



Meeting Needs.

**Exceeding Expectations.**

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# IPR TOOLING INSPECTION & ANALYSIS SYSTEM (TIAS) PRODUCT OVERVIEW

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Official North American OEM Parts and Service Provider for Manesty Tablet Presses and Coaters

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# System Overview

## Designed For A Tablet Tool Room

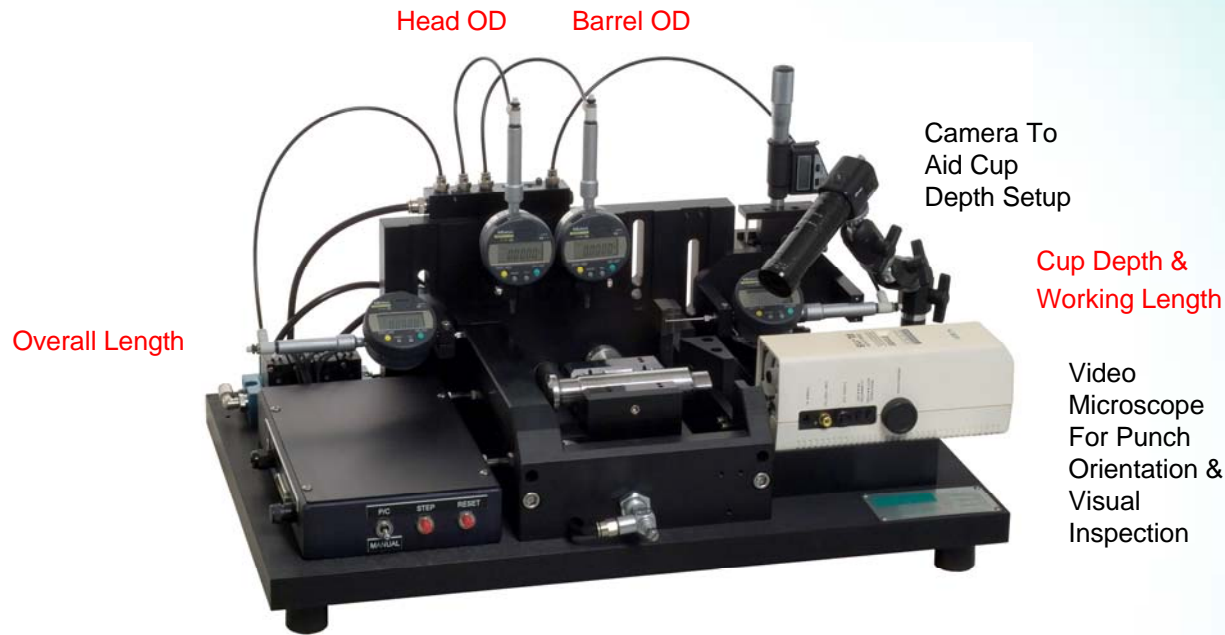
- **Manage a Complete Tooling Inventory**
- **Perform Accurate and Repeatable Tablet Tool Inspections**
- **Create A Paperless Tool Room System**
- **Optimize Tool Selection**
- **Provide Tool Wear Trending**
- **Provide A User-Friendly Operator Interface**



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# Automatic Tooling Inspection Fixture

## Streamline Measurements with Improved Accuracy & Efficiency



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# Automatic Tooling Inspection Fixture

Engineered For Precision Measurements



- Linear Slide Bearings
- Hardened Stainless Steel Inserts
- Three Point Adjustment For Precise Alignment
- Slide Tables with Digital Readout For Accurate & Easy Cup Depth Setup
- Digimatic Indicators with Air Drives



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# Video Microscope

## Empower Your Vision Inspection Capabilities



- Computer Screen Viewing
- 200X Magnification
- Proper Tool Orientation
- Punch Face Inspection
- Integrated Fluorescent Light Source



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# Software Overview

Easy To Use Software Packed with Functionality  
For Any Tool Room Operator

- **Windows 2000 / XP Professional Compatible**
- **Microsoft Access Forms**
- **Borland Interbase Database**
- **Client Server Architecture**
- **TIAS Inspection Software (Version 5)**
- **Stand Alone or Network**
- **21 CFR Part 11 Compliant**



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# Tooling Inspection

## Receive NEW Tooling

Inspection Number:

Inspection Date: 11/4/2002

Inspected By: KPESCIETTO

Purchase Order:

Set Number:

Set Condition:

Receipt Date:

Site Location:

Machines:

Control Number:

Upper Drawing:

Revision:

Lower Drawing:

Revision:

Supplier:

Upper Punch

Tool Count: 0

Tool Size:

Bin Location:

Lower Punch

Tool Count: 0

Tool Size:

Bin Location:

Die

Tool Count: 0

Tool Size:

