

[Fig. 1]

		16030/AD2	16030/AK3 1%	16030/AK5 2%	16030/AK5 3%	16030/AK5 4%	16030/AK3 5%
	Raw material (%)						
S	SOD. CITRATE	0,19%	0,20%	0,20%	0,20%	0,20%	0,20%
S	GELLAN GUM	1,73%	1,78%	1,78%	1,78%	1,78%	1,78%
S	BEEF GELATIN	3,86%	3,96%	3,96%	3,96%	3,96%	3,96%
S	SORBITOL	0,96%	0,99%	0,99%	0,99%	0,99%	0,99%
S	GLYCERIN	0,96%	0,99%	0,99%	0,99%	0,99%	0,99%
S	DEXTRIN	10,60%	10,90%	10,90%	10,90%	10,90%	10,90%
S	TARTRA. DYE	0,01%	0,01%	0,01%	0,01%	0,01%	0,01%
S	BLUE DYE	0,05%	0,05%	0,05%	0,05%	0,05%	0,05%
F	MCT	57,51%	26,49%	26,49%	26,49%	26,49%	26,49%
F	SUNFL. OIL	0,00%	24,97%	24,97%	24,97%	24,97%	24,97%
F	MENTHOL	17,47%	20,81%	20,81%	20,81%	20,81%	20,81%
F	FLAVOR. COMP.						
		3,64%	5,83%	5,83%	5,83%	5,83%	5,83%
F	SILICA	1,50%	1,50%	1,50%	1,50%	1,50%	1,50%
F	WATER	1,50%	1,50%	1,50%	1,50%	1,50%	1,50%
	Total	100,00%	100,00%	100,00%	100,00%	100,00%	100,00%

[Fig. 2]

		16030/AD2	16030/AK3 1%	16030/AK5 2%	16030/AK5 3%	16030/AK5 4%	16030/AK3 5%
	Dry deposit (&)	4	1	2	3	4	5
	Ratio (PVCD/TEC) %	100/0	90/10	90/10	90/10	90/10	90/10
	Dry matter of preparation	20,0%	20,0%	20,0%	20,0%	20,0%	20,0%
SUSPENSION of PVCD		39,2%	35,3%	35,3%	35,3%	35,3%	35,3%
TRIETH. CITRATE			2,0%	2,0%	2,0%	2,0%	2,0%
WATER		60,8%	62,7%	62,7%	62,7%	62,7%	62,7%
	Total	100,0%	100,0%	100,0%	100,0%	100,0%	100,0%

[Fig. 3]

		16030/AD2	16030/AK3 1%	16030/AK5 2%	16030/AK5 3%	16030/AK5 4%	16030/AK3 5%
Film coating solution	Dry matter (%)	20	20,2	20,2	20,2	20,2	20,2
	Viscosity (cP)	0,9	2	2	2	2	2
	pH at 20°C	2	2,5	2,5	2,5	2,5	2,5
	Density (g/cm ³)	1,088	1,088	1,088	1,088	1,088	1,088
Capsule before film coating	Mean weight (mg)	21,60	21,52	21,52	21,52	21,52	21,52
	Diameter (mm)	3454	3511	3511	3511	3511	3511
	sd	21	43	43	43	43	43
	Hardness (kgF)	1,43	1,54	1,54	1,54	1,54	1,54
	sd	0,15	0,21	0,21	0,21	0,21	0,21
	Deformation ratio (%)	23	23	23	23	23	23
	sd	5	3	3	3	3	3
	Sound at break (db)	85	88	88	88	88	88
Capsule after film coating	sd	3	2	2	2	2	2
	Mean weight (mg)	22,60	21,70	21,70	22,04	22,38	22,68
	Diameter (mm)	3491	3529	3544	3573	3563	3550
	sd	37	51	53	59	47	42
	Hardness (kgF)	1,44	1,60	1,62	1,64	1,67	1,64
	sd	0,14	0,15	0,16	0,20	0,23	0,17
	Deformation ratio (%)	29	23	23	23	24	24
	sd	3	2	2	2	3	2
Final capsule after immersion test at 60°C for 6 minutes	Sound at break (db)	87	87	88	87	86	87
	sd	2	3	3	2	3	2
	Hardness (kgF)	1,28	0,50	1,60	1,68	1,83	1,97
	sd	0,15	0,20	0,21	0,22	0,18	0,14
	Deformation ratio (%)	26	89	34	34	35	35
	sd	3	1	4	4	3	2
Final capsule after dissolution test at 37°C for 20 minutes	Sound at break (db)	84	0	86	82	87	88
	sd	2	0	2	19	2	2
	Hardness (kgF)	1,33	0,47	1,33	1,54	1,53	1,82
	sd	0,41	0,18	0,38	0,34	0,15	0,16
	Deformation ratio (%)	25	89	37	26	25	24
	sd	14	1	26	11	2	2
	Sound at break (db)	82	0	76	91	89	90
	sd	20	0	25	3	9	1

