



# PHARMA DEVILS

PRODUCTION DEPARTMENT

## STANDARD OPERATING PROCEDURE

<b>Department:</b> Production	<b>SOP No.:</b>
<b>Title:</b> Cleaning and Operation of Sticker Labelling Machine (Make MYSTERY) with Domino Printer	<b>Effective Date:</b>
<b>Supersedes:</b> Nil	<b>Review Date:</b>
<b>Issue Date:</b>	<b>Page No.:</b>

### 1.0 OBJECTIVE:

To lay down a procedure for Cleaning and Operation of Sticker Labeling Machine (Make: MISTRY) with Domino printer.

### 2.0 SCOPE:

This procedure is applicable to the Cleaning and Operation of Sticker Labeling Machine (Make: MISTRY) with Domino Printer with in Production Area.

### 3.0 RESPONSIBILITY:

Technical Associate : Cleaning and Operation

Officer and Executive : Supervision

Head Production : SOP compliance

IPQA Person : Line Clearance

### 4.0 DEFINITION (S):

NA.

### 5.0 PROCEDURE:

#### 5.1 CLEANING:

5.1.1 Remove all material of previous product/batch from the machine.

5.1.2 Remove the "UNDER PROCESS" status label and affix "TO BE CLEANED" Status Label on machine with signature of production officer.

5.1.3 Remove all over printed Sticker labels and destroy them after reconciliation as per respective BPR.

5.1.4 Remove the release paper roll from the unwinding roller

5.1.5 Clean the unwinding rollers with 70% v/v IPA solution and with dry lint free cloth.

5.1.6 Clean all the sticky material from the label release plate with 70% v/v IPA solution.

5.1.7 Clean the sensor with dry cloth.

5.1.8 Clean the conveyor belt, bottle guide with wet cloth followed by lint free dry cloth.

5.1.9 Clean the wrapper round belt & bottle guide (rubber) with wet lint free cloth and remove all the sticky materials from there gently.

5.1.10 Wipe the SS machine covers with wet cloth followed by dry cloth.

#### 5.2 Cleaning for printing head:

5.2.1 Remove the ink cartridge from the printing unit.

5.2.2 Clean the head of the ink cartridge with the help of lint free cloth.

5.2.3 Store the ink cartridge in to the poly bag.



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5.2.4 Frequency: At the end of process.

Status Labeling: - Affix "CLEANED" label on the machine as per SOP.

5.2.5 Record the details of cleaning of sticker labeling machine in equipment usage and cleaning log sheet as per SOP.

### 5.3 Machine set up and Operation:

5.3.1 Ensure that sticker labeling machine is cleaned.

5.3.2 Ensure the status of the calibration status of pressure gauge installed in sticker labeling machine for rejection system.

5.3.3 Ensure the display of pressure gauge is NLT 4.0 bar. If drop the pressure below 4.0 bar conveyor stopped automatically and display of pressure gauge shown actual reading. When air pressure is reaches 4.0 bar or more pushers will be healthy and run the conveyor. Challenge Test of pusher for rejection system of sticker labeling machine to be performed as per in SOP which is applicable.

5.3.4 Bottles feed that feed one bottle from other and maintain the distance between two consecutive bottles.

5.3.5 Adjust bottle guide direct the bottle in a single direction.

5.3.6 Bottle label sensor sense the label and help in the dispensing.

5.3.7 Adjust the height of the label by adjusting the roller and guides with the help of rotating lever for up and down position of the label guide assembly.

5.3.8 Adjust the tightness of sticker roll ribbon from dancing roll spring and from stainless steel tension strip.

5.3.9 Switch on the machine and following screen will be displayed:



5.3.10 Touch the "SCREEN" and following screen will be displayed:



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- 5.3.11 Press the “START” key to stop the machine and press “STOP” to start the machine.
- 5.3.12 Total dispensed label by machine will be reflected into the box represented as “PRODUCTION COUNT”
- 5.3.13 Press the “BOTTLE FEED START” to start the worm for bottle in feed into the label dispensing site.
- 5.3.14 Press “INCH” for the adjustment of label to move slightly in forward direction.
- 5.3.15 Press “LABEL REFRESH” key after every stoppage of machine.
- 5.3.16 To stop conveyor please ensure no bottle left on the conveyor.
- 5.3.17 Touch the “SETTING” key and new screen will be opened as “PASSWORD KEY PAD” as below:



- 5.3.18 Feed the password and press “ENTER”.
- 5.3.19 After that following screen will be displayed:

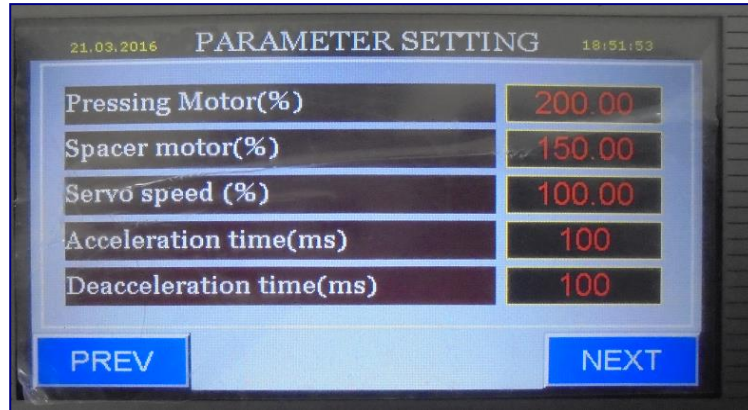


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5.3.20 Following are the details:

S.No.	Parameter name	Description
1.	Pressing motor %	For adjusting massage belt pressure according to the bottle dimension.
2.	Spacer motor %	For controlling the speed of WORM as it maintains the distance between the two consecutive bottles.
3.	Servo speed %	Actual speed of the machine/ label output speed at label dispensing site.
4.	Acceleration time(ms)	It is the time taken by machine between dispensing of two consecutive labels
5.	Deacceleration time(ms)	Delay for arrival of label at the dispensing site before second bottle reaches the labeling site.

