



**OPERATIONAL QUALIFICATION PROTOCOL CUM REPORT
FOR
ALU-ALU BLISTER PACKING MACHINE**

**OPERATIONAL QUALIFICATION
PROTOCOL CUM REPORT
FOR
ALU-ALU BLISTER PACKING
MACHINE**

EQUIPMENT ID No.	
LOCATION	Packing-01
DATE OF QUALIFICATION	
SUPERSEDES PROTOCOL CUM REPORT No.	NIL



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1.0 PRE – APPROVAL:

INITIATED BY:

DESIGNATION	NAME	SIGNATURE	DATE
OFFICER/EXECUTIVE (QUALITY ASSURANCE)			

REVIEWED BY:

DESIGNATION	NAME	SIGNATURE	DATE
OPERATING MANAGER (QUALITY ASSURANCE)			
HEAD (PRODUCTION)			
HEAD (ENGINEERING)			

APPROVED BY:

DESIGNATION	NAME	SIGNATURE	DATE
HEAD (QUALITY ASSURANCE)			



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2.0 OBJECTIVE:

- To verify that the equipment operates in accordance with the design and user requirements as defined by set Acceptance Criteria and complies with relevant cGMP Requirements.
- To verify the Operational features of Blister Packing Machine and to ensure that it produces desired Quality & rated output according to manufactures specifications.
- To verify all the Operational features from user point of view of the Equipment, Cleaning Procedure, Start up & Shut down Procedure and Safety Features.

3.0 SCOPE:

- The scope of this operational qualification protocol cum report is limited to qualification of Alu-Alu Blister Packing Machine (Make- Pampac) to be installed in the Packing.
- This Protocol will define the methods and documentation used to perform OQ activity the Blister packing machine for OQ. Successful completion of this Protocol will verify that Blister packing machine meet all acceptance criteria and ready for Performance Qualification.



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4.0 RESPONSIBILITY:

The Validation Group, comprising of a representative from each of the following departments, shall be responsible for the overall compliance of this Protocol cum Report:

DEPARTMENTS	RESPONSIBILITIES
Quality Assurance	<ul style="list-style-type: none">• Initiation, Authorization, Approval and Compilation of the OQ Protocol cum Report.• Co-ordination with Production and Engineering to carryout OQ.• Monitoring of operational Qualification Activity.
Production	<ul style="list-style-type: none">• Review & Pre Approval of Protocol cum Report.• To Co-ordinate and support for Execution of Qualification study as per Protocol.• Post Approval of Qualification Protocol after Execution.
Engineering	<ul style="list-style-type: none">• Review & Pre Approval of Protocol cum Report.• Co-ordination, Execution and technical support in Blister packing machine OQ Activity.• Calibration of Process Instruments.• Responsible for Trouble Shooting (if occurs during execution).• Post Approval of Qualification Protocol after Execution.



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5.0 EQUIPMENT DETAILS:

Equipment Name	Blister Packing Machine
Equipment	
Manufacturer's Name	Pampac
Model	cGMP Model
Location of Installation	Packing

6.0 SYSTEM DESCRIPTION:

Functional Description

The Blister Packaging Machine; model BQS is designed to produce blisters as per approved blister format drawing. For the PVC blisters, the forming foil is heated, and the cavities are formed using compressed air through blowing plate. For ALU-ALU blisters, the cavities are formed with the help of compressed air through cylinder and forming plugs. The product is fed into the formed cavities. An aluminium lidding foil at sealing station seals the formed web. Blisters of the required size are cut with the help of the cutting tool.

The machine consists of following major stations and functions:

Forming foil rollmount

The forming Foil reel is mounted on the spindle provided at the left bottom side of the machine. Two spindles are provided in the machine; one reel is in a process and another is a standby to minimize the machine downtime.

The reel is mounted on two cones, one is fixed and the other is adjustable.

The reel position with respect to the front plate of the machine can easily be set with the knob according to format parts. The center of the Foil reel should be at 185mm from the front plate.

Forming foil splicing unit

Splicing unit is provided on the machine:

- To properly cut the forming Foil.
- To join the finish foil end with subsequent foil, start and.
- To clean the Foil with cleaning mat (using air pressure).

The clamping of foil is done mechanical clamps, which has rubber pad to clamp forming foil.

