

STRIPFOIL

Deblistering Technology

STRIPFOIL **DEBLISTERING MACHINES** **WORKTOP RANGE**



OPERATION MANUAL



MACHINES COVERED

Stripfoil Mini manual deblister machine

Stripfoil Mini Pro manual deblister machine

Stripfoil Moto semi-automatic deblister machine

Videos showing how to use the Stripfoil deblister machines can be viewed and downloaded at the links below:

Stripfoil Moto: <http://download.stripfoil.com/Stripfoil-Moto.mp4>

Stripfoil Mini: <http://download.stripfoil.com/mini.mp4>

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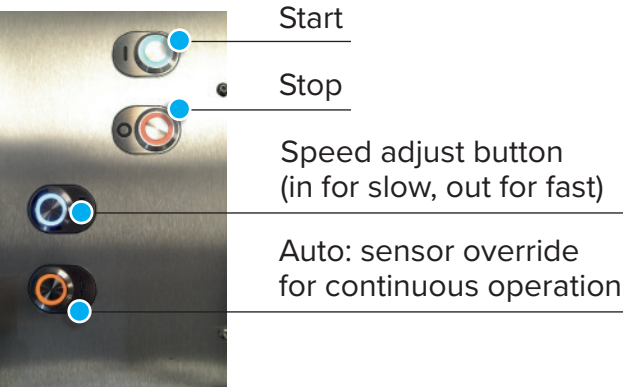
INTRODUCTION

Operate the Stripfoil deblistering device on a horizontal and stable surface. Position the rear of the machine on the edge of the table so that the empty blisters which are discharged from the back, can be collected in a bin, bag or tote. Alternatively place the empty blister collection tray behind the machine. Place the tablet collection tray inside the machine, ensuring it is pushed in fully.

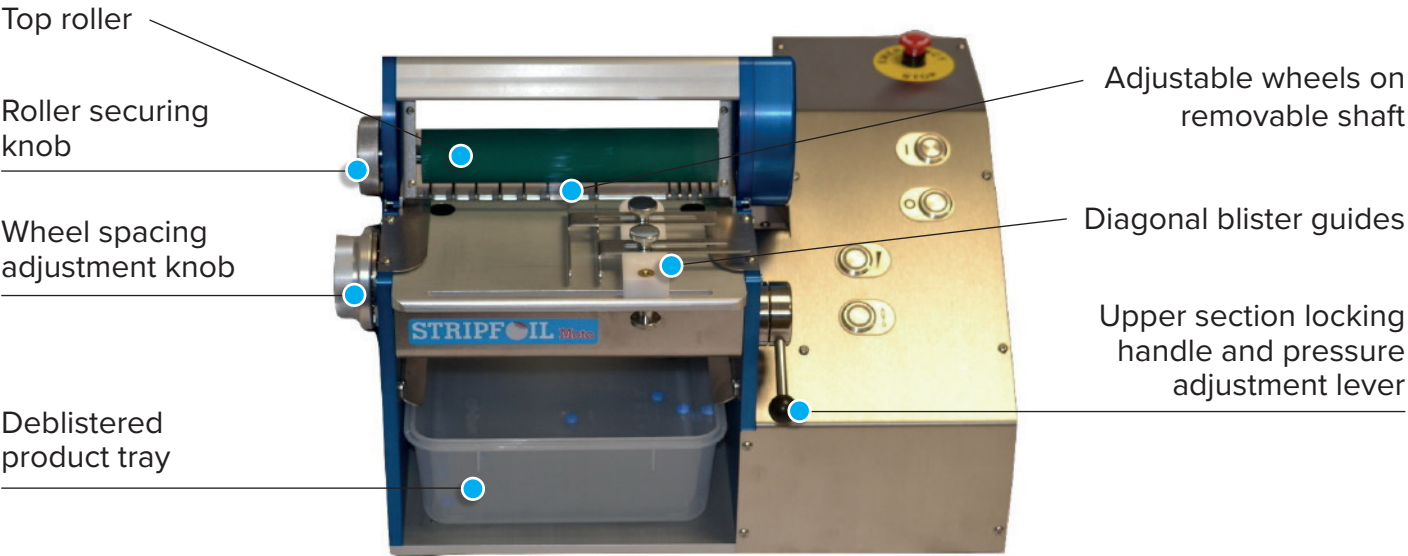
If using the Stripfoil Moto, connect to the power supply with the lead provided and turn on the switch above the power inlet.

