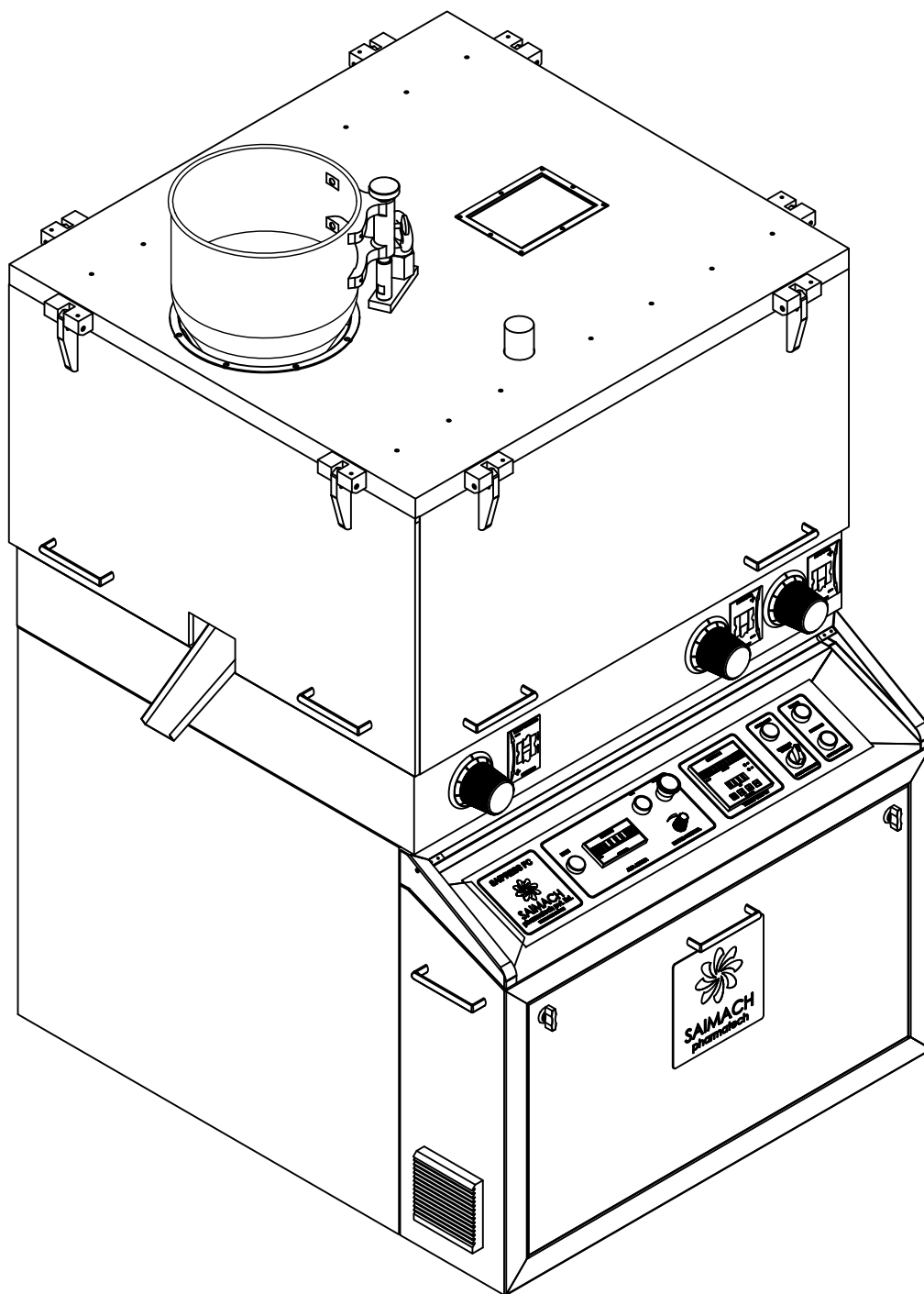


SMD-20

SINGLE SIDE ROTARY TABLATING MACHINE

INSTRUCTION MANUAL



SMD-20



SAIMACH PHARMATECH PVT. LTD.
6, Laxmi Estate, B/H Navneet Prakashan Compound,
Ajod Dairy Road, Rakhial, Ahmedabad - 380023, Gujarat, INDIA.
Email : sales@saimach.com / contact@saimach.com
Website : www.saimach.com

PART LIST WITH DRAWING

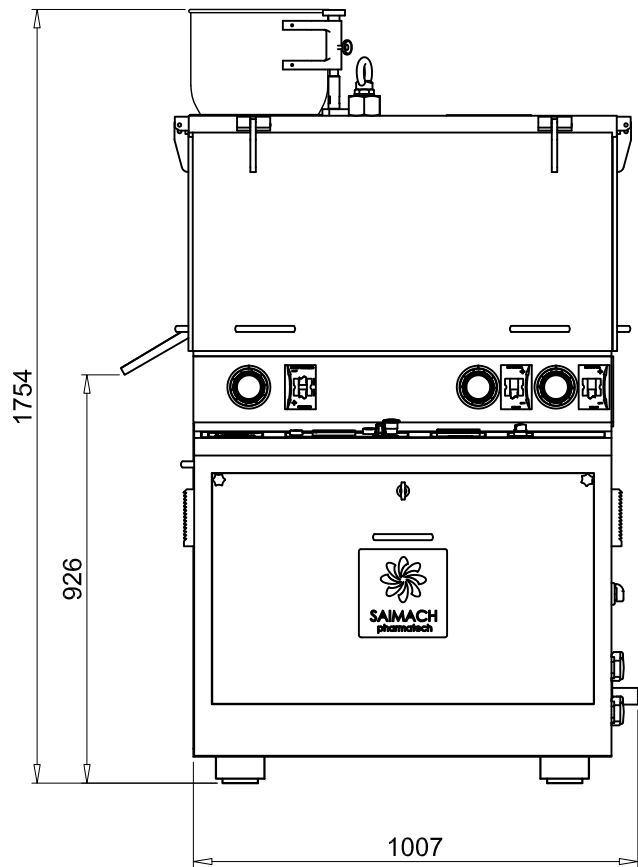
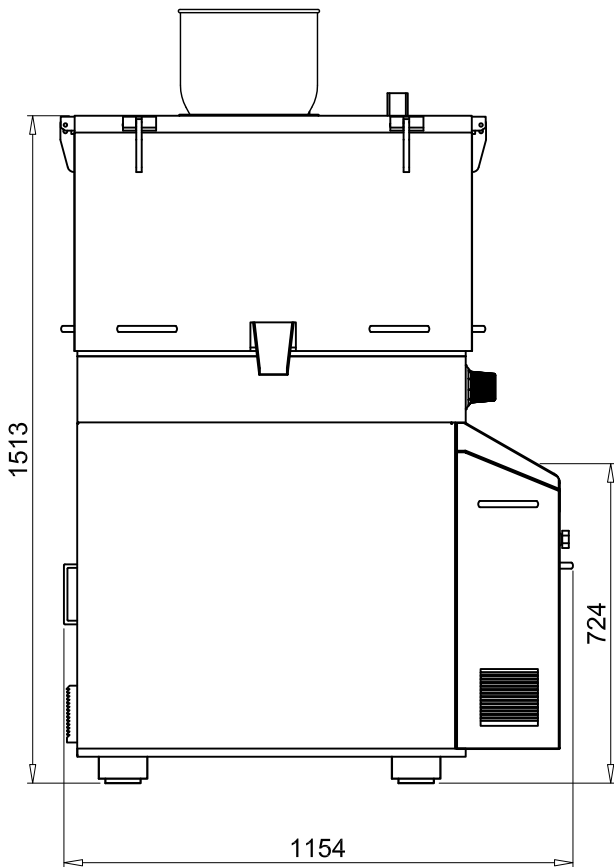
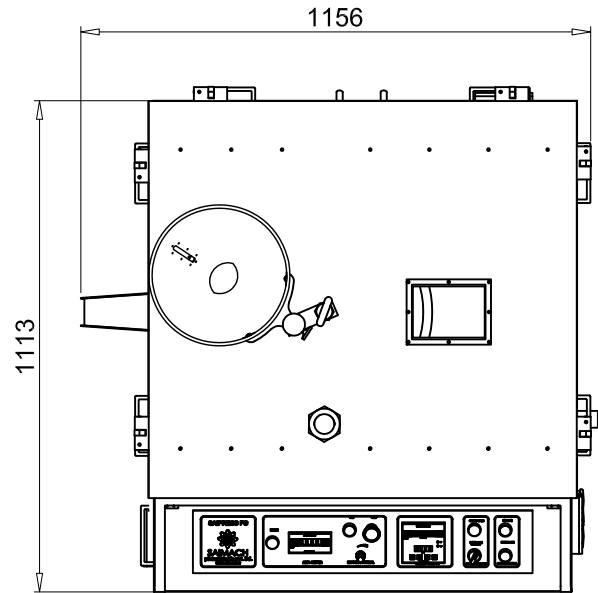
M/C NAME:- SMD-20



SAIMACH PHARMATECH PVT. LTD.
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INDEX

