

Qualification Documentation

Alarm and Function Testing

Glaxo Wellcome Production
France

CUK 2060

Cartoning machine

Serial Number

Overall order no.

752937

3100001306

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Alarm and Function Testing Plan

CUK 2060

Cartoning machine

752937

**Glaxo Wellcome Production
France**

Alarm and Function Testing Plan approval by ROTZINGER PharmaPack GmbH (before execution)

Function	Name	Position/Company	Signature	Date
Created by				
Reviewed by				
Approved by				

Alarm and Function Testing Plan approval by Glaxo Wellcome Production (before execution)

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1 References

No.	Title
[1]	Order confirmation
[2]	SOP-AG-06.012e: Qualification deviation procedure
[3]	SOP-AG-23.006e: Handwritten documentation for qualification
[4]	SOP-AG-24.005e: Procedure for change control
[5]	Alarm and Function Testing Report

2 Introduction

This document forms the Alarm and Function Testing of the RPP equipment installed at Glaxo Wellcome Production, France. The execution of this document shows that the product administration as well as faults, messages, warnings and software switches function correctly.

3 Scope

This document contains the Alarm and Function Testing Plan and the references necessary to collect and record the evidence that shows the CUK 2060, 752937 operates correctly.

The test results will be approved after completion of the Alarm and Function Testing Report.

4 Test philosophy

The following chapter describes the general test philosophy for this Alarm and Function Testing.

4.1 Test approach

The objective of this Alarm and Function Testing is to gather and document evidence that verifies that the RPP equipment operates according to the manufacturer's requirements and updated design documents.

The Alarm and Function Testing plan has been produced according to the agreed scope of supply in [1], which is based on current GMP requirements.

It will be approved prior to execution by ROTZINGER PharmaPack GmbH and Glaxo Wellcome Production representatives. After testing, and closing of the nonconformances, the Alarm and Function Testing report can be issued and approved.

All information for an individual test as well as any additional documentation used or collected during the Alarm and Function Testing execution, will be attached to the individual test protocols and annotated with the test number, date and initials (see [2]).

The agreed acceptance criteria for each test are defined in the test scope (see chapter 7.2).

4.2 Test structure

All qualification tests of this document have the following structure:

- Test title
- Test number
- Test objective
- Test prerequisites
- Test procedure
- Acceptance criteria
- Data to be recorded (if applicable)
- Test result(s)
- Comments
- Final test assessment

4.2.1 Access protection

The machine software provides an access protection feature.

- The administrator can create and manage access rights of individual users. A matrix of user levels can be defined with corresponding rights. These settings can be adjusted to the customers requirements by "Admin". All changes are noted in the audit trail.
- Operation is not possible without log on, except for machine stop (Normal Stop) and Emergency-Stop.
- Only one user at a time can be logged on.
- The access matrix is saved in protected mode. Viewing and access by the Admin only.
- Every user is uniquely identified as a defined person by way of a biometric process or 2 independent elements, such as for example: User name and password. At this time, no provision is intended to tie in a biometric or technical user identification (mapping of fingerprint, iris, transponder, ...), therefore the terms user name and password are always used in the following.
- Configuration of these 2 elements:
 - Alphanumeric input is possible
 - Minimum x, maximum y characters parameters - x, y can be set by the Admin.
 - The user name is unique and allocated definitely to one access authorization.

- Only the Admin can create or disable, but not delete, a user name
(FDA 21 CFR Part 11 §11.300(b)/GMP Vol.4 Annex 11: 12.1)
- The password expires automatically after x days, the user is informed y days previous to that date - x,y parameters can be set by the Admin
(FDA 21 CFR Part 11 §11.300(b)/GMP Vol.4 Annex 11: 12.1)
- The password must not be identical with the user name.
- The last x passwords of the user are saved and disabled for reuse. The new password differs by at least y characters from the previous saved passwords - x,y parameters can be set by the Admin.
- "No?Go" list for passwords. The Admin can set a "No-Go" list to passwords. In this way typical passwords such as: ROTZINGER, machine type, company name, first name, ... can be excluded.
- User name and password are saved in protected mode. There is no access to passwords for anyone. The Admin can only reset passwords. In case of new users or reset passwords the user is requested on his/her first logon to change the password.
- The password is not displayed in plain text during input. If the keyboard is superimposed the keys do not move during password input. The position of the Cursor is not displayed in the superimposed keyboard panel.
- 3 elements are required for changing the password: Input of previous password, input of new password, repeated input of new password.
- After x invalid inputs the system is disabled and an entry is made to the audit trail concerning the unauthorized access attempt. (FDA 21 CFR Part 11 §11.300(d)/GMP Vol.4 Annex 11: 12.3) Further consequences are open for configuration, also in multiple sequences:
 - Canceling of disable by Admin only
 - User?disable, canceling user?disable by Admin only
 - Inhibit?time run of y minutes parameters - x, y can be set by the Admin
- Automatic logout after x minutes, no further action. The last UserID is suggested to the user within y minutes, the user enters his/her password only. After y minutes both elements must be entered again parameters - x, y can be set by the Admin.
- Access to program files, operating system, system time/date and the machine?generated data for Admin only; Access to these features is not provided for users.

4.2.2 Version management

Version management - format - product - recipe data

- When creating a new format, a count up "number" is generated (e.g. "1" ;"2" ;"3"), the format name can be renamed, the text is open for configuration (e.g. "Aspirin 50 mg)
- One format can include different drafts or released versions with corresponding machine setting parameters. For a newly created draft version, the (version) number is increased by 1. When the draft is released to "released version" it changes its status from draft to released. (e.g. Format 1 and released version 4 will be named version 1.004)
- Preset format parameters can only be changed in a draft version. The draft version can be released, a released version can be activated for production.
- Versions can be disabled by a user (definition per matrix), however only the Admin can delete versions. All existing versions are shown in the HMI.

