

# User Guide

# AutoSealer 1001

Operation & Service



**USER GUIDE**  
is available on  
our website @

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# 1 Introduction

Rx Systems, Inc. is very pleased you decided to join the growing number of AutoSealer owners.

Operating the AutoSealer, you will appreciate the basic but efficient design of quality components. With proper care and maintenance you can expect years of trouble free service.

This User Guide will make you familiar with the features, operating principals, procedures, necessary maintenance and troubleshooting of the Rx Systems AutoSealer.

**Note: Please keep all packaging materials. REPLACEMENT PACKAGING is EXPENSIVE and REQUIRED for shipping.**

## 2 Specifications, Features

### 2.1 Specifications

Overall Dimensions:

Width: 14-1/2”

Depth: 16-1/2” w/o slide rails

Height: 13-5/8”

Weight: 85 lbs.

Electrical: 115 volt, 12 amp, 1380 watts, 60 Hz

### 2.2 Features

- Temperature, Time and Pressure are controlled for a consistent seal.
- 2-card design with the added flexibility of using either sealing trays on pressure board, 2 single paddles or 1 double paddle.
- Fewer moving parts means less maintenance.
- No compressor means less noise – no tubes and lines to install.
  - Just plug it in and you are ready to go.
- Safe two-handed operation.
- Emergency shutoff.
- Air cooled outer shell limits access to heat plate for safety.
- Adjustable sealing time, 1-10 seconds.
- Unique paddles reduce moisture during seal.

### 3 Identification of Controls

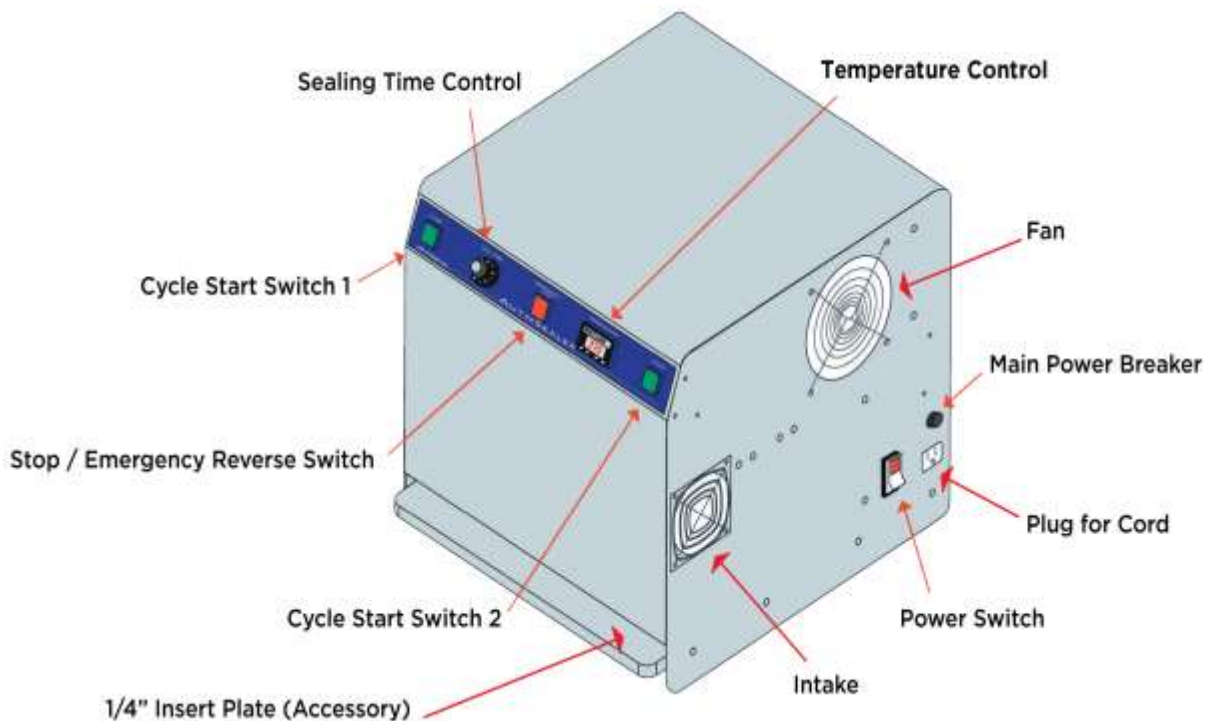
**Power Switch:** Turn main power off and on.

