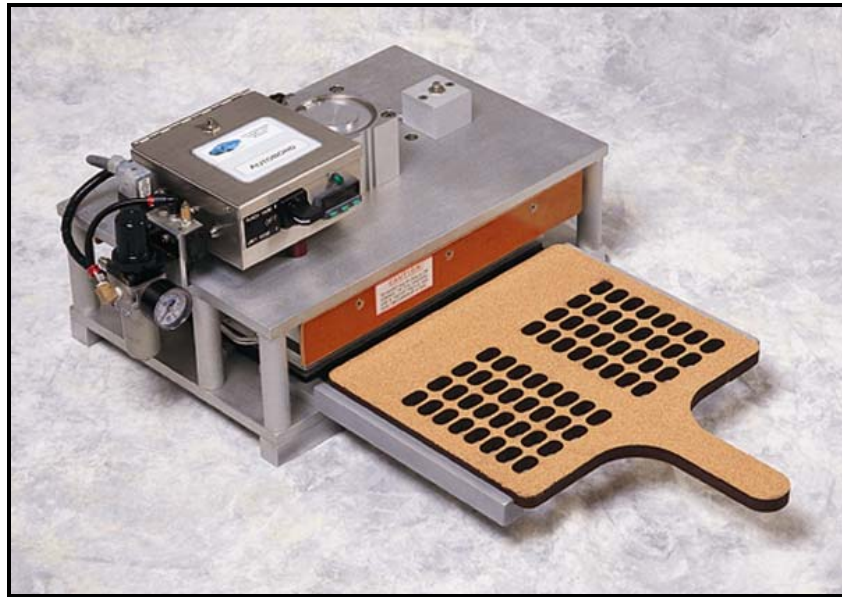




MTS AUTOBOND™

OPERATIONS MANUAL



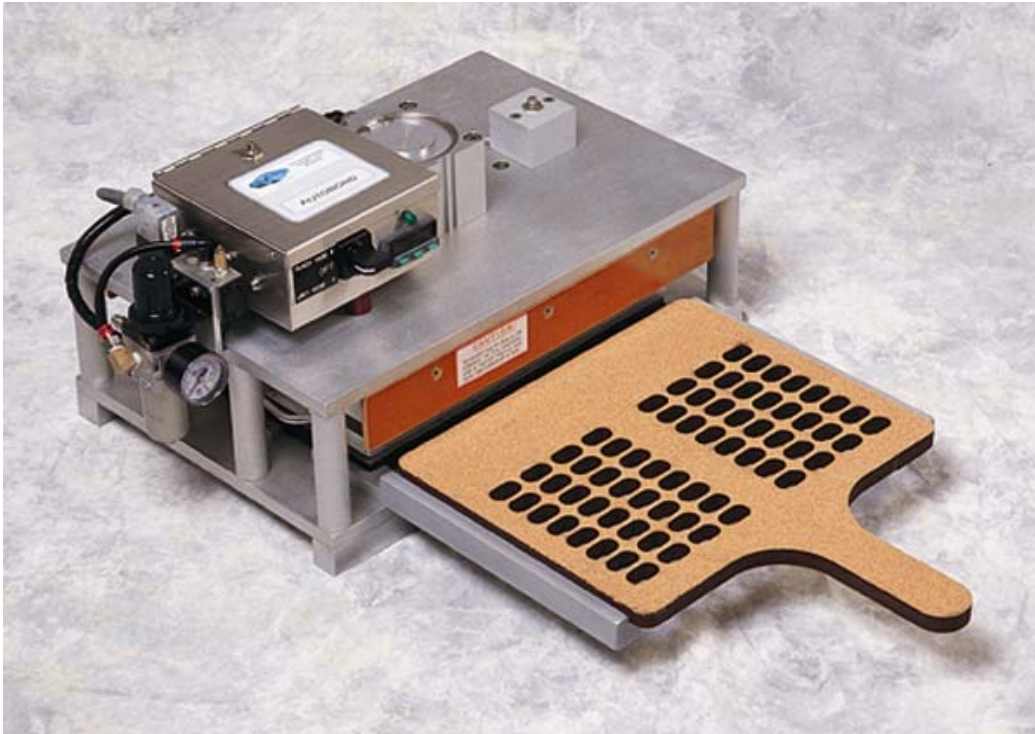
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1. Introduction and Features of the Autobond

MTS Autobond Heat sealers are an innovative product for automated heat sealing of medication punch cards. Unlike some of the sealing problems associated with manual presses, the MTS Autobond heat sealer consistently delivers a permanent seal.