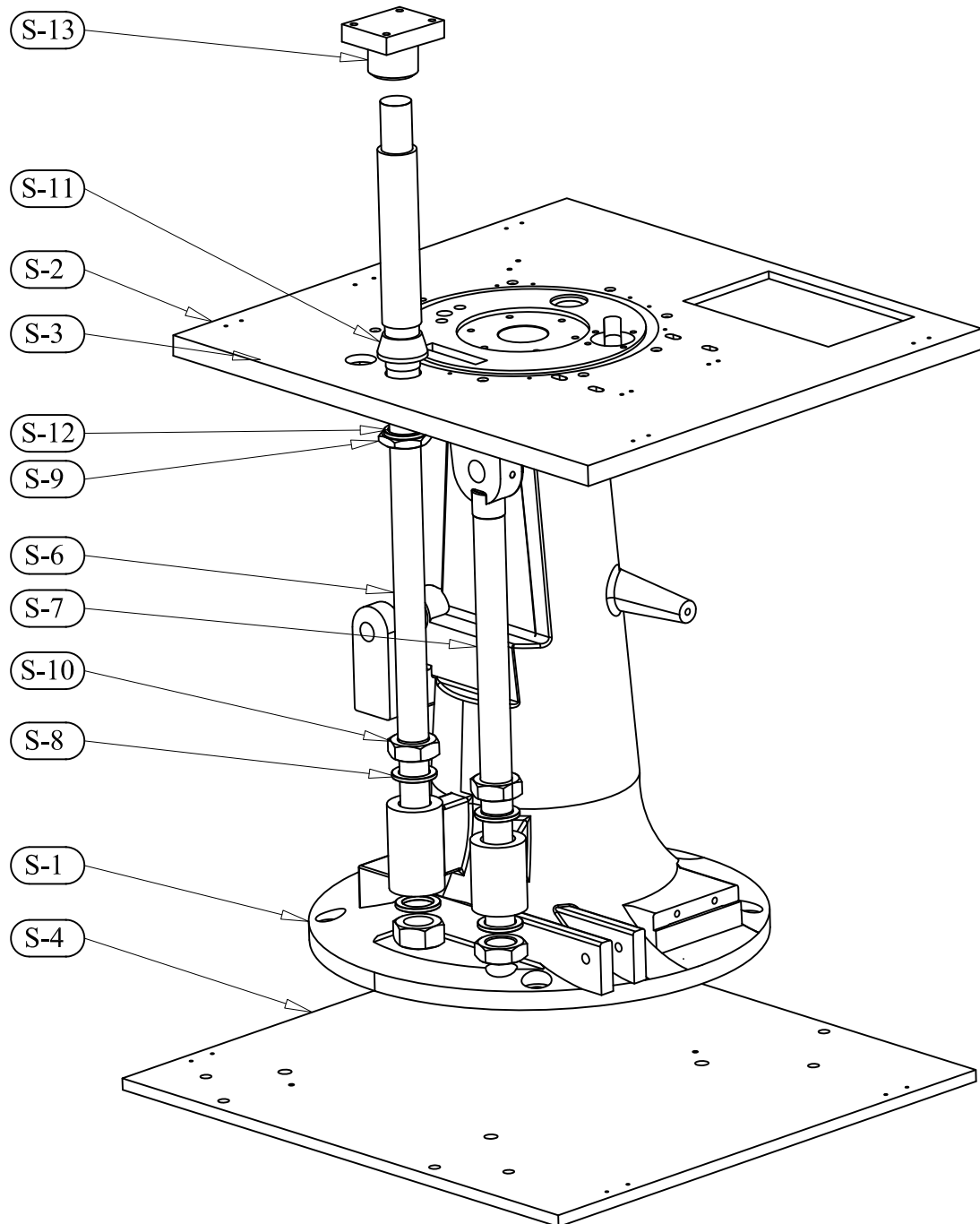
FIG. NO-1	BASE ASSEMBLY
FIG. NO-2	DRIVE ASSEMBLY
FIG. NO-4	LOWER ROLL CARRIER & PRESSURE LEVER ASSEMBLY
FIG. NO-5	TURRET ASSEMBLY
FIG. NO-6	DOZERS ASSEMBLY
FIG. NO-11	HOPPER ASSEMBLY
FIG. NO-12	UPPER & LOWER GUARD ASSEMBLY
FIG. NO-13	LUBRICATING OIL LINE ASSEMBLY
FIG. NO-19	LOWER PRE COMPRESSION ASSEMBLY
FIG. NO-21	UPPER PRE COMPRESSION ASSEMBLY
FIG. NO-24	FEED FRAME FOR PRE-COMPRETION
FIG. NO-25	UPPER CAM DISC ASSEMBLY FOR P.C
FIG. NO-31	HEAD ASSEMBLY WITH P.C & PENETRATION
FIG. NO-33	OUTSIDE CONTROL ASSEMBLY



M/C NAME:- SMD-20
 ASSLY NAME:- G.A. DRAWING



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M/C NAME:- SMD-20
 ASSLY NAME:- BASE ASSEMBLY



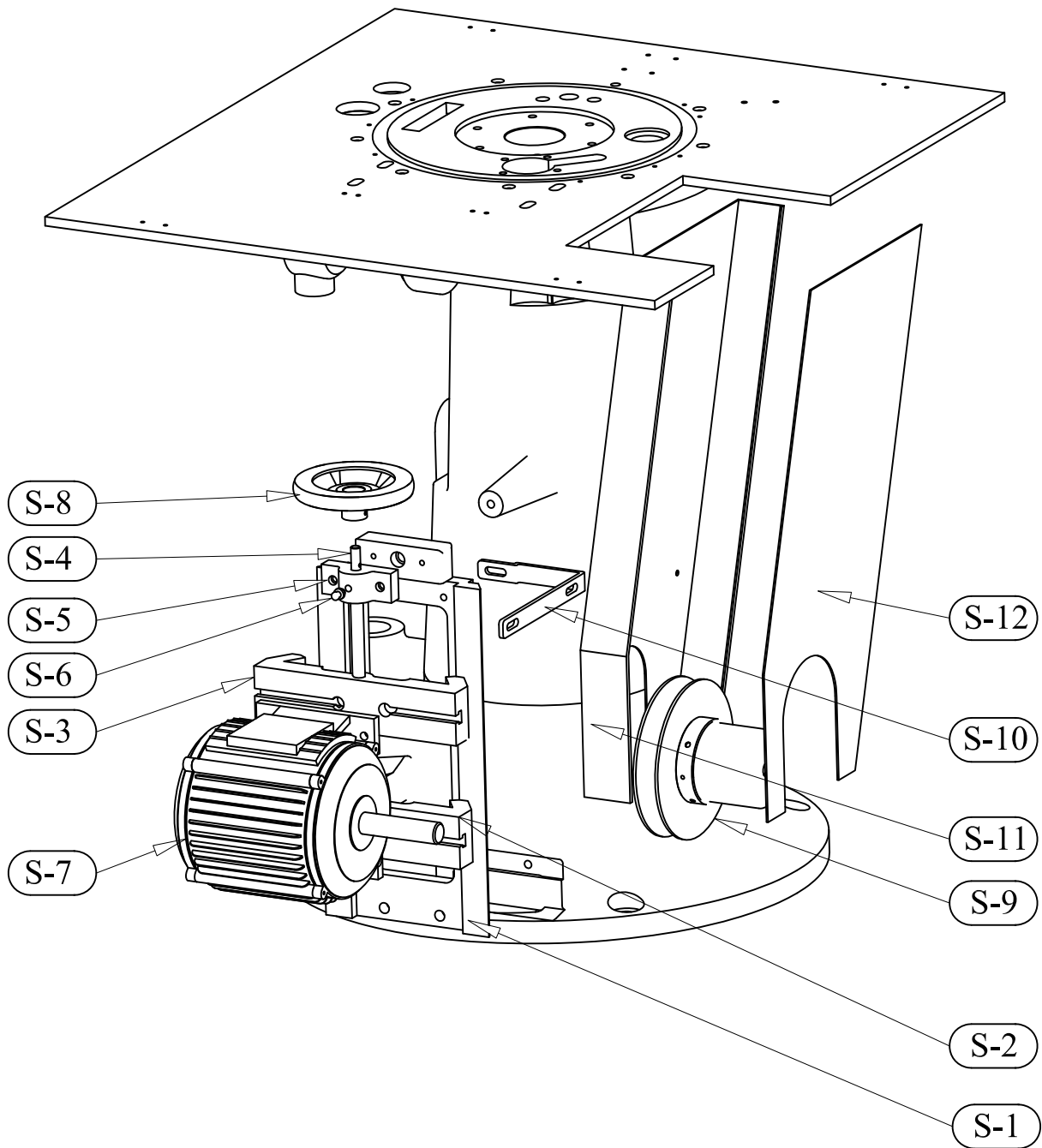
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ITEM NO.	PART NO.	TITLE	QTY.
1	AH32D10100	MAIN BODY- P.C	1
2	AH01A1020Z	TOP PLATE	1
3	AH32B101B0	S.S CLADING ON TOP PLATE	1
4	AH01A10300	BOTTOM PLATE	1
6	AH18A10200	MAIN PILLER	1
7	AH01A10600	SIDE SUPPORT PILLER	1
8	AA14A10300	MAIN PILLAR WASHER BOTTOM	5
9	AA14A10400	TABLE NUT	1
10	AA14A10500	HEXAGONAL NUT	5
11	AH01A11100	TABLE COLLAR LOWER	1
12	AA14A10700	MAIN PILLAR WASHER MIDDLE	1
13	AA14A10600	TOP FLANGE FOR PRESSURE ROD	1

M/C NAME:- SMD-20

ASSLY NAME:- BASE ASSEMBLY

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M/C NAME:- SMD-20
 ASSLY NAME:- DRIVE ASSEMBLY



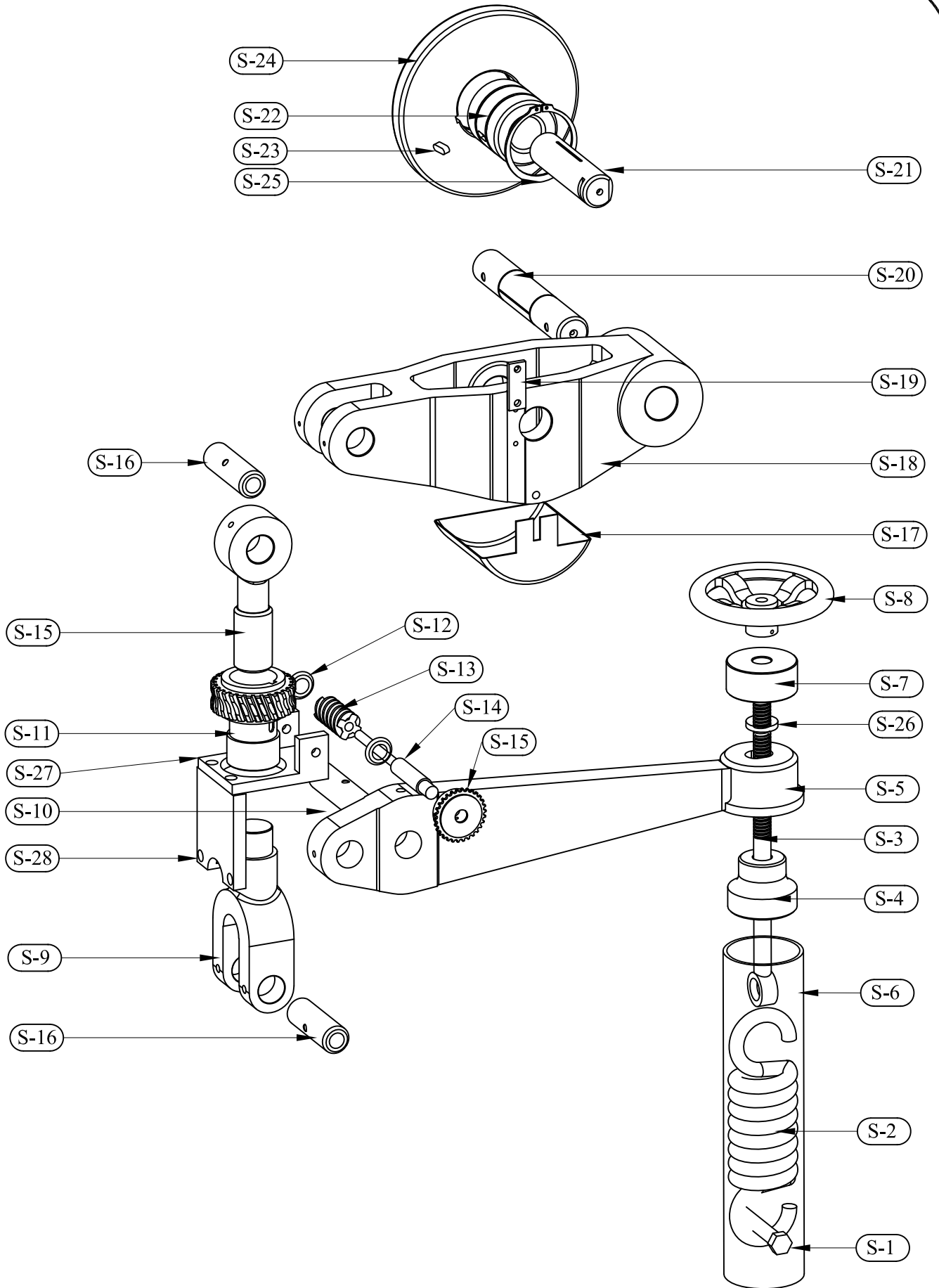
SAIMACH PHARMATECH PVT. LTD.
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ITEM NO.	PART NO.	TITLE	QTY.
1	AH02D10100	MOTOR RAIL BRACKET	1
2	AH02D10200	MOVING MOTOR RAIL	1
3	AH02D10300	DRAGGING MOTOR RAIL	1
4	AH02A10400	MOTOR ADJ. SCREW	1
5	AH02D10500	MOTOR ADJ. SCREW BRACKET	1
6	B/O	1/8 BSP GREASE NIPPLE	1
7	B/O	MOTOR 5HP , 1440 RPM, FOOT MOUNTED	1
8	AA12D101A0	MOTOR ADJ. HAND WHEEL	1
9	B/O	VARIABLE SPEED PULLEY	1
10	AH02A10800	CLAMP FOR BELT GUARD	1
11	AH02A10900	BELT GUARD	1
12	AH02A11000	BELT GUARD COVER	1
13	B/O	BELT C-76	1
14	B/O	BEARING 51101	1