**Timer:** 1 to 10 second sealing times – set it once and forget it.

**Thermometer/Thermostat:** Digital thermometer gives temperature readout. Thermostat maintains heat setting in one unit.

**Green Start Buttons:** Two-handed operation for safety.

**Red Stop/Emergency Button:** Your AutoSealer is equipped with a red emergency release button, when pressed will raise the heat plate, allowing you to remove the paddle/tray and card(s). This button will light when activated/pressed and must be reset by pressing it again at the completion of the releasing cycle before the two green buttons are pressed again.



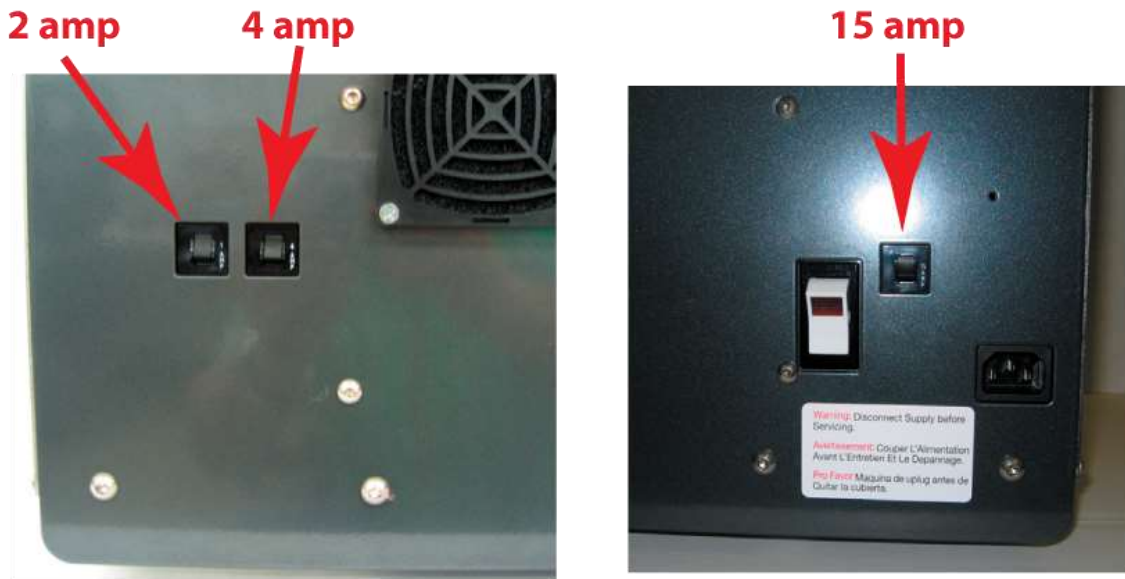
## 4 Special Features

### Cooling Fan

- The cooling fan will turn on at approximately **280 degrees** and continue to cool your AutoSealer even when turned off until the temperature goes below **140 degrees**.

### Circuit Breakers

- The AutoSealer is protected by three circuit breakers; one on the right side frame near the power switch and two on the left side of the machine.



## 5 Operating Instructions

The AutoSealer will automatically seal pill cards at a constant temperature and pressure over a set time – you only need to push two buttons to start the sealing cycle. But before you do, there are some one-time adjustments you need to make.