MAIN PARTS

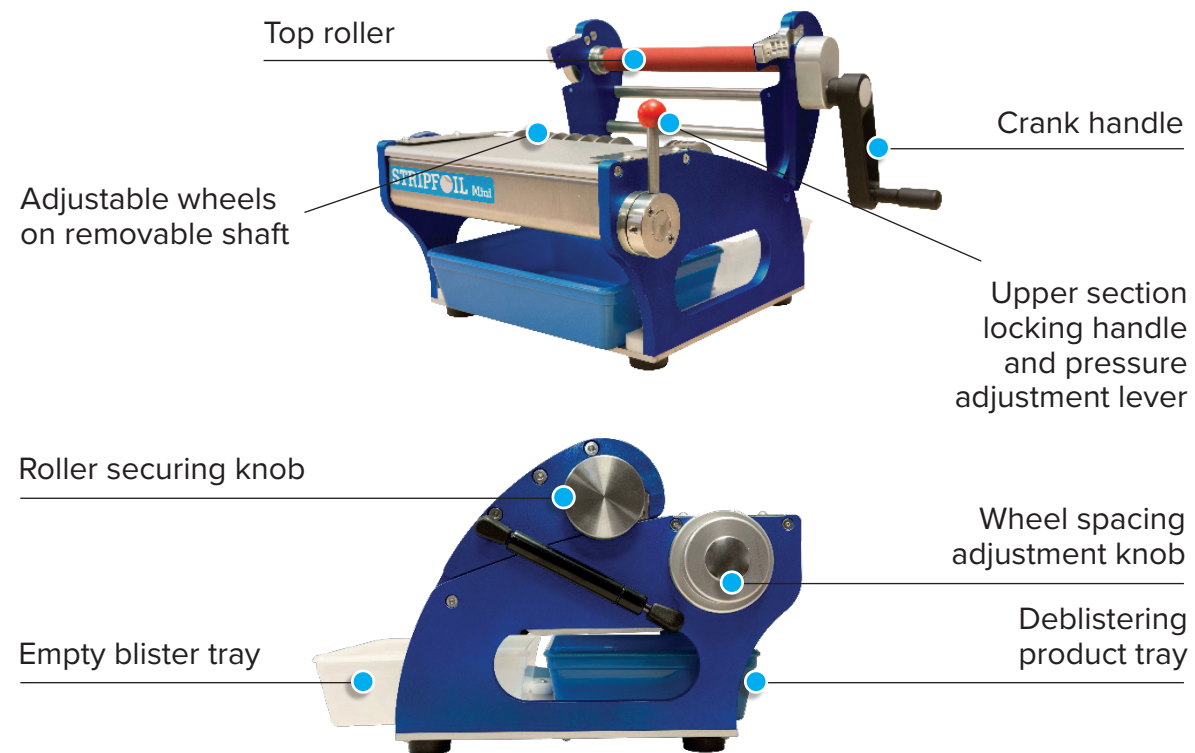
The Stripfoil machines comprise a roller secured in the top section of the deblisterer. When in operation this section is held in the closed position by the locking handle. The blisters are drawn over a number of wheels whose positions are primarily adjusted by the adjustment knob to the left of the machine. The empty blisters are discharged to the rear of the Stripfoil machine while the deblistered product falls into the tray inside the machine.