Forming foil unwinding station

This station is provided to unwind the forming Foil. A dancing lever and two sensors are provided to start and stop unwinding of the foil, which is driven by an induction motor. When dancing lever



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comes in front of upper sensor, it senses the lever and motor starts unwinding the foil. When dancing lever goes down, a down sensor senses the lever and motor stops unwinding the foil.

Forming foil joint scanner

After the unwinding station, a scanner is provided to check Foil joint. This scanner checks the Foil joint and gives the input to a control system to reject the blister.

Heating station

The heating station is provided to heat the thermoforming Foils i.e., PVC, PVC/PVDC, and Triplex before forming of the cavity. It consists of top and bottom heating plates. A Foil is heated to its plastic state by holding the Foil between two heating grates. The Heating plates are Teflon coated to avoid sticking of Foil to the plates.

Temperature required to heat these Foils are about 100°C to 130°C .

The pneumatic cylinders are mounted at front side of the machine to operate the top and bottom plates.

Forming station - thermoforming

In this station cavities are formed in the forming Foil as per specified layout. The heated forming Foil comes to the forming station. The Foil is continuously moving forward, and station is intermittently moving forward and backward. This station consists of bottom plate, top plate, bottom forming plate. Blowing plate and other pneumatic parts.

A hydraulic cylinder moves the bottom forming plate upward and the forming Foil clamped between top and bottom forming plates. These elates are mounted on moving plates that are guided by four pillars and bearings

Cavity formation takes place; by blowing air in case of PVC Foil or by plugs in case of ALU Foil.

A special pneumatic cylinder is provided to drive plugs to form the cavities in Aluminium Foil.

In case of ALU-ALU forming; plugs operated with multistage pneumatic cylinder. To generate the required force for formation of cavities in Aluminium Foil, a separate reservoir is provided. In case of PVC-ALU forming; cavities formed by the compressed air of pressure approximately 6 bars.

Top and bottom cooling plates are provided in between Forming and Blowing / Plug guide elates to cool the web after cavity formation. The temperature required to cool the web is about 8 to 16°C depending on the forming Foil to be processed, circulated through the cooling plates.

Forming station-cold forming



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This attachment is required in case of cold (Aluminium) forming film. This includes:

- Parts for Forming
- Multistage Pneumatic Cylinder
- Air Reservoir

Above mentioned parts help to generate force required to form the cavities in Aluminium foil which require more force as compared to PVC film.

Standard feeding system Feeding system consists of:

- A hopper that stores the product and feed to a linear vibrator by gravity.
- A linear Vibrator that transfers the product to the distributor plate.
- A rotary vibrator that feeds the product further to the feeding channel. A feeding sector is a change part provided to feed the products from the distributor plate to the feeding channel.

This sector has a slot to remove dust. Powder and chips from the product.

The feeding channel from a rotary vibrator to a guide plate changes depending on the type of product to be packed. This channel is classified as:

- Continuous feeding channel: This system is required for flat tablet, capsules etc.
- Spring type feeding channel: This system is required for DS tablet.

Drum feeding system

Product feeding in Aluminium formed web is critical because of cavity shape. Drum feeding system is used to feed the product in such cavities. Tablets from the distributor plate/rotary vibrator are transferred to the drum either through continuous or spring channels depending on tablets. If spring channels are used, then feeding shoe is provided to transfer the tablets on the drum.

Product is transferred into cavities by rotating drum. Drum cavities are synchronized with web cavities. This unit is driven by servo motor and it linked with MMI. This is suitable only for ALU/ALU forming Foil

Wiper brush

The wiper brush is provided to remove an excess product from the formed web. It is mounted after the dedicated feeding system.

A universal motor drives the rotating brush and *speed* controller controls its speed.

Lidding foil roll mount

The lidding foil reel is mounted on a collet. It is locked with a nut on its fixed position. A dancing lever and two sensors are provided to start and stop unwinding of the foil, which is driven by a



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motor. When dancing lever comes in front of upper sensor. It senses the lever and motor starts unwinding the foil. When dancing lever goes down, a sensor senses the lever and motor stops. Another sensor is provided to monitor the foil presence. If the sensor does not sense the foil, it gives signal to PLC and machine stops.

Lidding foil joint scanner/PRC Scanner

After the unwinding station, a scanner is provided to check Foil joint. This scanner checks the Foil joint and gives the input to a control system to reject the blister. This scanner also works to check “Print Mark” on the lidding foil for PRC system.