M/C NAME:- SMD-16

ASSLY NAME:- DRIVE ASSEMBLY

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M/C NAME:- SMD-20
 ASSLY NAME:- LOWER CARRIER & PRESSURE LEVER ASSLY



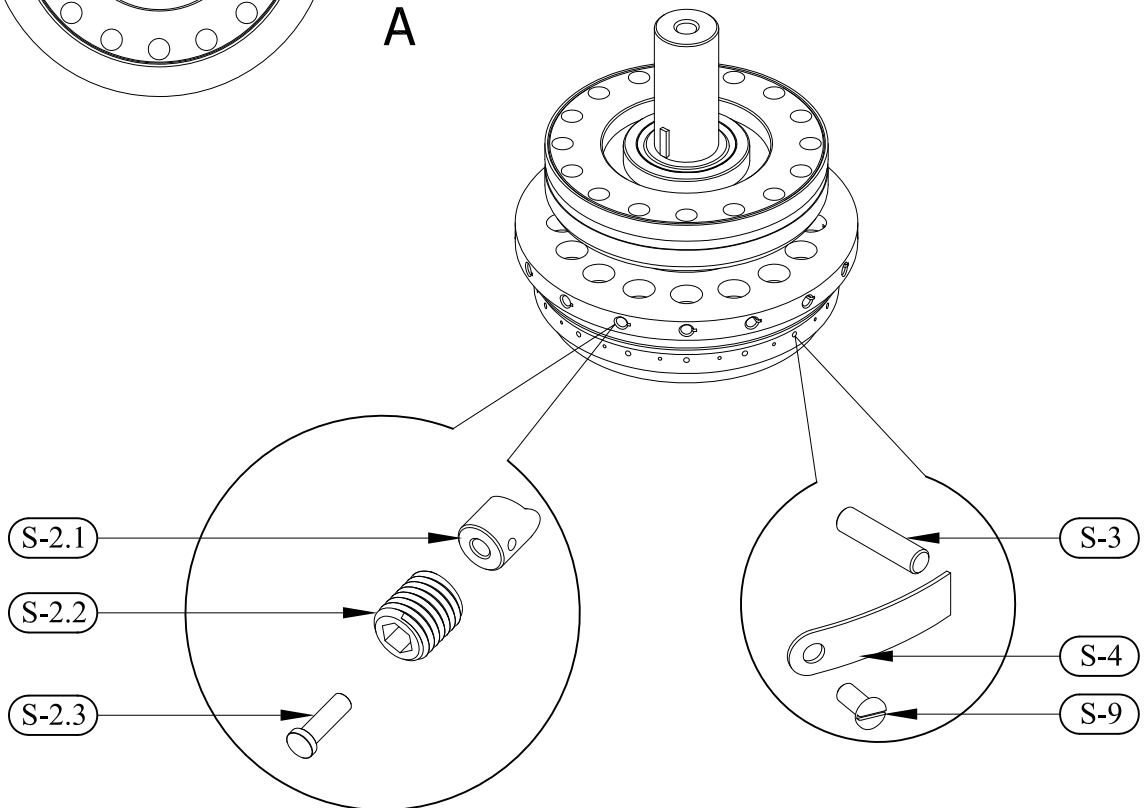
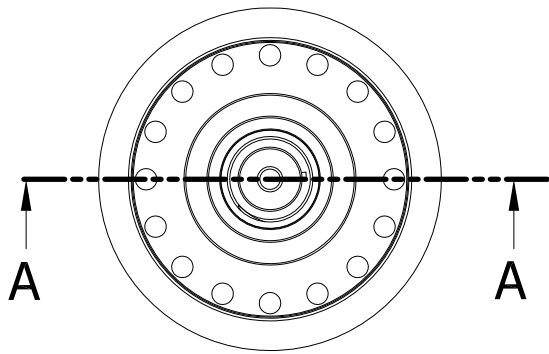
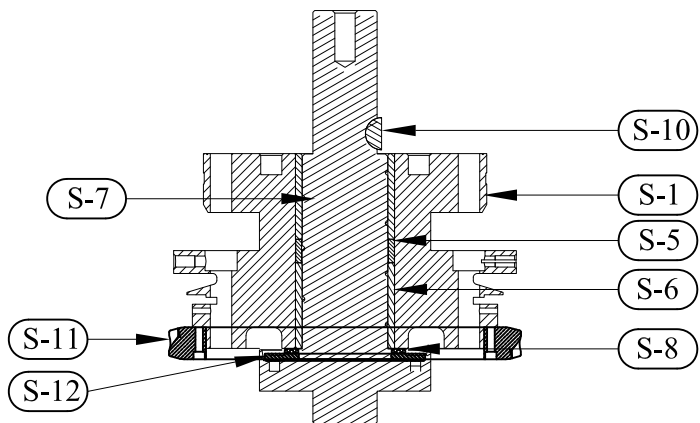
SAIMACH PHARMATECH PVT. LTD.
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ITEM NO.	PART NO.	TITLE	QTY.
1	B/O	5-8-2inch MS HEX	1
2	AH04A90100	TENSION SPRING	1
3	AH04A10200	SAFETY SCREW	1
4	AH04D10300	SPRING GUID BLOCK	1
5	AH04D10400	PRESSURE LEVER	1
6	AH04A10500	SPRING CASING	1
7	AH04A10600	PRESSURE LEVER WASHER	1
8	AH04D10700	SAFTY HAND WHEEL	1
9	AH04D10800	FORK	1
10	AH04E11000	PRESSURE LEVER PIN	1
11	AH17A12200	PRESSURE WHEEL OS CONTROL	1
12	B/O	BEARING 51100 THRUST BEARING	2
13	AH17A12700	WORM FOR PRESSURE WHEEL	1
14	AH17A11500	PRESSURE CONTROL SHAFT FOR O.S. CONTROL	1
15	AH17A12900	CHAIN SPROCKET 30 TEETH, 1/4"	1
16	AH04E11600	EYE BOLT PIN & FORK PIN	2
17	AH04D11700	OIL TRAY	1
18	AH04D11800	LOWER ROLL CARRIER	1
19	AH04A11900	STOP PICE	1
20	AH04E12000	FULCRUM PIN	1
21	AH04E12100	LOWER ROLL PIN	1
22	AA03E10300	LOWER ROLL BUSH	1
23	AH04A12300	KEY AT LOWER ROLL BUSH	1
24	AH04E12400	LOWER ROLL	1
25	B/O	CIRCLIP Ø85 MM EXTERNAL	2
26	B/O	THRUST BEARING NO.51104	1
27	AH17A12300	BRACKET FOR PRESSURE O.S. CONTROL	1
28	AH17A11900	SUPPORT FLAT FOR PRESSURE OS CONTROL	1

M/C NAME:- SMD-20

ASSLY NAME:- LOWER CARRIER & PRESSURE LEVER ASSLY

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M/C NAME:- SMD-20
ASSLY NAME:- TURRET ASSEMBLY



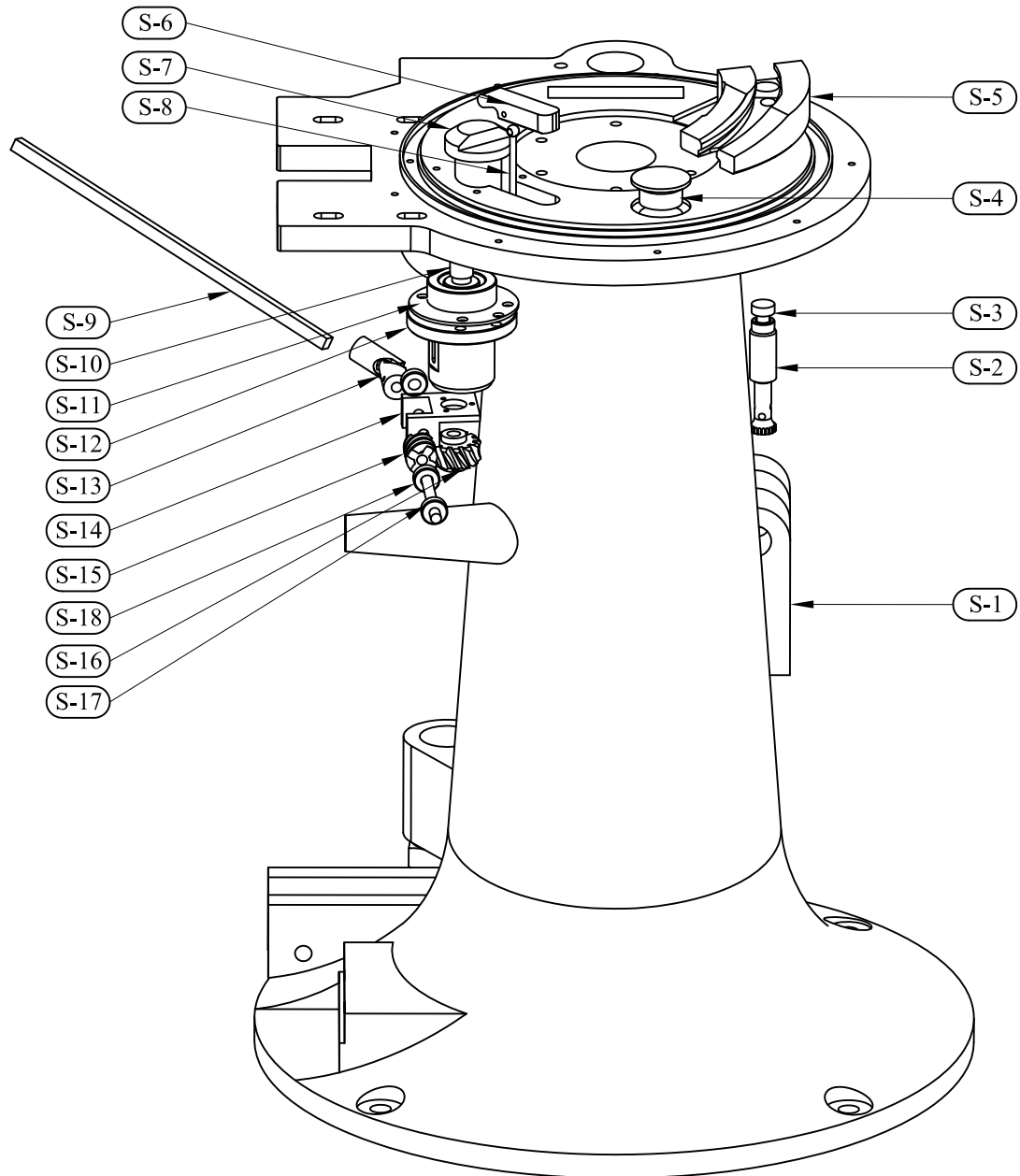
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ITEM NO.	PART NO.	TITLE	QTY.
1	AI05D20100	TURRET 20 STN.	1
2.1	AH05A50200	DIE SCREW BODY	20
2.2	AH05A50300	DIE SCREW END	20
2.3	AH05A50400	DIE SCREW COUPLING SCREW	20
3	AH05F50500	BREAK PLUG 23 MM LONG.	20
4	AH05A90600	ANTI TURNING STRIP	20
5	AH05C10700	SLIVE FOR TURRET	1
6	AH05C10800	BUSH FOR TURRET	2
7	AH05D10900	CENTER PILLER	1
8	B/O	THRUST BEARING SKF-AXF 100135	1
9	B/O	BOLT FOR ANTI TURNING STRIP	20
10	AH05A11000	WOODRUF KEY	1
11	AH05C11100	TURRET RING	1
12	AH05C11200	CENTER PILLAR WASHER	1