STRIPFOIL MINI PRO | STRIPFOIL MOTO



STRIPFOIL MINI



OPERATION

The Stripfoil machines recover the product by drawing the blister between the driven top roller and the adjustable wheels. The wheels should be positioned so that they support the blister between the product rows and at the edges of the blister. In operation the blister is inserted between the top roller and the wheels, product side up. The empty blister is discharged at the back of the machine and the deblistered product is collected in the tub.

Rotating the locking handle downwards locks the top of the machine in place and controls the pressure between the top roller and the blister.

Knob upwards (light pressure)

Knob outwards (medium pressure)

Knob downwards (full pressure)



OPERATING PROCESS

The following process should be used when operating the Stripfoil machine:

- 1 Move the locking handle upwards so the top section is released.
- 2 Adjust the wheel positions to the individual blister layout. See the section 'Setting the wheel positions' (page 10).
- 3 Ensure a wheel supports the right hand edge of the blister.
- 4 Lower the top section and secure in place by lowering the locking handle. The pressure on the blister can be adjusted by movement of this handle.
- 5 Ensure the Stripfoil Moto is plugged in, the emergency stop button is released and the red power light at the rear of the machine is illuminated. Press the start button, which should illuminate green.
- 6 Put the deblistered product recovery and empty blister trays in position.
- 7 Place a blister to the left hand side of the bed so that the edge of the blister is fully under the guide and the first row of product is tight against the guide on page 7.
- 8 The diagonal guides can be positioned to hold the right hand side of the blister, as shown on page 7.
- 9 Push the blister forward under the roller, keeping the first row of product against the guide. The Stripfoil Moto motor will start when the black sensor in front of the top roller detects a blister drawing the blister into the machine. On the Stripfoil Mini range this is done by turning the crank handle clockwise.
- 10 Inspect the recovered product and empty blister.
- 11 If required repeat from step 1, amending the position of the wheels or the locking handle until the blister is successfully deblistered.
- 12 If this still fails to recover the product, try with a different diameter top roller. Whilst the larger rollers are normally suited to larger or more delicate products they may also give improved recovery with other medications.
- 13 Once deblistering is complete clean the machine before recovering the next product. See the section 'Cleaning' (page 16).

SETTING THE WHEEL POSITIONS

Important:

- The deblistering wheels can only be adjusted when the top is in the raised position.
- Capsules, caplets and ovals should be fed pointed end first, see capsule picture Fig 1.
- **It is vital that the free edge of the blister is supported by a wheel.**
- To prevent the blister from twisting or moving sideways when fed, position the adjustable diagonal guides to hold the free edge of the blister.

Regularly spaced blisters

When the wheel adjustment knob is turned, the left hand wheels space evenly, enabling quick adjustment for regularly spaced blisters.

Fig 1. Place the blister on the bed of the Stripfoil so the left hand product row is tight against the guide. Rotate the wheel adjustment knob so the wheels are positioned between the product rows and also support the right hand edge of the blister.

For fine setting extend the wheels slightly further than required, then close the wheel spacing for the individual blister.

Fig 2. An alternative method is to adjust the wheels so they are in approximately the correct position and then make the final adjustments with the blister inverted on top of the wheels. Place the blister product side down on top of the wheels with the left hand row of product against the left hand wheel, then turn the adjustment knob so that