Sealing station

This station is provided to seal the formed web with a lidding foil. The bidding foil can be Aluminium, paper or child proof foil. This station consists of bottom grate, toe plate, and bottom sealing plate, top sealing plate, heater plate and pneumatic parts.

Sealing is done in between the top and bottom sealing plate with hydraulic pressure. The formed web with product and lidding foil comes to the sealing station. A guide piece guides the formed web and lidding foil aligned with each other. A hot Sealing plate exerts pressure on the web and lidding foil to seal the web. Hydraulic power pack develops the pressure as per requirement. Temperature required for the seating is about 180 °C to 240 °C depending on format size, forming foil and lidding foil.

Note:

The initial temperature of the sealing will may vary by 15 to 20 degrees more or less than the set limit when the machine starts the first time in the morning or after power off for long duration. Starts the function of the machine after temperature steady to its set limit. In machine running temperature variation will be +/- 5 degree.

Cooling station

The cooling station is provided to cool the sealed web immediately after sealing. This station consists of the top plate, bottom plate and the change part cooling plate. The web is guided in between top plate and the change part cooling plate. The bottom plate is operated in every cycle and the pneumatic cylinder, which is operated by PLC, controls the operation.

Pulling station

The pulling station is provided to pull the sealed web in continuous motion. The web is pulled by pulling roller and the thrust roller. The pulling roller is driven by servo



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motor. Speed of the servo motor is controlled by PLC program and parameters entered for blister format.

Web loop detection system

Web guide is provided to hold and align the sealed web properly before embossing and perforation station.

Loop Setting: Round disc used to hold and position the web. Position of this disc is adjustable with the square rod laterally according to the cavities on the web. It is adjustable with knob to rotate the disc around the stud. Main purpose of the loop adjuster is to adjust loop for NFD count. Web guide: Guides provided to guide the sealed web before embossing and perforation station.

Perforation station

In this station, perforation is done on a sealed web according to the blister layout. Assembly of perforation blade does this function. It consists of blade holding block, which is spring loaded and mounted on a fixed plate. A counter plate is mounted on a moving plate. A slit on the counter plate is used to guide the blade during perforation.

Embossing station

This station is provided to facilitate coding of useful information on a sealed web. The sealed web passes through the embossing tool; an adjustable web guide aligns the web before embossing. A spring-loaded clamp exerts a continuous pressure on the web. A Letter holder is mounted in the upper side and a counter tool is mounted on the bottom side. A moving plate with the counter tool forces the web against letters and code on the web.

Number of letters in embossing tool depends on blister size or requirement. Maximum 40 letters can emboss on per blister.

Indexing station

Indexing station consists of indexing roller that indexes the web in punch tool for cutting the blister. Indexing roller is designed as per cavity shape. A servomotor drives this roller, which are mounted on backside of the roller.

A sensor is provided to sense the web when the web gets jammed in punching station and loop formed in between punching and indexing roller. The sensor senses the sealed web and stops the machine.

Punching station

In this station, punching tool cuts the Blisters as per the Blister layout. It consists of a punch and a



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die (cutting plate) that decides the blister shape. The punch is moving, and the die is fixed with guide pillar. A support plate is fixed on the die plate to guide the web in contact with the die for precise cutting. After Blister punching, another cutter fitted on bottom side of the moving elate, and then cuts whatever wastage left.

Punch speed depends on the blister layout and is in multiple of machine cycles. If one cycle consists of one blister, then ratio is 1:1, If one cycle consists of two blisters, punching speed is double (Number of tacks are not important).

Blister pickup station

The Blister pickup unit picks up the blisters from punching tool and drops them at different angles as per the requirement:

- 45^0 : To reject the blisters and drop them inseparate collection bin
- 90^0 : To accept and drop the blisters on the transfer conveyor
- 180^0 : To accept and drop the blisters in separate collection bin when downstream machine is not ready.

Blisters are picked up with suction cups mounted on the sucker arms. An air venturi generates the vacuum and it is connected to the sucker arms through a channel.

Blister Accept or Reject signal to pick up system is given through either NFD or Camera.

Based on this signal, pick up unit drops the blister at above mentioned position.

Tower lamp

Tower lamp is installed on the top of the machine which shows the status of the machine in terms of running, stop, and ready mode. These lights blow with the hooter installed in the machine. The yellow light blows ON when the machine is ready to RUN. Green light blows ON when the machine is in running state. Red light blows ON when the machine stops due to any fault or error in the system.

