



# PHARMA DEVILS

PRODUCTION DEPARTMENT

## STANDARD OPERATING PROCEDURE

<b>Department:</b> Production	<b>SOP No.:</b>
<b>Title:</b> Operation and Setting of Camera System Installed at Sticker Labeling and Leaflet Outsarter (Make-Jekson)	<b>Effective Date:</b>
<b>Supersedes:</b> Nil	<b>Review Date:</b>
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**Vernacular SOP:** No

### 1.0 OBJECTIVE:

1.1 Operation and Setting of Camera System Installed at Sticker Labeling and Leaflet Outsarter (Make-Jekson).

### 2.0 SCOPE:

2.1 The procedure is applicable to the Operation & Setting of camera System installed at sticker labeling and leaflet outsarter (Make-Jekson) in Production area.

### 3.0 RESPONSIBILITY:

- 3.1 Technical Associate : Operation
- 3.2 Officer and Executive : Verification of operation
- 3.3 Officer and Executive IPQA : Line clearance and SOP Compliance
- 3.4 Head Production : SOP Compliance

### 4.0 DEFINITION (S):

- 4.1 Done By- The activity performed by the Person
- 4.2 Verified By- Evidence that establish or confirm the accuracy or truth of activity

### 5.0 PROCEDURE:

#### 5.1 Operation

- 5.1.1 Turn on the power supply and UPS supply given to the Jekson camera system.
- 5.1.2 After power on UPS become steady then turn on the controller.
- 5.1.3 Wait for 180 seconds until the countdown goes zero (Countdown on display).
- 5.1.4 Login into BPO (Jekson Code Reader) with particular user and its password screen will display as follow:-



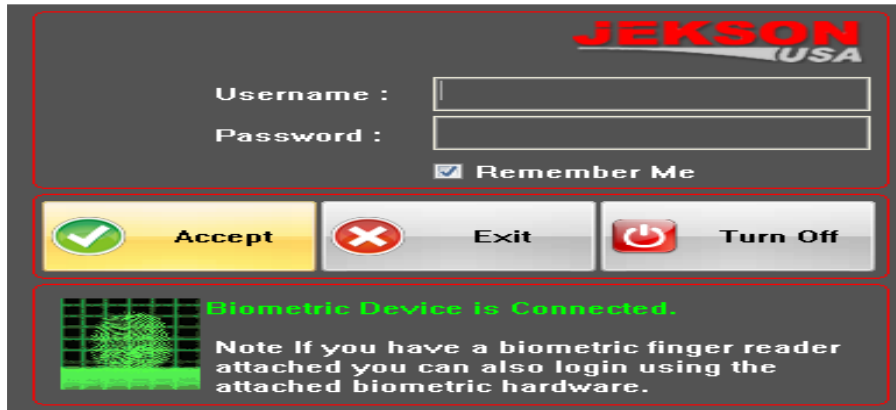


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5.1.5 Three different user has different rights assignment as mentioned below:

S.no.	Type of Functions	User Rights Assignment(Y/N)		
		Operator	Supervisor	Admin
1.	RUN/STOP machine	Y	Y	Y
2.	Parameters Setting	N	Y	Y
3.	Change Password	N	N	Y

5.1.6 For running the existing batch with same product click on 'START INSPECTION'.

And to start a new batch click on GO option.