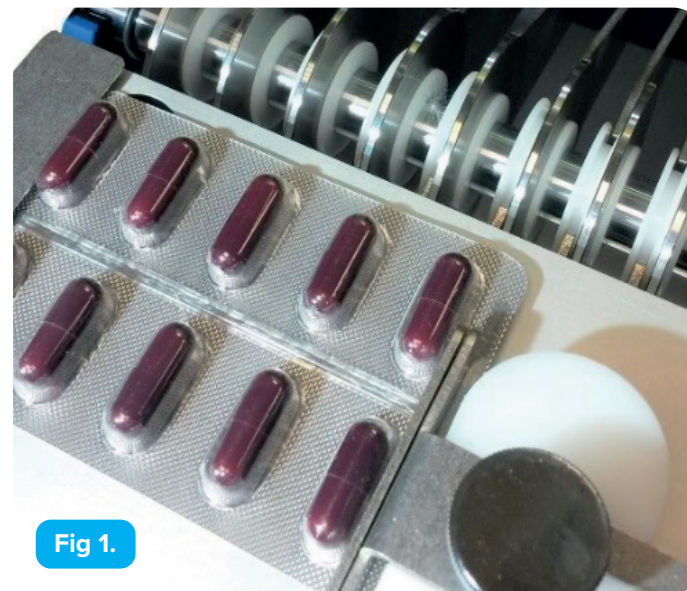


Fig 1.

the wheels are positioned between the product rows and also support the right hand edge of the blister. Remove the blister, lower the top section and feed the blister product side up. This is also a useful check that the wheels are correctly positioned.

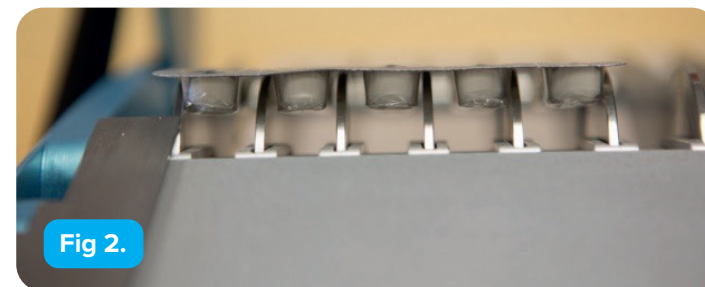


Fig 2.



Fig 3.

Fig 3. For best results position the wheels as close as possible to either side of the product row. For widely spaced blisters it may be necessary to have more than one wheel between rows.

Irregularly spaced blisters

A second bar is supplied with individually movable wheels that should be placed to the right hand side of the machine when the bar is inserted. These wheels can be moved individually for irregular blisters. When using the right hand bar close the mechanism on the left hand side fully. See the following link relating to the use of this bar:

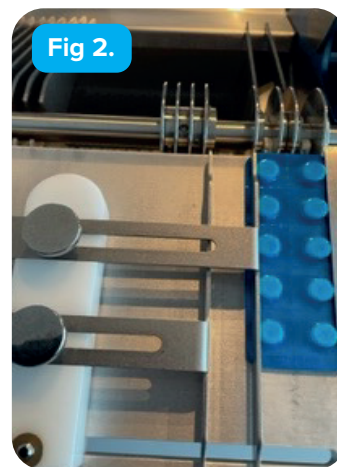
<http://download.stripfoil.com/FixedWheels-EN.mp4>

Fig 1. Separate the individual wheels and position the right hand wheel in line with the right hand side guide. Tighten this with a 2mm hex key to fix it in place. Position the blister so the right hand product row is tight against the right hand guide. Move each wheel individually so the blister is supported on either side of each product row and also supported at the left hand edge of the blister. It may be necessary to have two wheels between product rows. Fix the wheels in place using the hex key.



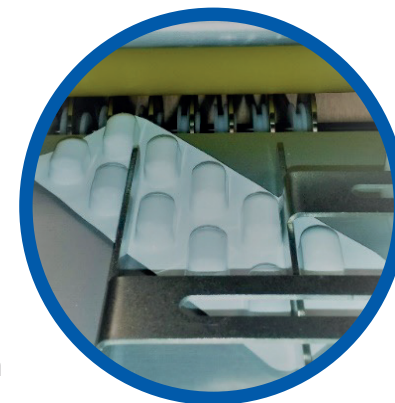
Fig 2. The diagonal guides can be unscrewed and rotated to guide the left hand side of the blister and prevent it from rotating when fed.

Fit the metal clip-on guides **under** the shaft, between the wheels, as shown in Fig 2 so the empty blister is discharged to the back of the machine and does not fall into the tablet collection bin.



