

**DOCUMENT TYPE:**

MACHINE SETUP SHEET

**DOCUMENT NUMBER:** MSS 717 ETAL**DCO NUMBER:** 019460**ISSUE DATE:** 7/2/2019 | 7:37 AM EDT**EFFECTIVE DATE:** 7/17/2019 | 8:37 AM EDT**PAGE 1 of 7****CATALOG NUMBER:** REFER TO DMR**PACKAGING** REFER TO TABLE I**DEPARTMENT:** PACKAGING**SCHEDULE NUMBER:** REFER TO RELEASED SCHEDULE

## REVISION HISTORY

DATE:	DCO#	REASON FOR CHANGE	CHANGE FROM:	CHANGE TO:	REQUESTED BY:
8/11/2015	015753	Creating a MSS due to a new packaging combination. Part# 7191-1 - 13MIL A-PET Clear approved under sample# 3572 with current part# 7515FS - Coated Tyvek. The MSS form is required to be a controlled document, therefore adding the form number and DCO number on form.	N/A	N/A	M. Vera
10/26/2015	015993	The Forming Air gauge is not part of the set up, therefore removing "Forming Main" gauge from MSS's Air Pressure section and adding "Forming" in front of Air Assist gauge.  Add unit of measure to the Air Pressure section since gauges reflect both units of measure.  Catalog 716, 770 & 7165 are affected by the new packaging combination, therefore catalog 716, 770 & 7165 were added to the Table 1.	1. Air Assist  4. Old DCO# 015753	1. Forming Air Assist  2. Add Bar / PSI  3. Add Catalogs 716, 770 & 7165 to Table 1 4. New DCO# 015993	Mary Vera
4/6/2016	016375	Machine Set up Sheet format was changed to add space to record correctly the timer from the machine and the Main Air Pressure gauge will read for reference only. Refer to External Audit# EA-CA16002.  Catalog 717 & 732 are affected by the new tooling and packaging combination, therefore catalog 717 & 732 were added to the Table 1.	1. Old template  3. Old DCO# 015993	1. New template 2. Add Catalogs 717 & 732 to Table 1 3. New DCO# 016375	M. Vera



DOCUMENT TYPE:

## MACHINE SETUP SHEET

DOCUMENT NUMBER: MSS 717 ETAL  
DCO NUMBER: 019460

Title: DIXIE-VAC 3 MACHINE SETUP SHEET PAGE 2 of 7

## REVISION HISTORY (Continued)

DATE:	DCO#	REASON FOR CHANGE	CHANGE FROM:	CHANGE TO:	REQUESTED BY:
6/14/2019	019460	To use part# 7515 as an alternative to part# 7515FS; that have been used before switching to part# 7515FS. Also these combinations of packaging material of Coated Tyvek with 13 Mil A-Pet have been validated per Packaging Validation Protocol P10168, P10169 & P10172, therefore packaging material will not change or affect product/package integrity. The result indicated that the machine when operated at the required parameters set on this MSS, gave the desired product results. Therefore this MSS 717 ETAL can be used with either packaging material combination of part# 7515FS with part# 7191-1 and part# 7515 with part# 7191-1. Cat# 723C, 9199 & 9201 belongs to this tooling family, therefore catalogs will be added to Table 1.	Old DCO# 016375	Add Catalogs 723C 9199 & 9201 to Table 1 Add "Packaging Combination" sections to Table 1. New DCO# 019460	M. Vera

**DOCUMENT TYPE:****MACHINE SETUP SHEET****DOCUMENT NUMBER: MSS 717 ETAL****DCO NUMBER: 019460**

**Title:** DIXIE-VAC 3 MACHINE SETUP SHEET  
**PAGE 3 of 7**

"Refer to the Released schedule for CPM (Cycle Per Minute)"

