



**PHARMA DEVILS**  
QUALITY ASSURANCE DEPARTMENT

**FACTORY ACCEPTANCE TEST PROTOCOL CUM REPORT FOR AUTOMATIC  
CAPSULE FILLING MACHINE AF 90 T-11**

**FACTORY ACCEPTANCE TEST PROTOCOL CUM REPORT**

**EQUIPMENT NAME: AUTOMATIC CAPSULE FILLING MACHINE AF 90 T-II**

**REVISION HISTORY**

Rev.	Date	Authorized By:	Revision Summary
00	-----NA-----	-----NA-----	-----NA-----



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<b>Prepared By (Name &amp; Designation)</b>	<b>Signature</b>	<b>Date</b>
(Production)		
(Quality Assurance)		

<b>Checked By (Name &amp; Designation)</b>	<b>Signature</b>	<b>Date</b>
(Production )		
(Maintenance)		
(Quality Assurance)		

<b>Approve By (Name &amp; Designation)</b>	<b>Signature</b>	<b>Date</b>
(Quality Assurance)		



**FACTORY ACCEPTANCE TEST PROTOCOL CUM REPORT FOR AUTOMATIC  
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- 2.0 Objective:** The objective of this protocol cum Report is to ensure that the Automatic Capsule Filling Machine AF90T is manufactured as per designed specification at manufacturer site and to check the basic performance of the machine at manufacturer Site.
- 3.0 Scope:** This protocol is applicable to the machine manufactured by M.....
- 4.0 Responsibility:**
- 4.1 ACG PAM Engineers Shall be responsible for:**
- 4.1.1** Fabrication of Equipment as per Design Specification.
  - 4.1.2** To manufacture the machine as per URS.
  - 4.1.3** To provide all related drawings Equipment manual, safety feature.
- 4.2 ..... Shall be responsible for:**
- 4.2.1** To carry out the execution of FAT
  - 4.2.2** To verify that machine is designed as per URS
  - 4.2.3** To verify that machine complies GMP standard
- 5.0 Procedure:**
- 5.1** Take out photocopy of the approved protocol cum Report for the Factory Acceptance Test to be carried out at manufacture's Site.
  - 5.2** Carry out the below tests mentioned in the below table at manufacture's Site.
  - 5.3** Check the basic operation of the machine.
  - 5.4** In case any deviation observes during FAT, document it in deviation section.
  - 5.5** Ensure that corrective action taken is meeting the user requirement specification.
  - 5.6** If deviation is acceptable, document in observed deviation section and provide proper justification.
  - 5.7** If deviation does not acceptable, inform the manufactures for necessary action.
  - 5.8** If deviation acceptable, provide final conclusion.
  - 5.9** Ensure that following listed documents are provided.
    - Operation & Maintenance Manual
    - Electrical & mechanical schematic diagram
    - Process and utility diagram
    - Critical spare part list



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**6.0 Acceptance Criteria:**

- 6.1 The equipment shall fulfill the selection criteria & its purpose of application.
- 6.2 The equipment shall be as per purchase order.
- 6.3 Accessories shall be as per purchase order.
- 6.4 The equipment shall meet pre-selected design parameters.

**7.0 Verification Sheet:**

S.No.	Parameter	Specification	Observation	Checked By (Sign & Date)
<b>Capsule Filling Machine</b>				
1.	<b>Output</b>			
	For powder filling	Up to 90, 720 capsules/hr.		
	Capsule Size	#0/#2 powder filling		
	Overall Dimension	2820 (L) mm x 2600 (W) mm x 2050 (H) mm Approx.		
	Equipment weight	2000 kg Approx.		
2.	<b>Structure</b>			
	Material	Mild Steel, painted, enclosed on all sides by SS 304 covers		
	Structure covers	120-140 grit finish outside		
3.	<b>Top cover Assembly</b>			
	Position	Above top plate		
	Manufacturer	ACG-Pam		
	Specification	Enclosure with toughened glass doordoor		
	Material of support frame	Aluminium anodized, phoenix Mecanno make		
	Surface Finish	Satin finish		
4.	<b>Drive Assembly</b>			
	Position	Below the top plate for performing various operations		
	Manufacturer	ACG-Pam		
	Specification	Drive assembly for AF 90T		
	Material	Alloy Steel		
	Cams	En 36		
	Bearings	INA/IKO/RNST/FAG		
5.	<b>Turret Assembly</b>			