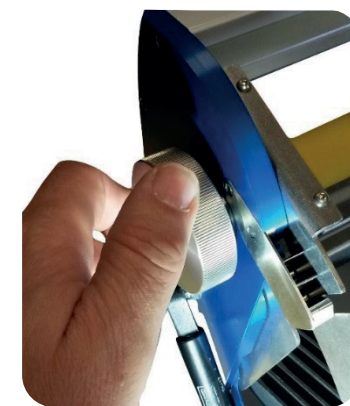
Diagonal product

Products which are lying diagonally on the blister can be recovered using the adjustable guide. Loosen the thumb screw holding the guide block in position and slide it to the right of the bed. Adjust the spacing of the support wheels as for regular blisters. However it is best not to use the far left wheel but position the left hand row of medication against the second wheel instead. Place the blister in the feeding position on the bed and adjust the two guides to suit the product spacing on the blister and to hold the blister in position when feeding. Feed the blister so that the product is at right angles to the top roller. When deblistering diagonal product using the Stripfoil Moto, press the auto button to override the sensors.



CHANGING THE TOP ROLLER

With use, the coating of the top roller will wear out. Since the roller is used predominantly on the left side, it can be reversed. With the top of the Stripfoil in the raised position, unscrew the roller securing knob, withdraw the roller and reinsert with the right hand end of the roller engaging with the housing.



If the coating of the top roller is worn out on both ends it will need replacing.

CHOICE OF TOP ROLLER

Alternative top rollers are available. While the majority of products can be recovered with the yellow roller and adjustment of the roller pressure using the locking handle, larger or more fragile medication may be more successfully deblistered with a larger diameter roller. We recommend that the green roller is used for capsules, caplets and larger oval shaped medication.

When using the larger diameter rollers, the top section will engage in a different locking position when closed.



REMOVING THE WHEEL SHAFT

Close the mechanism on the left hand side fully.

With the top of the machine in the raised position, remove the wheel section by lifting out the wheels and shaft as a unit.

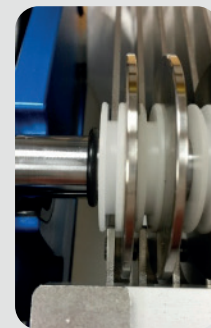
Ensure that the bar is kept horizontal when being lifted and not levered from one end as this can break the plastic elements of the wheels.



Replacing the wheels

To position the shaft and wheels, fully close the mechanism to the left hand side.

Holding the shaft in your hand, slide the wheels to the left side of the shaft. With the white plastic to the left of the wheels, position the shaft on the machine so that each plastic wheel sits into the metal support.



It is vital that the black O-rings at either end of the bar are away from the housing and closer to the position shown in the photo. Otherwise the O-rings can prevent the lid of the machine from closing.

MAINTENANCE

Normally no maintenance is required because all the rotating parts have maintenance free bearings. However, it is vital that the wheels and supporting shaft are cleaned regularly, daily as a minimum.

The fan outlet at the rear of the machine should be inspected regularly and cleared of any dust build up.

Spare parts

Spare parts can be order by contacting Pharma Engineering Ltd by email at info@stripfoil.com.

Stripfoil Moto safety

The Stripfoil Moto is fitted with the following safety features:

- A 3 amp fuse at the rear of the machine.
- An emergency stop button on the top of the control panel. The machine will not start if this is depressed.
- A clear guard to the front of the machine preventing finger trapping. This turns the motor off if lifted.

CLEANING PROCEDURE

While it is for each user to determine their own cleaning procedure based on the medication being deblistered, the following is our suggestion.

Cleaning intervals

The Stripfoil machine should be cleaned between different medication types or batches. As a minimum it should be cleaned at least once a day. If the operator finds it difficult to turn the wheel spacing adjustment knob, they should remove and clean the wheel and shaft assembly so the individual wheels move freely on the bar when tipped.

Always clean the machine after use and leave ready for the next deblistering operation or user.