Over printing unit

The printing unit is provided to print information like batch, manufacturing information and so on.

This unit is installed before the sealing station. The printing is done on lidding foil at a pitch distance (depending on blister layout) to have print on every blister. The lidding foil is passed through a stereo roller and a pressure roller. Stereos are stuck on the stereo roller. An ink from the ink cartridge is transferred to the stereos and then from the stereos to the lidding foil



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The pressure between stereo roller and pressure roller can be adjusted with the help of knob to get sharp and clear printing.

7.0 PRE – QUALIFICATION REQUIREMENTS:

7.1 Verification of Documents:

- DQ Protocol Cum Report
- IQ Protocol cum Report
- Draft SOP for operating & Cleaning of Blister packing machine
- Draft SOP for Preventive Maintenance of Blister packing machine
- Electrical circuits diagram
- Technical specification of equipment

7.1.1 Procedure:

- Verify the above mentioned documents for availability, completeness and approval status
- If any deviation is observed the same has to be recorded giving reasons for deviation and approved. Deviation should be approved by Authorized person.
- Approved Drawings and supporting documents would form a part of the OQ Protocol cum report.

7.1.2 Acceptance Criteria:

All the documents should be available, complete and approved by respective authorities.



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8.0 CRITICAL VARIABLES TO BE MET:

8.1 VERIFICATION OF DOCUMENTS:

The results of any tests should meet the limits and acceptance criteria specified in the test documents. Any deviations or issues should be rectified and documented prior to OQ commencing.

S.No.	Document Name	Document / SOP No.	Completed (Yes/No)	Checked By Sign & Date	Verified By Sign & Date
1.	DQ Protocol Cum Report				
2.	IQ Protocol Cum Report				
3.	Draft SOP for operating & Cleaning of Alu – Alu Blister Packing Machine.				
4.	SOP for Preventive Maintenance of Alu – Alu Blister Packing Machine				

8.2 TEST EQUIPMENT CALIBRATION:

Verify that all critical instruments associated with the system will be in a calibrated state. Review the calibration status for the test equipment to be utilised and record the calibration due dates in the table below. All Equipment / Instrumentation must remain within the calibration due date for the duration of OQ test for which the item is used. If a due date potentially occurs during the testing period then the instrument must be recalibrated before it can be utilised.

Instruments Name	Instrument ID	Calibration On	Due On	Observed By Sign & Date

Verified By
Sign & Date:



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8.3 OPERATIONAL TEST:

8.3.1 Operate the Alu-Alu Blister Packing Machine as per Manufacturer's Manual / SOP and Check for the following functions of the Equipment. The Equipment should function as desired.

Operation	Acceptance criteria	Observation
Check correct working of Alu-Alu Blister Packing Machine BQS.	The machine should be operational	
Operate the machine as per its SOP. Check for proper	these function are satisfactory	
Check working of temperature controller, vacuum gauge and pressure gauges.	Displayed temperature, vacuum and pressure are within the set limits.	

Verified By

Sign & Date:

8.3.2 EMERGENCY SWITCH VERIFICATION:

Item	Acceptance Criteria	Observation	Observed By Sign & Date
Push Emergency STOP on HMI	The Machine will STOP immediately		
Push Emergency STOP above Indexing Station	The Machine will STOP immediately		

Verified By

Sign & Date:

8.3.3 VERIFICATION OF ALARMS & SAFETY INTERLOCKS:

Item	Acceptance Criteria	Observation	Observed By Sign & Date
Emergency stop press on console	The machine will stop immediately		
Emergency stop press at indexing	The machine will stop immediately		
Vacuum key OFF from HMI	The machine will stop at cycle end / will not start		
Base foil end	The machine will stop at cycle end		
Lidding foil end	The machine will stop at cycle end		
Web slippage at indexing	The machine will stop at cycle end		
Product level sensor ON &	The linear vibrator will stop / will start		