4.2.3 Audit trail

- All user actions related to process, quality and product as well as parameter changes must be recorded in the audit trail: e.g.:
 - Logon/logout of users, also invalid access attempts and system disable
(FDA 21 CFR Part 11 §11.300(d)/GMP Vol.4 Annex 11: 12.1, 12.3)
 - Modifications of the access matrix
(FDA 21 CFR Part 11 §11.10(d)/GMP Vol.4 Annex 11: 12.1, 12.3)
 - Faults, errors, message display
 - Creating, changing format/recipe data (filling/empty weights, ...)
 - Change of defaults of checking devices (code reader, camera, ...)
 - Checking devices On/Off
 - Options On/Off

- Format change
- Modifications of sizes / speeds / reject limits/ weights, ... relevant to product (machine speed, r.p.m. powder scroll, tamping pressure, shift register ...)
- Change of operating mode (Line, Automatic, Setup, ...)
- The audit trail is kept batch?related. A filter can be used to fade out events outside the batch (before and during interruptions of the batch).
- Example for batch?related: All events before starting the batch, during a batch interruption and during the batch are written to the audit trail, which is concluded at the end of the batch.
- If no batch management has been realized, the audit trails are managed by a different logical system, such as e.g. by days.
- Audit trails can be neither modified nor deleted.
- Audit trails are stored with a security system, any later entries/modifications are detected by the system (FDA 21 CFR Part 11 §11.10(c)/GMP Vol.4 Annex 11: 7.1, 12.1)
- All audit trail entries show the action, the complete user name, date and time (FDA 21 CFR Part 11 §11.10(e)/GMP Vol.4 Annex 11: 12.1, 12.3, 12.4)
- The audit trails can be according to criteria such as user, activity, date and time filtered and printed online.
- The user can enter a free comment to the log at any time, e.g. via the superimposed keyboard.
- The audit trails are part of the production report.

Example of an audit trail:

Time	User	Text
08/20/2020 3:11:44 pm	Maier	User logged on (name: group_xyx)
08/20/2020 3:12:44 pm	Maier	switch <30> Data from <off> to <on>
08/20/2020 3:15:44 pm	Maier	User logged out (name: group_xyx)

4.3 Test procedure

The procedure for executing each test is defined in the test scope table (see chapter 7.2) and/or in the test protocol.

4.4 Test prerequisites

If applicable the prerequisites for each test are listed in the test protocol.

4.5 Data to be recorded

A data specification that needs to be retained as documented evidence, will be stored in the relevant test procedure.

4.6 Test result

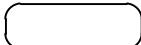
During test execution, individual test results have to be compared with the expected results, and an assessment has to be made for each acceptance criteria separately whether the result complies (yes) or does not comply (no).

A final assessment will close a test. "Results comply: Yes" (Passed) will be used if all acceptance criteria have been met. In case one or more acceptance criteria can not be met, the test will be assessed as failed ("Results comply: No").

The final assessment of a test (or retest) will then be recorded in the test scope (see chapter 7.2).

4.7 Handwritten entries and comments

Data entries, comments, corrections or signatures manually written onto the prepared test protocol will be performed in accordance with [3] into the rounded boxes of the document as the test is executed.

Example: 

Any correction to handwritten data will be made by the person entering the data. Each page used for executing the qualification is to be signed and dated.

Data that is gathered by instrumentation onto a recorder will be printed and attached to a test protocol. Applicable data calculations will be transferred to a computer and the calculation will be printed and attached to a test protocol. All attachments will be signed by the responsible author.

4.8 Deviation handling

All exceptions that are discovered during execution are to be entered into the deviations sheet according to [2] using the deviation sheet in chapter 7.3.

The deviation sheets are collected in the Alarm and Function Testing deviation chapter of the Alarm and Function Testing folder.

4.9 Change control

Changes during the qualification activities of this document shall be treated according to GDP.

4.10 Test summary

Status of the Alarm and Function Testing execution, and follow up actions after completion of the Alarm and Function Testing, are shown in [5].

4.11 Personnel involved in testing

All personnel involved in the qualification activities of this document will be listed using the table in chapter 7.1.

5 Test scope

A list of tests to be performed including the test procedures and acceptance criteria to be used during the Alarm and Function Testing can be found in the table in chapter 7.2: Test scope.

Following execution, the completed table will contain the final result for each test. It will then be placed in the "test scope chapter".

6 Glossary

AFT	Alarm and Function Testing
CFR	Code of Federal Regulations
FDA	Food and Drug Administration
FLT	Fault (message)
GDP	Good Documentation Practice
GMP	Good Manufacturing Practice
ME	Message
PLC	Programmable Logic Controller
QD	Qualification Documentation
SOP	Standard Operating Procedure
SWS	Software Switch
SWSOPM	Software Switch for Operation Mode
SWT	Software Key
URS	User Requirement Specification
WA	Warning (message)
n.a.	not applicable

7 Appendix

7.1 Identification of all Personnel involved

All personnel involved in the qualification activities of this document will be listed in the table below and identified in the relevant test protocols.

The involved personnel must be authorized and familiar with the machine operation.

7.2 Test scope

A list of all tests to be performed during the Alarm and Function Testing (AFT), including information on the execution of the tests and acceptance criteria, are listed in the following table. After the execution of the tests, this table also contains all final results for each test.

The test protocols for the executed tests listed in the following table are filed as an appendix to the Alarm and Function Testing Plan in index 2 as "Alarm and Function Testing Execution".

Cartoning machine CUK 2060

No.	Test title	Acceptance criteria	Deviation (No.)	Results comply		
				Test (yes/no)	Retest (yes/no)	Date/Signature
2	Software version	<ul style="list-style-type: none"> The software version is documented. 				
3	Check HMI menu, buttons and switches					
3.1	Spotcheck HMI	<ul style="list-style-type: none"> HMI menu and page tab spotcheck is OK 				
4	Access protection					
4.1	Create new User	<ul style="list-style-type: none"> User settings are adjusted according to data of table New user can be created Added user is documented in Audit trail with correct date and time 				
4.2	Log-in	<ul style="list-style-type: none"> Only one user at a time can be logged in Functions can only be actuated when a valid user is logged in 				
4.3	Password rules	<ul style="list-style-type: none"> If not all rules are followed, the password can not be changed If all rules are followed, the password can be changed 				

