



Genesis Packaging Technologies

D-26898 INSTRUCTIONS FOR USING THE GENESIS PACKAGING TECHNOLOGIES AIR CRIMP® WAC –1000

OVERVIEW

The Air-Crimp® WAC-1000 is a semi-automatic handheld tool used for crimping and de-crimping metal seals on glass and plastic vials. This tool is simple in operation and utilizes air assist, operating at low pressures. Use standard safety procedures, such as wearing safety glasses during operation and follow instructions on maximum air pressure, to limit exposure to hazards.

UNPACKING INSTRUCTIONS, ASSEMBLY, INSTALLATION

Remove the packing material from around the tool. There is packing material around the Gauge Regulator Assembly and the Air Crimp. The Gauge Regulator Assembly and the Air Crimp are connected by the Hose Assembly so no assembly is required. See Figure 1A for reference. Figure 1B shows the Air Crimp WAC 1000 with WAC-1007 (Holder, cord, and counterbalance).

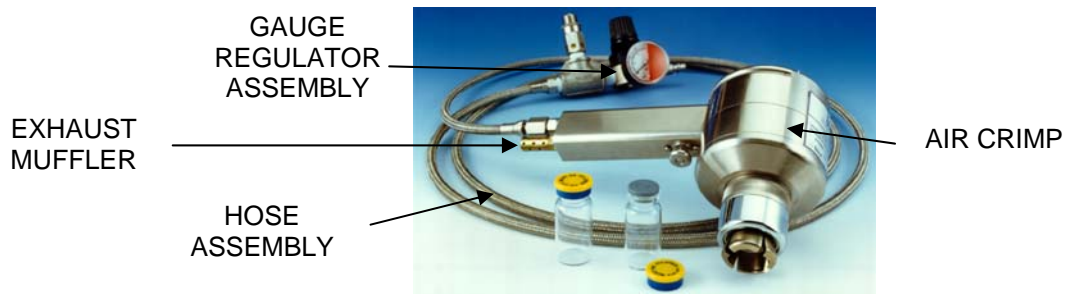


Figure 1A. Air Crimp WAC 1000

The WAC-1007 Accessory Kit includes a Holder, Retractor Cord, and Counter Balance. The WAC-1007 relieves weight from the WAC-1000, making operation less labor intensive.



Figure 1B. Air Crimp WAC 1000 with WAC 1007 Accessory Kit

The WAC-1000 is normally operated on compressed air. It can also be operated on compressed gases such as nitrogen if the vials must be filled in a special atmosphere.

⚠ WARNING NEVER USE OXYGEN

In the case of operation with an alternative gas, there is provision for venting the exhaust away from the unit. This feature must be specified and consists of removing the Exhaust Muffler (Figure 1A) on the air outlet, and replacing with a hose, venting away from the crimping area.

There is a quick disconnect supplied as part of the stainless steel covered Teflon hose. Use this quick disconnect at the regulator if you need mobility, instead of piping the regulator directly into the air supply system.

⚠ CAUTION *The maximum pressure setting for the discharge side of the regulator should not exceed 120 pounds. **Under no circumstances should a pressure of over 50 psi be used to crimp or decrimp vials.** Refer to Table 2.*

SETUP AND OPERATION INSTRUCTIONS

1. Select the K-Head (jaw head used for crimping vials) or KO-Head (jaw head used for decrimping vials). A complete range of Heads from 8mm to 43mm, (refer to Table 1) are available. Other types are available on special request.

Table 1.