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OFF in auto mode during AUTO feeding			
Low air pressure (below 4 bar)	The machine will stop at cycle end		
Low temperature of forming top plate (15°C less than set)	The machine will stop at cycle end/ will not start		
High temperature of forming top plate (20°C less than set)	The machine will stop at cycle end/ will not start		
Thermocouple open of forming bottom plate	The machine will stop at cycle end/ will not start		
Low temperature of forming bottom plate (15°C less than set)	The machine will stop at cycle end/ will not start		
High temperature of sealing bottom plate (20°C less than set)	The machine will stop at cycle end/ will not start		
Thermocouple open of forming bottom plate	The machine will stop at cycle end/ will not start		
Low temperature of sealing top plate (15°C less than set)	The machine will stop at cycle end/ will not start		
High temperature of sealing top plate (20°C less than set)	The machine will stop at cycle end/ will not start		
Thermocouple open of sealing top plate	The machine will stop at cycle end/ will not start		
High temperature of chilled water	The machine will stop at cycle end		
Water supply off in running	The machine will stop at cycle end		
Machine guard open in running	The machine will stop at cycle end/ will not start		
Base foil splicing joint detection	Blisters will be rejected at 45° as per count		
Lidding foil splicing joint detection unsealed blisters detection	Blisters will be rejected at 45° as per count		
Unemboss blister detection	Blisters will be rejected at 45° as per count		
Unprinted blisters detection	Blisters will be rejected at 45° as per count		
Loop sensor ON top & bottom in running	Machine will stop at cycle end		

Verified By

Sign & Date:



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8.3.4 VERIFICATION OF INCORRECT PARAMETERS INPUT/INVALID INSTRUCTIONS:-

The aim of this test is to verify the machine output in case of incorrect parameter input/invalid instructions.

Item	Acceptance Criteria	Observation	Observed By Sign & Date
Forming top & bottom plate temperature	Error message should display on screen with instruction for upper limit		
Sealing top plate temperature	Error message should display on screen with instruction for upper limit		
Embossing / perforation temperature	Error message should display on screen with instruction for upper limit		
Cam value	Error message should display on screen with instruction for upper limit		
Air Pressure	Error message should display on screen with instruction for upper limit		
Machine Speed	Error message should display on screen with instruction for upper limit		

Verified By
Sign & Date:



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8.3.5 POWER FAILURE VERIFICATION:

Item	Acceptance Criteria	Observation	Observed By Sign & Date
Main Power shut down	Equipment stops in safe and secure condition		
Main Power Restored	Equipment can be restarted with no problems or adverse conditions.		

Verified By
Sign & Date:

Inference:

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Reviewed By
Sign & Date:

9.0 REFERENCES:

The Principle Reference is the following:

- Validation Master Plan.
- Schedule-M – “Good Manufacturing Practices and Requirements of Premises, Plant and Equipment for Pharmaceutical Products.”
- WHO Essential Drugs and Medicines Policy, QA of Pharmaceuticals, Vol-2 – Good Manufacturing Practices and Inspection.

10.0 DOCUMENTS TO BE ATTACHED:

- Operation And Maintenance Manual
- Copy of SOPs
- Any Other Relevant Documents



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11.0 DEVIATION FROM PREDEFINED SPECIFICATION IF, ANY:

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12.0 CHANGE CONTROL, IF ANY:

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13.0 REVIEW (INCLUSIVE OF FOLLOW UP ACTION, IF ANY):

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14.0 CONCLUSION:

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15.0 RECOMMENDATION:

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16.0 ABBREVIATIONS:

No.	:	Number
WHO	:	World Health Organization
cGMP	:	Current Good Manufacturing Practices
EU	:	European Union
QA	:	Quality Assurance
IQ	:	Installation Qualification
OQ	:	Operational Qualification
EQ	:	Equipment
VSF	:	Blister Packing Machine
MOC	:	Material of Construction
NLT	:	Not Less Than
HP	:	Horse Power
KW	:	Kilo Watt
SS	:	Stainless Steel
ID.	:	Identification
Kg	:	Kilo Gram
Ltrs	:	Liters
mm	:	Millimeter
MCB	:	Miniature Circuit Breaker



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17.0 POST APPROVAL:

PREPARED BY:

DESIGNATION	NAME	SIGNATURE	DATE
OFFICER / EXECUTIVE (QUALITY ASSURANCE)			

REVIEWED BY:

DESIGNATION	NAME	SIGNATURE	DATE
OPERATING MANAGER (QUALITY ASSURANCE)			
HEAD (PRODUCTION)			
HEAD (ENGINEERING)			

APPROVED BY:

DESIGNATION	NAME	SIGNATURE	DATE
HEAD (QUALITY ASSURANCE)			