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1.0   OBJECTIVE

To lay down the procedure for Operation and Cleaning of Condot Printer.

2.0   SCOPE

The procedure is applicable for Operation and Cleaning of Condot Printer in External Preparation area.

3.0   RESPONSIBILITY

Production: Associates/Officer /Executive/Manager

Head Production: To ensure execution & compliance.

Head QA: To ensure the compliance.

4.0   PROCEDURE

4.1   Preliminary Checks:

4.1.1   Visually inspect and check the machine and the area for the cleanliness.

4.1.2   Remove the 'cleaned' label and affix the 'under process' label on the equipment.

4.1.3   Take the line clearance of the conveyor , there should not be any carton or Tube of previous batches on the conveyor and area.

4.1.4   Confirm Product and Batch number of the batch that is to be code.

4.1.5   The followings are always taken in to consideration before starting the operation of the machine and get the line clearance accordingly.

4.1.6   Whether the same batch of the same product is to be continued or new batch of the same product is to be packed.

4.1.7   Whether a different product is to be taken on the machine.

4.2   Set up for Condot Printer:

4.2.1.   Feed the coding programmed as per Below instruction (Message editing):

4.2.2.   Open the OBJ INK draw program from desktop.

4.2.3.   Click on the New option of file option for new massage editing.

4.2.4.   Select the option HP51645A in HEAD TYPE menu from the display screen.

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4.2.5.   Select 12.7 mm for head engine type option for single pen on the screen.

4.2.6.   Select width as per requirement for space on carton for coding.

4.2.7.   Select the unit and should be in mm.
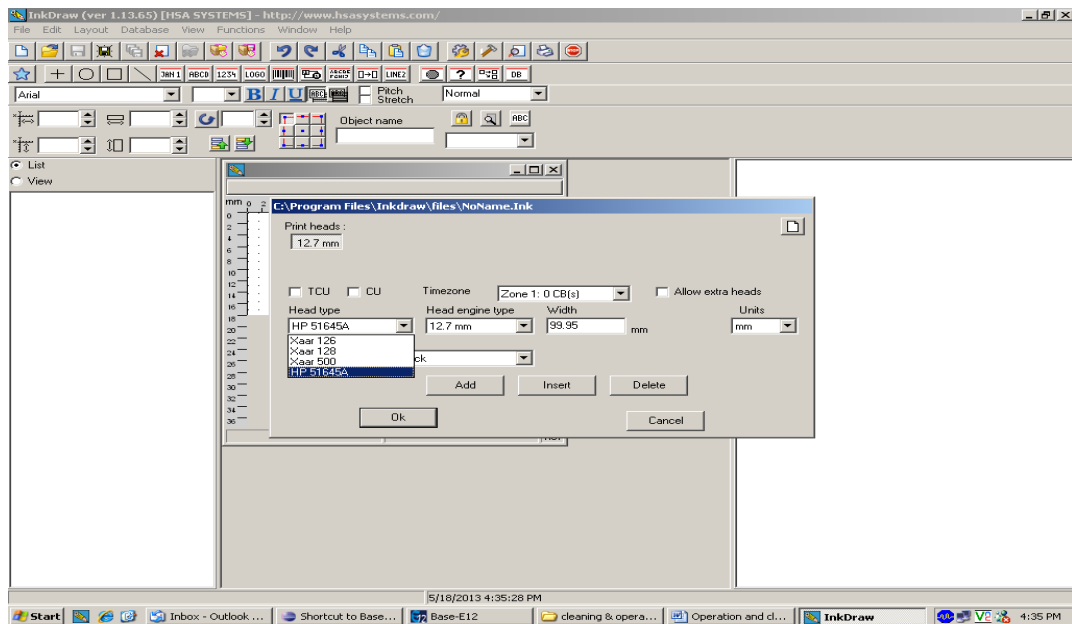
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4.2.8   Click the option "OK". Then canvas appears as…….
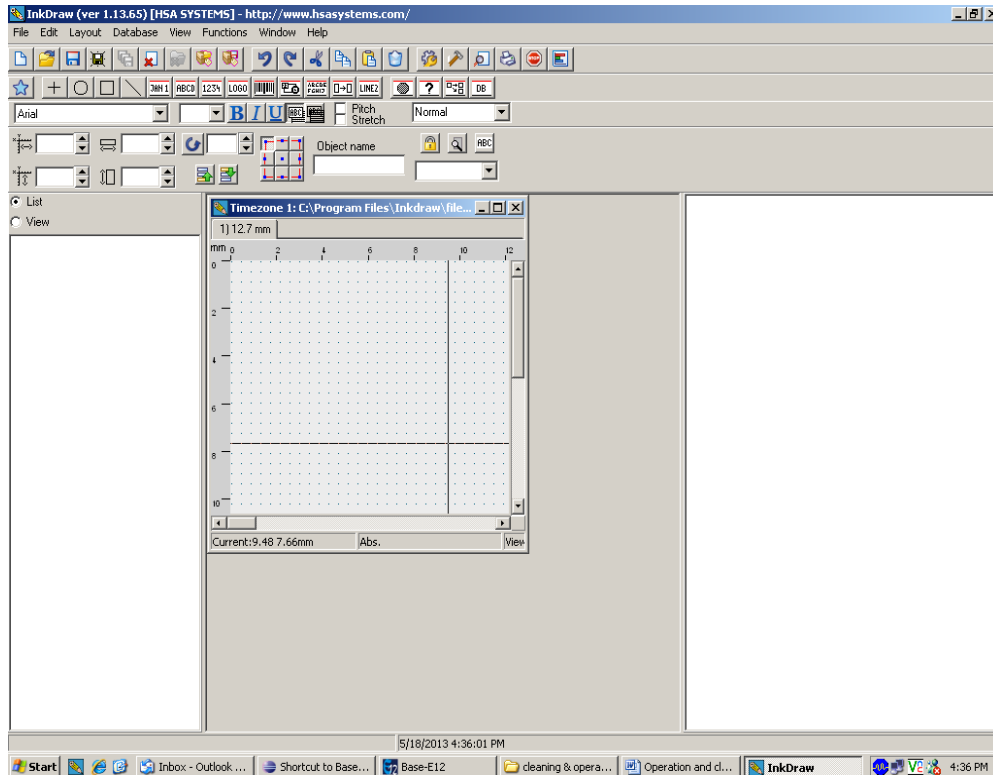
4.2.9   Select "ABCD" option from the main screen.