M/C NAME:- SMD-20

ASSLY NAME:- TURRET ASSEMBLY

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M/C NAME:- SMD-20
 ASSLY NAME:- DOZZER ASSEMBLY



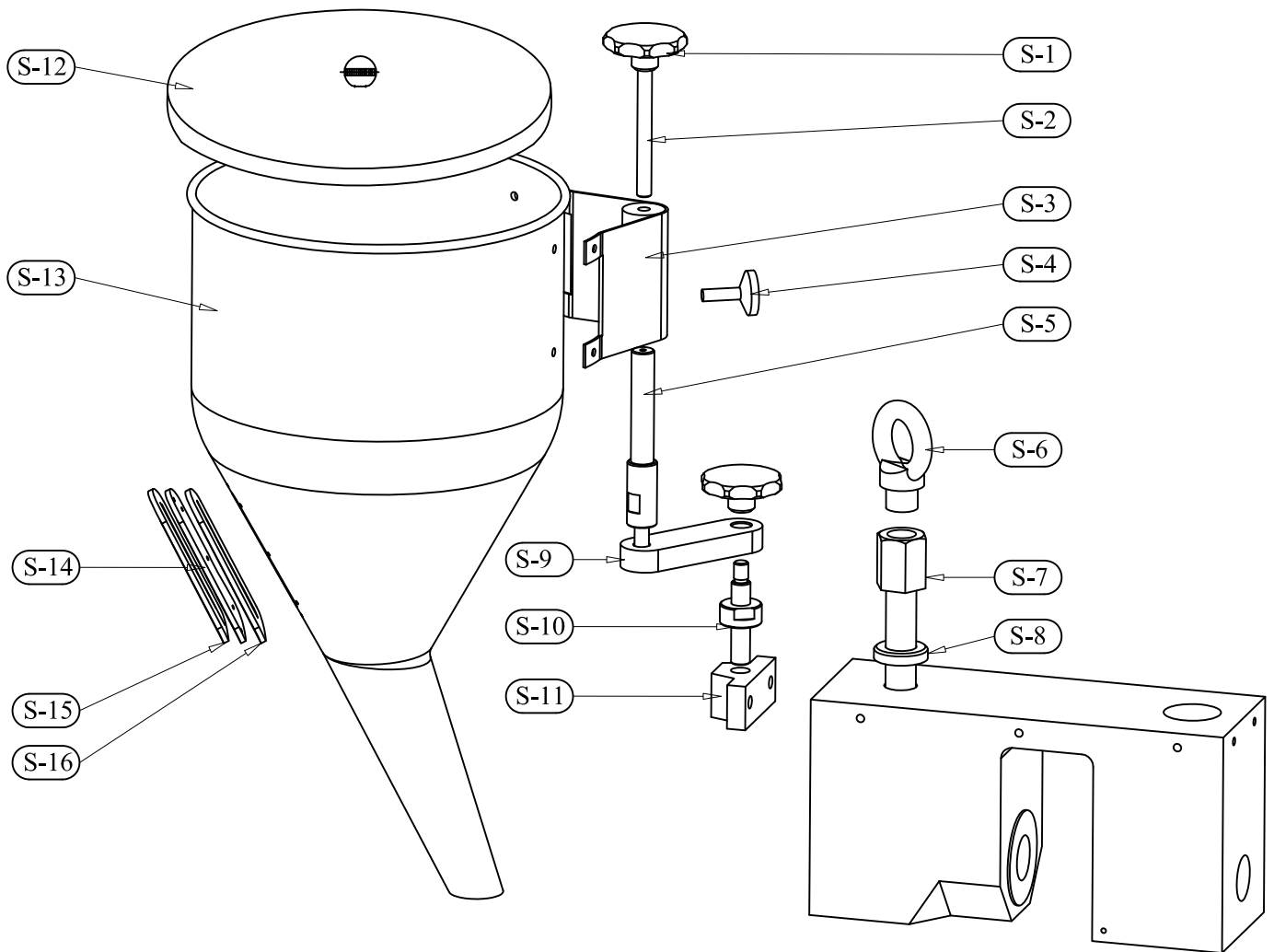
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ITEM NO.	PART NO.	TITLE	QTY.
1	AH01D10100	MAIN BODY	1
2	AH06A11700	PUNCH ADJ. SCREW	1
3	AH06E21600	PUNCH ADJ. CAM	1
4	AG06A11900	TABLE PLUG	1
5	AH06A11500	LOWER TRACK	1
6	AH06E20800	WEDGE	1
7	AH06E10100	WEIGHT DOZZER	1
8	AH06A11000	EYE PIN	1
9	AH17A11600	SQ. BAR	1
10	AH06A10400	DOZZER SPINDLE	1
11	AH06F20200	DOZZER RUBBER PACKING	1
12	AH06D10300	DOZZER BOSS	1
13	AH17A13000	UNIVERSAL JOINT	2
14	AH17A12000	BRACKET FOR DOZER O.S.CONTROL	1
15	AH17A12600	WORM FOR DOZZER	1
16	AH17A12400	WORM WHEEL FOR DOZZER	1
17	AH17A12500	WORM PIN FOR DOZZER O.S. CONTROL	1
17	B/O	THRUST BEARING 51100	2

M/C NAME:- SMD-20

ASSLY NAME:- DOZZER ASSEMBLY

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M/C NAME:- SMD-20
 ASSLY NAME:- HOPPER ASSEMBLY



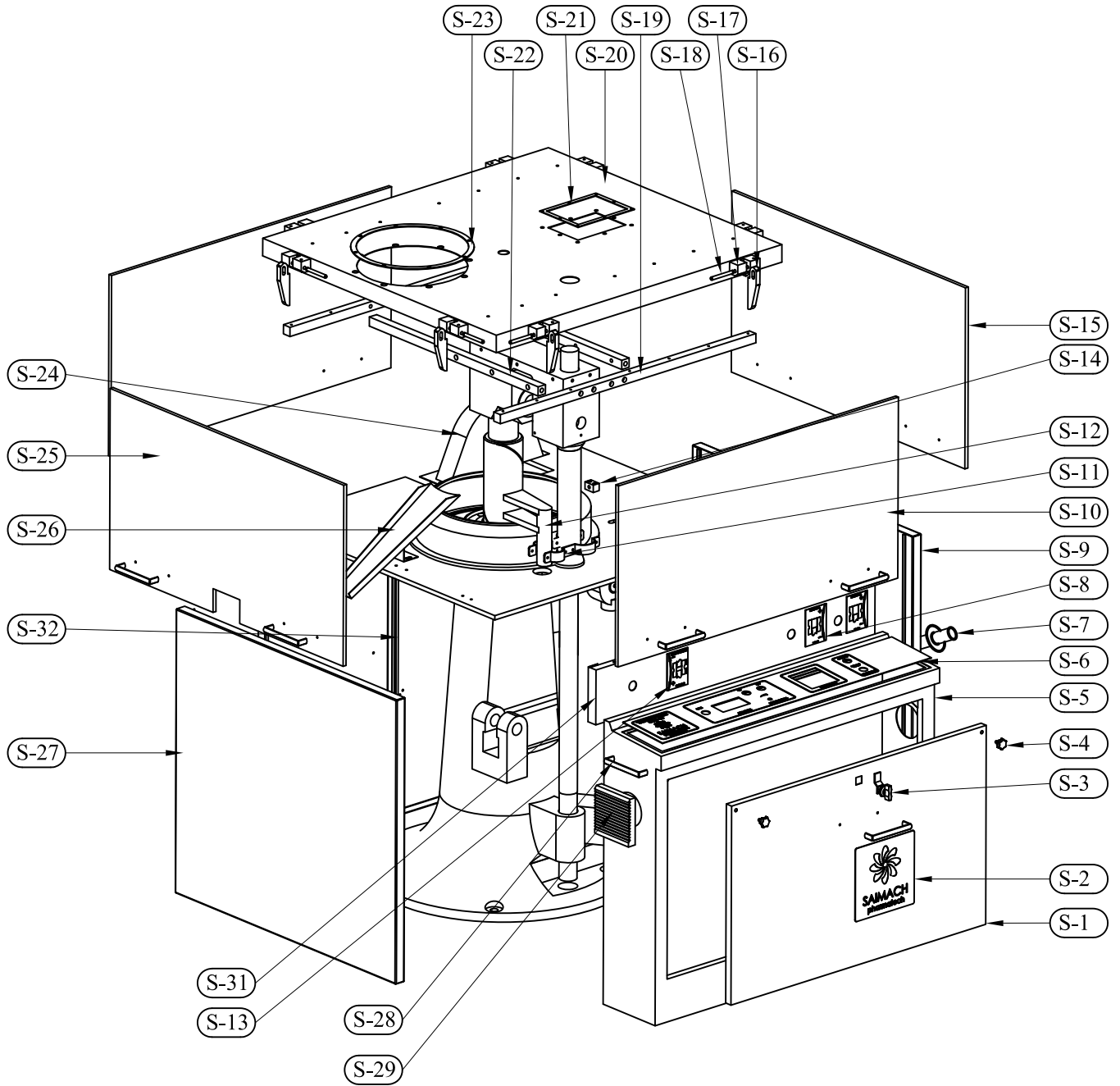
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ITEM NO.	PART NO.	TITLE	QTY.
1	AA18C51100	HOPPER ADJUSTING KNOB	2
2	AA18A10900	HOPPER ADJUSTING SCREW	1
3	AA18B10400	HOPPER FIXING BRACKET	1
4	AA18A10700	HOPPER CLAMP SCREW	1
5	AH11A103AX	HOPPER BRACKET SUPPORT PC-1	1
6	AH11A102B0	HOOK AT TOP PC-2	1
7	AH11A102A0	HOOK AT TOP PC-1	1
8	AH11A11100	WASHER AT HEAD BOLT	1
9	AA18A10600	HOPPER LINK	1
10	AA18A10500	HOPPER LINK STUD	1
11	AA18A10300	HOPPER BRACKET	1
12	AH11B20900	LID FOR HOPPER	1
13	AH11B20100	HOPPER	1
14	AA18F30200	ACRYLIC WINDOW FOR HOPPER	1
15	AA18B115A0	HOPPER WINDOW PC-1	1
16	AA18B115B0	HOPPER WINDOW PC-2	1

