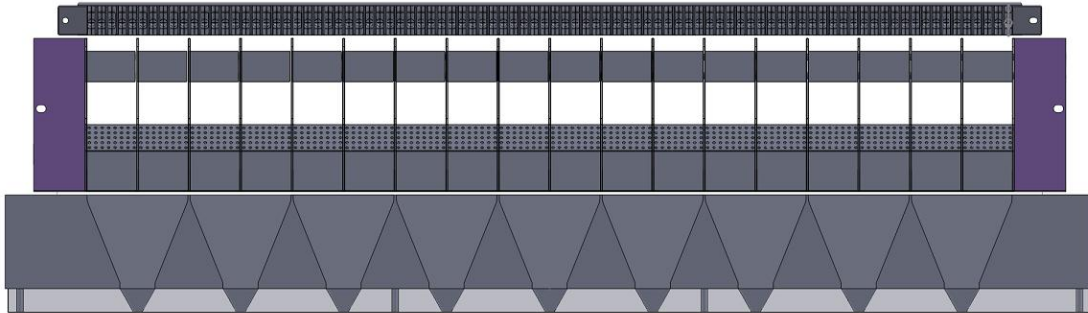
5 Drop Slat, 1 Division

Typically on a 42 inch machine the slats will have 72 or 90 cavities per slat, depending on tablet size. This means the number of tablets that will drop per division is either 4 or 5 tablets. We call this either a 4 or 5 Drop Slat.



Typical setup for 18 Bottles “UP”: Slats, Divider and the Funnel all lines up.

The following figure shows a 5 Drop Slat with an 18 Division Divider into a 9 UP Funnel filling 9 Bottles.



Typical setup for 9 Bottles “UP”: Slats, Divider and the Funnel all lines up.

The Funnel groups 2 Divisions per Bottle.

This means that with each slat 5 tablets x 2 divisions = 10 tablets per slat into 1 Bottle! If we run 10 Slats per Bottle there will be 100 tablets in each of the 9 Bottles.

Slat Patterns: (more terminology)

It is sometimes necessary to create ***patterns*** of slats to achieve a certain tablet count not equally divisible by the number of tablets dropping into the bottle per slat. In these situations we may use ***Partially Active*** slats that have some blank ***lanes*** without cavities. We may also need to use ***Blank*** slats with no cavities at all to fill the machine with all 72 slat positions.

In the following pages we will provide some example set up scenarios.

**Example#1: 100 count small tablets.**

We will use a 5 Drop Slat with an 18 UP Funnel, filling 18 bottles.

$100 / 5 = 20$  Slats to run.

- On the SETUP Screen on the machine you will enter:
  - Tablet Count = 100
  - Total Slats = 20
  - Blanks Slats = 0
  - Bottles Up = 18

**Example#2: 100 count Large tablets.**

We will use a 4 Drop Slat with an 18 UP Funnel, filling 18 bottles.

$100 / 4 = 25$  Slats to run.

- On the SETUP Screen on the machine you will enter:
  - Tablet Count = 100
  - Total Slats = 25
  - Blanks Slats = 0
  - Bottles Up = 18

### **Example#3: 1000 count Large tablets.**

We will use a 4 Drop Slat with a 9 UP Funnel, filling 9 bottles.

$1000 / 8 = 125$  Slats to run. (Remember we are combining 2 divisions into each bottle.)

- On the SETUP Screen on the machine you will enter:
  - Tablet Count = 1000
  - Total Slats = 125
  - Blanks Slats = 0
  - Bottles Up = 9

### **Example#4: 500 count Small tablets.**

We will use a 5 Drop Slat with a 9 UP Funnel, filling 9 bottles.

$500 / 10 = 50$  Slats to run. (Remember we are combining 2 divisions into each bottle.)

- On the SETUP Screen on the machine you will enter:
  - Tablet Count = 500
  - Total Slats = 50
  - Blanks Slats = 0
  - Bottles Up = 9

**Example#5: 500 count Large tablets.**

We will use a 4 Drop Slat with a 9 UP Funnel, filling 9 bottles.

$500 / 8 = 62.5$  Slats to run. This requires a bit more explanation.

We will need 62 Active 4 drop slats, 1 partial active 2 drop and 9 blank slats. The 9 blanks completes the machine requirement of 72 slats.

$62 \times 4 = 248$  Active

$+ 1 \times 2 = 2$  Partial Active

$+ 9 \times 0 = 0$  Blanks

$250$  per division  $\times 2$  Divisions = 500 tablets into 9 bottles.

On the SETUP Screen on the machine you will enter:

- Tablet Count = 500
- Total Slats = 72
- Blanks Slats = 9
- Bottles Up = 9

The filler will run all 72 slats per cycle. When Blanks are greater than zero, the bottles will begin to '**Index**' out during the time the blanks are over the dividers.

**Example#6: 90 count Large tablets.**

We will use a 4 Drop Slat with an 18 UP Funnel, filling 18 bottles.

$90 / 8 = 22.5$  Slats to run.

Again the .5 indicates that a partial slat will be necessary.

We will need 22 Active 4 drop slats, 1 partial active 2 drop (the .5) and 1 blank slat. This pattern of 24 slats repeats 3 times to fill the machine with 72 slats. ( $24 \times 3 = 72$ )

$22 \times 4 = 88$  Active

+  $1 \times 2 = 2$  Partial Active

+  $1 \times 0 = 1$  Blank

90 per division x 1 Division = 90 tablets into 18 bottles.

For more information contact:



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