



PHARMA DEVILS

PRODUCTION DEPARTMENT

STANDARD OPERATING PROCEDURE

Department: Production	SOP No.:
Title: SOP for Inspection of Punch and Dies	Effective Date:
Supersedes: Nil	Review Date:
Issue Date:	Page No.:

Purpose: To lay down operating procedure for inspection of Punch & Dies.

Scope: This procedure is applicable to

Responsibility: Production Chemist
To supervise the activity

Procedure:

1. Take a punch and die set for inspection from punch store
2. Clean and count all punches and dies before examination.
3. By using punches and dies Measurement check all parameter such as
 - Head, neck Barrel, Stem, Tip, Concavity, Outer surface polish, any embossed logo or name inside the punch surface etc. of punches.
 - Check no damages should be there on Tip of the Punch and embossed characters of any logo.
 - Check Punch with GO-NO GO gauge for any damage on the head of the Punches.
4. Check dies thoroughly with Venire Calipers all parameter such as
 - Internal Diameter, Outer Diameter, Length, Smooth flat surface, any browse or ohms inside of dies any fine cracks and locking knurling etc.
5. Discard the Punches and Dies that fails or repair it from engineering personals.
6. After doing this examination of punches set found OK then it can be used for Further compression of 50 lacs. tablets .
7. Record the observation in the record file.