[Fig. 4]

[illegible]

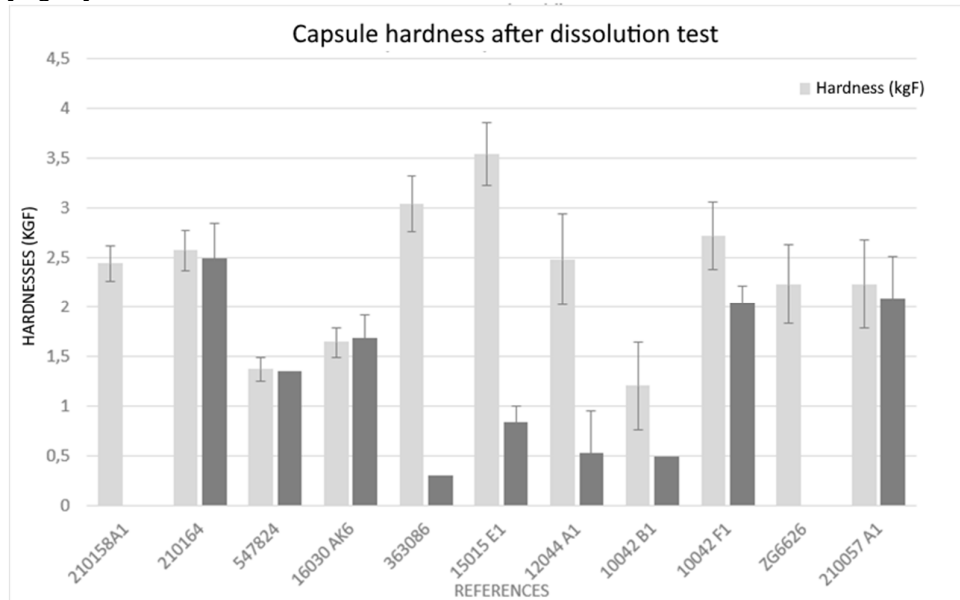
[Fig. 5]

[illegible]

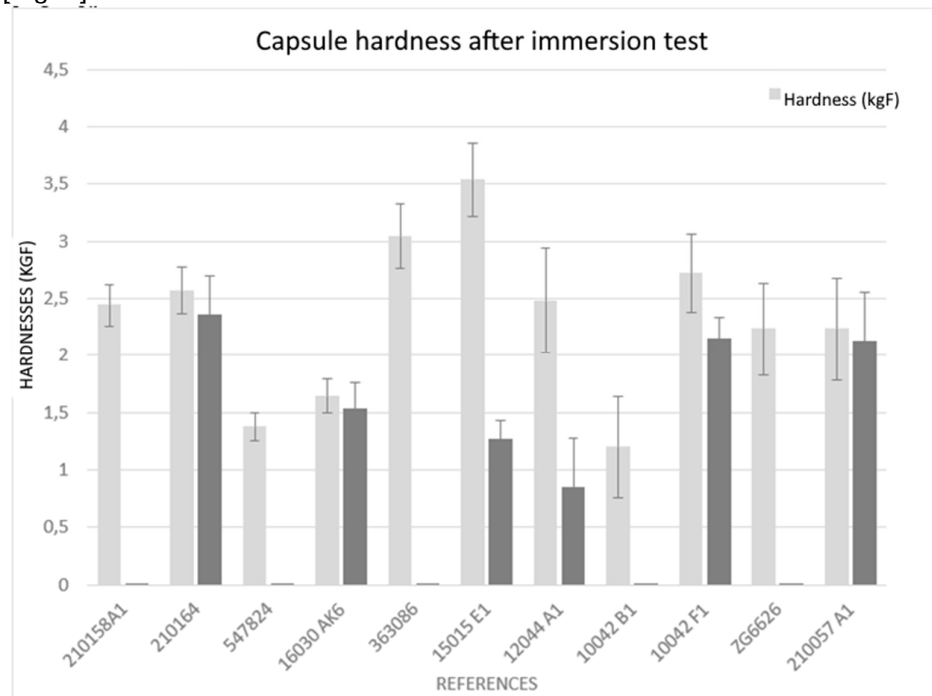
[Fig. 6]