5.2 **Setting for camera 1 for overprinting:**

5.2.1 User has to click on 'INLOOP MODE' to start conveyor and take snap shot screen will as shown below:

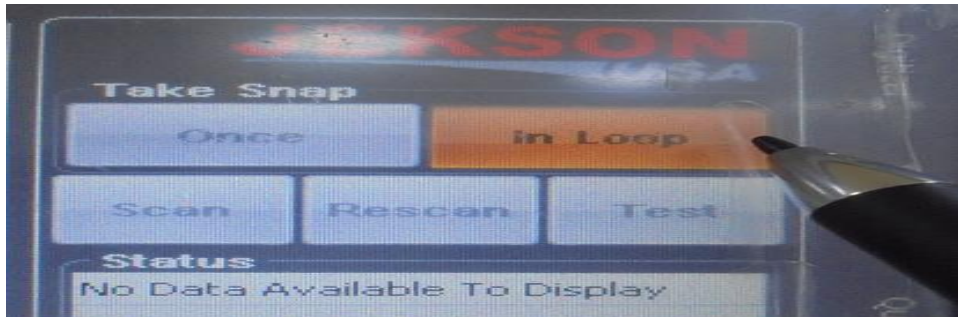


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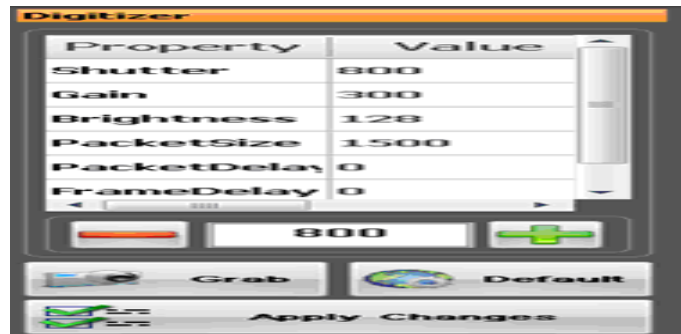
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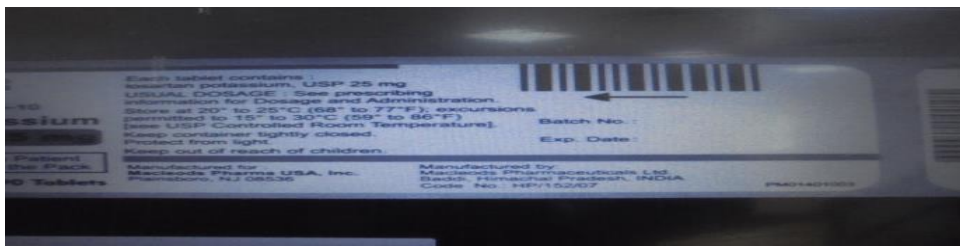
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5.2.2 Pass one sticker label and printer will print the data and camera grabs an image of printed matter and Pharmacode. So user can see the image in IPC. If the image is dark or light user can change the camera setting from 'DIGITIZER' increase or decrease the shutter, brightness as per requirement display is mentioned below:-



5.2.3 If image is not in the center then user must have to change the GAP sensor position and set as per point no 5.2.2.



5.2.4 When image will come in center then user have to teach PHARMACODE and OCR and 2D code.

5.2.5 TEACH OCR: For teaching OCR user must draw AOI (AREA OF INTEREST) and Select OCR for character reading OCR property will open automatically. User selects the comparison method, threshold, blob size, score and score difference of OCR for better performance and less rejection. OCR property will be displayed as follow:-