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4.2.10   Drag the cursor and select the text area as per the coding details one by one and the screen appears as.
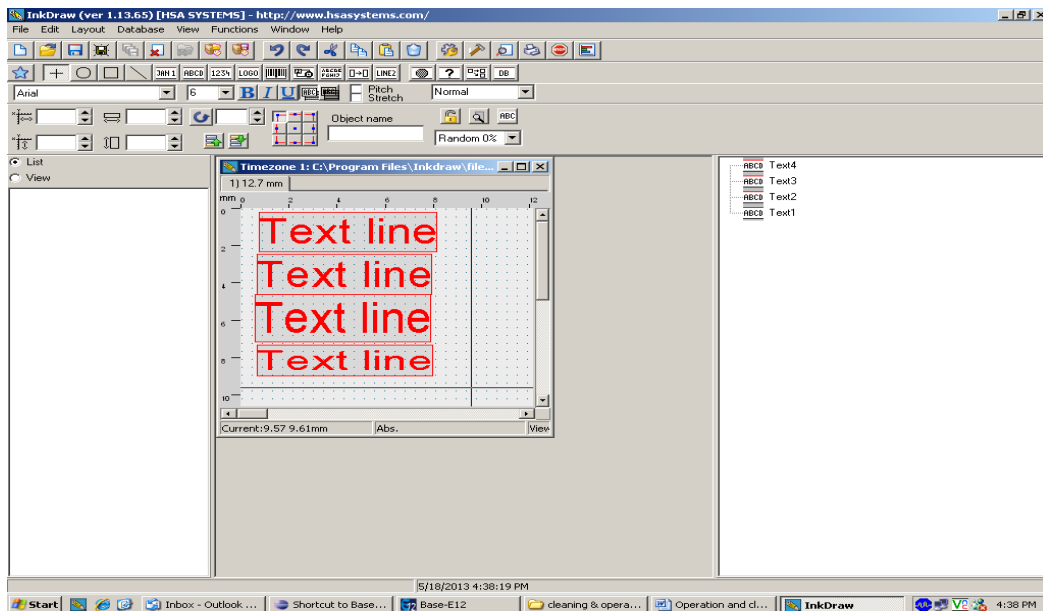
4.2.11   Select "Text-1" in the TCU mode by clicking. Text bar icon appeared on the main screen. Type the required text in the space given in the text bar icon then press the enter key.