1. Remove the AutoSealer from its packing. Save all packaging materials for future use – in the unlikely event that we need to repair the machine at our facilities.  
**Replacement packaging is expensive and required for shipping.**
2. Plug the AutoSealer into a standard 3-prong outlet. It is recommended to use a dedicated 20amp outlet.
3. Turn the power switch to “ON” – the red switch light will illuminate.
4. Temperature: Your AutoSealer is pre-set to heat to 315 degrees. Should you need to adjust this setting (note card type and respective temperature requirement):
  - a. Push and hold blue **set** button below digital readout.
  - b. While set button is pushed in – push the gray **up** arrow to increase temperature setting or gray **down** arrow to decrease.
  - c. When the digital meter reaches your desired setting release both buttons.
  - d. Your AutoSealer temperature is set.

**NOTE: DO NOT EXCEED THE TEMPERATURE REQUIREMENT FOR YOUR CARD – THIS WILL POTENTIALLY DAMAGE THE CARD.**

<u>CARD TYPE</u>	<u>TEMPERATURE</u>	<u>TIME</u>
<i>Uni-Series (6" x 9")</i>	<b>Temperature should be set at 315 degrees For all Rx Systems Pill cards.</b>	<i>3 seconds</i>
<i>M-Series (6" x 9")</i>		<i>3 seconds</i>
<i>Rx Series (6.375' x 9")</i>		<i>5 seconds</i>
<i>UD Blister &amp; Foil</i>		<i>1 second</i>
<i>UD Card</i>		<i>2 seconds</i>
<i>MD-Series*</i>		<i>3 seconds</i>

## 5 Operating Instructions (con't.)

5. **Time Setting:** The AutoSealer can be set to seal packages at 1 to 10 seconds.

**Review the chart from the previous page to determine the appropriate time settings for your medication packaging.**

- To set time – turn the black numbered dial to the listed time for your respective card.

**You are now ready to begin sealing cards. The temperature and time will be pre-set each time the machine is turned on. Repeat steps (4) and (5) only to make adjustments.**

6. Place filled sealing paddles (or trays on pressure board) in the AutoSealer. Always seal two cards, even if second card is empty.
7. Press the two green buttons at the same time; this two-hand action is for safety – do not attempt to start the sealing process with one hand.
8. When the heat plate releases pull the paddle(s)/trays from the AutoSealer.

**\* When using cards with extra deep blisters, 3/4" such as the Rx Systems MD-Series (Multi-Dose), remove the spacer plate from the heat seal area.**





## Related Products

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AutoFiller - Item #3500



Deblisterer - Item #1110

## Accessories

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Pressure Board - Item #1047



Slide Rails - Item #1000R



UNI Series Single Paddle  
Item #1404



M Series Single Paddle  
Item #M400



UNI Series Double Paddle  
Item #1410



M Series Double Paddle  
Item #M410



UD Double Paddle  
Item #UD410

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62 and 90 count versions also available.  
To see a full assortment of paddles, [visit our website @  
www.rxsystems.com/Products/Equipment/MedicationPackaging/SealingAccessories.aspx](http://www.rxsystems.com/Products/Equipment/MedicationPackaging/SealingAccessories.aspx)

## 7 Maintenance

The intake vents on both sides of the machine and exhaust fan at the side of the machine should be checked weekly. If the filters of the 3 side vents are dirty, remove the media guards to get to the filters. Once removed they can be cleaned with a mild soap and water. Once they are clean and dry, replace. Replacements can be purchased from Rx Systems.

Monthly, the cover should be removed to check for dirt and dust. **AS ALWAYS, THE COVER SHOULD NOT BE REMOVED UNTIL THE MACHINE IS COOL (ABOUT .5 HOUR AFTER BEING SHUT OFF) AND UNPLUGGED.** Apply one or two drops of chain saw bar oil (sold by Rx Systems) or synthetic oil to the hole labeled in the middle of the cross bar.

Check condition of yellow pressure springs (4515).