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	Position	Cylindrical disc above Machine Top, holding cap & body bush holders		
	Manufacturer	ACG-Pam		
	Specification	Turret assembly of AF 90T		
	Material	Aluminium casting		
	Surface finish	Electro less nickel plated		
6.	<b>Loader Assembly</b>			
	Position	Above machine top plate to load empty capsules in bushes		
	Manufacturer	ACG-Pam		
	Specification	Loader assembly AF 90T		
7.	<b>Magazine</b>			
	Material	Aluminium		
	Surface Finish	Black Hard anodized		
8.	<b>Rectifier raceway &amp; finger Assembly</b>			
	Material	SS316/Brass		
	Surface finish	320 grit mirror finish/Electro less nickel plated		
9.	<b>Reservoir &amp; baffled plate</b>			
	Material	SS 316 L		
	Surface finish	320 grit mirror finish		
10.	<b>Powder Filling Device</b>			
	Position	Above machine top plate to provide powder for filling operation		
	Manufacturer	ACG-Pam		
	Specification	Powder filling device		
11.	<b>Hopper</b>			
	Material	SS 316 L		
	Surface finish	320 grit mirror finish		
	Capacity of Hopper	20 Ltrs.		
	Force feeding System	Stirrer is provided in mail hopper		
	Powder level sensor	Power level sensor given at one stages for lower level with visual alarm. Low level sensor will stop the machine after (1-19 sec) of alarm initiation.		
12.	<b>Empty Capsule Hopper</b>			



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	Position	Above machine top plate to provide capsule for filling operation.		
	Manufacturer	ACG-Pam		
	Material	SS 316		
	Finish	320 grit mirror finish		
	Capacity of Hopper	27 Ltrs.		
	Sensor in hopper	Two sensors in empty capsule hopper. Low level sensors on the sorter elevator and upper level sensor off the sorter elevator. If low level sensor remains active for 90 sec. the machine is stopped		
13.	<b>Pin plate Assembly</b>			
	Position	Above machine top plate to perform various operations like closing, ejection, bush cleaning, removing unopened capsules		
	Manufacturer	ACG-Pam		
	Specification	Pin Plate Assembly		
	Material	Alloy steel		
	Surface finish	Electroless nickel plated		
14.	<b>Unopen, closing, Ejection pin</b>			
	Material	SS 316L		
	Surface finish	Matt finish 120-140 grit matt finish		
15.	<b>Bush cleaning pin</b>			
	Material	Brass		
	Surface finish	ENP		
16.	<b>Limit Switches (4 Nos.)</b>			
	Specification	Door safety switches		
	Position	Aluminium plate of top cover Assembly		
	Manufacturer	Essen		
	Model No.	MBC 1		
	Actuating Force	723 gms. (max.)		
	Release Force	170 gms. (min.)		
	Pre travel	1.5 mm (max.)		
	Over travel	4.6 mm.		
	Movement	0.08 mm. (max)		
	Differential			