**TOOLING:**

<b>Tooling Family: F</b>	
Stroke Length	170
Forming Box	F-170-F
Forming DIE Heater Top	F-170-FH
Forming DIE Heater Bottom	Required
Sealing Box	F-170-S
Sealing DIE Heater - Top	F-170-SH
Sealing Heater Insert Top	F-170-SHI
Forming Insert (s)	Refer to Table 1
Draw Depth	Refer to Table 1
Punch Knife	Required
Circular Knife	Required
Cross Cutting Knife	N/A
Scrap Wheels	Required
Vacuum	Not Required
Plug	Required
Ink	Refer to DHR
Tooling Code Example: Refer to Table 1	
For Tooling Code Explanation - Refer to SOP 09-82	

<sup>1</sup>The Sealing Heater Insert Top is welded into the Sealing Die Heater Top



**DOCUMENT NUMBER:** MSS 717 ETAL  
**DCO NUMBER:** 019460

**DOCUMENT TYPE:**

MACHINE SETUP SHEET

**Title:**

DIXIE-VAC 3 MACHINE SETUP SHEET

**PAGE 4 of 7****Temperature Controllers**

		<b>MIN</b>	<b>MAX</b>
Seal Temperature	(Celsius)	105	120
Forming Temperature	(Celsius)	110	120
Heating Top Temperature	(Celsius)	N/A	N/A
Heating Bottom Temperature	(Celsius)	N/A	N/A
Forming Plug Temperature	(Celsius)	N/A	N/A
Forming Box Temperature	(Celsius)	N/A	N/A

**Timers**

	<b>MIN</b>			<b>MAX</b>
	Seconds	10th of a Second	Seconds	10th of a Second
Seal Timer	3	2	2	9
Form Time	2	0	1	0
Form Top Time	N/A	N/A	NA	N/A
Plug Delay	N/A	N/A	NA	N/A
Foil Warm Timer	1	5	1	5
Seal Potentiometer	N/A	N/A	N/A	N/A
Form Potentiometer	N/A	N/A	N/A	N/A

**Air Pressure**

<b>FOR REFERENCE ONLY</b>	<b>MIN</b>	<b>MAX</b>
	Bar / PSI	Bar / PSI
Machine Main	6 / 87.02	8 / 116.03
Seal Bladder	2 / 29.00	4 / 58.01
Forming Air Assist	2 / 29.00	5 / 72.51

DCO# 016284

Form# 09-44-01

*For Use Only By Busse Hospital Disposables.**This Document Contains Proprietary Information.**Must Not Be Reproduced Or Disclosed To Others Without Prior Written Approval.*



