

TECHNOPHAR DIE ROLL PRODUCTION RATES (Capsules/ hour)

Die Roll Size	Capsule Size	Rows	Div	Cavities	RPM								Efficiency over a 4"x 6" machine @ 5 RPM		
					2.5	3.0	3.5	4.0	4.5	5.0	6.0	7.0		8.0	
4" x 2.756" (LAB)	2 Oval	1	31	31	4,650										
4" x 6"	2 Oval	11	31	341		61,380	71,610	81,840	92,070	102,300					
4" x 7.25"	2 Oval	15	31	465		83,700	97,650	111,600	125,550	139,500					1.36
6" x 10"	2 Oval	21	46	966		173,880	202,860	231,840	260,820	289,800	347,760	405,720	463,380		2.83
6" x 12"	2 Oval	24	46	1104		198,720	231,840	264,960	298,080	331,200	397,440	463,680	529,920		3.24
4" x 2.756" (LAB)	3 Oval	1	30	30	4,500										
4" x 6"	3 Oval	10	32	320		57,600	67,200	76,800	86,400	96,000					
4" x 7.25"	3 Oval	13	32	416		74,880	87,360	99,840	112,320	124,800					1.30
6" x 10"	3 Oval	20	44	880		158,400	184,800	211,200	237,600	264,000	316,800	369,600	422,400		2.75
6" x 12"	3 Oval	24	44	1056		190,080	221,760	253,440	285,120	316,800	380,160	443,520	506,880		3.30
4" x 2.756" (LAB)	4 Oval	1	29	29	4,350										
4" x 6"	4 Oval	9	29	261		46,980	54,810	62,640	70,470	78,300					
4" x 7.25"	4 Oval	11	29	319		57,420	66,990	76,560	86,130	95,700					1.22
6" x 10"	4 Oval	17	43	731		131,580	153,510	175,440	197,370	219,300	263,160	307,020	350,880		2.80
6" x 12"	4 Oval	21	43	903		162,540	189,630	216,720	243,810	270,900	325,080	379,260	433,440		3.46
4" x 2.756" (LAB)	5 Oval	1	27	27	4,050										
4" x 6"	5 Oval	8	26	208		37,440	43,680	49,920	56,160	62,400					
4" x 7.25"	5 Oval	11	28	308		55,440	64,680	73,920	83,160	92,400					1.48
6" x 10"	5 Oval	16	41	656		118,080	137,760	157,440	177,120	196,800	236,160	275,520	314,880		3.15
6" x 12"	5 Oval	19	41	779		140,220	163,590	186,960	210,330	233,700	280,440	327,180	373,920		3.75
4" x 2.756" (LAB)	6 Oval	1	26	26	3,900										
4" x 6"	6 Oval	8	27	216		38,880	45,360	51,840	58,320	64,800					
4" x 7.25"	6 Oval	10	28	280		50,400	58,800	67,200	75,600	84,000					1.30
6" x 10"	6 Oval	15	38	570		102,600	119,700	136,800	153,900	171,000	205,200	239,400	273,600		2.64
6" x 12"	6 Oval	18	38	684		123,120	143,640	164,160	184,680	205,200	246,240	287,280	328,320		3.17
4" x 2.756" (LAB)	7.5 Oval	1	25	25	3,750										
4" x 6"	7.5 Oval	7	25	175		31,500	36,750	42,000	47,250	52,500					
4" x 7.25"	7.5 Oval	9	25	225		40,500	47,250	54,000	60,750	67,500					1.29
6" x 10"	7.5 Oval	13	37	481		86,580	101,010	115,440	129,870	144,300	173,160	202,020	230,880		2.75
6" x 12"	7.5 Oval	16	37	592		106,560	124,320	142,080	159,840	177,600	213,120	248,640	284,160		3.38
4" x 2.756" (LAB)	10 Oval	1	23	23	3,450										