No.	Test title	Acceptance criteria	Deviation (No.)	Results comply		
				Test (yes/no)	Retest (yes/no)	Date/Signature
4.4	Password validity	<ul style="list-style-type: none"> The user is informed y days before the password validity expires (default y= 25) The password validity expires automatically after x days (default x= 30) 				
4.5	Identical name: User and password	<ul style="list-style-type: none"> Identical names for user and password are not possible 				
4.6	New password	<ul style="list-style-type: none"> The last x passwords of the user are saved and disabled for reuse (default x = 10) As soon as x = 10 other passwords have been saved the first password can be used again 				
4.7	Change of password	<ul style="list-style-type: none"> New password is accepted Entry to audit trail correct 				
4.8	User-account locked (disable)	<ul style="list-style-type: none"> After x invalid log-in attempts the user account is disabled and an entry concerning the unauthorized access attempt (default x= 3) is made to the audit trail The disabled user account can be enabled by the administrator 				
4.9	Disable time	<ul style="list-style-type: none"> After x invalid log-in attempts the system is disabled for y minutes and an entry concerning the unauthorized access attempt (default x= 3), (default y= 3 min) is made to the audit trail 				

No.	Test title	Acceptance criteria	Deviation (No.)	Results comply		
				Test (yes/no)	Retest (yes/no)	Date/Signature
4.10	Automatic log-out / log in again	<ul style="list-style-type: none"> Automatic log-out after x minutes Log in again with the same user and password is possible Action of Log out is recorded in audit trail Action of Log in is recorded in audit trail 				
5	Audit trail					
5.1	Audit trail entries -time stamp	<ul style="list-style-type: none"> All entries show the activity, user name, date and time correctly 				
5.2	Audit trail entries	<ul style="list-style-type: none"> All entries in the audit trail show the activity, user name, date and time The entries can be filtered and printed online based on various criteria (user, activity, date and time, batch) Entries can not be modified or deleted 				
6	Version management for recipe					
6.1	Version management in case of new recipe (product version)	<ul style="list-style-type: none"> When creating a new recipe, it will be generated with the designation count up number "x"; a new version with count up number "y" After enabling the draft version (only) the status changes 				
6.2	Disable version (product data)	<ul style="list-style-type: none"> Versions can be deleted or disabled When the corresponding filters are selected, all existing versions are open for viewing Entry to audit trail is correct 				

No.	Test title	Acceptance criteria	Deviation (No.)	Results comply		
				Test (yes/no)	Retest (yes/no)	Date/Signature
6.3	Enable version / batches for production	<ul style="list-style-type: none"> Disabled recipe versions can not be enabled for production Older batch numbers can not be enabled for production 				
6.4	Create new recipe	<ul style="list-style-type: none"> A new recipe can be created on the basis of an existing recipe version A new draft version can be created on the basis of a current recipe version 				
6.5	Activate recipe	<ul style="list-style-type: none"> Only recipe versions with status "Draft" or "Enabled" can be activated 				
6.6	Block recipe version	<ul style="list-style-type: none"> Status of selected recipe version changes from "Enabled" to "Disabled" and cannot be released or activated 				
6.7	Delete recipe version	<ul style="list-style-type: none"> Status of selected recipe version changes to "Deleted" Deleted recipe versions can no longer be released or activated 				
7	Batch Management					
7.1	Create new batch	<ul style="list-style-type: none"> A new batch can only be created if previous batch has been completed 				
7.2	Start batch	<ul style="list-style-type: none"> Only the new created batch can be started 				
7.3	Interrupt and resume batch	<ul style="list-style-type: none"> Batch can be interrupted and resumed 				
7.4	Complete batch	<ul style="list-style-type: none"> After batch is completed, batch data can be saved or printed and batch cannot be resumed again 				

No.	Test title	Acceptance criteria	Deviation (No.)	Results comply		
				Test (yes/no)	Retest (yes/no)	Date/Signature
7.5	Batch history	<ul style="list-style-type: none"> “Batch history” displays when and by whom status of batch has been changed 				
7.6	Store batch data	<ul style="list-style-type: none"> Batches are stored as .zip-file in selected folder with correct name (+ date and time) 				
7.7	Restore batch data	<ul style="list-style-type: none"> Batch is restored from .zip-file and listed in “Batch management” 				
7.8	Delete batch data	<ul style="list-style-type: none"> Batches with status “Restored” can be deleted from “Batch management” Batches with status “Stored” can be deleted from “Batch management” Batches with status “Completed” can not be deleted from “Batch management” 				
7.9	Print history of batch data	<ul style="list-style-type: none"> Recipe data and results can be viewed and printed 				
7.10	Print batch data	<ul style="list-style-type: none"> Batch data can be printed when active batch is completed or after a batch has been selected for history Batch data can be printed on connected printer Batch data can be exported to a selected folder as .pdf-file 				
8	Reports and print outs					
8.1	Recipe print out	<ul style="list-style-type: none"> It is possible to print or save the recipe data 				

No.	Test title	Acceptance criteria	Deviation (No.)	Results comply		
				Test (yes/no)	Retest (yes/no)	Date/Signature
8.2	User right print out	<ul style="list-style-type: none"> It is possible to print or save the user rights 				
9	Basic function					
9.1	Boot IPC	<ul style="list-style-type: none"> IPC boots from the main drive of the system, and does not boot from the USB-flash drive 				
9.2	Service: Clean Display	<ul style="list-style-type: none"> Display turns grey and no touch input can be done After 30 seconds the HMI appears again 				
9.3	Service: Change system time	<ul style="list-style-type: none"> Change of the system time is possible 				
9.4	Alarmlists	<ul style="list-style-type: none"> Lists of the Faults, Warnings and Messages can be selected Lists of Faults, Warnings and Messages can be printed or saved as pdf 				
9.5	Operating hours counter	<ul style="list-style-type: none"> Operating hours counter is shown 				
9.6	Parameter limits	<ul style="list-style-type: none"> A value greater than the maximum limit cannot be confirmed A value smaller than the minimum limit cannot be confirmed A value between the minimum and maximum limit can be confirmed 				
9.7	HMI Language	<ul style="list-style-type: none"> The HMI language switches to the chosen language 				
9.8	Test protocols - Function tests software switches (SWS)					

