

**PRODUCT: INNOKOAT SOV (Solvent Film Coating System)**

**SPECIFICATIONS:**

S. No.	TEST	SPECIFICATION
1	Appearance	White/coloured powder.
2	pH 10 % suspension in purified water	Between : 4.0 to 9.0
3	Particle Size	NLT 99.0% w/w pass through 100# ASTM sieve.
4	Bulk density	Limit: 0.4 g/cc to 1.2 g/cc
5	Ash	NMT: 50.0 % w/w
6	Arsenic	NMT: 3.0 ppm
7	Heavy metals	NMT: 20.0 ppm

**Note: Customized product will be available on request.**

**METHOD OF USAGE:**

Coating Pan Size : 12" Conventional Coating Pan with 3 Baffles / Auto coater  
 Batch Size : 1.000 kg Placebo Tablets  
 Actual Weight gain : 2.5 % w/w on Tablets  
 Process Loss : 0.5 %  
 Quantity of Innokoat™: 30.0 gms (including loss)

**FORMULATION:**

Solvent	Reconstitution Level	Solvent Film Coating System	
Organic	5% w/w	Innokoat SOV	30 g
		Iso Propyl Alcohol	200 g
		Methylene Chloride	370 g
		Total	600 g

**PROCEDURE OF MIXING:**

Take required quantity of IPA in vessel. Stir with Propeller Stirrer to form vortex. Add Innokoat™ in to the vortex & then add required quantity of Methylene Chloride, continue to stir for 45 minutes. Pass the solution / dispersion through 80 mesh & then use for coating.

**COATING PARAMETERS:**

Coating Pan RPM : 25 to 30      Spray gun : 1 - 1.2 mm nozzle  
 Atomization Pressure : 1 – 1.5 kg / cm<sup>2</sup>      Spray Rate : 15 to 25 gms per minutes  
 Inlet Air Temp. : 60 to 65 °C      Product Bed Temp. : 40 to 45 °C

Prewarming: 10 mins at slow rpm or by inching  
 Post Drying: 5 mins at slow rpm or by inching at 40°C

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