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	Salient Features	Spring plunger actuator protected by a synthetic rubber cowl		
17.	<b>Proximity Sensor (Capacitive) for capsule Hopper</b>			
	Specification	Capsule & Pellet low level Sensor		
	Position	Capsule & Pellet hopper		
	Manufacturer	IFM		
	Model No.	KG5043 3008 BPKG / NI		
	Sensing range	8 mm		
18.	<b>Proximity Switches (Capacitive) for powder level</b>			
	Specification	Powder low level switches		
	Position	Powder tub		
	Manufacturer	IFM		
	Model No.	KG5043 3008 BPKG / NI		
	Sensing range	8 mm		
19.	<b>Proximity Sensor (Inductive)</b>			
	Specification	To detect '0' position of encoder		
	Position	Near encoder assembly (Inside structure)		
	Manufacturer	TAP		
	Model No.	GLP-12APS		
	Sensing range	1 mm		
20.	<b>Proximity Sensor (Inductive) for hand wheel</b>			
	Specification	To provide the signal for various operations		
	Position	Inside structure & near wheel shaft		
	Manufacturer	TAP		
	Model No.	GLP-12APS		
	Specification	10-30 VDC 250 mA		
	Sensing range	1 mm		
21.	<b>Proximity Sensor (Inductive) for main Motor</b>			
	Specification	To provide the signal for various operations		
	Position	Near main motor clutch		
	Manufacturer	TAP		
	Model No.	GLP-12APS		
	Specification	10-30 VDC, 250 mA		





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	Sensing range	1 mm		
22.	<b>Proximity Sensor (Inductive) for PMM motor</b>			
	Specification	To provide the signal for various operations		
	Position	On PMM motor gear box		
	Manufacturer	TAP		
	Model No.	GLP-12APS		
	Sensing range	1 mm		
23.	<b>Vacuum Valve</b>			
	Specification	ON/OFF valve for vacuum for capsule loading		
	Position	Inside structure		
	Manufacturer	Univer		
	Model No.	G-3232		
24.	<b>Encoder: 3600 PPR</b>			
	Specification	To provide signals for various operations		
	Position	Inside structure		
	Manufacturer	Fritz Kubler GMBH		
	Type No.	8.5000.8351.3600		
	Specification	10-30 VDC, 100mA		
25.	<b>Pressure Switch</b>			
	Specification	Air Pressure Switch		
	Position	Inside structure above filter regulator		
	Manufacturer	Indfoss		
	Model No.	IPS-100-20D8276		
	Range	0-100 psi (0-7 Kg/cm <sup>2</sup> )		
26.	<b>Vacuum valve</b>			
	Specification	ON / OFF valve for vacuum for capsule loading		
	Position	Inside structure		
	Manufacturer	Univer		
	Model No.	AG-3232		
	Range	(610 torr – 0.5 torr) 610 mm Hg – 0.5 mm Hg.		
27.	<b>Pressure Switch</b>			



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	Specification	Air Pressure switch		
	Position	Inside Structure above airmatic		
	Manufacturer	Indfoss		
	Model No.	IPS-100-20D8276		
	Range	0 – 100 psi (0-7 kg/cm <sup>2</sup> )		
28.	<b>Pressure Gauge for main Air inlet</b>			
	Specification	Vacuum gauge for capsule separation		
	Range	0-(-760) mm Hg		
	Position	On FR unit inside structure		
	Manufacturer	UTC		
	Size	Dia 52 mm		
29.	<b>Vacuum Gauge for capsule Separation</b>			
	Specification	Vacuum Gauge for capsule separation		
	Range	0-(-760) mm Hg		
	Position	On vacuum pump		
	Manufacturer	UTC		
	Model no.	25-2B		
	Size	Dia. 65 mm		
30.	<b>Gauge for Vacuum pump</b>			
	Specification	Vacuum gauge		
	Range	0-(-760) mm Hg		
	Position	On Vacuum Pump		
	Manufacturer	UTC		
	Size	Dia. 50 mm		
31.	<b>Main Motor</b>			
	Position	Inside Structure		
	Manufacturer	Bharat Bijli Limited		
	Type	1.10 Kw, 2.0 HP, 705 RPM, Amp-3.90, AC Brake, Motor Frame 112 L, 3 Phase		
	Protection Class	IP 55		
32.	<b>Power stirrer motor with Gear Box (PMM motor)</b>			
	Position	Inside structure		
	Manufacturer	Rotomotive		
	Type	71B-4 (Motor), B5030251471B5 (Gear		