No.	Test title	Acceptance criteria	Deviation (No.)	Results comply		
				Test (yes/no)	Retest (yes/no)	Date/Signature
9.8.1	SWS 50: COVER RAIL	<ul style="list-style-type: none"> • Test 1: Cover rail is lifted • Test 2: Cover rail is lowered 				
9.8.2	SWS 53: PERMANENT READING CODE	<ul style="list-style-type: none"> • Test 1: Code is displayed on control panel within the „Laetus-menu“ (blue frame) • Test 1: Code reading is active at standstill • Test 2: Code is not displayed on control panel within the „Laetus-menu“ (blue frame) • Test 2: Code reading is not active at standstill 				
9.8.3	SWS 54: VACUUM	<ul style="list-style-type: none"> • Test 1: If SWS 54 "Vacuum" is activated, the vacuum pump is running • Test 2: If SWS 54 "Vacuum" is deactivated, the vacuum pump is not running 				
9.8.4	SWS 56: MACHINE INSIDE LIGHT OFF	<ul style="list-style-type: none"> • Test 1: SWS 56 "Machine inside light off" is activated: Lamps in production room don't shine • Test 2: SWS 56 "Machine inside light off" is deactivated: Lamps in production room shine 				
9.8.5	SWS 100: INSERT DEFECTIVE PRODUCT	<ul style="list-style-type: none"> • Test 1: SWS 100 is activated: In case of defective product or defective leaflet, carton will be loaded but rejected on discharge belt • Test 2: SWS 100 is deactivated: In case of defective product or defective leaflet, product will be rejected without loading 				

No.	Test title	Acceptance criteria	Deviation (No.)	Results comply		
				Test (yes/no)	Retest (yes/no)	Date/Signature
9.8.6	SWS 106: CONTINUOUS INSERTION	<ul style="list-style-type: none"> • Test 1: Insertion pushers are activated • Test 2: Insertion pushers are deactivated 				
9.8.7	SWS 107: RELEASE PUSHER GUIDE RAIL	<ul style="list-style-type: none"> • Test 1: Insertion pushers are enabled • Test 2: Insertion pushers are disabled 				
9.8.8	SWS 200: CODE READER CARTON	<ul style="list-style-type: none"> • Test 1: SWS200 is activated: wrong or non-coded cartons are ejected • Test 2: SWS200 is deactivated: wrong or non-coded cartons are not recognized and ejected 				
9.8.9	SWS 203: AIR BLAST CARTON	<ul style="list-style-type: none"> • Test 1: Folding of the side flap is supported by blowing air • Test 2: Folding of the side flap is not supported by blowing air 				
9.8.10	SWS 204: GLUEING	<ul style="list-style-type: none"> • Test 1: If SWS 204 is activated, lower or upper flap are glued • Test 2: If SWS 204 is deactivated, no glueing is active 				
9.8.11	SWS 208: CONTINUOUS CALL CARTON	<ul style="list-style-type: none"> • Test 1: Folding cartons are drawn off and erected without product with each cycle • Test 2: Folding cartons are not drawn off and not erected without product with each cycle 				

No.	Test title	Acceptance criteria	Deviation (No.)	Results comply		
				Test (yes/no)	Retest (yes/no)	Date/Signature
9.8.12	SWS 257: CHECK CARTON OPEN SIDE FLAP	<ul style="list-style-type: none"> Test 1: If SWS 257 is not active, carton with open side flap is not rejected Test 2: If SWS 257 is active, carton with open side flap is rejected Test 2: If SWS 257 is active, counter 257 "Carton: Fault open side flap" increases by one per manipulated carton 				
9.8.13	SWS 300: LEAFLET DEVICE	<ul style="list-style-type: none"> Test 1: SWS 300 is activated: Leaflet device is active, leaflets are called Test 2: SWS 300 is deactivated: Leaflet device is not active, leaflets are not called 				
9.8.14	SWS 302: CODE READER LEAFLET REAR	<ul style="list-style-type: none"> Test 1: If SWS 302 "Code reader leaflet rear" is activated, all wrong or non-coded leaflets are not ejected Test 1: If SWS 302 "Code reader leaflet rear" is activated, counter "Code reader rear" increases by one per defective leaflet Test 2: If SWS 302 "Code reader leaflet rear" is deactivated, leaflets with wrong or missing code on rear side are not ejected 				
9.8.15	SWS 303: CHECK LEAFLET PRESENT	<ul style="list-style-type: none"> Test 1: SWS 303 "Check Leaflet present" is deactivated: Carton without leaflet will not be ejected Test 2: SWS 303 "Check Leaflet present" is activated: Carton without leaflet will be ejected 				

No.	Test title	Acceptance criteria	Deviation (No.)	Results comply		
				Test (yes/no)	Retest (yes/no)	Date/Signature
9.8.16	SWS 307: CONTINUOUS CALL LEAFLET	<ul style="list-style-type: none"> Test 1: SWS 307 "Continuous call leaflet" is activated, Leaflets are drawn off and folded without product with each cycle Test 2: SWS 307 "Continuous call leaflet" is deactivated, Leaflets are not drawn off and folded without product with each cycle 				
9.9	Test protocols - Function tests software switches infeed (SWS)					
9.9.1	SWS 400: ROBOT	<ul style="list-style-type: none"> Test 1: SWS 400 "Robot" is activated, Robot is active Test 2: SWS 400 "Robot" is deactivated, Robot stops and is not active 				
9.9.2	SWS 2005: INFEED: CHECK POSITION INHALER	<ul style="list-style-type: none"> Test 1: If SWS 2005 "Infeed: Check position inhaler" is activated, position of inhaler is checked Test 2: If SWS 2005 "Infeed: Check position inhaler" is deactivated, position of inhaler is not checked 				
9.9.3	SWS 500: INFEED	<ul style="list-style-type: none"> Test 1: SWS 500 "Infeed" is activated, infeed is active Test 2: SWS 500 "Infeed" is deactivated, infeed stops and is not active 				
9.9.4	SWS 501: INFEED: RUN EMPTY	<ul style="list-style-type: none"> Test 1: SWS 501 "Infeed: Run empty" is activated, infeed belt runs empty and stops automatically after predefined cycles Test 2: SWS 501 "Infeed: Run empty" is deactivated, cartoning machine and infeed stopped 				