Bin Location:

Record: 1 of 1

- Record
  - Set Number
  - Drawing Number
  - Tool Quantity
  - Tool Size
  - Tool Location
- View SOPs
- Establish Set Inspection Interval



# Tooling Inspection

Record Production Information & Track Usage

- Record
  - Set Number
  - Drawing Number
  - Tool Quantity
  - Tool Size
  - Tool Location
- View SOPs
- Establish Set Inspection Interval

# Tooling Inspection Detail

## Individual Tool Inspection Screen

	Measurement:	Variance from Spec:
Head Outer Diameter:		
Neck Diameter:		
Barrel Diameter:		
Tip Diameter Major Axis:		
Tip Diameter Minor Axis:		
Working Length (calculated):		
Overall Length:		
Cup Depth:		
Concentricity (T.I.R.):		
Head Hardness:		
Embossing Height:		
Head To Barrel Concentricity:		

- Measure Upper & Lower Tools
- Measure Dies
- New Inspections
- Usage Inspections
- Display Measurement Results with Variance From Specification
- Alarm If Out of Specification Event Occurs

# Inventory Look-up

## Paperless System

Product Code	Product Name	Set Number	Tablets Per Set	Hours Per Set
1001-10	10mg Large Tablets	TEST-001	0	0
1001-02	2mg Small Tablets	TEST-003	0	0
1001-05	5mg Medium Tablets	TEST-002	0	0

- Products
- Bin Locations
- Tool Description
- Set Numbers
- Tablets Produced
- Drawing Identification



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# Tablet Drawing

Define Critical Tooling Measurements Specific To Your Products

Tablet Drawing Maintenance

This Tablet Drawing cannot be modified as it is being referenced in 1 inspection record(s).

Specifications Products Tolerances

Tablet Drawing Number: TEST1-U Obsolete:

Drawing Revision: 0

Type: Upper Cup Depth: 0.0550

Drawing Date: 12/20/2002 Tip Diameter Major Axis: 0.4985

Supplier: ECD Tip Diameter Minor Axis: 0.3105

Hob Number: 12345A Die Inner Diameter Major Axis: 0.5000

Land: 0.0030 Die Inner Diameter Minor Axis: 0.3125

Tablet Diameter: 0.5000 x 0.3125 Embossing Letters: Test1-U

Shape: OVAL Embossing Height: 0.0090

Drawing Filename: C:\Documents and Settings\KenP\Desktop\Ariana-Dec2000.jpg

Title: 10mg Large Tablet - Upper

Comments:

Tablet Threshold for Set: 50,000,000 Overload Setting: 12.00 (kilonewtons)

Record: 1 of 6

- Create Drawing Numbers
- Identify Tip Features
- Record Embossing
- Attach Products
- Define Tablet Production Limit
- Attached Image File

# Reporting Functions

Maintain Detailed Inspection Reports For Quick Reference & Retrieval

- Customize Report Categories
- Statistical Summaries
- Detailed History of Tooling Inspections

Punch and Dies Inspection Detail Report						12/30/2002
Your Company Name Here						
<b>Inspection Number:</b>	1000009	<b>Upper Tool Size:</b>	B TYPE	Standard B-Type Punch		
<b>Purchase Order Number:</b>	Test1	<b>Lower Tool Size:</b>	B TYPE	Standard B-Type Punch		
<b>Inspection Date:</b>	12/20/2002	<b>Die Tool Size:</b>	1.1875" DIE	1.1875" OD Die		
<b>Set Number:</b>	IPR1	<b>Bin Location:</b>	IPR1 (U) TEST2 (L) TEST3 (D)			
<b>Product Name:</b>	Test	<b>Site Location:</b>	Test1			
<b>Inspection Type:</b>	U	<b>Upper Punch Count:</b>	10			
<b>Inspected By:</b>	TIASMANAGER	<b>Lower Punch Count:</b>	10			
<b>Supplier Name:</b>	Test	<b>Die Count:</b>	0			
<b>Upper Drawing Number:</b>	TEST1-U (0)	<b>Machines:</b>				
<b>Lower Drawing Number:</b>	TEST1-L (0)	<b>Comments:</b>	Repeatability			
<b>Tablet Press:</b>	Repeatability	<b>Condition:</b>	Fair			
<b>Number Of Tablets:</b>	1000000	<b>Lot Date:</b>	12/20/2002			
<b>Average Compression Force:</b>	0	<b>Lot Number:</b>	Repeatability			
<b>Uppers for Inspection Number 1000009</b>						
Tool ID	Barrel Diameter	Cup Depth	Head Outer Diameter	Overall Length	Working Length	
TEST1-U-01	0.7478	0.0473	0.9985	5.2502	5.2029	
TEST1-U-02	0.7479	<b>0.0465</b>	0.9984	5.2503	5.2038	
TEST1-U-03	0.7478	0.0471	0.9983	5.2502	5.2031	
TEST1-U-04	0.7478	<b>0.0462</b>	0.9982	5.2502	5.2040	
TEST1-U-05	0.7478	<b>0.0464</b>	0.9982	5.2502	5.2038	
TEST1-U-06	0.7477	<b>0.0465</b>	0.9979	5.2501	5.2036	
TEST1-U-07	0.7479	<b>0.0468</b>	0.9986	5.2505	5.2037	
TEST1-U-08	0.7477	<b>0.0463</b>	0.9978	5.2501	5.2038	
TEST1-U-09	0.7477	<b>0.0463</b>	0.9978	5.2502	5.2039	