4.2.12   Repeat the above step as per batch coding details.

4.2.13   Select the "FUNCTIONAL key" on the main screen tool bar then go to parameters and click. Screen appear as

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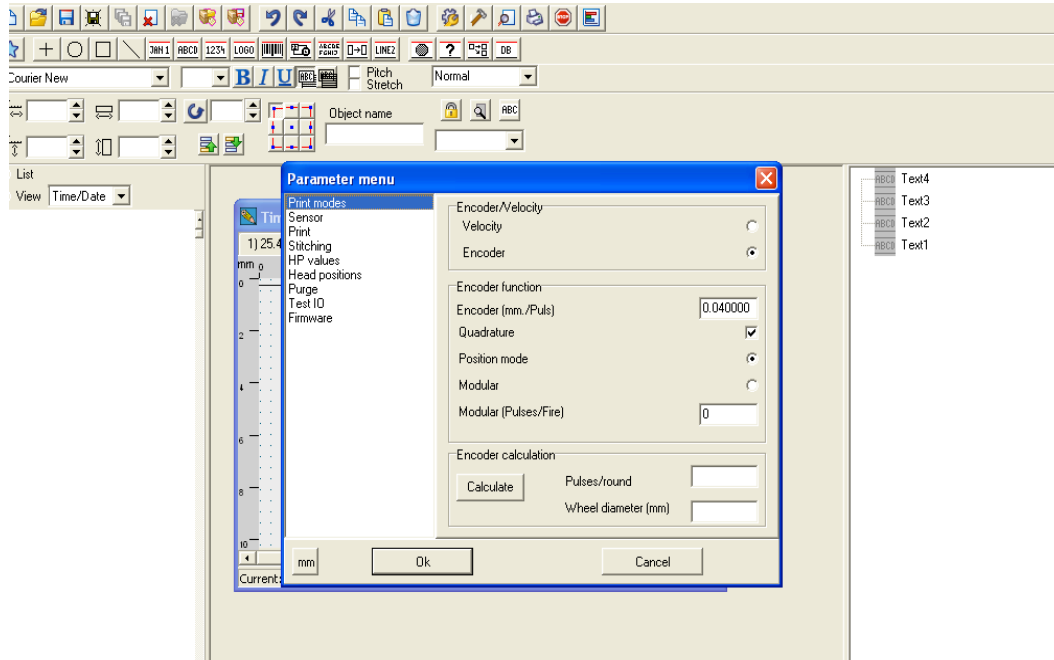
4.2.14   Eight options appear as:

4.2.14.1.   Print mode

4.2.14.2.   Sensor

4.2.14.3.   Print

4.2.14.4.   HP value

4.2.14.5.   Head position

4.2.14.6.   Purge

4.2.14.7.   Text IO

4.2.14.8.   Firmware

4.2.15   Select the "Print Mode" first. VELOCITY AND ENCODER appears on the same screen.

4.2.16   Select the encoder and go to calculation. Enter the 2500 value in pulse /round space.

4.2.17   Enter wheel diameter value as per requirement and calculate the icon .

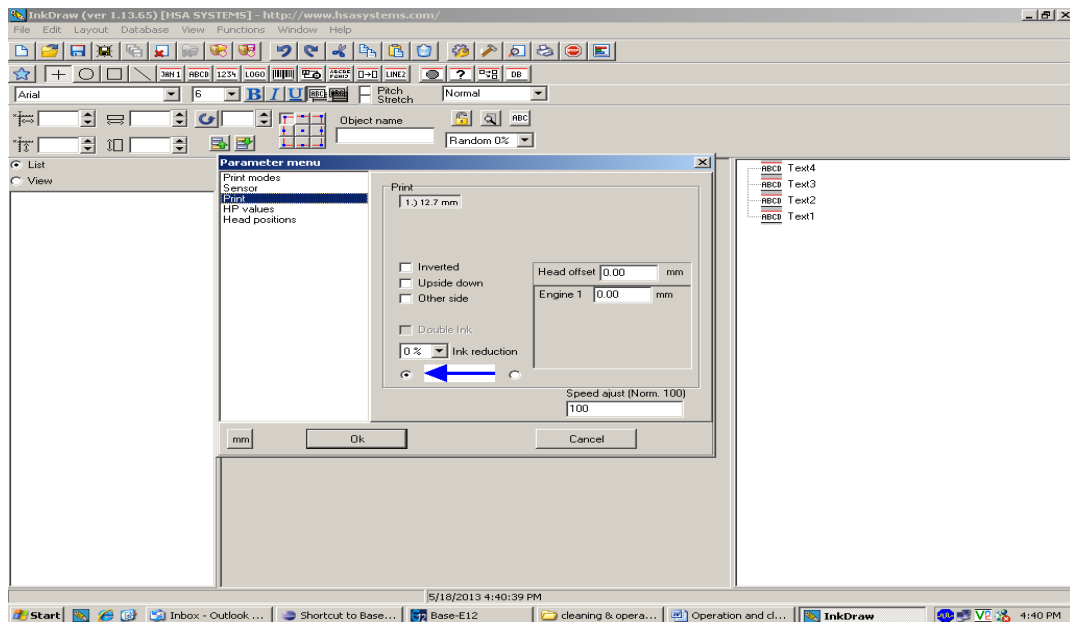4.2.18   Then click the "OK" icon.