2. Installation

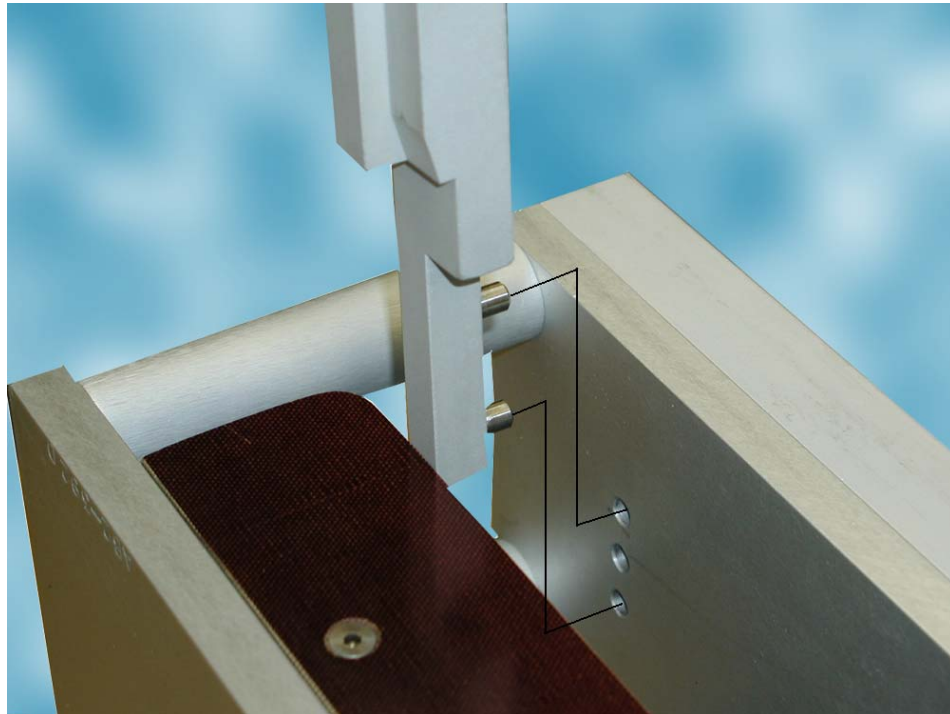
The Autobond has been securely packed for safe shipping. It is recommended that the box be saved for any future re-shipping needs.

Enclosed in the box are the Autobond, guide rails and corks (as per order).

Carefully remove the machine and components and place it on a sturdy level work surface, where it will be used, within reach of an 110v electrical outlet and compressed air outlet providing a minimum of 80psi.

The Autobond should be on a level work surface in an area free from distractions, having the bulk medications close to hand would be an advantage.

1. Fit the guide rails. They are placed on to the bottom plate of the sealer. Each rail is marked either R (right) or L (left). Push the two dowels into the holes and secure using the screws provided from the underside. Repeat for other side.



The paddle now fits onto the guide rails.

2. Plug the machine into the 110v and compressor outlets nearest the machine. Extension cords are not recommended.

3. Safety

The Autobond should be on a level work surface in an area free from distractions, preferably against a wall, near an electrical outlet. Close proximity to the bulk medications and to the area in which they will be stored after prepackaging, would also be beneficial.

As with any piece of electrical and air driven equipment, the safe operation requires the operator to observe and follow safe operating practices. Please report all unsafe operating practices to your immediate supervisor for local resolution.

Please ensure that you turn off and unplug the machine while carrying out any maintenance.

<p>Note: Internal surfaces are hot during operation.</p>

4. Operating the Autobond

1. Turn on the Autobond and wait for the temperature to increase to 300°F. (approximately 10 minutes)
2. Select corks suitable for the blisters you will be filling, i.e., 30 / 60 or 90 day
3. Select Seal time using the toggle switch on the side. 8 seconds for card and blisters. 3 seconds for foil and blister.
4. Fill blisters and place onto cork paddle.
5. Ensure cards are closed of foil is in place.
6. Slide the paddle into the Autobond using the handle. The paddle must travel all the way in to the stop. The paddle can jam if the sealer is activated while the paddle is still resting on the guide rails. This is potentially damaging to the Sealer.
7. Simultaneously push the buttons on either side of the Autobond. This lowers the heater plate on to the blisters. After the specified time (3 or 8 seconds), the heat plate is automatically raised.
8. When the Autobond has released the card, remove the paddle and take out the sealed cards.

<p>DO NOT PLACE HANDS INTO THE MACHINE</p>

4.1 Temperature Control Setting

The digital readout from this is the current temperature of the heat sealer.

The Set temperature, i.e., the temperature that the control is trying to maintain, is fixed at the factory; it will be 300°F.