# Reporting Functions

Tool Matching Report Optimizes Press Setup To Minimize Weight Variation

## Matching Report by Product

12/20/2002

Your Company Name Here

Product: TEST	Upper Set Number	Lower Set Number
	IPR1	IPR1

Upper Tool ID	Upper Working Length	Lower Working Length	Lower Tool ID
TEST1-J-04	5.2040	5.1961	TEST1-L-01
TEST1-J-09	5.2039	5.1980	TEST1-L-05
TEST1-J-08	5.2038	5.1980	TEST1-L-03
TEST1-J-05	5.2038	5.2002	TEST1-L-10
TEST1-J-02	5.2038	5.2004	TEST1-L-08
TEST1-J-07	5.2037	5.2010	TEST1-L-02
TEST1-J-06	5.2036	5.2015	TEST1-L-07
TEST1-J-10	5.2031	5.2016	TEST1-L-09
TEST1-J-03	5.2031	5.2029	TEST1-L-06
TEST1-J-01	5.2029	5.2045	TEST1-L-04
<b>Count: 10</b>	<b>Avg: 5.2036</b>	<b>5.2004</b>	<b>Count: 10</b>

- Select Tool Sets
- Maximize Weight Control



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# Reporting Functions

Variance Report Optimizes Tool Selection  
For Optimal Press Setup

## Tool Variance Report

12/30/2002

Your Company Name Here

Tool Type: U    Set Number: IPR1    Last Tool-Level Inspection for Set: 1000009  
Measurement: Working Length    Average: 5.2039    Variance: -0.001    to .001  
Product: Test

### Tools that Failed

Tool ID	Set Number	Last Inspection	Measurement
TEST1-J-09	IPR1	1000009	5.2069

Total tools that failed: 1

### Tools that Passed

Tool ID	Set Number	Last Inspection	Measurement
TEST1-J-01	IPR1	1000009	5.2029
TEST1-J-02	IPR1	1000009	5.2038
TEST1-J-03	IPR1	1000009	5.2031
TEST1-J-04	IPR1	1000009	5.2040
TEST1-J-05	IPR1	1000009	5.2038
TEST1-J-06	IPR1	1000009	5.2036
TEST1-J-07	IPR1	1000009	5.2037
TEST1-J-08	IPR1	1000009	5.2038
TEST1-J-10	IPR1	1000009	5.2031

Total tools that passed: 9

- User Defined Variance Tolerances
- Out-of-Tolerance Tool Identification



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# TIAS CUSTOMERS

## IPR Customer References

Proctor & Gamble

KV

McNeil PR

Apotex

Abbott Labs - North Chicago

Cardinal Health

Purdue Canada

Teva

Pfizer Lincoln

Genpharm

Yamanouchi

Wyeth GPR

Biovail

Pfizer Ireland

Novartis Spain

Alza

Wyeth NY

J & J Puerto Rico

Bristol Myers Squibb PR

Pfizer Morris Plains

NOW Foods

Pfizer PR

Purdue Wilson NC

Weider Nutrition

Pfizer Morris Plains

Pfizer Brooklyn

Pfizer Canada

Pfizer Groton

Schering-Plough

Mylan WV

Pfizer Ann Arbor

Abbott Labs - Abbott Park

Aventis-HMR

Barr Labs (Duramed)

Mallinckrodt

McNeil Ft. Washington

Merck PR

Novartis Canada

Novartis Lincoln

Novartis Suffern

Novopharm

Perrigo Allegan

Perrigo Greenville, SC

Searle Brasil

Searle Mt. Prospect

Searle Skokie

Syntex ICN PR

Bayer Meyerstown

Leiner (Granotec)



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# TIAS Benefit Summary

Meeting Needs...Exceeding Expectations!

- Improved Quality Assurance
- Accurate Audit Trail
- Tighter Inventory Control
- Streamlined Inspection Process
  - New Tooling
  - In-Process Inspections
- Improved Planning, Troubleshooting, and Design
- Reduced Number of Urgent Purchases



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