5.3.21 Select the field against the key to open keypad for entering the numeric value to increase or decrease any parameter.


5.3.22 After entering all parameters press PREV and go back to the operational screen as displayed in 5.3.9 and run the machine by pressing START.

5.3.23 At the time of Pharmacode / Over printing challenge test as per frequency mentioned in the SOP, ensure the proper working of pusher rejection system.

### 5.4 Setting of Domino Printer:

5.4.1 Switch "ON" the power supply of the printer controller unit screen will display as;



5.4.2 Press  key (lock) then screen will display as:

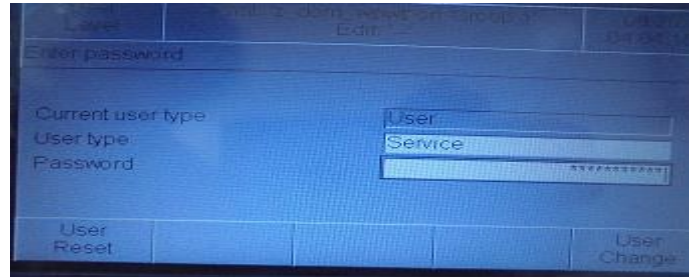


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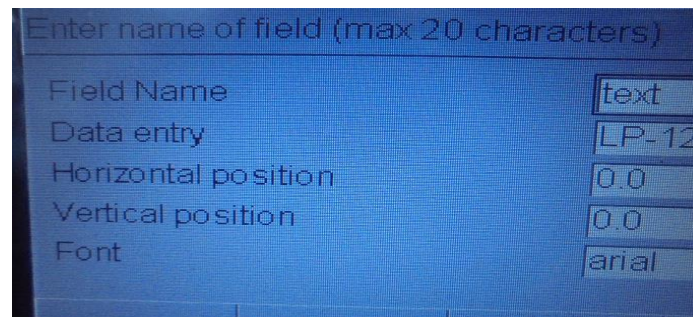
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5.4.3 Select the field and enter the user type (SERVICE) and password respectively then press user change.

5.4.4 For setting of new message press  key and go into the NEW FIELD MESSAGE, then press EDIT message then press EDIT FIELD screen will display as:



5.4.5 Enter the desired TEXT in the Data entry column by selecting the field with the help of arrow keys displayed on HMI as  and enter the words and numeric value with the help of Key pad on HMI.

5.4.6 Set the position of the line with the help of HORIZONTAL and VERTICAL positions.

5.4.7 Set the font type (ARIAL) and size for the text (04 to 30).

5.4.8 Set the rotation of the text (if required).

5.4.9 After entering all parameters press ACCEPT NEW VALUES.

5.4.10 For starting second line again follow the point no.5.4.4. And set the HORIZONTAL and VERTICAL value to set the position of the line (NOTE: If not done then both lines will superimpose on each other).

5.4.11 After entering all values select DEFINATION and screen will display following parameters:

S.No.	Parameter name	Description
1.	MESSAGE HEIGHT	Displays number of heads (height of each head is 12.7 mm)
2.	MESSAGE WIDTH	Displays width of canvas (Limit: INFINITY)
3.	FORWARD MARGIN	Displays margin to be kept after starting of canvass
4.	END MARGIN	Displays margin to be kept after ending of text.
5.	PRINT START MODE	Displays PRINT TYPE i.e. ENCODER base or sensor base
6.	PRINT SPEED MODE	Displays PRINT speed i.e. ENCODER base or sensor base



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7.	PRODUCTION SPEED	It is the Velocity of the print (If production speed kept low print will expand and vice versa will happen if speed kept high)
8.	PRINT DIRECTION	It displays in which direction we want to print i.e left to right or right to left.
9.	# OF PRINTS PER OBJECT	Number of prints required on sensing of one object.

5.4.12 After entering all parameters press ACCEPT NEW VALUES.

5.4.13 Then LOAD the message to run the file.

5.4.14 For starting and stopping the print we have to press ,  and  .

### 5.5 Precautions:

5.5.1 Do not take out Cartridge while machine is in ON conditions.

5.5.2 If machine displays cartridge ink level low change the cartridge if required.

5.5.3 For cleaning of cartridge always switch OFF the machine and use dry lint free cloth.

5.5.4 Ensure no fold on pressure connecting pipe of pusher.

### 6.0 ABBREVIATION (S):

SOP : Standard Operating Procedure

HMI : Human Machine Interface

### 7.0 REFERENCE (S):

SOP: Status Labeling.

SOP: Operation and setting of camera system installed at sticker labeling and leaflet outserter (Make – jekson).

SOP: Cleaning and operation of pack i 2 camera inspection system.

### 8.0 ANNEXURE (S):

NA

### 9.0 DISTRIBUTION:

**Master Copy** : Quality Assurance

**Controlled Copy (S)** : Production department, Quality Assurance

**Reference Copy (S)** : Production department