Die Roll Size	Capsule Size	Rows	Div	Cavities	RPM								Efficiency over a 4" x 6" machine @ 5 RPM	
					2.5	3.0	3.5	4.0	4.5	5.0	6.0	7.0		8.0
4" x 6"	10 Oval	7	22	154		27,720	32,340	36,960	41,580	46,200				
4" x 7.25"	10 Oval	9	23	207		37,260	43,470	49,680	55,890	62,100				1.34
6" x 10"	10 Oval	13	34	442		79,560	92,820	106,080	119,340	132,600	159,120	185,640	212,160	2.87
6" x 12"	10 Oval	15	34	510		91,800	107,100	122,400	137,700	153,000	183,600	214,200	244,800	3.31
4" x 2.756" (LAB)	12 Oval	1	19	19	2,850									
4" x 6"	12 Oval	7	22	154		27,720	32,340	36,960	41,580	46,200				
4" x 7.25"	12 Oval	9	21	189		34,020	39,690	45,360	51,030	56,700				1.23
6" x 10"	12 Oval	13	31	403		72,540	84,630	96,720	108,810	120,900	145,080	169,260	193,440	2.62
6" x 12"	12 Oval	16	31	496		89,280	104,160	119,040	133,920	148,800	178,560	208,320	238,080	3.22
4" x 2.756" (LAB)	20 Oval	1	19	19	2,850									
4" x 6"	20 Oval	6	19	114		20,520	23,940	27,360	30,780	34,200				
4" x 7.25"	20 Oval	7	19	133		23,940	27,930	31,920	35,910	39,900				1.17
6" x 10"	20 Oval	11	28	308		55,440	64,680	73,920	83,160	92,400	110,880	129,360	147,840	2.70
6" x 12"	20 Oval	13	28	364		65,520	76,440	87,360	98,280	109,200	131,040	152,880	174,720	3.19
4" x 2.756" (LAB)	40 Oval	1	16	16	2,400									
4" x 6"	40 Oval	5	16	80		14,400	16,800	19,200	21,600	24,000				
4" x 7.25"	40 Oval	6	16	96		17,280	20,160	23,040	25,920	28,800				1.20
6" x 10"	40 Oval	9	23	207		37,260	43,470	49,680	55,890	62,100	74,520	86,940	99,360	2.59
6" x 12"	40 Oval	11	23	253		45,540	53,130	60,720	68,310	75,900	91,080	106,260	121,440	3.16
4" x 2.756" (LAB)	80 Oval	1	13	13	1,950									
4" x 6"	80 Oval	4	13	52		9,360	10,920	12,480	14,040	15,600				
4" x 7.25"	80 Oval	5	13	65		11,700	13,650	15,600	17,550	19,500				1.25
6" x 10"	80 Oval	7	19	133		23,940	27,930	31,920	35,910	39,900	47,880	55,860	63,840	2.56
6" x 12"	80 Oval	9	19	171		30,780	35,910	41,040	46,170	51,300	61,560	71,820	82,080	3.29
4" x 2.756" (LAB)	11 Oblong	1	26	26	3,900									
4" x 6"	11 Oblong	5	28	140		25,200	29,400	33,600	37,800	42,000				
4" x 7.25"	11 Oblong	6	28	168		30,240	35,280	40,320	45,360	50,400				1.20
6" x 10"	11 Oblong	9	38	342		61,560	71,820	82,080	92,340	102,600	123,120	143,640	164,160	2.44
6" x 12"	11 Oblong	11	38	418		75,240	87,780	100,320	112,860	125,400	150,480	175,560	200,640	2.99
4" x 2.756" (LAB)	14 Oblong	1	26	26	3,900									
4" x 6"	14 Oblong	4	24	96		17,280	20,160	23,040	25,920	28,800				
4" x 7.25"	14 Oblong	5	26	130		23,400	27,300	31,200	35,100	39,000				1.35

Die Roll Size	Capsule Size	Rows	Div	Cavities	RPM								Efficiency over a 4" x 6" machine @ 5 RPM	
					2.5	3.0	3.5	4.0	4.5	5.0	6.0	7.0		8.0
6" x 10"	14 Oblong	8	38	304		54,720	63,840	72,960	82,080	91,200	109,440	127,680	145,920	3.17
6" x 12"	14 Oblong	9	38	342		61,560	71,820	82,080	92,340	102,600	123,120	143,640	164,160	3.56
4" x 2.756" (LAB)	16 Oblong	1	24	24	3,600									
4" x 6"	16 Oblong	4	24	96		17,280	20,160	23,040	25,920	28,800				
4" x 7.25"	16 Oblong	5	24	120		21,600	25,200	28,800	32,400	36,000				1.25
6" x 10"	16 Oblong	8	35	280		50,400	58,800	67,200	75,600	84,000	100,800	117,600	134,400	2.92
6" x 12"	16 Oblong	9	35	315		56,700	66,150	75,600	85,050	94,500	113,400	132,300	151,200	3.28
4" x 2.756" (LAB)	20 Oblong	1	22	22	3,300									
4" x 6"	20 Oblong	4	22	88		15,840	18,480	21,120	23,760	26,400				
4" x 7.25"	20 Oblong	5	22	110		19,800	23,100	26,400	29,700	33,000				1.25
6" x 10"	20 Oblong	7	32	224		40,320	47,040	53,760	60,480	67,200	80,640	94,080	107,520	2.55
6" x 12"	20 Oblong	9	32	288		51,840	60,480	69,120	77,760	86,400	103,680	120,960	138,240	3.27
4" x 2.756" (LAB)	22 Oblong	1	23	23	3,450									
4" x 6"	22 Oblong	4	22	88		15,840	18,480	21,120	23,760	26,400				
4" x 7.25"	22 Oblong	5	22	110		19,800	23,100	26,400	29,700	33,000				1.25
6" x 10"	22 Oblong	7	34	238		42,840	49,980	57,120	64,260	71,400	85,680	99,960	114,240	2.70
6" x 12"	22 Oblong	9	34	306		55,080	64,260	73,440	82,620	91,800	110,160	128,520	146,880	3.48
4" x 2.756" (LAB)	24 Oblong	1	22	22	3,300									
4" x 6"	24 Oblong	4	21	84		15,120	17,640	20,160	22,680	25,200				
4" x 7.25"	24 Oblong	5	22	110		19,800	23,100	26,400	29,700	33,000				1.31
6" x 10"	24 Oblong	7	32	224		40,320	47,040	53,760	60,480	67,200	80,640	94,080	107,520	2.67
6" x 12"	24 Oblong	8	32	256		46,080	53,760	61,440	69,120	76,800	92,160	107,520	122,880	3.05
4" x 2.756" (LAB)	38 Round	1	15	15	2,250									
4" x 6"	38 Round	7	15	105		18,900	22,050	25,200	28,350	31,500				
4" x 7.25"	38 Round	9	15	135		24,300	28,350	32,400	36,450	40,500				1.29
6" x 10"	38 Round	13	22	286		51,480	60,060	68,640	77,220	85,800	102,960	120,120	137,280	2.72
6" x 12"	38 Round	16	22	352		63,360	73,920	84,480	95,040	105,600	126,720	147,840	168,960	3.35

Average efficiency of 4" x 7.25" over 4" x 6" @ 5 RPM	1.28
Average efficiency of 6" x 10" over 4" x 6" @ 5 RPM	2.75
Average efficiency of 6" x 12" over 4" x 6" @ 5 RPM	3.30