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		Box) 0.37 KW, 0.5 HP, 1350 RPM, Amp 1.0		
	Protection class	IP 55		
33.	<b>Machine Mount</b>			
	Position	Below structure		
	Manufacturer	Avmount		
	Specification	NAV 08 M 16 x 1.5		
34.	<b>Pneumatic cylinder</b>			
	Position	Inside turret well		
	Manufacturer	Festo		
	Type No.	AEVC-32-5-I-5		
	Operating pressure	6 bar (6 kg/cm <sup>2</sup> )		
	Max. Pressure	10 bar (10 kg/cm <sup>2</sup> )		
35.	<b>Pneumatic cylinder for capsule loading</b>			
	Position	On loader plate		
	Manufacturer	Festo		
	Type No.	ADVU-20-10-P-A,		
	Operating pressure	6 bar (6 kg/cm <sup>2</sup> )		
	Max. pressure	10 bar (10 kg/cm <sup>2</sup> )		
36.	<b>Pneumatic cylinder for group sampling</b>			
	Position	Below exit chut		
	Manufacturer	Festo		
	Type No.	DG-6-10		
	Operating pressure	6 bar (6 kg/cm <sup>2</sup> )		
	Max. pressure	10 bar (10 kg/cm <sup>2</sup> )		
37.	<b>Solenoid Valve</b>			
	Position	On pneumatic panel inside structure		
	Manufacturer	Festo		
	Type No.	MFH-3-1/8 SEU		
	Model No.	Type MFH-3-1/8 SEU Part no. 1121		
	Operating pressure	6 bar (6 kg/cm <sup>2</sup> )		
	Max pressure	10 bar (10 kg/cm <sup>2</sup> )		
38.	<b>Solenoid Valve</b>			
	Position	On pneumatic panel inside structure		
	Manufacturer	Festo		



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	Specification	Single Solenoid		
	Type No.	MFH-3-1/8 SEU		
	Operating pressure	6 bar (6 kg/cm <sup>2</sup> )		
	Range	0.5-8 bar		
39.	<b>Solenoid Valve for Capsule loading cylinder ON/OFF</b>			
	Position	On pneumatic panel inside structure		
	Manufacturer	Festo		
	Specification	Single loaded		
	Type No.	MFH-5-1/8		
	Operating pressure	6 bar (6 kg/cm <sup>2</sup> )		
	Range	1.8-8 bar		
40.	<b>Solenoid Valve coil</b>			
	Position	Fitted on solenoid valve		
	Manufacturer	Festo		
	Type No.	MSFG-24DC/42AC		
41.	<b>Filter Regulator for Main Air</b>			
	Specification	To provide the filtered air at a set pressure		
	Position	Inside structure near hand wheel		
	Manufacturer	Airmatic		
	Model No	B13-023		
	Size	6 mm		
	Max. Pressure	12 Kg/cm <sup>2</sup>		
	Pressure Range	0-9 Kg/cm <sup>2</sup>		
	Element Rating	25 microns		
42.	<b>Timer Belt</b>			
	Position	Drive assembly		
	Manufacturer	Optibelt		
	Specification	8 mm pitch, 1200 mm length, 30 mm width, 150 teeth		
43.	<b>A.C. Drives</b>			
	Position	Control sample assembly		
	Manufacturer	Schneider Electric		
	Specification	ATV12HU15M2, 1.5 KW/2.0 HP		
44.	<b>PLC</b>			



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	CPU make	Mitsubishi		
	Position	Inside the control panel box		
	Model	40MT/ESSLOT13Y		
	PLC Input / Output	24 Input / 16 Output		
45.	<b>MMI</b>			
	Model	GOT 1000		
	Position	On pendant control panel		
	Manufacturer	Mitsubishi		
	Keyboard	Touch Screen		
	Serial interface	RS-232, RS422		
	Display	5.7" diagonal		
	Supply Voltage	20.4-26.4±20% VDC		
46.	<b>Vacuum Pump for Capsule Separation</b>			
	Specification	Dry Vacuum Pump		
	Manufacturer	Becker		
	Type	KVT3.80		
	Pressure	22-25" of Hg		
47.	<b>Motor for Vacuum Pump</b>			
	Position	Fitted in Vacuum pump		
	Manufacturer	Becker		
	Type	2.4 KW, 1140 RPM, Amp 6.6, 3 phase		
48.	Basic cGMP Requirement	There should not be any crack crevice easy to operate and to clean. All the safety has been covered		