4.2.19   Repeat the step no.4.2.13 and Select the sensor in the screen. Positive edge and Negative edge appears. Select the positive edge. Then click the "OK" icon.

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4.2.20   Repeat the step no.4.2.13 and Select the "Print" in the screen. Direction arrow appears as in the picture.

4.2.21   Ensure the direction of arrow is from right to left. Then click the "OK" icon.

4.2.22   Repeat the step no. 4.2.13 and Select the HP value. Select the "Resolution mode" screen appears as

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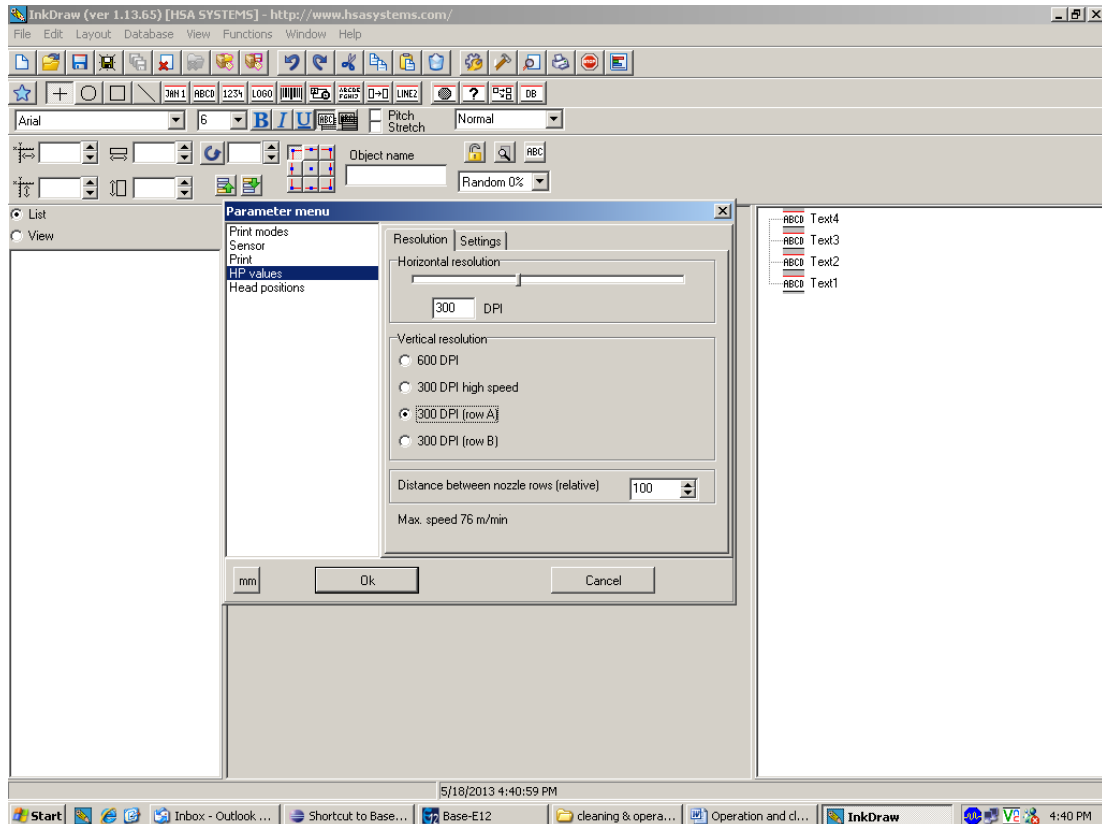
4.2.23 Select the Resolution as 300 DPI (row A) and click the "OK" icon.