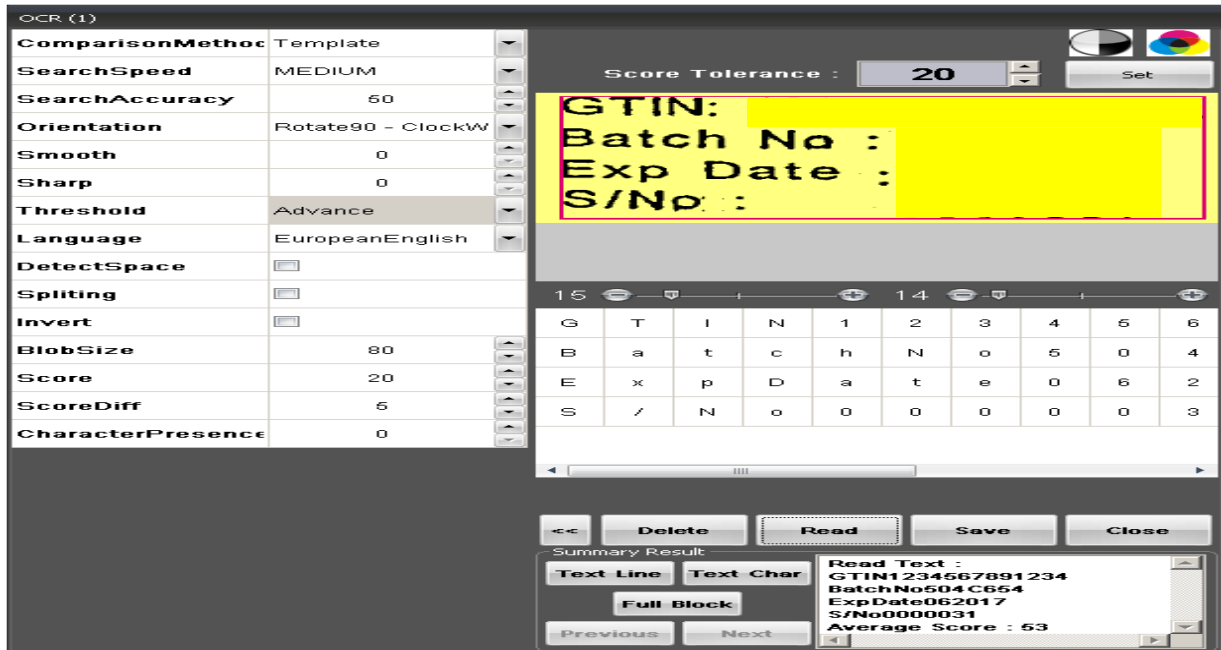


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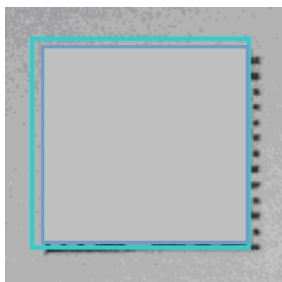
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5.2.6 To set the threshold of OCR user has to uncheck click mark mentioned in dialogue box with yellow background. User must keep search accuracy in high mode for fast inspection. User can use smooth and sharp option for setting threshold. User must uncheck the splitting option from property. User must have to do check mark in DIVISION and SPECIAL CHARACTER in OCR property. User has to set score blob size and score difference. Now SAVE and TEST it. OCR AOI will show green in HMI.

### 5.3 Setting for camera 1 For 2D Code (If Applicable):

5.3.1 Now give the AOI for 2D code and select the option for 2D Code.





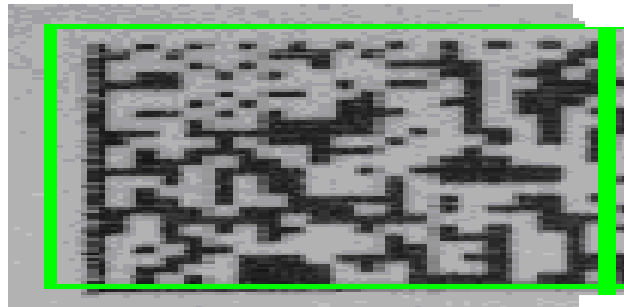
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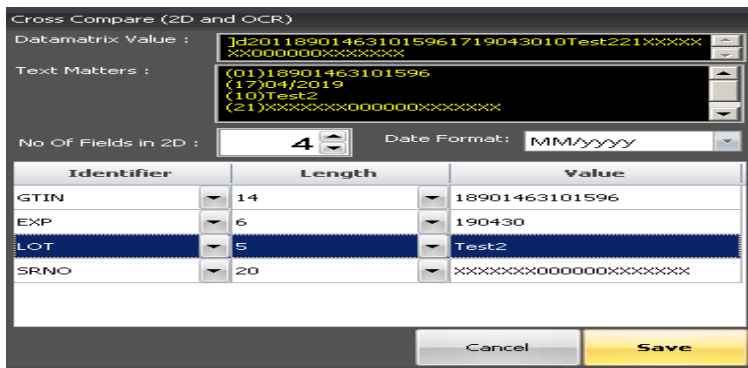
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5.3.2 Now click on “Decode” option and “Save” it. OCR AOI will show green line as shown in below screen shot:



5.3.3 By selecting the cross comparison between 2D Code Datamatrix value and text matter, printed matter is compared with 2D code with for details screen shot attached below:



5.3.4 Now click on “Save” option for saving the cross comparison between 2D Code Datamatrix value and text matter.

### 5.4 Setting of camera 2 For Pharmacode at Leaflet outsarter Machine:

5.4.1 For setting of camera start the leaflet outsarter machine which will attach the leaflet on the bottle with the help of glue applicator then bottle will pass under the camera and camera will grab the image.

5.4.2 If the image is dark or light user can change the camera setting from ‘DIGITIZER’ increase or decrease the shutter, brightness as per requirement.

5.4.3 When image will come in center then user have to teach PHARMACODE of leaflet.

5.4.4 **Teach PHARMACODE:** User must draw AOI and select Pharmacode for reading OCR property will open automatically. Select the parameter like orientation, method, color tolerance and Height Percentage.