M/C NAME:- SMD-20

ASSLY NAME:- HOPPER ASSEMBLY

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M/C NAME:- SMD-20
 ASSLY NAME:- UPPER & LOWER GUARD ASSEMBLY



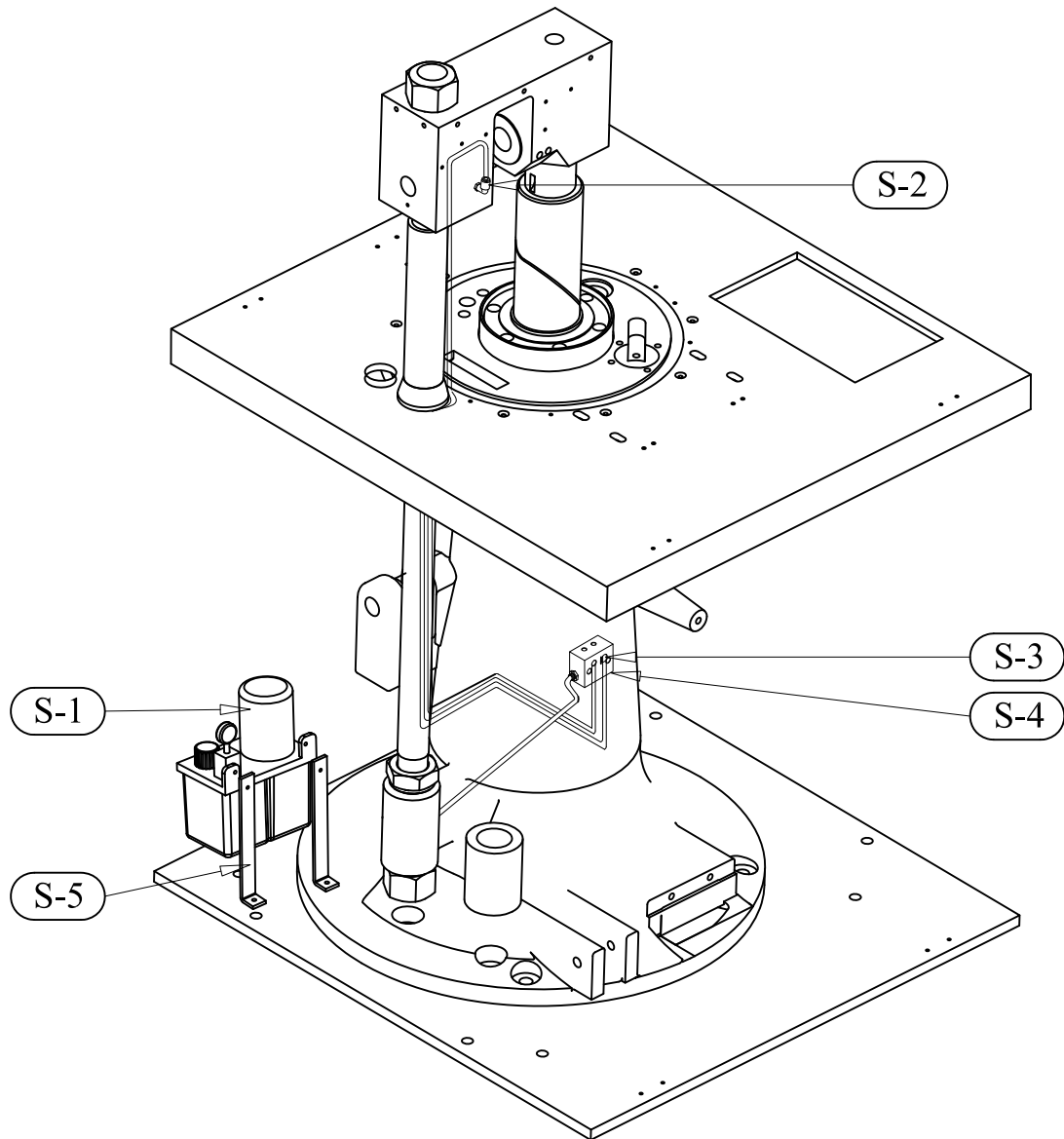
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 Ahmedabad-380023

ITEM NO.	PART NO.	TITLE	QTY.
1	AH17B102BX	FRONT PANEL DOOR	1
2	AA13B10100	SAIMACH LOGO	1
3	B/O	LOCK AT PANEL	1
4	B/O	M6 KNOB AT PANEL BOX	2
5	AH17B1020X	LOWER GUARD FRONT PANEL TYPE	1
6	AH17B10800	PANEL PLATE	1
7	AA20B21100	EYE NOZZLE	1
8	AH17B11100	WEIGHT LABLE	1
9	AH17B1030X	LOWER GUARD L.H. SIDE	1
10	AH12F31000	UPPER GUARD_2	2
11	AH12B12400	CLAMP FOR DUST NOZZEL	1
12	AH12B12500	DUST NOZZEL	1
13	AH17B11000	HARDNESS LABLE	1
14	AH12A10800	GEAR BOX ADJUSTING STUD	2
15	AH12B11100	LOWER GUARD REAR	1
16	AH12A11700	UPPER GUARD HING STRIP	8
17	AH12A11600	UPPER GUARD HING BLOCK	8
18	AH12A10100	UPPER GUARD HING PIN	8
19	AH12A10700	TIE BAR -R.H FOR HEAD	1
20	AH12B12300	HOOD	1
21	AA17B10600	HOOD WINDOW	1
22	AH12A10300	TIE BAR FOR HEAD	2
23	AH12B10200	HOOD RING	1
24	AH12A10400	PULLY GUARD	1
25	AH12F31900	UPPER GUARD FRONT SIDE	1
26	AH12B22100	SPOUTCH	1
27	AH17B1040X	LOWER GUARD R.H. SIDE	1
28	AH12B12000	HANDLE	12
29	B/O	AIR VENT	3
30	AH12B12900	WIRE PIPE	1
31	AH17B1060X-PC	LOWER GUARD TOP COVER - P.C	1
32	AH12B1120X	LOWER GUARD RH & LH SIDE	2
33	AH17B11000-PC	TABLET THICKNESS PRE-HARDNESS LABEL	1

M/C NAME:- SMD-20

ASSLY NAME:- UPPER & LOWER GUARD ASSEMBLY

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M/C NAME:- SMD-20
ASSLY NAME:- LUBRICATION OIL LINE ASSEMBLY



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SR. NO:- 13.2

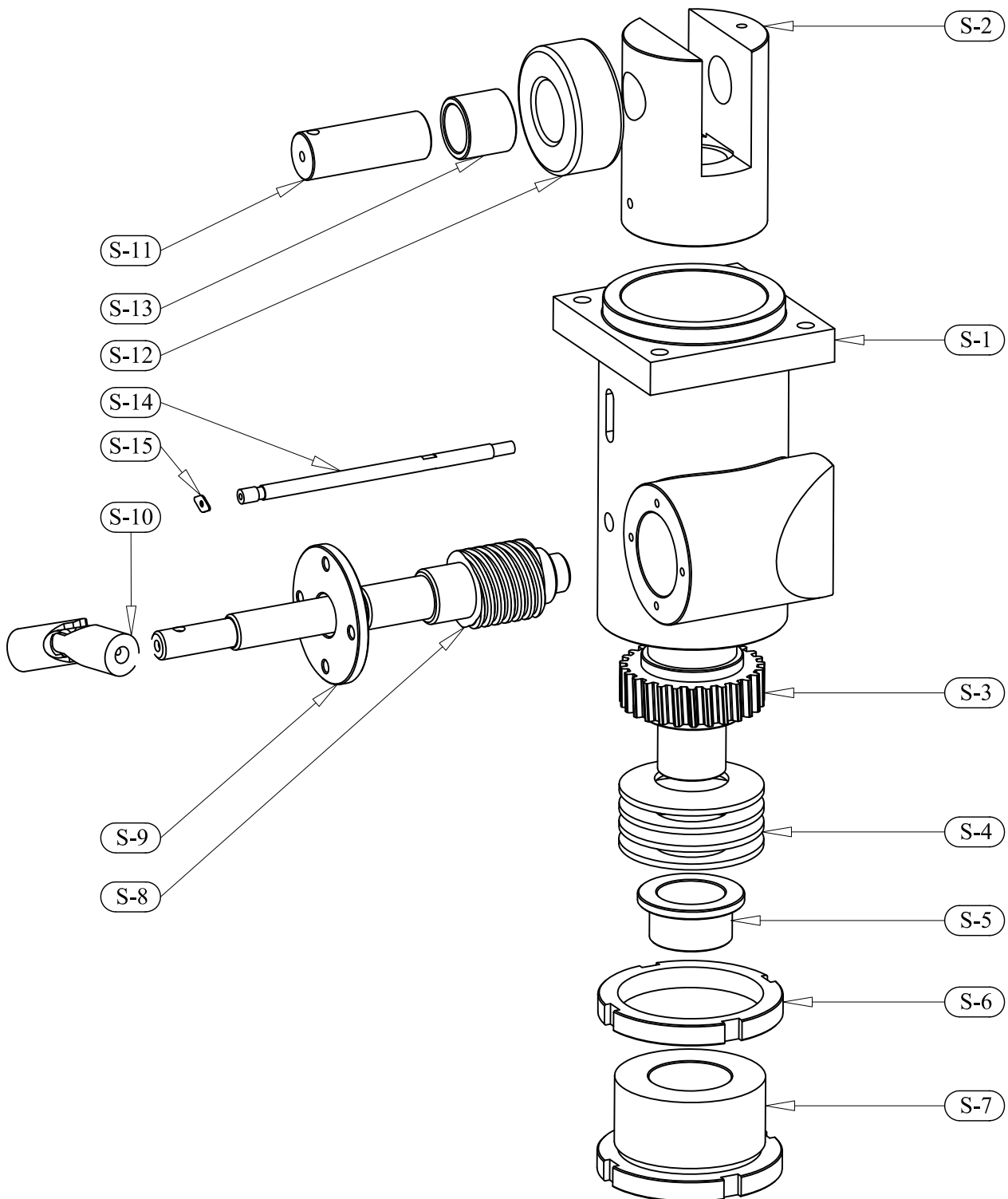
ITEM NO.	PART NO.	TITLE	QTY.
1	B/O	AUTO LUBRICATION OIL PUMP	1
2	B/O	ELBOW	1
3	B/O	MAIL NPT	1
4	AH13A10200	MANIFOLD	1
5	AS01A11500	CLAMP FOR LUB OIL PUMP	2

