

The below information pertains to the lids on a roll (LOR) module for the unit dose versions of the DOSIS tower. Some of the identified processes should be performed at every roll change and others should be performed periodically to ensure continued operation of your DOSIS towers.

How to Load Material on the LOR

*** CAUTION:** Failure to use a new core on the take-up shaft each time a new roll is installed on the supply shaft can cause the module to fail to reach the end of the new roll.

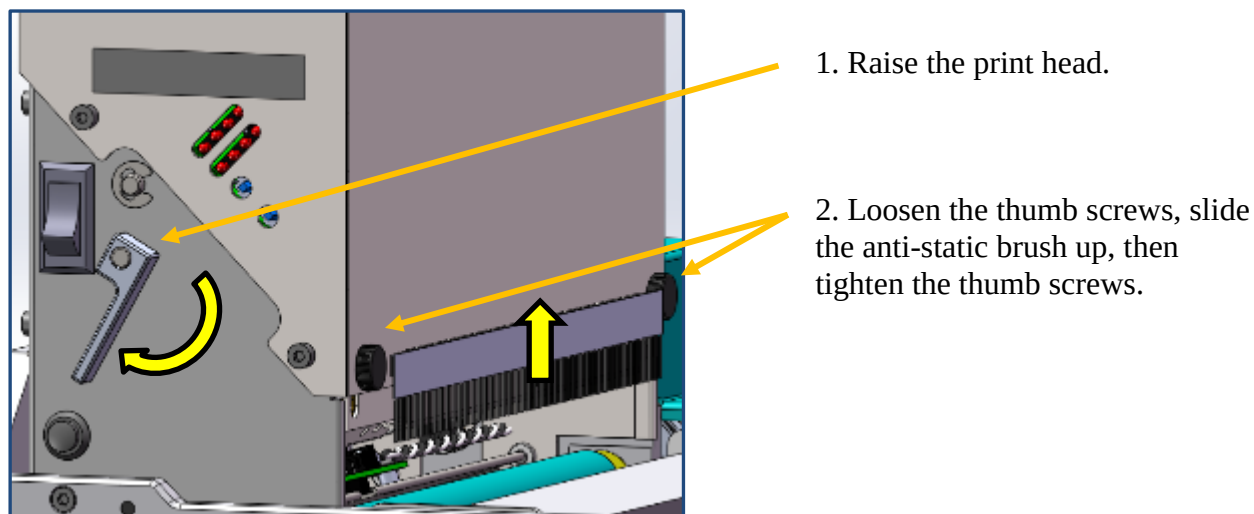


Figure 1

3. If replacing an empty roll, remove the take-up core with the liner and throw it away. Move the empty supply core from the supply shaft to the take-up shaft.*
4. Install a new or partial roll of lids onto the supply shaft.
5. Route the material through the paper guides, over the platen roller, and pull enough material through to extend across the sealer plate.
6. Keeping the first lid on the roll, remove the second and third lids from the liner and set one of them aside for step 9, below.
7. Continue to route the material under the peeler roller, to the right and over the stationary roller, then to the empty take-up core.
8. While holding the first lid against the take-up core, rotate the supply shaft counterclockwise to remove slack in the material.
9. Attach the first lid to the take-up core using the other lid you set aside earlier in step 6.
10. Lower the print head by rotating the lever to the right until it detents into the “locked” position. See figure 1.

11. After “locking” the print head, “Present” a lid using the small buttons to the right of the print head lever. Once the lid is presented, remove it from the liner by hand, then “Retract” the system.
12. Loosen the thumb screws, slide the anti-static brush down, then tighten the thumb screws.
13. Close the packager door and hit “Run” on the touchscreen.