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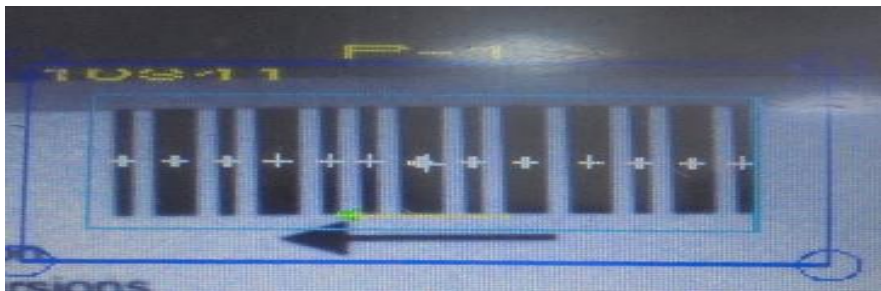
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Pharmacode (1)	
<b>Value</b>	382
<input type="checkbox"/> CodeValue	0
<b>PMSpeed</b>	MEDIUM
<b>SearchAccuracy</b>	50
<b>ExtendedSearchArea</b>	<input checked="" type="checkbox"/>
<b>Orientation</b>	PICKET
<b>Method</b>	GrayScale
<b>Direction</b>	Right To Left
<b>PharmaType</b>	STANDARD
<b>QuiteZone</b>	6
<b>ColorTolerance</b>	9
<b>Contrast</b>	0
<b>BarAngleDifference</b>	20
<b>CheckStandards</b>	<input type="checkbox"/>
<b>HeightPercent</b>	30
<b>Invert</b>	<input checked="" type="checkbox"/>

Buttons: Delete, Decode, Save, Close

- 5.4.5 NOTE: Height percentage is used for rejecting pharmacode in case of extra bar or height variable. If user wants to reject even a bar with small size the height percentage value must be kept higher.



- 5.4.6 Now click on "Save and Run" option and give the model name and then give batch No. for starting the inspection



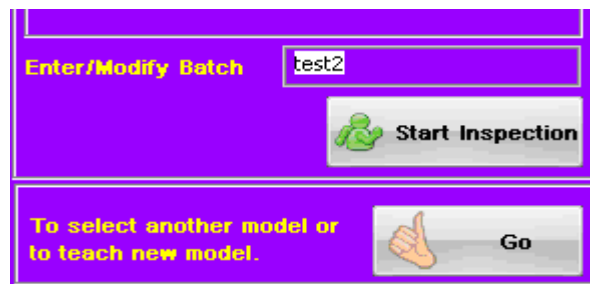


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### 5.5 Challenge test of Camera 1 for Pharmacode on Sticker label:

- 5.5.1 Stop the machine and add one extra parallel line or merge lines together of Pharmacode in label.
- 5.5.2 Now start the machine and camera must detect and reject the faulty label and faulty bottle must be fall into rejection box.
- 5.5.3 Record the observation in Annexure - I, "Challenge Test for Camera and Pusher of Sticker Labelling Machine".

### 5.6 Challenge Test of Camera 1 for without Overprinting Detail on sticker label:

- 5.6.1 Stop the overprinting by printer.
- 5.6.2 Start machine and check the image of overprinting on screen, printer shall not give print to label.
- 5.6.3 Further start the overprinting by printer and ensure on screen for overprinting detail on label.
- 5.6.4 Camera detect the miscoded label and faulty bottle must be rejected and fall into rejection box.
- 5.6.5 Record the observation in Annexure - I, Format, "Challenge Test for Camera and Pusher of Sticker Labeling Machine".

### 5.7 Challenge test of Camera 1 for 2D Code on sticker label (If Applicable):

- 5.7.1 Stop the machine.
- 5.7.2 Mark or Deface the 2D Code by marking big dot in center of 2D Code with marker.