M/C NAME:- SMD-20

ASSLY NAME:- LUBRICATION OIL LINE ASSEMBLY



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M/C NAME:- SMD-20
 ASSLY NAME:- PRE-COMPRESSION (LOWER) ASSEMBLY



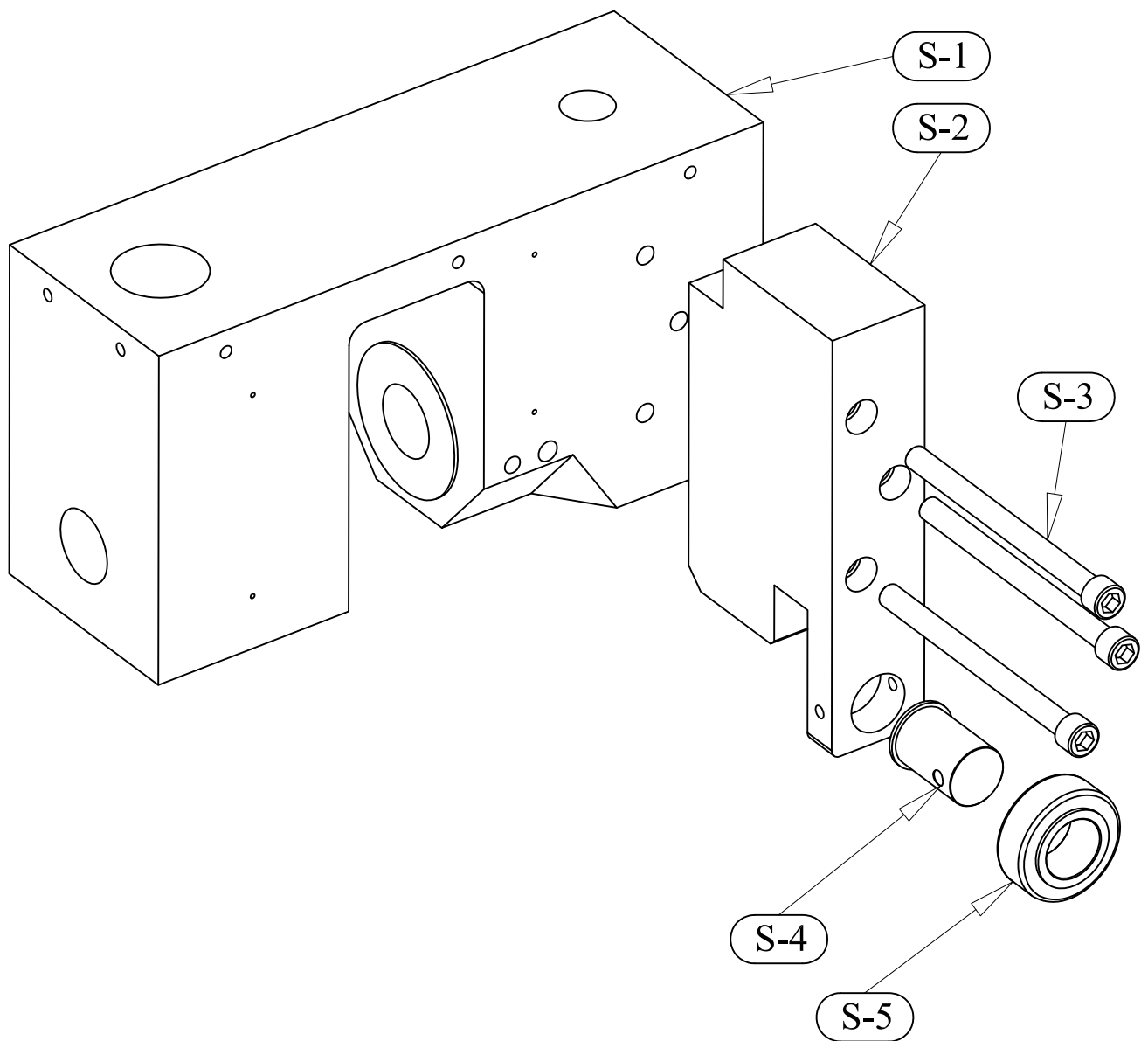
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ITEM NO.	PART NO.	TITLE	QTY.
1	RA05D10100	PRE-COMPRESSION ADJ. HOUSING (PRESSING)	1
2	RA05A10200	HOUSING FOR PRE-COMPRESSION ROLL	1
3	RA05A10300	GEAR 27 T. FOR LOWER PRE-COMPRESSION ADJ.	1
4	B/O	DISC SPRING	4
5	RA05A10500	BUSH AT PRE-COMPRESSION NUT	1
6	RA05A10600	CHECK NUT FOR PRE-COMPRESSION NUT	1
7	RA05A10700	PRE-COMPRESSION ADJ. NUT FOR LOWER PRESSING	1
8	RA05A10800	WORM SHAFT FOR PRE-COMPRESSION ADJ.	1
9	RA05A10900	COVER FOR PRE-COMPRESSION ADJ.	1
10	AH17A13000	UNIVERSAL JOINT	1
11	RA05E11100	PRE-COMPRESSION ROLL PIN	1
12	RA05E11200	PRE-COMPRESSION ROLL (LOWER)	1
13	RA05A11300	BUSH AT PRE-COMPRESSION ROLL	1
14	AH19A10100	STUD FOR INDICATOR (AT LOWER PRE-COMPRESSURE)	1
15	RA04B11100	INDICATOR	1
16	AH19E10200	FULCRUM PIN	1

M/C NAME:- SMD-20

ASSLY NAME:- PRE-COMPRESSION (LOWER) ASSEMBLY

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M/C NAME:- SMD-20
ASSLY NAME:- UPPER PRE-COMPRTION ASSEMBLY



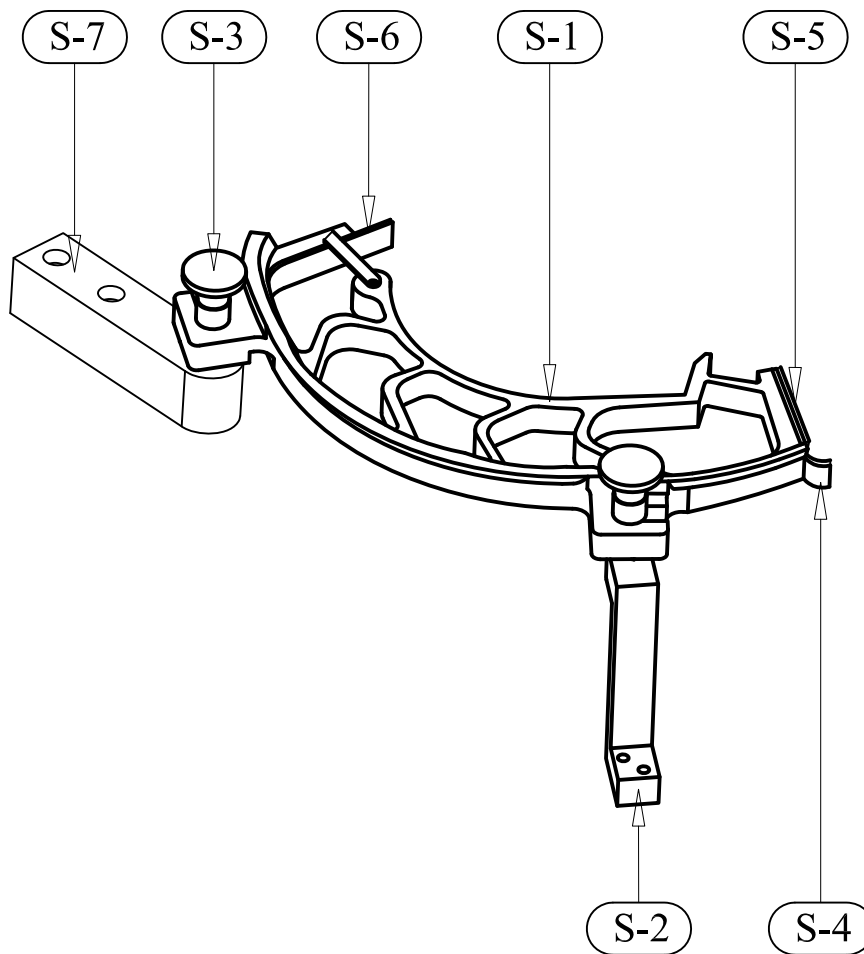
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ITEM NO.	PART NO.	TITLE	QTY.
1	AH21D10100	HEAD	1
2	AH21A10200	HEAD FOR UPPER PRE-COMPRETION	1
3	B/O	M12 X 150 L. ALLEN CAP BOLT	3
4	AH21E10300	PRE. COM. UPPER PRESSURE ROLL PIN	1
5	AH21E10400	PRE-COMPRETION ROLL UPPER	1

M/C NAME:- SMD-20

ASSLY NAME:- UPPER PRE-COMPRETION ASSEMBLY

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M/C NAME:- SMD-20
ASSLY NAME:- FEED FRAME ASSEMBLY



