

Case History

CUSTOMER: BIOCOR ANIMAL HEALTH

LOCATION: OMAHA, NEBRASKA

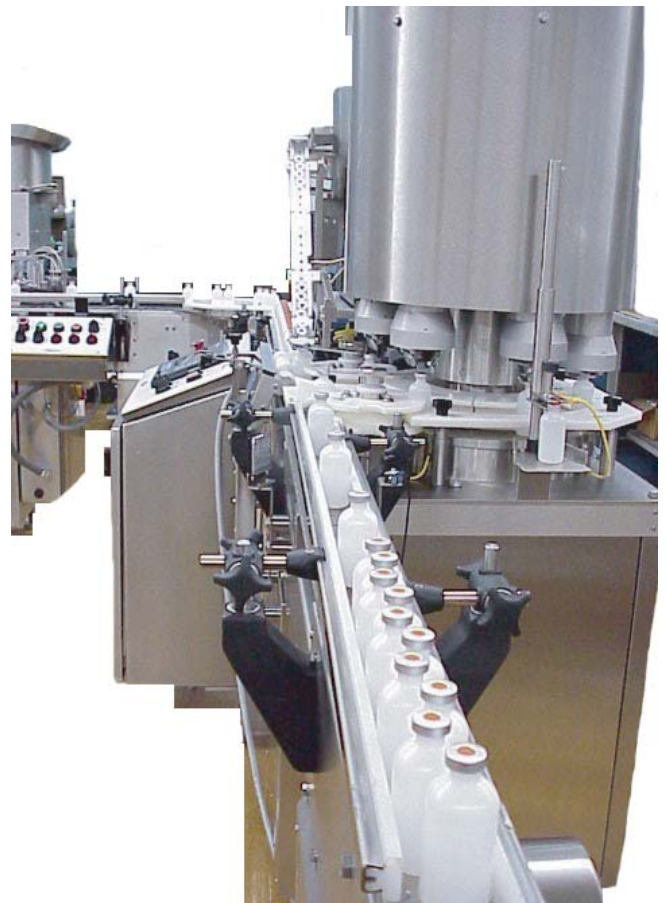
MACHINE LINE: VR840 8 HEAD FILLER, RS200 STOPPER, CM200 CRIMP CAPPER AND UNSCRAMBLING TABLE.

APPLICATION: FILL, STOPPER AND CRIMP CAP 30, 60 & 250 ML VIALS AT SPEEDS OF 100, 50+ AND 25+ VIALS PER MINUTE RESPECTIVELY. PRODUCTS FILLED = ALUMINUM HYDROXIDE & PROTEIN.

BioCor Animal Health is a subsidiary of the CSL Group, headquartered in Melbourne, Australia.

The Biocor facility in Omaha has been supplying vaccines since 1964, and has recently increased production with their new Cozzoli packaging line.

Find out more about Biocor products at www.biocorah.com.



OPERATIONAL LINE SEQUENCE:

Containers are placed on the unscrambling table, where they are automatically fed into the filler infeed conveyor. The containers are allowed into the filling station by a gating device, adjustable for different container sizes.

After completion of the fill cycle, filled containers travel to the RS400 Stoppering Station, where full stopper insertion occurs. After stoppering, containers then travel to the CM200 Crimping Station, where aluminum crimp seals are adhered.

Continued on page 2

BioCor Case History, Continued



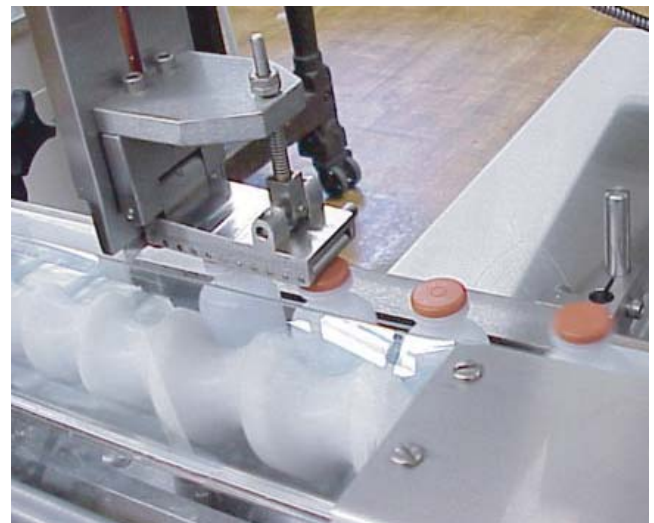
The Cozzoli VR840 8 operates using a diving nozzle system for profile filling. Fill accuracies up to +/- 0.5% of fill volume can be achieved using this filling system.

Containers enter the filling machine via the gating device and are filled using the diving nozzle system. The VR840 is a positive displacement liquid filler, operating on a 4" pump stroke. This filler is equipped with a total of 8 stainless steel syringes for fill volumes up to 600 ml, and speeds up to 120 bottles per minute. After the fill is complete, containers cycle out of the filler and enter the Stoppering System.

BioCore's RS200 Stoppering System is comprised of a vibratory sorting bowl, stopper feed chute, container feed screw and stopper pressing foot. This machine is stoppering three container sizes with 20mm and 30mm stoppers. Sensors are located on the stopper chute for stopper make-up and on the conveyor for container make-up and back-up.



Stoppers are sorted with a vibratory sorting bowl, then travel down the stopper feed chute, where they are positioned to be accepted by the vial.



A pressing foot helps gently push the stopper firmly in place as the vial passes, making contact. Stoppered vials then travel downstream to the CM200 Crimping Station.

BioCor Case History, Continued

Traveling down the conveyor, the filled and stoppered vials are captured by an infeed starwheel for entry into the CM200 continuous motion rotary crimping machine. This machine also has a vibratory bowl; orienting the aluminum caps for placement into the feed chute.

As the stoppered containers pass underneath, the containers strip-off the aluminum cap as it enters the infeed star wheel. The container then passes into the main star wheel, where the crimp head lowers. Contact with the cap activates the crimp head rollers to begin the progressive roll seal process.



Stoppered containers are positioned to accept an aluminum cap from the feed chute.



Filled and stoppered containers enter the CM200, stripping off an aluminium crimp cap from the feed chute.

Simple push button controls are located on the RS200 Stoppering Machine and CM200 Crimping Machine for ease of operator adjustment.



Allen Bradley SLC 503 Programmable Logic Controls are used throughout this line, providing for consistent operation.

The Panelview makes it easy for the operator to recall preset fill volumes and speed settings.





50 Schoolhouse Road, Somerset, NJ 08873-1289 USA
Phone: 732-564-0400, Fax: 732-564-0444
Email: sales@cozzoli.com, Internet: www.cozzoli.com

BioCor Case History, Continued

CRIMPING OPERATIONAL SEQUENCE:

A fixed cup is used in each crimp head to prevent rotation of the container, and the crimping skirt height is easily adjusted for each size crimp. An automatic vial height adjustment is included with this machine for ease of container changeover. Simply place a the container on the height gauge, and the height is measured and corrected automatically on the crimper. This machine will crimp 20 and 30 mm seals.



Filled, stoppered and crimp sealed containers exit the packaging line.



Cozzoli Machine Company offers
IQ/OQ/PQ Protocols on all equipment.

For more information on this line, please contact the Cozzoli Sales Department, Phone: 732-564-0400, Fax: 732-564-0444, or Email: sales@cozzoli.com