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- 5.7.3 Now start the machine and camera must detect and reject the faulty label and faulty bottle must be fall into rejection box.
- 5.7.4 Record the observation in Annexure - I, Format, "Challenge Test for Camera and Pusher of Sticker Labeling Machine".
- 5.8 **Challenge test for No label bottle:**
- 5.8.1 Stop the machine. Select the 'escape' button on MMI or touch the toggle button for head 'on/off' and this will inhibit the sticker labeling machine to dispense label for running bottle on conveyor belt. Start the sticker labeling machine.
- 5.8.2 When bottle pass through the labeling message belt no label shall be dispense for this bottle.
- 5.8.3 Select the 'run' button from MMI or touch the toggle button for head 'on/off' and this will further start label dispensing.
- 5.8.4 Ensure that 'no labeled bottle' shall be detected and fall into rejection box.
- 5.8.5 Record the observation in annexure - I, Format "Challenge Test for Camera and Pusher of Sticker Labeling Machine".
- 5.9 **Challenge test for No label bottle(For no label sensor installed on Pharmapack sticker labeling machine):**
- 5.9.1 Stop the sticker labeling machine.
- 5.9.2 Manually remove the label after GAP sensor and before wrapping belt from the roll.
- 5.9.3 Start the sticker labeling machine.
- 5.9.4 Pass the bottle through conveyor.
- 5.9.5 Follow point 5.8.4 and 5.8.5.
- 5.10 **Challenge test of camera 2 for Pharmacode on package insert:**
- 5.10.1 Stop the machine.
- 5.10.2 Now take a bottle from the conveyor with package insert stick on its cap.
- 5.10.3 Add one extra parallel line or merge lines together in Pharma code of package insert.
- 5.10.4 Place the bottle back on conveyor belt.
- 5.10.5 Start the machine and camera must detect and reject the bottle having faulty package insert on it. Faulty package insert must be fall into rejection box along with bottle.
- 5.10.6 Record the observation in annexure - I, Format, "Challenge Test for Camera and Pusher of Sticker Labeling Machine".
- 5.11 **Challenge test for Pusher for rejection system of sticker labeling machine.**





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5.11.1 Obstruct the Compressed air supply of rejection pusher by removing air supply port or folded supply pipe. Conveyor stop automatically as supply air is low.

5.11.2 If conveyor is not stopped, stop the activity and inform to engineering for rectification.

**FREQUENCY: At start of Batch, after every four hour, on every start up and at end of operation or after any maintenance work.**

5.12 **Precaution:**

5.12.1 Keep the machine on stable surface.

5.12.2 Wait for 180 seconds until the countdown goes zero on after switch 'on' the camera.

5.12.3 For smooth running of rejection system at machine never add or remove any bottle after sticker labeling worm.

**NOTE: (1) Procedure of Challenge test for camera 1 shall be followed in case of:**

- **Pharmacode Challenge Test**
- **Sticker label without overprinting details.**
- **Sticker label overprinting with 2D code (if Applicable).**

**(2) Procedure of Challenge test for camera 2 shall be followed where leaflet outserter is used.**

**6.0 ABBREVIATION (S):**

6.1 SOP : Standard Operating Procedure

6.2 OCR : Optical Character Reader

6.3 ROI : Region Of Interest

6.4 AOI : Area Of Interest

6.5 IPC : Industrial Programming Controller

**7.0 REFERENCE (S):**

7.1 SOP: Status labeling

**8.0 ANNEXURE (S):**

Annexure No.	Title of Annexure	Format No.	Mode of Execution
Annexure I	Challenge Test For Camera And Pusher Of Sticker Labeling Machine		Control Copy



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### 9.0 DISTRIBUTION:

- 9.1 **Master Copy** : Quality Assurance
- 9.2 **Controlled Copy (S)** : Production department (01), Quality Assurance (01)
- 9.3 **Reference Copy (S)** : Production department (07)

### 10.0 REVISION HISTORY

S.No.	Version No.	Change Control No.	Reason (s) For Revision	Detail of Revision	Effective Date
01	00		New SOP	NA	



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### ANNEXURE I

#### CHALLENGE TEST FOR CAMERA AND PUSHER OF STICKER LABELLING MACHINE

**FREQUENCY:** AT START OF BATCH, AFTER EVERY FOUR HOURS, ON EVERY STARTUP AND AT END OF OPERATION OR AFTER ANY MAINTENANCE WORK

**EQUIPMENT ID:**

**AREA :**

Date	Time	# For No labeled container	# For overprinting detail	# For 2D Code overprinting	# For Pharmacode reader (Camera 1)	# For Pharmacode reader(Camera 2)	\$ For Rejection system of sticker labeling machine	Done by	Verified By

# Record 'OK' if faulty bottle detected & rejected by camera system and record 'Not Ok' if faulty bottle not detected & rejected by camera system & write NA where camera 1 or 2 or 2D code overprinting are not applicable.

\$ Record "OK" if conveyor stop automatically upon obstruction of compressed air supply, and record "Not Ok" if conveyor not stop automatically. Stop the activity until unless problem is rectified.