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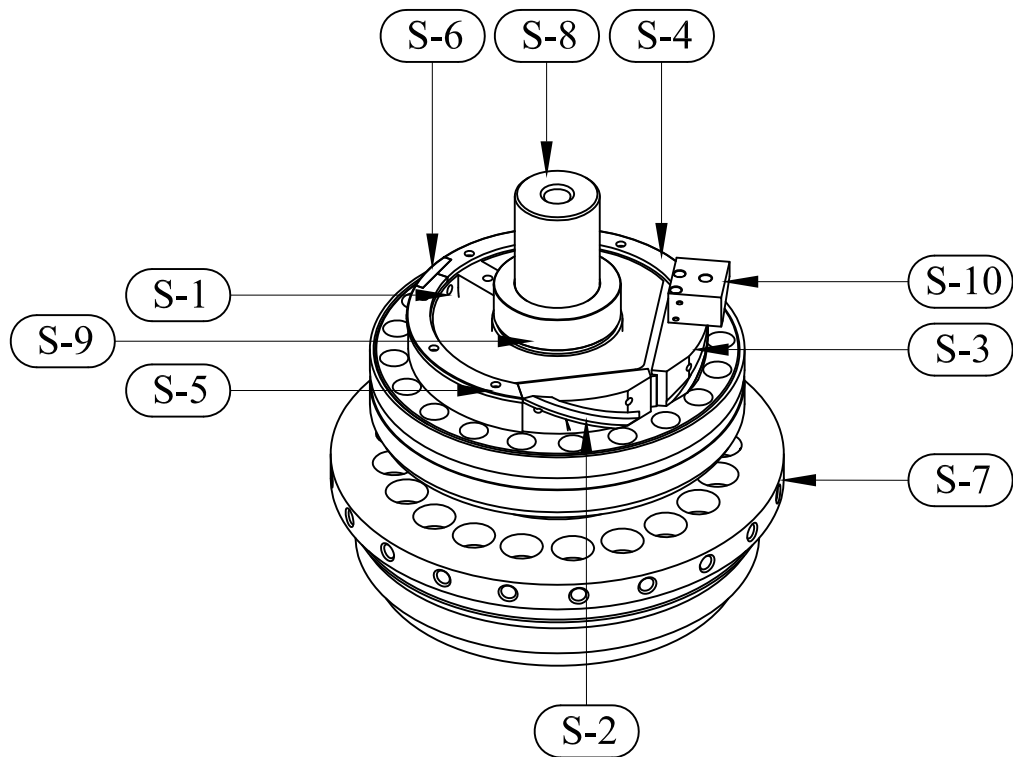
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ITEM NO.	PART NO.	TITLE	QTY.
1	AH24C10100	FEED FRAME	1
2	AH09D10200	'Z' BRACKET	1
3	AH09B10300	KNOB FOR FEED FRAME	2
4	AH24C104A0	TAKE OFF PLATE (INNER)	1
5	AH24C104B0	TAKE OFF PLATE (OUTER)	1
6	AH24C10500	POWDER SCRAPER PLATE	1
7	AH09A10600	FEED FRAME MOUNTING BRACKET	1
8	AH09B10700	NUT FOR FEED FRAME KNOB	2

M/C NAME:- SMD-20
ASSLY NAME:- FEED FRAME ASSEMBLY



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M/C NAME:- SMD-20
ASSLY NAME:- UPPER CAM DISC ASSLY



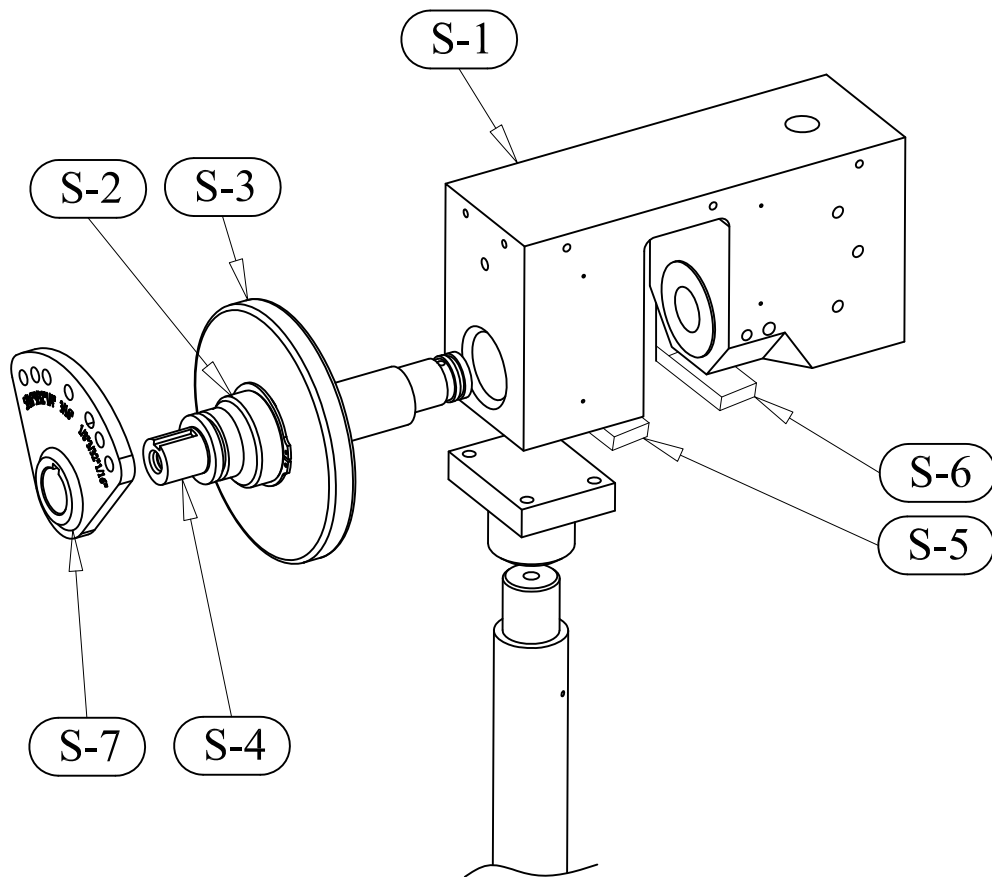
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Ahmedabad-380023

ITEM NO.	PART NO.	TITLE	QTY.
1	AH25D10100	UPPER CAM PLATE	1
2	AH25E10200	LOWERING TRACK AT UPPER CAM PLATE	1
3	AH25E10300	LIFTING TRACK AT UPPER CAM PLATE	1
4	AH25E10400	FICTION PLATE BIG	1
5	AH25E10500	FICTION PLATE SMALL	1
6	AH25E10600	TAKE OUT PICES AT UPPER CAM PLATE	1
7	AI05D20100	TURRET 20 STN	1
8	AH05D10900	CENTER PILLER	1
9	AH25A10700	CAM BODY SPACER	1
10	AH07A10800	UPPER OIL CUP PAD	1
11	B/O	OIL CUP SMALL	1

M/C NAME:- SMD-20

ASSLY NAME:- UPPER CAM DISC ASSLY

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M/C NAME:- SMD-20
ASSLY NAME:- HEAD ASSEMBLY



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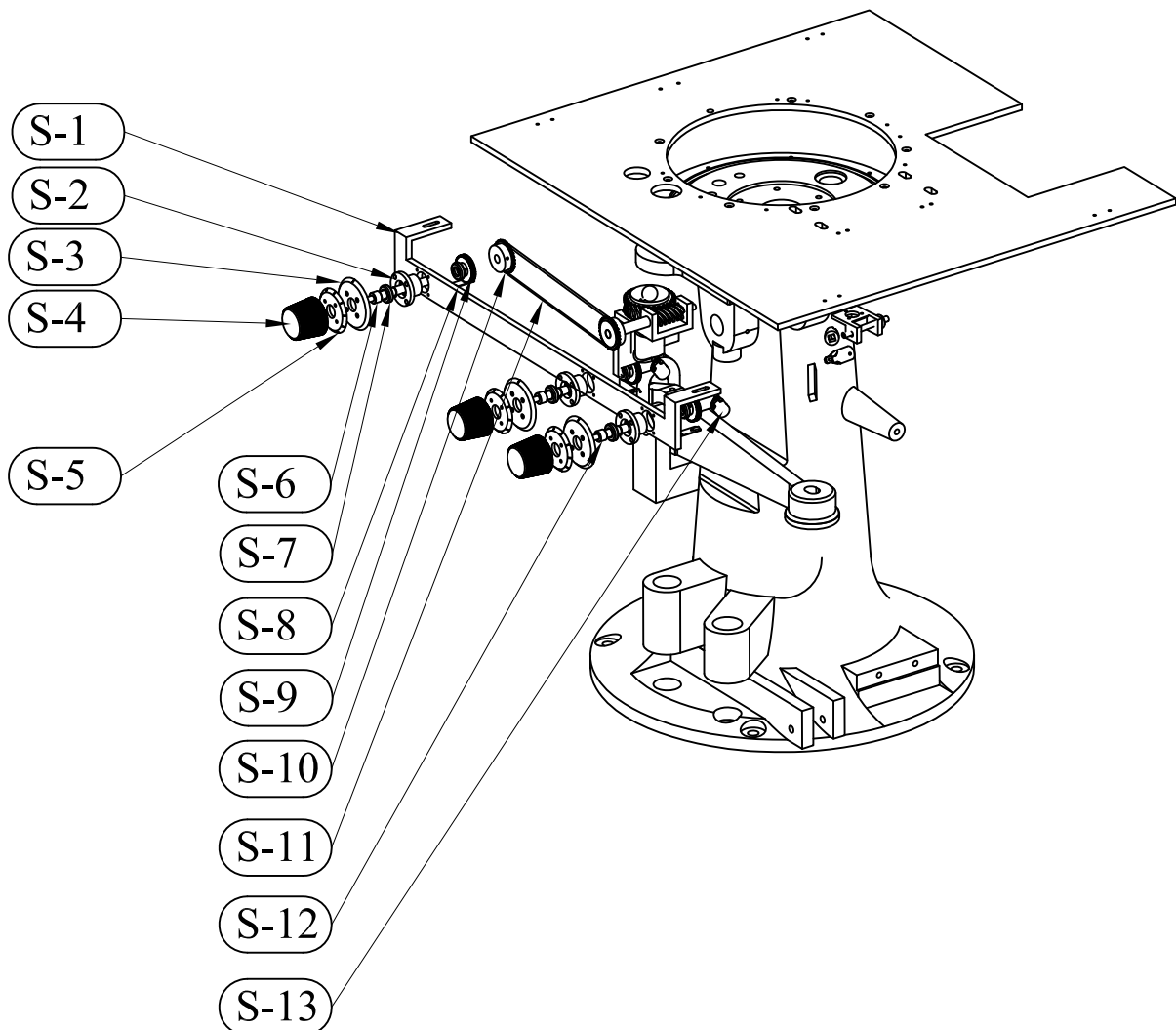
SR. NO:- 31.2

ITEM NO.	PART NO.	TITLE	QTY.
1	AH31D10100	HEAD	1
2	AA03E10300	LOWER PRESS ROLL BUSH	1
3	AA15E10400	UPPER & LOWER PRESS ROLL	1
4	AH08E10400	UPPER PRESS ROLL PIN	1
5	AH08B10500	OIL TRAY INNER	1
6	AH08B10600	OIL TRAY OUTER	1
7	AH18A1040X	PERFORATED SEGMENT	1

