



Title: Preventive Maintenance of Blister Packing Machine

SOP No.:		Revision No.:	00
Effective Date:		Supersedes No.	Nil
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1.1 OBJECTIVE

1.1 To describe a procedure for the preventive maintenance of blister packing machine.

2.0 SCOPE

2.1 This procedure applies to the Engineering department.

3.0 RESPONSIBILITY

3.1 Engineering

4.0 ACCOUNTABILITY

4.1 Plant Head

5.0 REFERENCE (S)

5.1 In-house.

6.0 PROCEDURE

6.1 Procedure for mechanical work:

- 6.1.1 Switch off the power supply of the machine and put "under maintenance" label.
- 6.1.2 Check main drive gearbox oil level and make up if oil level is less than half.
- 6.1.3 Clean the chains & sprockets, and lubricate them.
- 6.1.4 Clean and lubricate the bearing of forming and sealing stations.
- 6.1.5 Check the motor electrical connections & vacuum pump.
- 6.1.6 Clean compressed air filter and top the oil level in the FRL unit.
- 6.1.7 Tighten the line connection of blister forming roller re-circulating water for cooling.
- 6.1.8 Check thermostat setting of water cooler (Range 15 to 18 Deg C).

6.2 Procedure for electrical work:

- 6.2.1 Clean the panel with compressed air and tighten the wire connections.
- 6.2.2 Clean the carbon brush of sealing station roller/foil in feed motor.
- 6.2.3 Clean the temp. sensor and check the continuity of the sensor.

6.3 Procedure for trial run:

- 6.3.1 Switch on the main power supply & also switch on the compressed air supply.
- 6.3.2 Start the machine as per the SOP.
- 6.3.3 Check & record the observations as per Annexure-1.

6.4 Procedure for handover of the machines:

- 6.4.1 Switch off the power supply.
- 6.4.2 Remove under maintenance label & affix preventive maintenance status tag and inform the concerned department.

6.5 Frequency of preventive maintenance is monthly.



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7.0 HISTORY

7.1 Details are given below.

SOP No.	REASON FOR CHANGE	EFFECTIVE DATE

8.0 ABBREVIATIONS: The abbreviations used in the SOP are as follows:

- 8.1 SOP - Standard Operating Procedure
- 8.2 No. - Number
- 8.3 QA - Quality assurance



PHARMA DEVILS

ENGINEERING DEPARTMENT

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ANNEXURE-I

PREVENTIVE MAINTENANCE CHECK LIST FOR BLISTER PACKING MACHINE

Equipment ID No. _____

Date: _____

S.No.	Particulars	Done/Not Done	Remarks
1	Checking of punching tool alignment.		
2	Checking of all movable parts and lubricate them.		
3	Check & change gear alignment.		
4	Check solenoid valves.		
5	Check the tuning of the machines.		
6	Check the servomotor.		
7	Check air filter regulators.		
8	Check all the safety switch.		

Done by
(Sign & date)

Checked by
(Sign & date)