An air hose or a vacuum cleaner can be used to clean. Always remember to wear the appropriate eye protection. Care should be taken not to disconnect any of the internal wiring.

The outside of the AutoSealer can be cleaned with a window cleaner or similar product.

These maintenance suggestions are just that, suggestions. The volume of your work will dictate how often maintenance should be performed.

## 8 Replacement Parts List

We recommend using Rx Systems parts to insure reliable operation of equipment. Any use of non-RXS approved parts can void your equipment warranty.

ITEM #	DESCRIPTION
4500	Power Switch
4503A	4" Fan
4505	Heat Plate
4507	Start Button
4509	Stop/Emergency Button
4511	3" Filter Assembly
4512	3" Filters, (5/pkg)
4515	Pressure Spring G6 (set of 4)
4516	Return Spring G6 (set of 4)
4517	Power Supply Kit
4518	Watlow Control
4527	Micro Switch
4528C	Thermocouple
4531A	Power Cord
4545	Motor
4546A2	2 amp Breaker
4546A4	4 amp Breaker
4546A15	15 amp Breaker

*Also available, a complete line of sealing trays and paddles. Paddles available for single or double card operation.*

# Troubleshooting Guide

Problem	Action To Take
No Heat, No Lights	<ul style="list-style-type: none"> <li>• Check Main Breaker - replace if needed</li> <li>• Check power source and breakers</li> <li>• Check power cord - Is it plugged in?</li> </ul>
No Heat, power light on - heater light off	<ul style="list-style-type: none"> <li>• Watlow Control inoperative - to replace, contact Rx Systems.</li> </ul>
No Heat, power light on - heater light on	<ul style="list-style-type: none"> <li>• Heating Element inoperative - replace Heat Plate.</li> </ul>
Uncontrolled Heat <ul style="list-style-type: none"> <li>- Overheating</li> <li>- Low Heat</li> </ul>	<ul style="list-style-type: none"> <li>• Watlow Control inoperative - to replace, contact Rx Systems.</li> <li>• Possibly Thermocouple or Heating Element to replace, contact Rx Systems.</li> </ul>
Heat Plate will not return (go up): <ul style="list-style-type: none"> <li>a. Cannot remove paddle</li> <li>b. Can remove paddle</li> </ul>	<ul style="list-style-type: none"> <li>a. 2 amp breaker on left side of sealer may have blown (see pg. 4) - replace breaker.</li> <li>b. Return Springs have broken - contact Rx Systems. Replace Return Springs.</li> </ul>

**Do Not remove the protective outer shield without confirming power is disconnected and heat plate is cool.**

**This shield protects you from the heat plate and electrical components that can cause injury.**

If you have any questions, please call us at **1-800-922-9142**. We will be happy to assist you.

**Please have Serial Number and Part Number of machine noted when calling for repair or replacement parts. These numbers are located on the Serial ID tag on the back of the machine.**

## 10 Two Year Warranty

Rx Systems warrants its AutoSealer for two years from the original date of purchase. The warranty covers defects in material and workmanship. Within the applicable warranty period, the AutoSealer will be repaired or replaced at Rx Systems discretion.

Voided Warranty: In the event an AutoSealer is returned for warranty work and is ***improperly packaged, the warranty may be voided.*** If you need proper packaging, please call Rx Systems, it is available at a cost and required for shipping.

An extended warranty may be purchased. Call Rx Systems sales staff for more information.

The information contained herein is based upon our research and believed to be accurate, but the accuracy and completeness of our recommendations is not guaranteed. The user shall determine the suitability of the product for their intended use before using the product and the user assumes all risk and liability whatsoever in connection with the use of the product. **Neither seller nor manufacturer shall be liable for any injury, loss or damage, direct or consequential, arising out of the use of or inability to use the product.** The following is made in lieu of all warranties, express or implied: Seller's and Manufacturer's only obligation shall be to repair, replace or credit such quantity of the product proved to be defective.