**8.0 Technical Specification of Air Displacement Unit (Model ADU 100)**

S.No.	Parameter	Specification	Observation	Checked By (Sign & Date)
1.	Main structure with handle			



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	Material	SS304		
	Surface Finish	320 grit mirror finish		
2.	<b>Dust Collector with cover</b>			
	Position	Above the main structure		
	Specification	Powder Collector		
	Manufacturer	ACG-Pam		
	Material	SS316		
	Surface finish of Frame	320 gritt mirror finish		
3.	<b>Filter Bag</b>			
	Position	Inside dust collector		
	Manufacturer	RP trading		
	Specification	5 micron		
	Air Permeability at WC 10M	4 to 9 cc/sec/cm <sup>2</sup>		
	Material	Synthetic fabric		
4.	<b>Impeller housing</b>			
	Position	Inside structure		
	Manufacturer	ACG-Pam		
	Specification	Provide suction inside dust collector		
	Material	Aluminium casting		
5.	<b>Motor</b>			
	Position	Above blower casing		
	Manufacturer	Hindustan Electric Motors		
	Type	1.5 KW, 2.0 HP, 2860 RPM, 3.10 Amp, 3 phase		
	Protection	IP 55		

**9.0 Technical Specification of Compact Air Displacement Unit (Model-CADU 100)**

S.No.	Parameter	Specification	Observation	Checked By (Sign & Date)
1.	<b>Trolley structure with cover</b>			



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	Material	Mild steel, SS304		
	Manufacturer	ACG-Pam		
	Surface Finish	120-140 grit matt finish		
2.	<b>Dust Collector with cover</b>			
	Position	Above the main structure		
	Specification	Powder Collector		
	Manufacturer	ACG-Pam		
	Material	SS316		
	Surface finish of Frame	320 gritt mirror finish		
3.	<b>Filter Bag</b>			
	Position	Inside dust collector		
	Manufacturer	RP trading		
	Specification	5 micron		
	Air Permeability at WC 10M	4 to 9 cc/sec/cm <sup>2</sup>		
	Material	Synthetic fabric		
4.	<b>Impeller housing</b>			
	Position	Inside structure		
	Manufacturer	ACG-Pam		
	Specification	Provide suction inside dust collector		
	Material	Aluminium casting		
5.	<b>Motor</b>			
	Position	Above blower casing		
	Manufacturer	Hindustan Electric Motors		
	Type	1.5 KW, 2.0 HP, 2860 RPM, 3.30 Amp, 3 phase		
	Protection	IP 44		

**10.0 Technical Specification of Empty Capsule Sorter Model ECS 100**

S.No.	Parameter	Specification	Observation	Checked By (Sign & Date)
1.	<b>Main body with doors</b>			



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	Material	SS304		
	Surface Finish	320 grit mirror finish		
2.	<b>Blower</b>			
	Position	Inside main body		
	Specification	M.S. body powder coated		
	Manufacturer	ACG-Pam		
3.	<b>Core Tube</b>			
	Position	Above cooling fan		
	Manufacturer	ACG-Pam		
	Material	SS 316		
	Surface finish	320 gritt mirror finish		
4.	<b>Capsule sorting device</b>			
	Position	Above main body		
	Manufacturer	ACG-Pam		
	Specification	Sorting of capsule		
	Material	SS316		
5.	<b>Empty Capsule Deflector</b>			
	Position	Above capsule sorting device		
	Manufacturer	ACG-Pam		
	Material	SS 316		
	Surface finish	320 grit mirror finish		
6.	<b>Hopper</b>			
	Position	Above empty capsule deflector		
	Manufacturer	ACG-Pam		
	Material	SS 316		
7.	<b>Empty capsule collection Box</b>			
	Position	Fitted to ECS main body cover		
	Manufacturer	ACG-pam		
	Material	SS316		
8.	<b>Motor</b>			
	Position	Inside main body		
	Manufacturer	VBM Enterprise		
	Type	Model No-SI 23/15028/S3, 135 Watts, 2600 RPM, 0.5 Amp, 230 Volts.		