No.	Test title	Acceptance criteria	Deviation (No.)	Results comply		
				Test (yes/no)	Retest (yes/no)	Date/Signature
9.9.5	SWS 505: INFEED: CALL PRODUCT	<ul style="list-style-type: none"> Test 1: SWS 505 "Infeed: Call product" is activated, products are called at the infeed Test 2: SWS 505 "Infeed: Call product" is deactivated, no products are called at infeed belt 				
9.10	Test protocols - Function tests software switches operation mode (SWSOPM)					
9.10.1	SWSOPM 1: AUTOMATIC	<ul style="list-style-type: none"> Test 1: SWSOPM 1 "Automatic" is activated, Operating mode „Automatic“ is active Test 1: SWSOPM 1 "Automatic" is activated, Message is displayed on control panel (ME 40) Test 2: SWSOPM 2 "Setup" is activated, Operating mode „Automatic“ is not active Test 2: SWSOPM 2 "Setup" is activated, Message is displayed on control panel (ME41) 				
9.10.2	SWSOPM 2: SETUP	<ul style="list-style-type: none"> Test 1: SWSOPM 2 "Setup" is activated, Operating mode „Setup“ is active Test 1: SWSOPM 2 "Setup" is activated, Message is displayed on control panel (ME 41) Test 2: SWSOPM 1 "Automatic" is activated, Operating mode „Setup“ is not active Test 2: SWSOPM 1 "Automatic" is activated, Message is displayed on control panel (ME 40) 				

No.	Test title	Acceptance criteria	Deviation (No.)	Results comply		
				Test (yes/no)	Retest (yes/no)	Date/Signature
9.10.3	SWSOPM 3: INCHING PANEL	<ul style="list-style-type: none"> • Test 1: SWSOPM 3 "Inching panel" is activated, Operating mode „Inching panel“ is active • Test 1: SWSOPM 3 "Inching panel" is activated, Message is displayed on control panel (ME 42) • Test 2: SWSOPM 1 "Automatic" is activated, Operating mode „Inching panel“ is not active • Test2: SWSOPM 1 "Automatic" is activated, Message is displayed on control panel (ME 40) 				
9.10.4	SWSOPM 4: INCHING CABLE	<ul style="list-style-type: none"> • Test 1: SWSOPM 4 "Inching cable" is activated, Operating mode „Inching cable“ is active • Test 1: SWSOPM 4 "Inching cable" is activated, Message is displayed on control panel (ME 43) • Test 2: SWSOPM 1 "Automatic" is activated, Operating mode „Inching cable“ is not active • Test 2: SWSOPM 1 "Automatic" is activated, Message is displayed on control panel (ME 40) 				
9.10.5	SWSOPM 6: OPEN STOP BRAKE	<ul style="list-style-type: none"> • SWSOPM 6 "Open stop brake" is activated, Chosen drive can be moved manually • SWSOPM 6 "Open stop brake" is activated, Warning is displayed on control panel (WA 198: Machine: Drive brake(s) opened) 				

No.	Test title	Acceptance criteria	Deviation (No.)	Results comply		
				Test (yes/no)	Retest (yes/no)	Date/Signature
9.10.6	SWSOPM 7: ZERO DRIVE	<ul style="list-style-type: none"> SWSOPM 7 "Zero drive" is activated, Drive is zeroed 				
9.10.7	SWSOPM 8: INCHING SINGLE AXIS	<ul style="list-style-type: none"> Test 1: Operating mode „Inching single axis“ is active Test 1: Message is displayed on control panel (ME 47) Test 2: Operating mode „Inching single axis“ is not active Test 2: Message is displayed on control panel (ME 40) 				
9.10.8	SWSOPM 9: ROBOT: REFERENCE RUN	<ul style="list-style-type: none"> Message is displayed on control panel (ME448 "Robot: Reference run") when SWSOPM 9 is activated Reference run of robot is performed 				
9.10.9	SWSOPM 60: LINE MODE DOWNSTREAM EQUIPMENT	<ul style="list-style-type: none"> Test 1: SWSOPM 60 "Line mode downstream equipment" is activated: Machine is in line mode. In case of faults fault message will be displayed on control panel and machine stops. Test 2: SWSOPM 60 "Line mode downstream equipment" is deactivated: Machine is not in line mode. In case of faults fault message is not displayed on control panel and no machine stop. 				
9.10.10	SWSOPM 62: MACHINE: AUTOMATIC RESTART	<ul style="list-style-type: none"> Test 1: SWSOPM 62 "Machine: Automatic restart" is activated, Machine restarts automatically Test 2: SWSOPM 62 "Machine: Automatic restart" is deactivated, Machine does not restart automatically 				

No.	Test title	Acceptance criteria	Deviation (No.)	Results comply		
				Test (yes/no)	Retest (yes/no)	Date/Signature
9.10.11	SWSOPM 63: LINE MODE UPSTREAM EQUIPMENT	<ul style="list-style-type: none"> Test 1: SWSOPM 63 "Line mode upstream equipment" is activated, Machine is running with infeed. Test 2: SWSOPM 63 "Line mode upstream equipment" is deactivated, Machine is running without infeed 				
9.11	Test protocols - Function tests software switches operation mode drive (SWSOPM_DRV)					
9.11.1	SWSOPM_DRV 1015: MAIN DRIVE	<ul style="list-style-type: none"> SWSOPM_DRV 1015 "Main drive" is activated, Message is displayed on control panel "Do you really want to set drive to zero" 				
9.11.2	SWSOPM_DRV 1054: ROBOT: DRILL AXIS	<ul style="list-style-type: none"> Robot drive drill axis can be moved by hand 				
9.11.3	SWSOPM_DRV 1055: ROBOT	<ul style="list-style-type: none"> Robot drive can be moved by hand 				
9.11.4	SWSOPM_DRV 1063: ROBOT: INFEED BELT	<ul style="list-style-type: none"> Drive of infeed belt robot can be moved by hand 				
9.11.5	SWSOPM_DRV 1075: INFEED: OVERHEAD CONVEYOR	<ul style="list-style-type: none"> Drive of infeed: overhead conveyor can be moved by hand 				
10	Test protocols - Messages (ME)					

