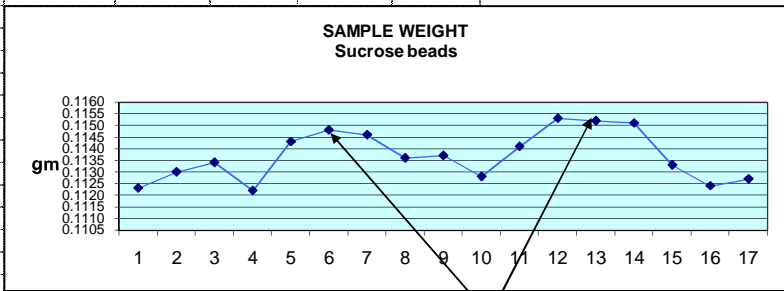


						Date	4/2/2007
Material	Sucrose coated beads			Est. Bulk Density	1.0 -1.02 gm/cc	Particle size	24-36 mesh
Desired Sample size	1. 0.1125m g, into size 5 capsules					rh	45%
Desired accuracy	Repeatability of samples @ .125gm				Pipette Size	.125 dia. PIPETTE (36 mg)	

0.125 Tip		Sample weight		Control unit settings	
Micrometer setting		g	Set point	Vacuum (in hg)	Air (psi)
0.63	10u filter	0.1123			
	No scraper	0.1130		20	12
		0.1134			
		0.1122			
		0.1143			
		0.1148			
		0.1146			
		0.1136			
		0.1137			
		0.1128			
		0.1141			
		0.1153			
		0.1152			
		0.1151			
		0.1133			
		0.1124			
		0.1127			
		0.1137	Av		
		0.1137	Mean		
		0.0011	Std Dev		



Sample weight variation due to variation in individual bead weight and location within the supply vessel. (second order effect)

Setup/calibration time was approx 10 minutes for initial calibration.

Material condition: Granular white powder of varying particulate size ranging from 24 to 36 micron with an irregular shape.

Required periodic sifting to normalize particle size distribution. Sample repeatability is somewhat dependent on particle size. (see note 4 and graph above)

1. Samples tended to pack in the pipette using the flat scraper surface. Causes tap density variation. Required double dispense cycle for some samples to clear pipette.
2. Do not recommend leveling the tip to prevent granules from locking together in the tip which prevents a complete discharge. Test performed without leveling step.
3. Recommend .125 dia. Capsule Tip for the "0" capsules. The standard tip provides an acceptable discharge without blowback but OD limits operators view of the capsule.
4. Bead or granule shape variation and bead to bead weight variation were the cause of most of the sample deviation.
5. Filled 5 capsules after mounting in holder. Average weight of fill = 0.1119 gm

Average weight of fill = 0.1119 gm
Average cycle time = 4 seconds per capsule (After calibration)
Average bead weight = .4mg
Bead weight range = .3 to .5 mg