



PHARMA DEVILS

PRODUCTION DEPARTMENT

STANDARD OPERATING PROCEDURE

Department: Production	SOP No.:
Title: Cleaning and operation of Induction Cap Sealer (SIGMA JR)	Effective Date:
Supersedes: Nil	Review Date:
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1.0 OBJECTIVE:

To lay down a procedure for cleaning and operation of induction cap sealer (SIGMA JR).

2.0 SCOPE:

This SOP is applicable for cleaning and operation of induction cap sealer (SIGMA JR.) in production.

3.0 RESPONSIBILITY:

Technical Associate : For cleaning and operation of machine.

Officer / Executive Production : For checking.

Head Production : SOP Compliance

4.0 DEFINITION(S):

NA

5.0 PROCEDURE

5.1 Cleaning

5.1.1 Carry out the following procedure for batch to batch or product to product changeover.

5.1.2 Disconnect the machine by switch "OFF" the power supply.

5.1.4 Clean the all the height adjustment gauge, bottle guide with wet mop followed by dry mop.

5.1.5 Clean all the sticky material from induction plate, head, platform and outer body Surface with wet mop followed by dry mop.

5.1.6 For cleaning refer to the points given in "LINE CLEARANCE CHECKLIST "

5.1.7 Affix "CLEANED" label on the machine as per SOP.

5.1.8 Record the details of cleaning of induction cap sealer in equipment usage log sheet as per SOP.

5.2 Machine "SET UP"

5.2.1 Setting of "INDUCTION SEALELER HEAD"

Height of induction sealing head is adjusted by its vertical movement upon the given slide by rotating given knob in clockwise or anticlockwise direction.

5.2.1.1 Setting of "BOTTLE UNDER INDUCTION PLATE"



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For better induction, bottle shall be exposed to maximum electromagnetic field generated under induction plate. To achieve this platform is given with circle having variable diameter and bottle with different diameter can be set into given circle.

5.2.1.5 **Setting of “GAP BETWEEN BOTTLE AND INDUCTION PLATE”**

The GAP adjusted between plate and bottle is 3-5 mm.

5.2.1.6 **Setting of “SEALING TIME”**

It can be set by given (▲) increment or (▼) decrement push button on PLC. Sealing time limit shall be 2-3 sec.

5.3 **OPERATION:**

3.1 Connect the machine to power. Switch “ON” the induction cap sealer machine.

5.3.2 After few time GREEN indicator will confirm that “Induction Is Ready”

5.3.3 Adjust the bottle into circle given on platform and set bottle guide surrounding circumference of circle.

5.3.4 Push the button OR press the paddle to start sealing “ON”

5.3.5 While sealing is going on for specified time a RED indicator will remain ‘ON’ and time set on PLC will start to decrease till zero and when sealing completed indicator gets ‘OFF’

5.4 **Precaution:**

5.4.1 Lid shall be tight on bottle neck.

5.4.2 Induction cap sealer generates electromagnetic field, So do not wear any jewelry such as watches, rings or bracelets while working near sealing head.

6.0 **ABBREVIATION (S):**

SOP : Standard operating Procedure

NA : Not applicable

QA : Quality Assurance

7.0 **REFERENCE (S):**

SOP: Status labeling

SOP: Making entries in equipment usage and cleaning log sheet

Format No.: For cleaning refer to the points given.



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8.0 ANNEXURE (S):

NA

9.0 DISTRIBUTION:

Master Copy : Quality Assurance

Controlled copy : Production department, Quality Assurance

Reference Copy : Production department