No.	Test title	Acceptance criteria	Deviation (No.)	Results comply		
				Test (yes/no)	Retest (yes/no)	Date/Signature
10.1	ME 25: BATCH CONTROL: BATCH IS INTERRUPTED	• Message is displayed on control panel				
10.2	ME 26: BATCH CONTROL: BATCH IS NOT ACTIVE	• Message is displayed on control panel				
10.3	ME 27: BATCH CONTROL: BATCH IS ACTIVE	• Message is displayed on control panel				
10.3.1	ME 40: OPERATING MODE: AUTOMATIC	• Message is displayed on control panel				
10.3.2	ME 41: OPERATING MODE: SETUP	• Message is displayed on control panel				
10.3.3	ME 42: OPERATING MODE: INCHING MODE PANEL	• Message is displayed on control panel				
10.3.4	ME 43: OPERATING MODE: INCHING MODE CABLE FRONT	• Message is displayed on control panel				

No.	Test title	Acceptance criteria	Deviation (No.)	Results comply		
				Test (yes/no)	Retest (yes/no)	Date/Signature
10.4	ME 47: OPERATING MODE: INCHING MODE SINGLE AXES	<ul style="list-style-type: none"> Message is displayed on control panel 				
10.4.1	ME 48: OPERATING MODE: INCHING MODE CABLE BACK	<ul style="list-style-type: none"> Message is displayed on control panel 				
10.4.2	ME 160: MACHINE: OPERATIONAL	<ul style="list-style-type: none"> Message is displayed on control panel 				
10.4.3	ME 551: INFEED: PREMACHINE: NOT READY	<ul style="list-style-type: none"> Message is displayed on control panel 				
10.4.4	ME 2003: LEAFLET: CHECK CODE :FAULT	<ul style="list-style-type: none"> Message is displayed on control panel 				
10.4.5	ME 2004: CARTON: CHECK CODE :FAULT	<ul style="list-style-type: none"> Message is displayed on control panel 				
10.4.6	ME 2006: CARTON: CHECK OPEN SIDE FLAP, SLIDE IN: FAULT	<ul style="list-style-type: none"> Message is displayed on control panel 				

No.	Test title	Acceptance criteria	Deviation (No.)	Results comply		
				Test (yes/no)	Retest (yes/no)	Date/Signature
10.4.7	ME 2007: CARTON: CHECK OPEN SIDE FLAP, OPPOSITE SLIDE IN: FAULT	<ul style="list-style-type: none"> Message is displayed on control panel 				
10.4.8	ME 2008: CARTON: CHECK OPEN FOURTH FLAP: FAULT	<ul style="list-style-type: none"> Message is displayed on control panel 				
10.5	Test protocols - Warnings (WA)					
10.5.1	WA 27: CONTROL-PC: M-GUARD ENABLED	<ul style="list-style-type: none"> Warning is displayed on control panel 				
10.5.2	WA 28: CONTROL-PC: REMOTE MAINTENANCE ENABLED	<ul style="list-style-type: none"> Warning is displayed on control panel 				
10.5.3	WA 45: CONTROL CABINET: UPS NOT READY	<ul style="list-style-type: none"> Warning is displayed on control panel 				
10.5.4	WA 198: MACHINE: DRIVE BRAKE(S) RELEASED	<ul style="list-style-type: none"> Warning is displayed on control panel 				

No.	Test title	Acceptance criteria	Deviation (No.)	Results comply		
				Test (yes/no)	Retest (yes/no)	Date/Signature
10.5.5	WA 220: CARTON: PREWARNING LOW STOCK	<ul style="list-style-type: none"> • Warning is displayed on control panel 				
10.5.6	WA 232: GLUE UNIT: PREWARNING LOW GLUE LEVEL	<ul style="list-style-type: none"> • Warning is displayed on control panel 				
10.6	WA 300: LEAFLET: PREWARNING LOW STOCK	<ul style="list-style-type: none"> • Warning is displayed on control panel 				
10.7	WA 380: TURRET MAGAZINE: MINIMAL SUPPLY	<ul style="list-style-type: none"> • Warning is displayed on control panel 				
10.8	WA 381: TURRET MAGAZINE: NOT IN OPERATION MODE	<ul style="list-style-type: none"> • Warning is displayed on control panel 				
10.9	WA 480: ROBOT: DRIVE AXIS X POSITION LIMIT +	<ul style="list-style-type: none"> • Warning is displayed on control panel as soon as limit position is reached 				
10.10	WA 481: ROBOT: DRIVE AXIS X POSITION LIMIT -	<ul style="list-style-type: none"> • Warning is displayed on control panel as soon as limit position is reached 				

No.	Test title	Acceptance criteria	Deviation (No.)	Results comply		
				Test (yes/no)	Retest (yes/no)	Date/Signature
10.11	WA 482: ROBOT: DRIVE AXIS Y POSITION LIMIT +	<ul style="list-style-type: none"> Warning is displayed on control panel as soon as limit position is reached 				
10.12	WA 483: ROBOT: DRIVE AXIS Y POSITION LIMIT -	<ul style="list-style-type: none"> Warning is displayed on control panel as soon as limit position is reached 				
10.13	WA 484: ROBOT: DRIVE AXIS Z POSITION LIMIT +	<ul style="list-style-type: none"> Warning is displayed on control panel as soon as limit position is reached 				
10.14	WA 485: ROBOT: DRIVE AXIS Z POSITION LIMIT -	<ul style="list-style-type: none"> Warning is displayed on control panel as soon as limit position is reached 				
10.15	Test protocols - Faults (FLT)					
10.15.1	FLT 3: OPERATOR: NORMAL STOP ACTUATED	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.15.2	FLT 4: OPERATOR: INCORRECT OPERATING MODE SELECTED	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				