**11.0 Technical Specification of Mini Filled Capsule Sorter (Model MCS 100)**





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S.No.	Parameter	Specification	Observation	Checked By (Sign & Date)
1.	<b>Base structure with doors</b>			
	Material	Mild steel painted with SS cladding		
	Base Structure cover	SS 304		
	Surface Finish	120-140 grit matt finish		
2.	<b>Vibrator Assembly</b>			
	Position	Above the base structure		
	Manufacturer	ACG-Pam		
	Material of support bracket	SS304		
3.	<b>Loose cap sorter assembly</b>			
	Position	Above the vibrator assembly		
	Manufacturer	ACG-Pam		
	Material	SS 316/ Aluminium		
	Frame	320 gritt mirror finish		
	Cover plate	Acrylic sheet		
	Guide plate	Aluminium hard anodized		
Sorting plate	SS 316			
4.	<b>Motor</b>			
	Position	Above main body		
	Manufacturer	Rotomotive		
	Specification	0.18 KW, 0.25 HP, 1380 RPM, 0.5 amp, 3 phase		
	Protection	IP 55		
5.	<b>Vibrator Controller</b>			
	Position	Fitted on the electrical panel		
	Manufacturer	Electroquip		
	Specification	Model-VBC-96 Rang-BELVBTR-0003		
	Surface finish	320 grit mirror finish		

**12.0 Technical Specification of sorter elevator (Model SE 100)**

Sr. No.	Parameter	Specification	Observation	Checked By (Sign & Date)
1.	<b>Structure</b>			
	Material	Mild steel painted & clad by SS sheet enclosed on all sides by SS 304 covers.		
	Surface cover	120-140 grit matt finish		



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2.	<b>Capsule Hopper Assembly</b>			
	Position	Above structure		
	Manufacturer	ACG-Pam		
	Material of support bracket	SS316		
3.	<b>Sorting Section</b>			
	Position	Above structure for sorting capsules		
	Manufacturer	ACG-Pam		
	Material	SS 316/ Aluminium		
	Sorting plate	Aluminium alloy, anodised		
4.	<b>Air Blower Assembly</b>			
	Position	Inside structure		
	Manufacturer	ACG-Pam		
	Material	Aluminium casting		
5.	<b>Delivery Assembly</b>			
	Position	Above machine structure		
	Manufacturer	ACG-Pam		
	Material	SS316		
	Surface finish	320 grit mirror finish		
6.	<b>Air Blower Motor</b>			
	Position	Inside structure		
	Manufacturer	Hindustan electric Motors		
	Type	0.18 KW, 0.25 HP, 2780 RPM, 0.5 Amp, 3 phase		
	Protection	IP 55		
7.	<b>Vibrator Motor</b>			
	Position	Above structure		
	Manufacturer	Hindustan electric Motors		
	Type	0.093 KW, 0.125 HP, 870 RPM, 0.5 Amp, 3 phase		
	Protection	IP 55		

**13.0 Technical Specification Metal trap 03-V7**

S.No.	Parameter	Specification	Observation	Checked By (Sign & Date)
1.	Structure Assembly			



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	Material	Mild steel with electroless nickel plating with SS stand		
2.	<b>Test Coil</b>			
	Position	Above Frame		
	Specification	Sensing of metal particales		
3.	<b>Inlet Chute</b>			
	Position	Inside test coil		
	Material	Polycarbonate		
4.	<b>Outlet Chute</b>			
	Position	After test coil		
	Material	Polycarbonate		
5.	<b>Flap for ejection Mechanism</b>			
	Position	After test coil		
	Material	Food grade material UHMV		