**DOCUMENT NUMBER:** MSS 717 ETAL  
**DCO NUMBER:** 019460

**DOCUMENT TYPE:**

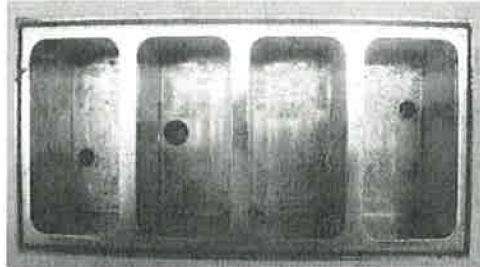
MACHINE SETUP SHEET

**Title:**

DIXIE-VAC 3 MACHINE SETUP SHEET

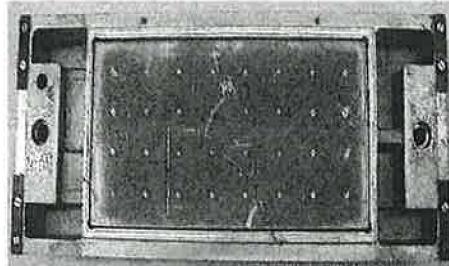
**PAGE 5 of 7**

Forming Box - F



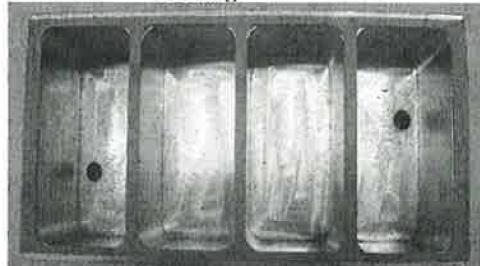
F-170-F

Forming Die Heater Top - F



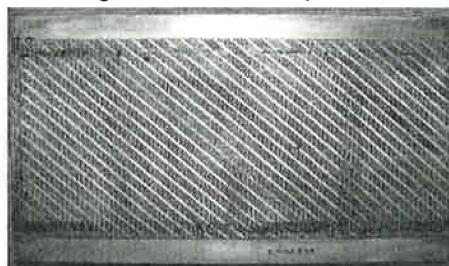
F-170-FH

Sealing Box - F



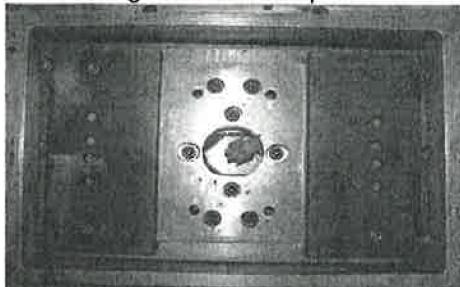
F-170-S

Sealing Heater Insert Top - F



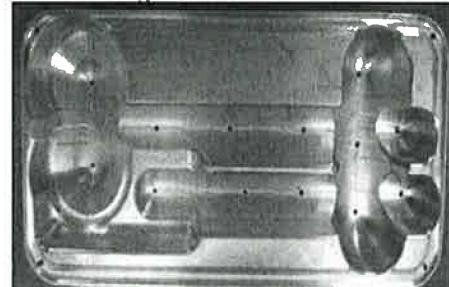
F-170-SHI

Sealing Die Heater Top - F



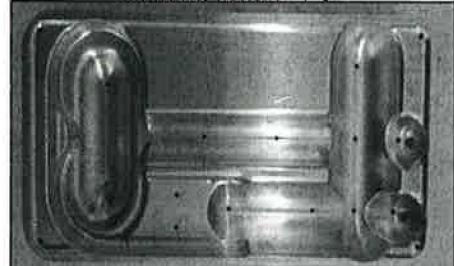
F-170-SH

Forming Insert - F7



F7

Forming Insert - F8



F8

Forming Insert - F10



F10

DCO# 016284

Form# 09-44-01

*For Use Only By Busse Hospital Disposables.*

*This Document Contains Proprietary Information.*

*Must Not Be Reproduced Or Disclosed To Others Without Prior Written Approval.*



DOCUMENT NUMBER: MSS 717 ETAL

DCO NUMBER: 019460

DOCUMENT TYPE:

MACHINE SETUP SHEET

Title:

DIXIE-VAC 3 MACHINE SETUP SHEET

PAGE 6 of 7

**TABLE 1**

Cat #	Private # if Applicable	Description	Tooling Code	Insert #	Packaging Combination
716	N/A	Skin Staple Remover	F^170^25^F10^287^22	F10	Part# 7191-1 with Part# 7515FS
717	N/A	Suture Removal Kit	F^170^25^F7^287^22	F7	Part# 7191-1 with Part# 7515FS
718	N/A	Suture Removal Kit	F^170^25^F8^287^14	F8	Part# 7191-1 with Part# 7515FS
723	N/A	Suture Removal Kit	F^170^25^F7^287^22	F7	Part# 7191-1 with Part# 7515FS
723C	N/A	Basic Suture Removal Kit With Floor Grade	F^170^25^F7^287^22	F7	Part# 7191-1 with Part# 7515FS
724	N/A	Suture Removal Kit	F^170^25^F7^287^22	F7	Part# 7191-1 with Part# 7515FS
726	N/A	Suture Removal Kit	F^170^25^F7^287^22	F7	Part# 7191-1 with Part# 7515FS
729	N/A	Suture Removal Kit	F^170^25^F7^287^22	F7	Part# 7191-1 with Part# 7515FS
732	N/A	Suture Removal Kit	F^170^25^F7^287^22	F7	Part# 7191-1 with Part# 7515FS
770	N/A	Skin Staple Remover	F^170^25^F10^287^22	F10	Part# 7191-1 with Part# 7515FS
5822	112-5822	Suture Removal Kit	F^170^25^F7^287^22	F7	Part# 7191-1 with Part# 7515FS
7165	716-IMC	Skin Staple Remover	F^170^25^F10^287^22	F10	Part# 7191-1 with Part# 7515FS
9199	570-0620	Skin Staple Remover / Henry Schein Private Label # 570-0620	F^170^25^F10^295^22	F10	Part# 7191-1 with Part# 7515FS
9201	570-0619	Suture Removal Kit / Henry Schein Private Label # 570-0619	F^170^25^F8^295^14	F10	Part# 7191-1 with Part# 7515FS

DCO# 016284

Form# 09-44-01

For Use Only By Busse Hospital Disposables.

This Document Contains Proprietary Information.

Must Not Be Reproduced Or Disclosed To Others Without Prior Written Approval.



DOCUMENT TYPE:

## MACHINE SETUP SHEET

DOCUMENT NUMBER: MSS 717 ETAL  
DCO NUMBER: 019460Title: DIXIE-VAC 3 MACHINE SETUP SHEET  
PAGE 7 of 7

## TABLE 1 CONTINUED

Cat #	Private # if Applicable	Description	Tooling Code	Insert #	Packaging Combination
716	N/A	Skin Staple Remover	F^170^55^F10^287^22	F10	Part# 7191-1 with Part# 7515
717	N/A	Suture Removal Kit	F^170^55^F7^287^22	F7	Part# 7191-1 with Part# 7515
718	N/A	Suture Removal Kit	F^170^55^F8^287^14	F8	Part# 7191-1 with Part# 7515
723	N/A	Suture Removal Kit	F^170^55^F7^287^22	F7	Part# 7191-1 with Part# 7515
723C	N/A	Basic Suture Removal Kit With Floor Grade	F^170^55^F7^287^22	F7	Part# 7191-1 with Part# 7515
724	N/A	Suture Removal Kit	F^170^55^F7^287^22	F7	Part# 7191-1 with Part# 7515
726	N/A	Suture Removal Kit	F^170^55^F7^287^22	F7	Part# 7191-1 with Part# 7515
729	N/A	Suture Removal Kit	F^170^55^F7^287^22	F7	Part# 7191-1 with Part# 7515
732	N/A	Suture Removal Kit	F^170^55^F7^287^22	F7	Part# 7191-1 with Part# 7515
770	N/A	Skin Staple Remover	F^170^55^F10^287^22	F10	Part# 7191-1 with Part# 7515
5822	112-5822	Suture Removal Kit	F^170^55^F7^287^22	F7	Part# 7191-1 with Part# 7515
7165	716-IMC	Skin Staple Remover	F^170^55^F10^287^22	F10	Part# 7191-1 with Part# 7515
9199	570-0620	Skin Staple Remover / Henry Schein Private Label # 570-0620	F^170^55^F10^295^22	F10	Part# 7191-1 with Part# 7515
9201	570-0619	Suture Removal Kit / Henry Schein Private Label # 570-0619	F^170^55^F8^295^14	F10	Part# 7191-1 with Part# 7515

DCO# 016284

Form# 09-44-01

DOCUMENT APPROVAL – Original Signatures appear on referenced DCO.

Packaging Manager

Quality Manager

For Use Only By Busse Hospital Disposables.

This Document Contains Proprietary Information.

Must Not Be Reproduced Or Disclosed To Others Without Prior Written Approval.