No.	Test title	Acceptance criteria	Deviation (No.)	Results comply		
				Test (yes/no)	Retest (yes/no)	Date/Signature
10.15.3	FLT 5: COMPRESSED AIR: MONITORING INLET PRESSURE	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.15.4	FLT 6: ETHERCAT: FAULT	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.15.5	FLT 7: COMPRESSED AIR: MONITORING SAFE SHUTDOWN	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.15.6	FLT 11: MOTION DRIVES: OVERLOAD POWER SUPPLY	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.15.7	FLT 16: MACHINE: HANDWHEEL IS ENGAGED	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.15.8	FLT 17: OPERATOR: OPERATING MODE CHANGE	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				

No.	Test title	Acceptance criteria	Deviation (No.)	Results comply		
				Test (yes/no)	Retest (yes/no)	Date/Signature
10.16	FLT 20: BATCH CONTROL: PARTIAL BATCH OBTAINED	<ul style="list-style-type: none"> Machine stops until the defined quantity of good products of the partial batch is obtained Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.17	FLT 21: BATCH CONTROL: COMPLETE BATCH OBTAINED	<ul style="list-style-type: none"> Machine stops when the defined quantity of good products of the batch size is obtained Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.17.1	FLT 22: VACUUM: OVERLOAD PUMP	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.17.2	FLT 23: VACUUM: MONITORING NEGATIVE PRESSURE	<ul style="list-style-type: none"> Machine stops Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.17.3	FLT 28: CONTROL CABINET: MONITORING SAFETY PLC	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				

No.	Test title	Acceptance criteria	Deviation (No.)	Results comply		
				Test (yes/no)	Retest (yes/no)	Date/Signature
10.17.4	FLT 30: MACHINE: WAS RACED BACKWARDS	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.17.5	FLT 34: MACHINE: REPAIR SWITCH DRIVES SWITCHED OFF	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.17.6	FLT 35: CONTROL CABINET: MONITORING MAIN SWITCH	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.17.7	FLT 41: CONTROL CABINET S2: OVERTEMPERATU RE	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.17.8	FLT 42: CONTROL CABINET S1: OVERTEMPERATU RE	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				

No.	Test title	Acceptance criteria	Deviation (No.)	Results comply		
				Test (yes/no)	Retest (yes/no)	Date/Signature
10.17.9	FLT 43: CONTROL CABINET: VOLTAGE MONITORING I IW00F2051 IW00F3052 IW00F3081 IW00F3082 IW00F3085 IW00F3086 IW00F3087	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.17.10	FLT 45: CONTROL CABINET: UPS NOT READY	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.17.11	FLT 327: LEAFLET: SENSOR MONITORING CROSS CHECK IN LEAFLET UNIT	<ul style="list-style-type: none"> Machine stops Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.17.12	FLT 77: MACHINE: FAULT MONITORING CONTACTORS DROPPED AWAY	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.18	FLT 79: LINE EMERGENCY STOP ACTUATED	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				

No.	Test title	Acceptance criteria	Deviation (No.)	Results comply		
				Test (yes/no)	Retest (yes/no)	Date/Signature
10.18.1	FLT 81: EMERGENCY STOP ACTUATED: OPERATING PANEL	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.18.2	FLT 87: GUARD OPEN: CARTON BELT	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.18.3	FLT 89: GUARD OPEN: DISCHARGE FRONT	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.18.4	FLT 90: GUARD OPEN: CONTROL CABINET SWIVELED OFF LEFT	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.18.5	FLT 91: GUARD OPEN: CONTROL CABINET SWIVELED OFF RIGHT	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.18.6	FLT 96: GUARD OPEN: HANDWHEEL	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				

No.	Test title	Acceptance criteria	Deviation (No.)	Results comply		
				Test (yes/no)	Retest (yes/no)	Date/Signature
10.19	FLT 100: GUARD OPEN: PRODUCT CHAIN 1	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.20	FLT 104: GUARD OPEN: INFEED	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.21	FLT 110: PRODUCT SENSING: CONSECUTIVE FAULT EXCESS HEIGHT	<ul style="list-style-type: none"> Machine stops Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.21.1	FLT 112: PRODUCT SENSING: SENSOR MONITORING	<ul style="list-style-type: none"> Machine stops Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.21.2	FLT 113: PRODUCT SENSING: SENSOR MONITORING EXCESS HEIGHT	<ul style="list-style-type: none"> Machine stops Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.22	FLT 120: INSERTION: SAFETY SENSOR	<ul style="list-style-type: none"> Machine stops Fault message is displayed on control panel Machine cannot be started as long as fault is active 				

No.	Test title	Acceptance criteria	Deviation (No.)	Results comply		
				Test (yes/no)	Retest (yes/no)	Date/Signature
10.23	FLT 123: INSERTION: OVERLOAD	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.24	FLT 124: GUARD OPEN: SLIDE IN	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.24.1	FLT 129: INSERTION: MONITORING SENSOR SAFETY SENSOR	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.24.2	FLT 134: GUARD OPEN: BELOW SLIDE IN	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.24.3	FLT 200: MACHINE: JAM AT DISCHARGE	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.24.4	FLT 201: DOWNSTREAM: STOP FROM MACHINE 1	<ul style="list-style-type: none"> Machine stops Fault message is displayed on control panel Machine cannot be started as long as fault is active 				

No.	Test title	Acceptance criteria	Deviation (No.)	Results comply		
				Test (yes/no)	Retest (yes/no)	Date/Signature
10.24.5	FLT 203: DOWNSTREAM: STOP FROM MACHINE 2	<ul style="list-style-type: none"> Machine stops Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.24.6	FLT 210: GUARD OPEN: CARTON MAGAZINE	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.24.7	FLT 212: GUARD OPEN: DISCHARGE TOP	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.24.8	FLT 213: CARTON: OVERLOAD SIDE FLAP FOLDER	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.24.9	FLT 219: CARTON BELT: LOWER POSITION NOT REACHED	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.24.10	FLT 220: CARTON: STOCK AT THE END	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.24.11	FLT 221: MACHINE: COVER RAIL OPEN	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				