**14.0 Technical Specification of Check Weigher (Model CW 100)**

S.No.	Parameter	Specification	Observation	Checked By (Sign & Date)
1.	<b>Main Body with doors</b>			
	Material for structure frame	Mild steel painted, enclosed on all sides by SS304 covers		
2.	<b>Vibrator</b>			
	Position	Inside main body		
	Manufacturer	ACG-Pam		
	Specification	220V AC		
3.	<b>Vibrator Controller</b>			
	Position	Inside main body		
	Manufacturer	Electroquip		
	Model no.	VBC-96		
4.	<b>Weighing Balance</b>			
	Position	Inside main body		
	Manufacturer	AND		
	Specifiaction	FX300I		
	Capacity	320 g		
5.	<b>Printer</b>			
	Position	Outside main body		



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	Manufacturer	Epson		
	Specification	LX 300, 80 column dot matrix printer		
6.	<b>Slot Sensor</b>			
	Position	End of vibrator track		
	Manufacturer	P.G. Electronics		
	Specification	IR slot sensor unit SL-15		
7.	<b>Filter Regulator (For Air)</b>			
	Specification	To provide filtered air at a set pressure		
	Position	On the structure		
	Manufacture	Airmatic		
	Model No.	MB10-023		
	Size	6 mm		
	Max. pressure	12 Kg/cm <sup>2</sup>		
	Pressure Range	0-9 Kg/cm <sup>2</sup>		
	Element rating	25 micron		
8.	<b>Pressure Gauge</b>			
	Specification	For operating Air Pressure 0-10 bar		
	Range	0-10.6 Kg/cm <sup>2</sup>		
	Position	On FR unit outside structure		
	Manufacture	Manometer		
	Size	Dia. 40 mm		
9.	<b>Solenoid Valve</b>			
	Position	Inside structure		
	Manufacturer	Festo		
	Type No	MFH-3-1/8 SEU		
	Operating Pressure	6 bar (6 Kg/cm <sup>2</sup> )		
	Max. Pressure	0.5-8 bar		
10.	Solenoid Coil			
11.	Position	Fitted on solenoid valve		
12.	Manufacture	Festo		
13.	Type	MSFG-24/42-50/60		

**15.0 Technical Specification of Filled Capsule Elevator (Model FCE 100)**

S.No.	Parameter	Specification	Observation	Checked By (Sign & Date)
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1.	<b>Base Plate and housing</b>		
	Position	Base of machine	
	Manufacturer	ACG-Pam	
	Material	SS304	
	Surface finish	320 grit mirror finish	
2.	<b>Top &amp; Bottom pipe</b>		
	Position	Above of base of machine	
	Manufacturer	ACG-Pam	
	Material	SS316	
3.	<b>Discharge chute</b>		
	Position	At the end of top pipe	
	Manufacturer	ACG-Pam	
	Material	SS316	
4.	<b>Impeller Assembly</b>		
	Position	Inside housing	
	Manufacturer	ACG-Pam	
	Material	SS316	
5.	<b>Air Blower Motor</b>		
	Position	Inside structure	
	Manufacturer	Hindustan Electric Motors	
	Type	0.18 KW, 0.25 HP, 2780 RPM, 0.5 Amp, 3 phase	
	Protection	IP 55	
6.	<b>MPCB</b>		
	Position	Inside structure	
	Manufacturer	Schneider Electric	
	Model	GV2ME05	
	Range	0.63-1 amp	

**16.0 Deviation:**

**Detail of Deviation**

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**Investigation**



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**Corrective Action:**

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**Acceptable: Yes/No**

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Name	Designation	Signature	Date

**17.0 Conclusion:**

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 .....  
 .....

	Name	Signature	Date
<b>FAT Carried Out By</b>			
<b>In the Presence of Manufacturer</b>			

**18.0 Abbreviation:**

Abbreviation	Expanded Form
FAT	Factory Acceptance Test
MOC	Material of construction



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URS	User Requirement Specification
GMP	Good Manufacturing Practices
MMI	Man Machine Inference



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**19.0 Post Approval Sheet:**

Executed By (Name & Designation)	Signature	Date
(Production)		
(Quality Assurance)		
(Maintenance)		

Approved By (Name & Designation)	Signature	Date
(Quality Assurance)		