



PHARMA DEVILS

PRODUCTION DEPARTMENT

STANDARD OPERATING PROCEDURE

Department: Production

SOP No.:

Title: Operation of Compression Machine

Effective Date:

Supersedes: Nil

Review Date:

Issue Date:

Page No.:

Purpose: To lay down operating procedure for the operation of Compression machine

Scope: This procedure is applicable for

Responsibility: Production Chemist
To supervise the activity

Pre-operating Check: Check no material or residue should be there.

Equipment used: Compression machine

Operating Procedure:

1. Check the cleaning of compression machine and surrounding area.
2. Identify the correct punches and dies for the product (as per BMR) to be taken and take out those punches from the tool room and take those to the compression area,
3. Set the dies first by hand then tight the screws. Ensure the tightness of the die by rotating the head of the die
4. Lubricate the lower punches and if they are irregular shape then set each punch by inserting the into the die cavity. Then tight the key so that the punch cannot move or dislocate it's position when the machine is running.
5. Pit the upper punches without lubricating it into the cavity.
6. Ensure while insertion of the upper punch the movement of the respective punches in their sockets
7. Rotate the machine by hand to ensure the smooth running of the machine if it not smooth; then "Do not operate the machine" and informs maintenance for the concern problem.
8. Then once again check the setting of machine by rotating it by hand.
9. Then assemble the other parts of machine such as feed frame, guards, hoppers, dust collectors, dust extractor etc.
10. Charge very little amount of the lubricated granules in the hopper and allow to fill the die cavity of the press. During this filling of die cavity observe that the flow of the granules in proper and uniform otherwise make necessary adjustment in the feed frame
11. Switch on the dust collector and dust extractor then start the press with minimum speed to ensure the setting of the feed frame Hopper etc has no disturbed the setting of machine
12. Discard the 2 to 3 trial run tablets.
13. Set the physical parameters like thickness, hardness, tablet weight etc. and Check those in In-process testing laboratory
14. When the parameters are within in the specified limit. Make the final adjustment and set the speed of machine so as to run the machine



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smoothly.

14. Once a container is filled store the tablets in a poly bag and remove the air inside the bag and tight it.

Precaution and check point

1. Speed of machine should be adjust when motor is stopped.
2. Compression machine should not run with punches and dies fitted unless it is making tablets.
3. Compression machine switch should not on directly on electrical supply. Always turn the machine by hands before starting under powder.
4. Check that the punches are free in punch guides and drop under their own weight. Punches move freely through the cam tracks. Punches heads should be smeared with oil.