- To view this temperature press and hold the left hand (LH) button on the calibration control.
- To change this setting;
 - Holding down the LH button, use the “Δ” and “∇” keys, this sets a new desired temperature.
 - When the desired temperature is displayed, release the keys. This is the new ‘set’ temperature.

If you try and set this too far away from the factory setting, then, when you release the LH key, ‘AL’ will be displayed in the readout. This means you have adjusted it too far. Please follow the same procedure to re-set.

4.2 Pressure Setting

The pressure is factory set to 100psi. If it requires adjustment, then lift the pressure adjustment knob, it will click up about 1/8 inch. Turning the knob clockwise increases the pressure; anti-clockwise decreases the pressure. Pushing the knob back down locks the pressure to current reading.

The air compressor must provide a minimum of 80psi at all times.

5. Routine Maintenance

5.1 Weekly Maintenance

- Drain air regulator bowl of any condensation / moisture.
 - To do this, place a container under the reservoir, and press on the nipple on the bottom, releasing any water into the container.
- Drain compressor of moisture.
 - With a container at the spout of the tap on the air tank, open the valve, any water will be forced into the container. Continue until only air comes out of the tap.

5.2 Cleaning

1. Ensure the machine is turned off and unplugged before cleaning the machine.
2. Let the machine cool down.
3. Clean the machine with a damp rag soaked in a little alcohol
4. Do not soak any part of the machine.
5. Leave machine to dry for approximately ½ an hour before using again.

6. Troubleshooting

6.1 Blister or Medication Sealed Directly to Heater Plate

1. The material will need to be removed as soon as possible from the heating plate.
2. Turn off and unplug the machine.
3. Remove the paddle and sealing pad.
4. **Using protective gloves.** Try to scrape off as much of the material with a non-metallic spatula and brass or stainless steel wire brush. Remove any debris.
5. Return sealing pad.
6. Plug in and turn on.

Seal 3-4 empty cards to further remove any residue

6.2 Cards are not Sealing Adequately

Check bottom of heat plate for melted material.

If the heater plate has been contaminated, follow above procedure.

If the plate is clean:

1. Check temperature, pressure and seal time.
2. The temperature should read at least 290F (Wait at least 10 minutes).
3. The air pressure on regulator should read at least 80 PSI.
4. The timer should be sealing for at least 3 or 8 seconds, as selected.

If any of the above items are incorrect, **please contact MTS. See 'Contacts' page.**

6.3 Loss of Power

The Calibration control green indicator does not laminate after turning on the machine or the sealer has stopped functioning, then the fuse may need to be replaced.

1. Unplug the Autobond.
2. Unscrew the fuse holder, located on the back of the control box.
3. Remove fuse, inspect, replace if necessary. Use Fuse of same value only - 0.75 Amp.
4. Replace Fuse holder cap.
5. Plug Sealer back in and turn on

6.4 Paddle has Jammed

If the paddle is still resting upon the rails when the sealer is actuated, then the upper heat seal platen may become jammed, trapping the paddle. This is potentially damaging to the sealer.

To correct this situation

1. Remove sealer from power and air sources.
2. The air cylinder (central on top of the machine) is held in place by 4 screws. These need to be loosened by 3 to 4 turns. This will allow you to remove the paddle.
3. Re-tighten the screws.
4. Connect the Autobond to the power and air sources.
5. If the sealer was not permanently damaged, it should now be operational again.

**IF YOU ARE EXPERIENCING ANY PROBLEMS,
PLEASE DO NOT HESITATE TO CONTACT MTS.**

Contact Information on Page 7

7. Contact Information

Technical Service (USA)	800-671-0470
Technical Service e-mail (USA)	technicals@mts-mt.com
Customer Service (USA)	800-845-0053

8. Technical Specifications

8.1 Power Supply

110 Volts 60 Hz

Autobond II – 7 Amp

Autobond III – 11 Amp

Autobond IV – 14 Amp

8.2 Air Supply

Operating Pressure 80 to 120 PSI

Average Usage: Autobond II – 0.29 CFM @ 100 PSI

Autobond III – 0.44 CFM @ 100 PSI

Autobond IV – 0.70 CFM @ 100 PSI

8.3 Overall Dimensions (Approximate)

	<u>Autobond II</u>	<u>Autobond III</u>	<u>Autobond IV</u>
Width:	12.25"	18"	21.5"
Length:	21.5"	21.5"	24"
Height:	11"	11"	11"
Weight:	55lbs	77lbs	98lbs

8.4 Seal Plate Operating Temperature

300F

8.5 Seal Time

8 or 3 Seconds - Selectable