4.2.24 Repeat the step no. 4.2.13 and Select the Head position CB1Head 1or CB1head 2.and press "OK" icon.

4.2.25 Repeat the step no. 4.2.13 and Select purge purge print engine 1 or 2 and press "OK" icon.

4.2.26 Select the file menu in main screen then go to "Save As" and save the file by given the suitable file name .ink.

4.2.27 Start the conveyor belt.

4.2.28 Open the ink draw, Select the file, and open the file, and give the print command to print matter on carton.

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4.2.29   Record the operation activity start time and end time in equipment usage log sheet as per SOP.
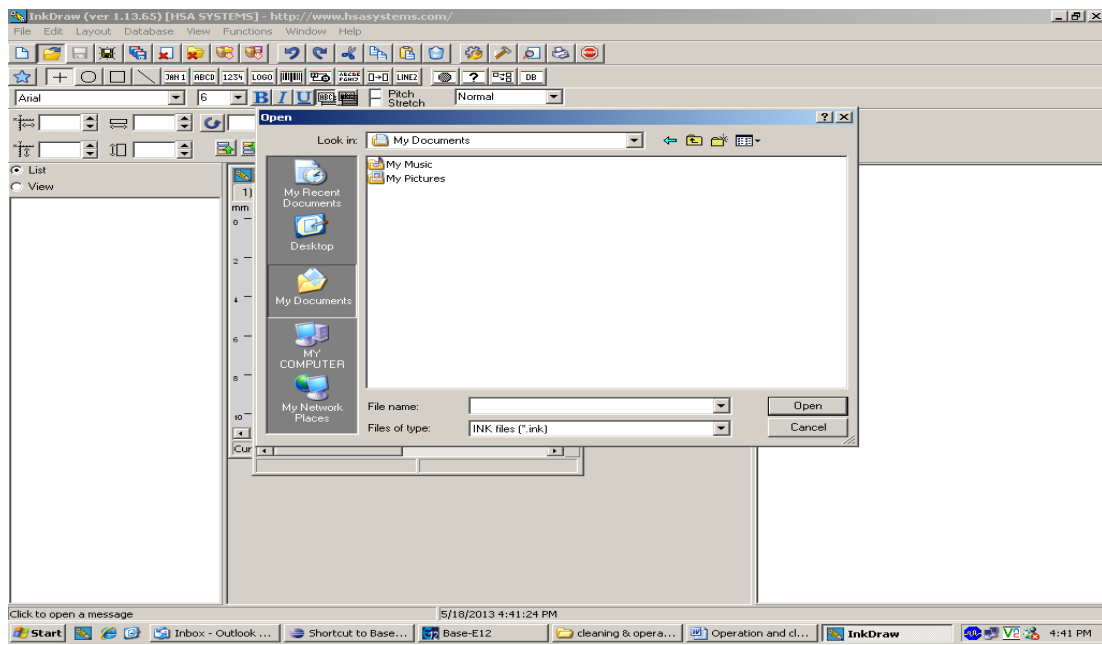
4.3   CLEANING

4.3.1   Ensure that all the materials of previous batch are removed.

4.3.2   Remove the "UNDER PROCESS "label and affix "TO BE CLEANED" label on the machine.

4.3.3   Ensure that main power supply should 'OFF'.

4.3.4   Clean the Ink cartridge with clean tissue paper.

4.3.5   Clean the top and outer surface of machine with the dry lint free cloth.

4.3.6   Replace the "UNDER PROCESS "status label by "CLEANED" status label on the machine with date and sign of the production officer.

4.3.7   Record the cleaning activity start time and end time in equipment usage log sheet as per SOP.

5.0   ANNEXURE (S):

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6.0   REFERENCE (S):

SOP- Procedure of filling of equipment log book

SOP-Preparation, approval, distribution control, revision and destruction of Standard Operating Procedure.

7.0   ABBREVIATION (S)/DEFINITION(S):

SOP   -   Standard operating Procedure

Min   -   Minutes

REVISION CARD

S.No.	REVISION No.	REVISION DATE	DETAILS OF REVISION	REASON (S) FOR REVISION	REFERENCE CHANGE CONTROL No.
1	00	---	---	New SOP	---