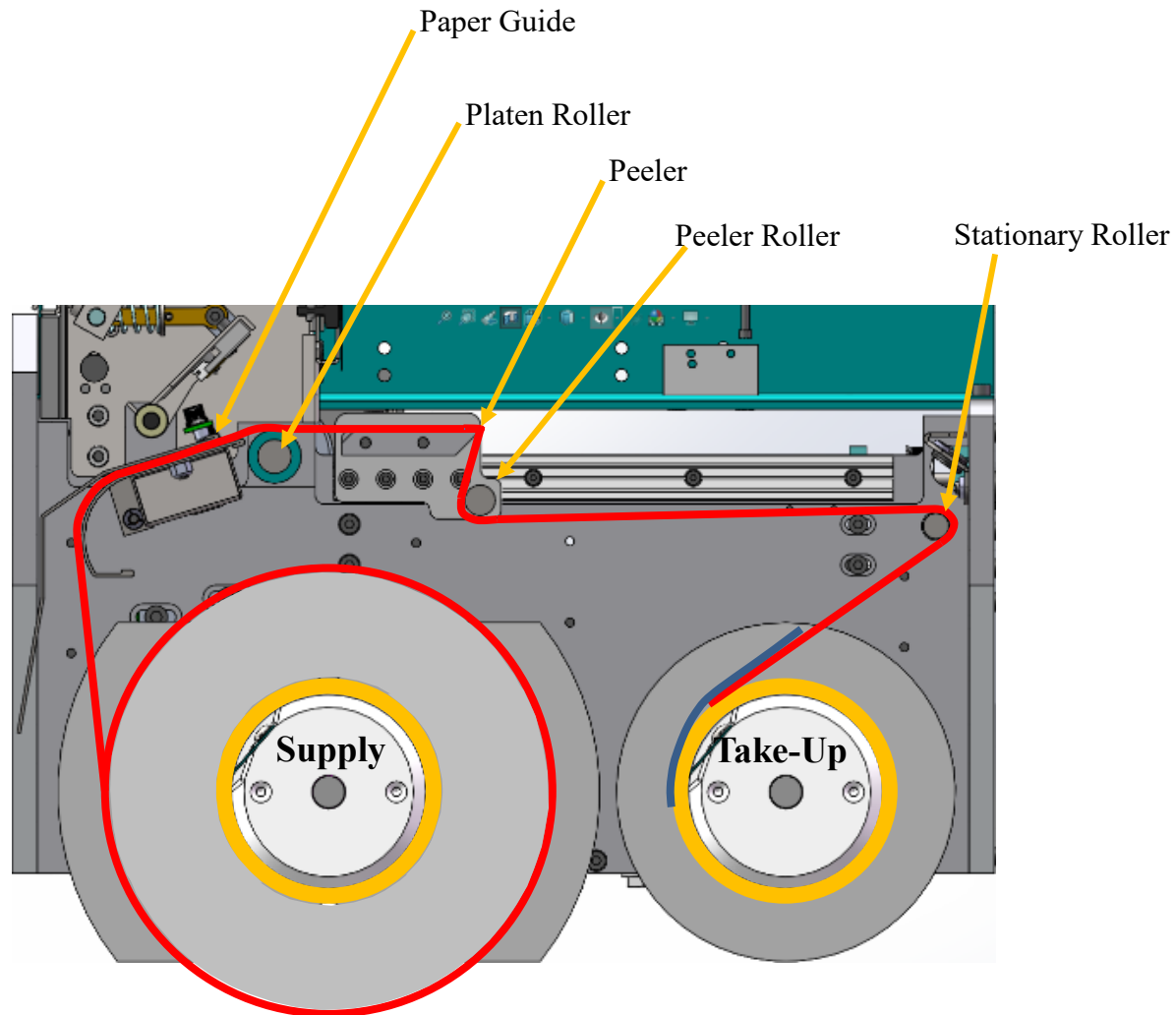


Figure 2

Cleaning the Print Head and Printer Roller

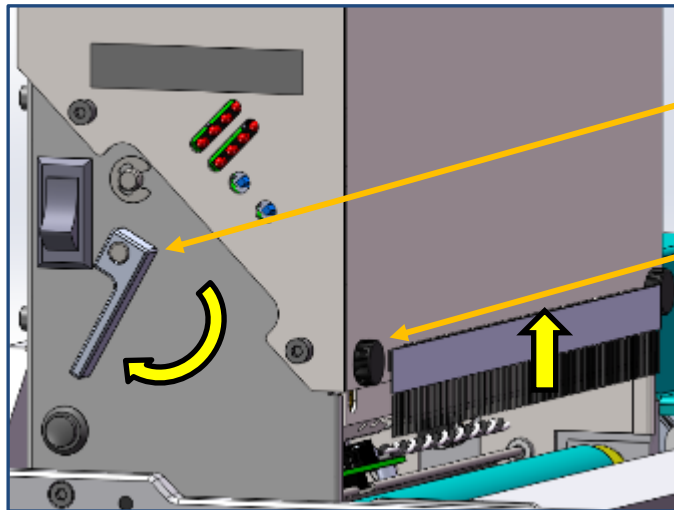


Figure 3

3. Clean the area of the print head, boxed in red below, with isopropyl alcohol and a foam swab similar to the one shown to the right. Be sure that all oil, adhesive, and debris are completely removed. Wipe off any excess alcohol with a dry swab.