		16030/AK3 5%	12044/A1	10042/B1	10042/F1	15015A1	15015/B1	15015/E1
Film coating solution	Dry matter (%)	20,2	11	13,1	14,1	50	50	4,7
	Viscosity (cP)	2	5	3	20	<500	<1000	1000
	pH at 20°C	2,5	7	6,9	10	8	8,5	4
	Density (g/cm ³)	1,088	1,1	1,02	1,1	1,03	1,02	1,05
Capsule before film coating	Mean weight (mg)	21,52	44,1	35,73	36,3	44,1	44,1	44,1
	Diameter (mm)	3511	4330	4150	4094	4330	4330	4330
	Sd	43	20			20	20	20
	Hardness (kgF)	1,54	3,05	1,71	1,71	3,05	3,05	3,05
	sd	0,21	0,29	0,25	0,25	0,29	0,29	0,29
	Deformation ratio (%)	22,7	41	28	28	41	41	41
	Sd	3	4	4	4	4	4	4
	Sound at break (db)	88	90	84	84	90	90	90
	sd	2	1	3	3	1	1	1
Capsule after film coating	Mean weight (mg)	22,68	40,4	35,8	41,1	45,9	45,7	45,1
	Diameter (mm)	3550	4293	4157	4358	4443	4403	4351
	sd	42	35	113	41	28	33	30
	Hardness (kgF)	1,64	2,48	1,21	2,73	3,20	2,78	3,52
	sd	0,17	0,46	0,44	0,36	0,55	0,24	0,32
	Deformation ratio (%)	24	19	12	23	28	33	27
	sd	2	2	4	2	5	3	2
	Sound at break (db)	87	92	74	92	94	93	96
	sd	2	4	26	2	2	1	1
Final capsule after immersion test at 60°C for 6 minutes	Hardness (kgF)	1,97	0,84	Non conform	2,16	Non conform	Non conform	1,26
	sd	0,14	0,43		0,19			0,17
	Deformation ratio (%)	35	81		38			90
	sd	2	13		3			0
	Sound at break (db)	88	0		49			0
	sd	2	0		35			0
Final capsule after dissolution test at 37°C for 20 minutes	Hardness (kgF)	1,82	0,53	0,49	2,04	Non conform	2,36	0,53
	sd	0,16	0,09	0,12	0,21		1,15	0,20
	Deformation ratio (%)	24	89	90	27		62	84
	sd	2	1	0	3		24	12
	Sound at break (db)	90	0	0	87		62	0
	sd	1	0	0	4		22	0

[Fig. 7]



[Fig. 8]



[Fig. 9]

	MINT CAPSCOAT 3500					
Characteristic						
Reference	16030/AK3 1%	16030/AK6	16030/AK5	16030/AK1	Extrapolation	Extrapolation
Film coating	PVDC	PVDC	PVDC	PVDC		
Mean weight (mg)	21,52	21,40	21,30	21,37	21,37	21,37
Thickness (mm)	3,511	3,483	3,492	3,436	3,436	3,436
Bare capsule vol. (µl)	22,7	22,1	22,3	21,2	21,2	21,2
Coating parameters						
Theoretical dry deposit (%)	1,00%	2,00%	3,00%	5,00%	15,00%	20,00%
Final weight/DD (mg)	21,735	21,828	21,939	22,439	24,576	25,644
Final thickness (mm)	3,517	3,496	3,512	3,472	3,552	3,596
Thickness of coating (µm)	3,10	6,62	10,06	17,86	57,97	79,76
Ratio (thickness x2)/capsule size	0,18	0,38	0,58	1,02	3,31	4,56