Description	Application
Air-Crimp WAC-1000	Complete Unit
WAC-1007 Air Crimper Hanging Kit	For Hanging Unit
K-83-NS K-Head Capper	8mm caps
K-83F-NS K-Head Capper	8mm Flip-Off caps
K-9.8-NS K Head Capper	9.8 mm
K-114-NS K-Head Capper	All 11mm caps
K-137-NS K-Head Capper	13-I and 13-10 caps
K-137TNS K-Head Capper	13-10T caps
K-137/50-165NS	13mm Flip-Tear Off caps
K-138F-NS K-Head Capper	13mm Flip-Off caps
K-14/79-NS	13mm Tear-Off
K-171F-NS K-Head Capper	16.5mm Flip-Off caps
K-205/70-25OF-NS K-Head Capper	20mm Flip-Tear Off caps
K-205F-NS K-Head Capper	20mm Flip-Off and Flip Off-Tear Off caps
K-207-NS K-Head Capper	20-1, 20-10, 20-10T caps
K-282/120-310F-NS K-Head Capper	28mm Flip-Off caps
K-282FTO-NS K-Head Capper	28mm Flip-Tear Off caps
K-285/100-NS K-Head Capper	28mm Inner caps
K-286T-NS K-Head Capper	28-31 caps
K-293T-NS K-Head Capper	28-10T caps
K-301-NS K-Head Capper	30-I caps
K-332F-NS K-Head Capper	32mm Flip-Off caps
K-332FTO-NS K-Head Capper	32mm Flip-Tear Off caps
K-460-NS K-Head Capper	43mm Short Skirt caps
K-460-FTO-NS	43mm FTO caps
K-465-NS K-Head Capper	43mm Long Skirt caps
KO-83-NS K-Head Decapper	All 8mm caps
KO-114-NS K-Head Decapper	All 11mm caps
KO-137-NS K-Head Decapper	All 13mm caps
KO-207-NS K-Head Decapper	All 20mm caps
KO-286T-NS K-Head Decapper	All 28mm caps
KO-301 K-Head Decapper	All 30mm caps
KO-332-NS K-Head Decapper	All 32mm caps

2. If present on the Crimper, unscrew the current K-Head and screw in the desired head. **DO NOT OVER TIGHTEN.** Finger tight is all that is needed.

3. To crimp a vial, set the regulator according to Table 2 below. The setting is based on vial size.

▲ NOTICE

Please view the pressure settings on the air gauge as a guide only for initial pressure adjustments since variations in rubber stopper durometer (hardness) need to be taken into account. Changes in pressure to suit stopper, glass and types of caps are necessary to arrive at satisfactory sealed product and involve minor poundage adjustments.

Table 2

CAP SIZE	PRESSURE SETTING
8mm, 11mm	15-25 lbs
13mm, 16.5mm, 18mm, 20mm	20-40 lbs
28mm, 30mm	30-40 lbs
32mm	30-40 lbs
43mm	30-40 lbs

4. Place a vial/stopper/cap combination squarely inside the K-Head and press the button on the handle of the Crimper.

TROUBLESHOOTING

If a desired seal is not achieved, refer to the following checks/adjustments:

- Do not set the pressure higher than needed or over crimping will occur.
- Always be sure the cap is straight on the vial and the vial is squarely into the crimper. If either the vial or cap is crooked, a poor seal may result.
- The same precautions are true when decapping. The vial and the cap must be inserted squarely into the head so that a firm grip is obtained all around the cap. Adjust the pressure until a smooth operation is obtained. This pressure is usually just a little higher than the equivalent pressure for capping.

MAINTENANCE

The Genesis Machinery Products' Air Crimp® is pre-lubricated at the factory, and under normal service, requires minimal maintenance (Refer to the Lubrication procedure below). For maximum life, ensure that the air supply is clean and free of moisture.

Lubrication

The only maintenance procedure needed on the WAC-1000 is performed as follows:

Once a year, put three drops of any good quality lubricating oil in the air intake of the handle. Hold the handle upright for five minutes to allow the oil to drain in. With the air disconnected from the WAC-1000, remove the Crimp Head and with a cotton swab long enough to keep fingers away from threads, apply grease to the entire cylinder wall. If the external surface needs to be cleaned, use a soft cloth and alcohol, as needed.

GMP Machinery Products is proud to carry on the quality and tradition of the **WESTCAPPER®**. GMP provides three different sealing mechanisms to meet all production and lab or pilot speed and quality requirements.

In addition, the GMP Phase-Shift™ Vial Washer and Laminar Flow Sterilization Tunnel work in concert to clean, depyrogenate, and sterilize vials in a variety of sizes with few change parts.

GMP Machinery — the foremost provider of packaging process management and machinery to the liquid pharmaceutical industry.

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