Cleaning agent

We recommend using Stripfoil Advanced Wipes.

- 70:30 isopropanol
- Strong non-linting cloth

The removable parts can also be cleaned in a dishwasher.

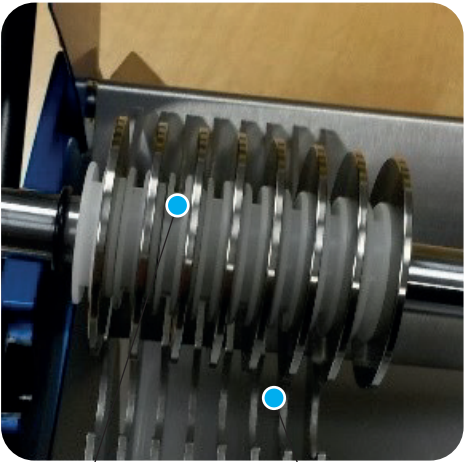
Cleaning record

Record that the deblistener machine has been cleaned and is ready for the next operation.



CLEANING METHOD

With the top of the deblisterer in the raised position and the mechanism fully closed, remove the wheel section by lifting out the wheels and shaft as a unit.



1. Clean the wheels and shaft.

2. Fully open and clean the wheel spacing mechanism.

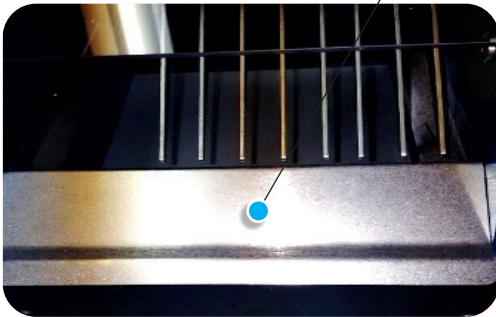
3. Clean the product collection tray and the empty blister collection tray.



4. Clean the product contact parts inside the machine.

5. Inspect and, if necessary, clean the top roller.

6. Inspect the machine for rogue tablets.



TROUBLESHOOTING

Stripfoil Moto doesn't start

- Check that the Stripfoil Moto is plugged in and the switch on the back is turned on.
- Check the emergency stop button is not pressed in.
- Check that the front clear guard is in the down position by moving it up and down.
- Remove the wheel assembly and see if the machine runs when the auto button is pressed. If the machine starts, the wheel assembly wasn't fully pushed home thus preventing the machine starting. Move the black O

rings at either end of the shaft further onto the shaft as these can block the housing.

Blister jams between the rollers

- Check that the wheels are adjusted correctly.
- Ensure the blister is pushed forward with the product tight to the guide.
- Ensure the roller is fully engaged in the housing at its left hand end.
- Use the diagonal guides to guide the free edge of the blister.

- Adjust the roller pressure using the locking handle.
- Try using a different diameter top roller.

Product is damaged

- Check that the wheels are adjusted correctly and are not too close to the product.
- Check that the wheels have not moved out of position during use.
- Ensure the blister is pushed forward with the product tight to the guide.

- Use the diagonal guides to guide the free edge of the blister, preventing it twisting.

- Adjust the roller pressure using the locking handle.

- Try feeding the blister in a different orientation.

- Try using a different top roller.

- Try using the individual wheels on the right hand side of the bed.

Product doesn't deblist

- Check that the wheels are adjusted correctly and are close enough to the product.

- Position two, or more, wheels between the product rows if possible.

- Check that the edge of the blister away from the guide is supported.

- Ensure the blister is pushed forward with the product tight to the guide.

- Ensure the top section is locked closed and in the correct position for the roller size.

- Adjust the roller pressure using the locking handle.

- Try deblistering the blister in a different orientation.

- Try deblistering using the individually set right-hand wheels.

- Try using a different top roller.

Wheels don't move smoothly when adjusting

- Remove the wheels and shaft and clean thoroughly.



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