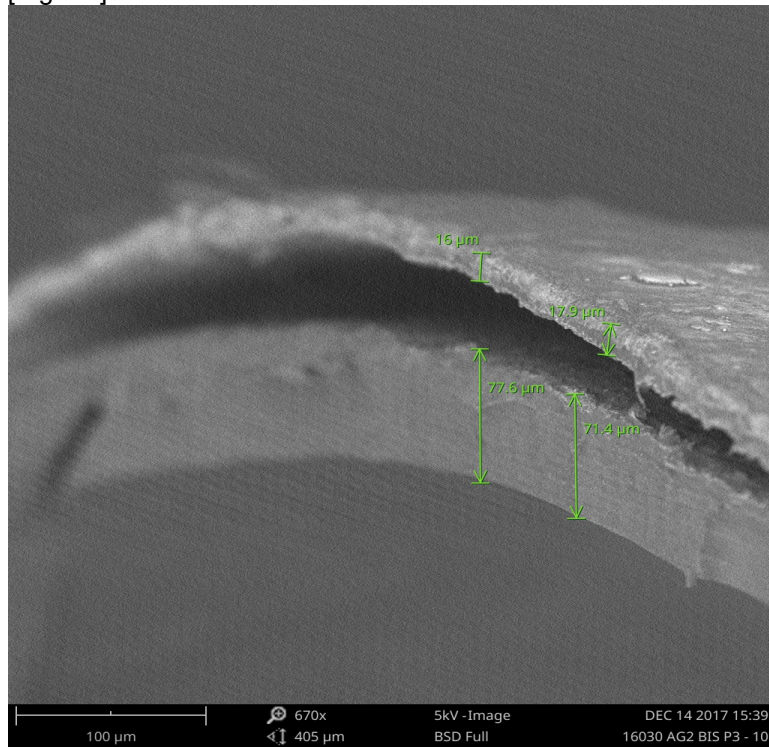
[Fig. 10]

	CITRON CAPSCOAT 5000					
Characteristic						
Reference	210164A1	210164	Extrapolation	Extrapolation	Extrapolation	Extrapolation
Film coating	PVDC	PVDC				
Mean weight (mg)	63,6	63,6	63,6	63,6	63,6	63,6
Thickness (mm)	5,049	5,049	5,049	5,049	5,049	5,049
Bare capsule vol. (µl)	67,4	67,4	67,4	67,4	67,4	67,4
Coating parameters						
Theoretical dry deposit (%)	1,00%	2,00%	3,00%	5,00%	15,00%	20,00%
Final weight/DD (mg)	64,236	64,872	65,508	66,780	73,140	76,320
Final thickness (mm)	5,058	5,068	5,078	5,098	5,209	5,269
Thickness of coating (µm)	4,43	9,36	14,36	24,60	80,03	110,20
Ratio (thickness x2)/capsule size	0,18	0,37	0,58	0,98	3,20	4,41

[Fig. 11]

	PEPPERMINT CAPSCOAT 4200						
Characteristic							
	Extrapolation	Extrapolation	Extrapolation	Extrapolation	10042/F1	Extrapolation	Extrapolation
Film coating					ETHYL CELLULOSE		
Mean weight (mg)	36,3	36,3	36,3	36,3	36,3	36,3	36,3
Thickness (mm)	4,094	4,094	4,094	4,094	4,094	4,094	4,094
Bare capsule vol. (µl)	35,9	35,9	35,9	35,9	35,9	35,9	35,9
Coating parameters							
Theoretical dry deposit (%)	1,00%	2,00%	3,00%	5,00%	15,00%	20,00%	39,00%
Final weight/DS (mg)	36,663	37,026	37,389	38,115	41,745	43,560	50,457
Final thickness (mm)	4,102	4,110	4,119	4,137	4,233	4,285	4,504
Thickness of coating (µm)	3,87	8,14	12,49	21,37	69,35	95,41	204,94
Ratio (thickness x2)/capsule size	0,18	0,39	0,59	1,02	3,30	4,54	9,76

[Fig. 12]



[Fig. 13]

