



MODE OF OPERATION IN PLC/ HMI SYSTEM

1.0 OBJECTIVE

To lay down a procedure for handling of mode of operation in PLC/ HMI System.

2.0 SCOPE

This procedure is applicable for mode of operation in PLC/ HMI System located in manufacturing area.

3.0 RESPONSIBILITY

Technical Associate : Machine Operation

Officer and Executive : Monitoring the parameters / Alarms and Edit of set parameters

Head Production : SOP compliance/ Creation of Recipe

IPQA : SOP compliance

4.0 DEFINITION (S)

NA

5.0 Operation in PLC/ HMI System

5.1 Assigning of Level

5.1.1 Three levels of passwords shall be assigned, as follows:

5.1.2 **Level- I:** For Technical Associates and Trainee Technical associate

5.1.2.1 In this level Technical associate and Trainee Technical associate can load the recipe and operate the machine as per the loaded recipe.

5.1.2.2 Before operation of machine Technical associates and Trainee Technical associate ensures that the loaded recipe is for particular batch (Program no. and Program Code).

5.1.3 **Level- II:** For Officers and Executives

5.1.3.1 In this level Officers and Executives can load the recipe, operate the machine as per the loaded recipe and edit the recipe as per variable parameters like Batch No., Lot No., Operator Name, manufacturing date, expiry date and air dry time example in RMG, FBD, Coating, and FBP.

5.1.3.2 Before operation of machine Officers and Executives ensures that the loaded recipe is for particular batch (Program no. and Program Code) and check the loaded recipe as per respective BMR.

5.1.4 **Level- III:** For Managers and Above

5.1.4.1 In this level Managers and above loads or create the recipe, operate the machine as per the loaded recipe, edit the recipe, and Delete the recipe.



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| 5.1.5 | Level | Allocation | Creation , loading and operation | Loading, Change in Batch No., Lot No., Operator Name, manufacturing date, expiry date and operation | Loading, and operation |
|-------|-------------|--|---|--|------------------------------|
| | Level- I | For Technical Associates and Trainee Technical | X | X | √ |
| | Level- II | For Officers and Executives | X | √ | √ |
| | Level - III | For Managers an | √ | √ | √ |

5.1.6 Before start of machine Officer production and Officer QA, should verified the recipe.

5.2 Operation of PLC/ HMI System in Granulation area :

5.2.1 Granulation-I :

RMG (Make- Kevin):

- Auto mode
- Manual mode
- Maintenance mode

FBD (Make-Alliance) :

- Auto mode
- Manual mode

5.2.2 Granulation-II :

RMG (Make- sainath):

- Auto mode
- Manual mode

FBD (Make-Anchor mark) :

- Auto mode
- Manual mode

5.2.3 Granulation-III :

RMG (Make- Bectochem):

- Auto mode
- Manual mode
- Maintenance mode



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FBD (Make- Bectochem) :

- Auto mode
- Manual mode
- Maintenance mode

5.2.4 **Granulation-IV :**

RMG (Make- Bectochem):

- Auto mode
- Manual mode
- Maintenance mode

FBD (Make-Bectochem) :

- Auto mode
- Manual mode
- Maintenance mode

5.2.5 **Pilot plant :**

RMG (Make- Kevin):

- Auto mode
- Maintenance mode

FBD (Make-Alliance) :

- Auto mode
- Manual mode

5.2.6 **FBP (Make-Anish) :**

- Auto mode
- Manual mode
- Maintenance mode

5.2.7 **Washing machine (Make- Cybernetik) :**

- Auto mode
- Manual mode

5.3 Operation of PLC/ HMI System in Coating area :

5.3.1 **Coating I (Make- Sejong):**

- Auto mode
- Manual mode

5.3.2 **Coating II (Make- Ganson):**

- Auto mode
- Manual mode



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5.3.3 Coating III (Make- Ganson):

- Auto mode
- Manual mode
- Maintenance mode

5.3.4 Coating IV (Make- Ganson):

- Auto mode
- Manual mode

5.3.5 Coating V (Make- Ganson):

- Auto mode
- Manual mode

5.3.6 Coating VI (Make- Ganson):

- Auto mode
- Manual mode
- Maintenance mode

5.3.7 Coating VII (Make- Ganson):

- Auto mode
- Manual mode
- Maintenance mode

6.0 ABBREVIATION (S)

- Q.A. : Quality Assurance
SOP : Standard Operating Procedure
HMI : Human Machine Interference
BMR : Batch Manufacturing Record
FBP : Fluid bed processor
RMG : Rapid Mixer Granulator
FBD : Fluid Bed Dryer

7.0 REFERENCES (S) : NA

8.0 ANNEXURE (S) : NA

9.0 DISTRIBUTION

- Master Copy** : Quality Assurance
Controlled copy (S) : Production department, Quality Assurance
Reference copy (S) : Production department