M/C NAME:- SMD-20
ASSLY NAME:- HEAD ASSEMBLY



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M/C NAME:- SMD-20
 ASSLY NAME:- OUTSIDE CONTROL ASSEMBLY



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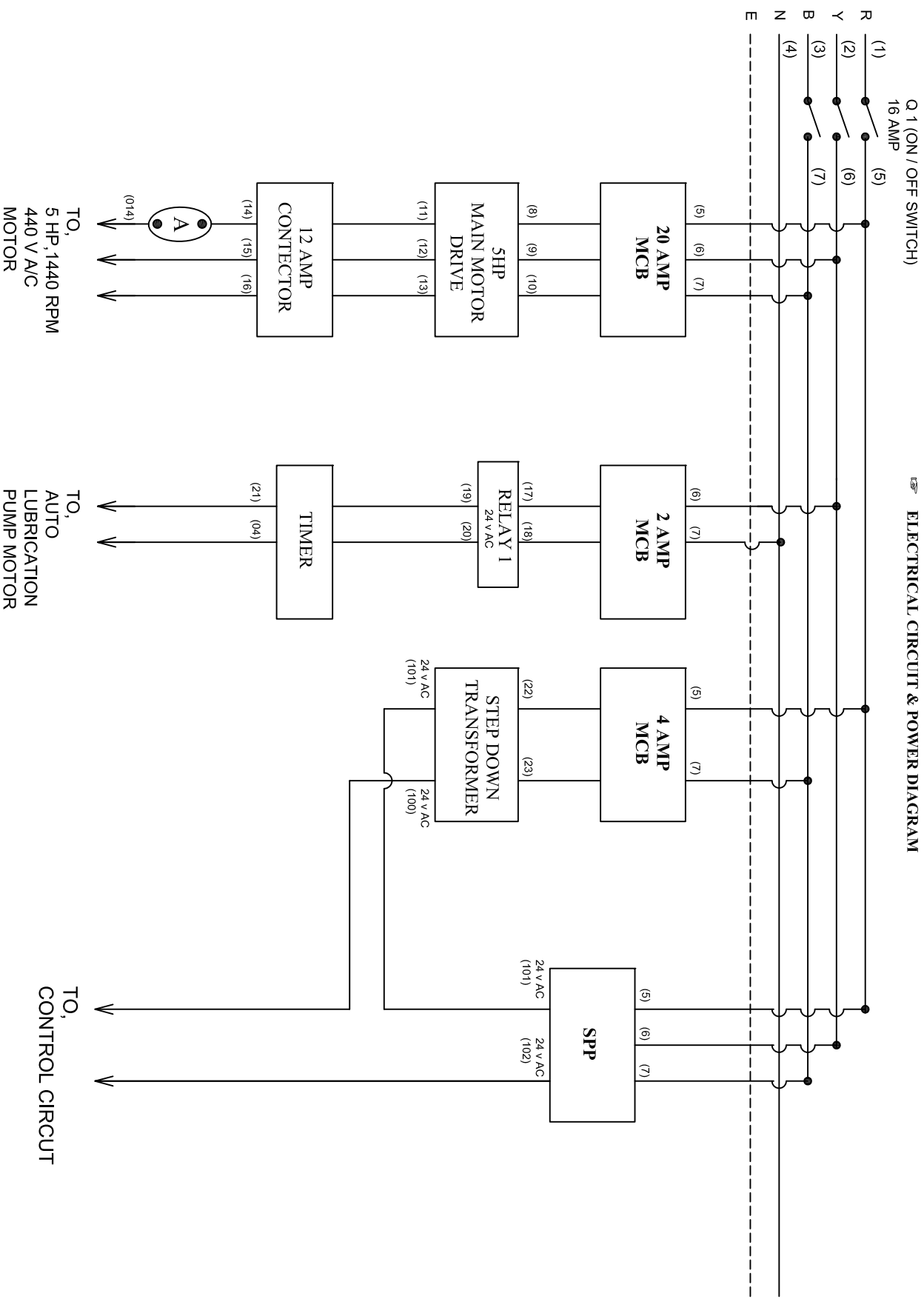
ITEM NO.	PART NO.	TITLE	QTY.
1	AH33A10100	SUPPORT BRACKET FOR O.S. CONTROL	1
2	AH17A11800	BEARING HOUSING	3
3	AH17C512C0	KNOB FOR O.S. CONTROL-PC3	3
4	AH17C512A0	KNOB FOR O.S. CONTROL-PC1	3
5	AH17C512B0	KNOB FOR O.S. CONTROL-PC2	3
6	AH17A1A300	SHAFT FOR KNOB R.H. SIDE	1
7	B/O	BEARING 6002	5
8	AH17A91700	GEAR STRIP	3
9	AH17A12100	50T GEAR FOR O.S. CONTROL	3
10	AH17A12900	CHAIN SPROCKET 30 TEETH	1
11	B/O	CHAIN 1/4", 590MM LONG	1
12	AH17A11400	SHAFT FOR KNOB L.H. SIDE	2
13	AH17A13000	UNIVERSAL JOINT	2

M/C NAME:- SMD-20

ASSLY NAME:- OUTSIDE CONTROL ASSEMBLY

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ELECTRICAL CIRCUIT & POWER DIAGRAM



WITH A.C DRIVE,
& AUTO LUB OIL PUMP

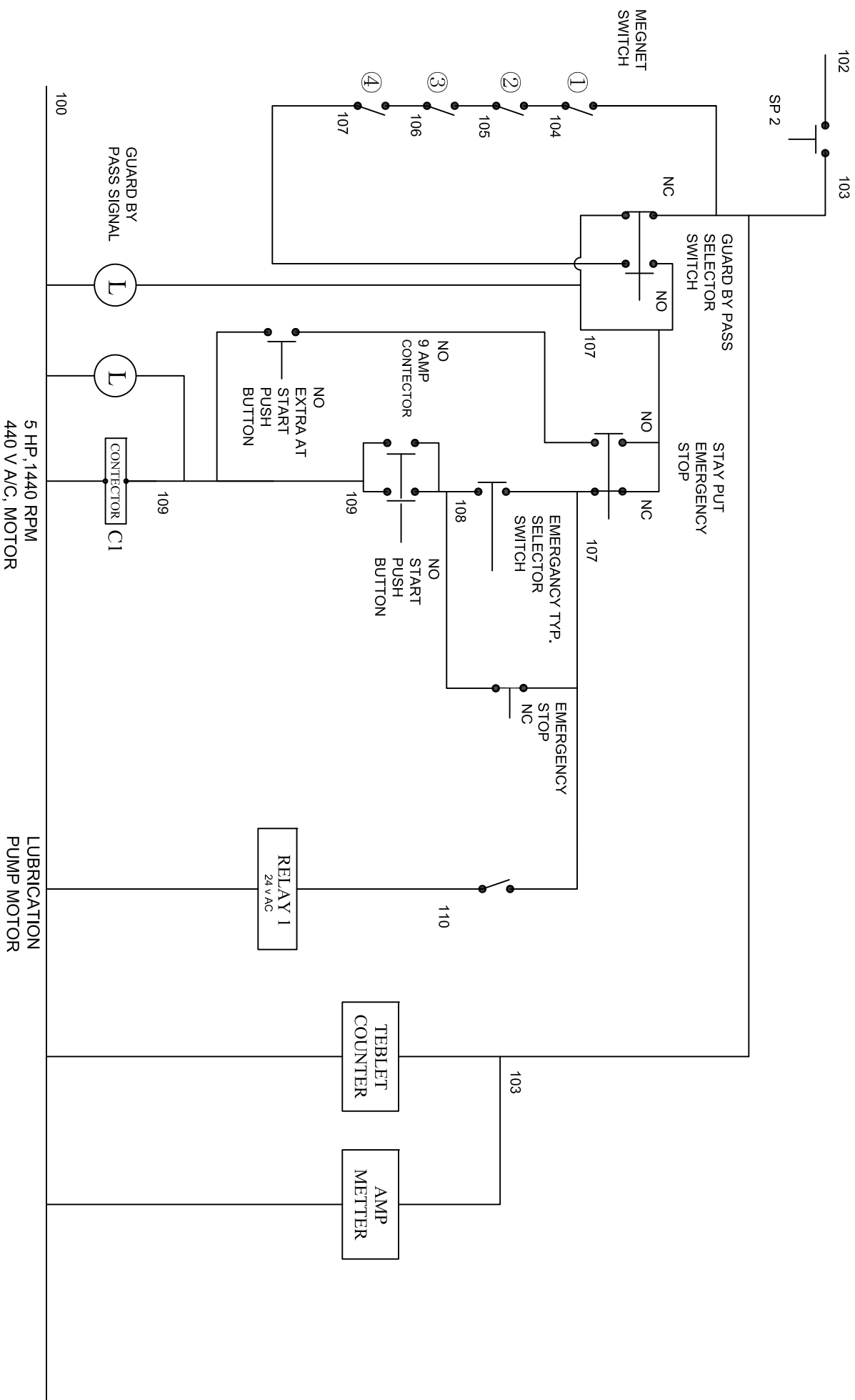
M/C NAME:- SAIPRESS-FC
ASSLY NAME:- WIRING DIAGRAM



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ELECTRICAL CONTROL DIAGRAM



WITH A.C DRIVE,
& AUTO LUB OIL PUMP

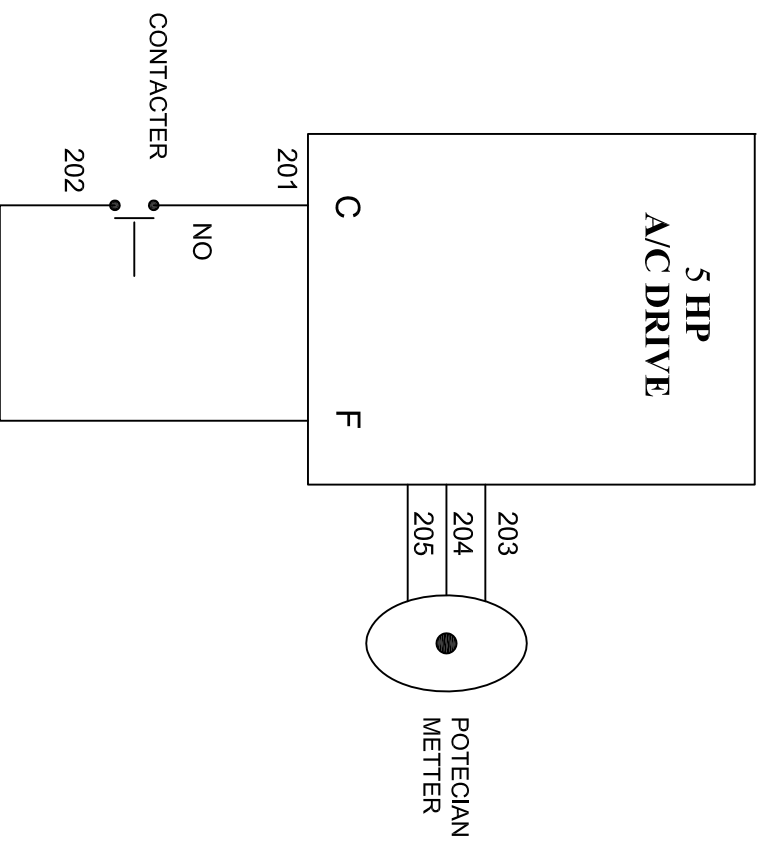
M/C NAME:- SAIPRESS-FC
ASSLY NAME:- WIRING DIAGRAM



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CONNECTION CIRCUIT DIAGRAM



WITH A.C DRIVE,
& AUTO LUB OIL PUMP

M/C NAME:- SAIPRESS-FC
ASSLY NAME:- WIRING DIAGRAM



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