Foam Swab

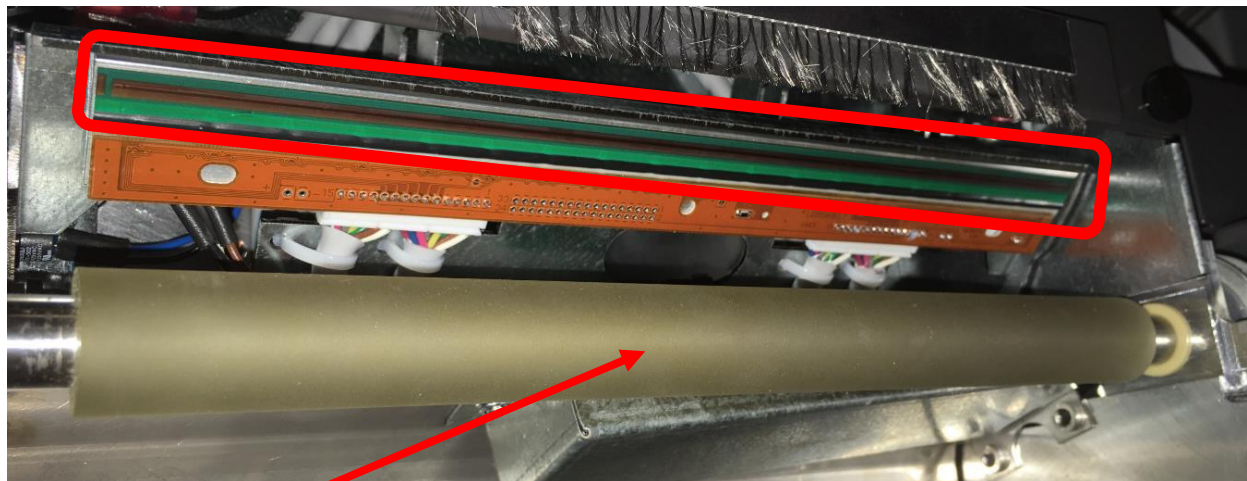


Figure 4

4. For the printer roller, use isopropyl alcohol on a lint free cloth or foam swab to remove all oil, adhesive, and debris from it. Be sure to clean the entire roller, not just the visible portion presented at opening. The roller is designed to be spun by hand, with some resistance, so all areas can be cleaned. Allow the alcohol to dry.

5. Once all the alcohol has evaporated, load the material according to the instructions.

Cleaning Paper Guides

During normal operation there may be a buildup of adhesive and/or small bits of paper fiber, dust, or other trash in and along the pathway between the supply core and the take up core. The below information provides instructions on how to clean these areas of the LOR module. At a minimum, we recommend that these procedures be performed whenever the lid roll is changed out.

1. In the case where adhesive from the lids has built up in the paper guides, a lint free cloth damp with isopropyl alcohol, can be gently slid between the paper guides in the direction shown below. Once the cloth is in position, work it back and forth in the paper guides to remove the adhesive build-up. Remove the cloth and wait for the alcohol to evaporate. Continue with step 2 before loading any material.

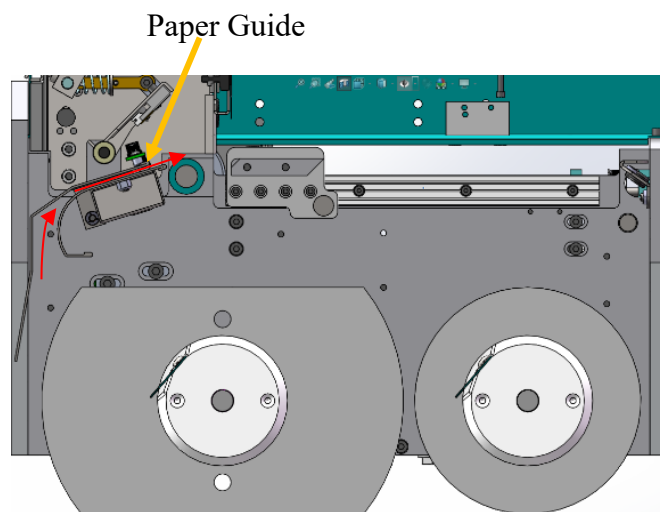


Figure 5

2. It is normal for paper fiber and dust to build up in the paper guides. If this happens it can cause issues with the print alignment on the lids. To clear debris from the paper guides, use canned air and direct the air into the gap between the upper paper guide and the printer roller (indicated below by the red line). Once cleaned, load or re-load the roll of lids.



Figure 6