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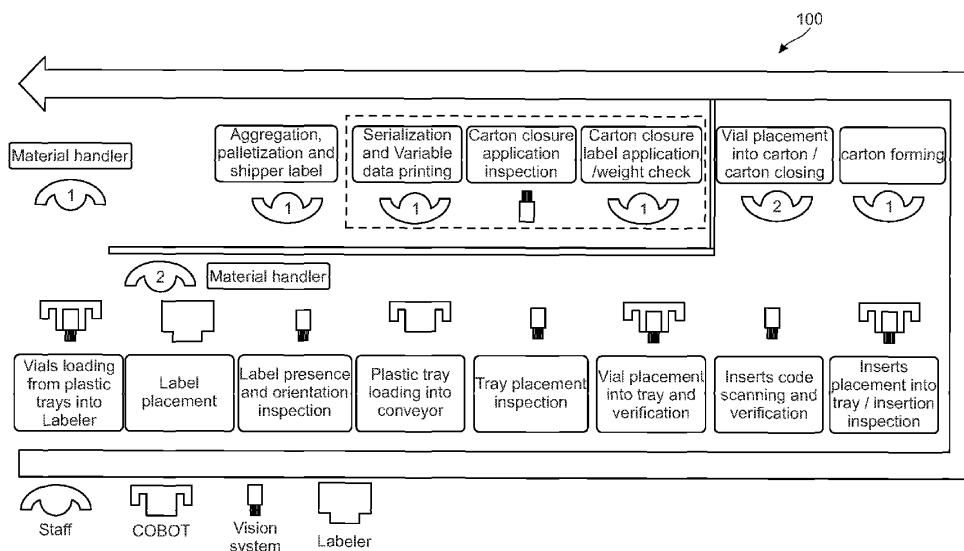


FIG. 1

(57) Abstract: Methods and systems for efficiently packing pharmaceutical products (e.g., vials) so as to reduce changeover times and reduce if not eliminates waste related to work in process inventory, defects, motion, and transportation and waiting times, particularly for capacities ranging between 10 and 70 Units per Minute.

[Continued on next page]

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