No.	Test title	Acceptance criteria	Deviation (No.)	Results comply		
				Test (yes/no)	Retest (yes/no)	Date/Signature
10.24.1 2	FLT 222: CARTON: CONSECUTIVE FAULT CROSSCHECK	<ul style="list-style-type: none"> • After 3 undetected cartons machine stops • Fault message is displayed on control panel • Machine cannot be started as long as fault is active 				
10.24.1 3	FLT 223: CARTON: PICKUP CHECK	<ul style="list-style-type: none"> • Machine stops • Fault message is displayed on control panel • Machine cannot be started as long as fault is active 				
10.24.1 4	FLT 224: CARTON BELT: OVERLOAD	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active 				
10.24.1 5	FLT 225: CARTON: CONSECUTIVE FAULT CODE READER	<ul style="list-style-type: none"> • Machine stops • Fault message is displayed on control panel • Machine cannot be started as long as fault is active 				
10.25	FLT 226: CARTON:\ FAULT CODE READER	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active 				
10.25.1	FLT 227: CARTON: SENSOR MONITORING CROSSCHECK	<ul style="list-style-type: none"> • Machine stops • Fault message is displayed on control panel • Machine cannot be started as long as fault is active 				

No.	Test title	Acceptance criteria	Deviation (No.)	Results comply		
				Test (yes/no)	Retest (yes/no)	Date/Signature
10.25.2	FLT 230: GLUE UNIT: OPERATING TEMPERATURE NOT REACHED	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.25.3	FLT 231: GLUE UNIT: DEVICE NOT READY	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.25.4	FLT 232: GLUE LEVEL IS TOO LOW	<ul style="list-style-type: none"> Machine stops Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.25.5	FLT 233: GLUE STATION 1: CONSECUTIVE FAULT CARTON SENSING	<ul style="list-style-type: none"> Machine stops Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.25.6	FLT 235: GLUE STATION 1: SENSOR MONITORING CARTON SENSING	<ul style="list-style-type: none"> Machine stops Fault message is displayed on control panel Machine cannot be started as long as fault is active 				

No.	Test title	Acceptance criteria	Deviation (No.)	Results comply		
				Test (yes/no)	Retest (yes/no)	Date/Signature
10.25.7	FLT 237: CARTON: SENSOR MONITORING PICKUP CHECK	<ul style="list-style-type: none"> • Machine stops • Fault message is displayed on control panel • Machine cannot be started as long as fault is active 				
10.25.8	FLT 250: CARTON EJECTION 1: OVERFILL COLLECTING CONTAINER	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active 				
10.25.9	FLT 251: CARTON EJECTION 1: CROSS CHECK	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active 				
10.25.10	FLT 254: CARTON EJECTION 1: SENSOR MONITORING CROSS CHECK	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active 				
10.26	FLT 272: CARTON: OPEN FLAP: SENSOR MONITORING SIDE FLAP REAR	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active 				

No.	Test title	Acceptance criteria	Deviation (No.)	Results comply		
				Test (yes/no)	Retest (yes/no)	Date/Signature
10.27	FLT 273: CARTON: OPEN FLAP: SENSOR MONITORING SIDE FLAP FRONT	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.28	FLT 294: CARTON: OPEN FLAP: CONSECUTIVE FAULT SIDE FLAP	<ul style="list-style-type: none"> Machine stops Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.28.1	FLT 301: LEAFLET: CONSECUTIVE FAULT CROSS CHECK IN PRODUCT CHAIN	<ul style="list-style-type: none"> Machine stops Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.28.2	FLT 302: LEAFLET: CROSS CHECK REJECT	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.28.3	FLT 304: LEAFLET: CONSECUTIVE FAULT CROSS CHECK IN UNIT	<ul style="list-style-type: none"> Machine stops Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.28.4	FLT 311: GUARD OPEN: LEAFLET UNIT TOP	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				

No.	Test title	Acceptance criteria	Deviation (No.)	Results comply		
				Test (yes/no)	Retest (yes/no)	Date/Signature
10.28.5	FLT 312: GUARD OPEN: LEAFLET UNIT REAR	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.28.6	FLT 321: LEAFLET: CONSECUTIVE FAULT CODE READER REAR	<ul style="list-style-type: none"> Leaflets with wrong / missing code will be ejected After 3 defective leaflets machine stops Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.28.7	FLT 322: LEAFLET: CONSECUTIVE FAULT CROSS CHECK IN CARTON	<ul style="list-style-type: none"> After 3 missing leaflets machine stops Fault message is displayed on control panel Machine cannot be started as long as fault is active Cartons without leaflets will be ejected 				
10.28.8	FLT 325: LEAFLET: SENSOR MONITORING CROSS CHECK IN CARTON	<ul style="list-style-type: none"> Machine stops Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.28.9	FLT 326: LEAFLET: SENSOR MONITORING CROSS CHECK IN PRODUCT CHAIN	<ul style="list-style-type: none"> Machine stops Fault message is displayed on control panel Machine cannot be started as long as fault is active 				

No.	Test title	Acceptance criteria	Deviation (No.)	Results comply		
				Test (yes/no)	Retest (yes/no)	Date/Signature
10.28.10	FLT 327: LEAFLET: SENSOR MONITORING CROSS CHECK IN LEAFLET UNIT	<ul style="list-style-type: none"> Machine stops Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.28.11	FLT 347: LEAFLET: SENSOR MONITORING CODE READER REAR	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.29	FLT 410: ROBOT: GUARD OPEN: BELT 1	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.30	FLT 412: ROBOT: EMERGENCY STOP FRONT ACTUATED	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.31	FLT 414: ROBOT: GUARD OPEN: PRODUCT CHAIN	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.32	FLT 417: ROBOT: GUARD OPEN: TURN AROUND PRODUCT CHAIN	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				

No.	Test title	Acceptance criteria	Deviation (No.)	Results comply		
				Test (yes/no)	Retest (yes/no)	Date/Signature
10.33	FLT 421: ROBOT: GUARD OPEN: FRONT LEFT	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.34	FLT 422: ROBOT: GUARD OPEN: FRONT RIGHT	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.35	FLT 436: ROBOT: GUARD OPEN: CYCLE BELT	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.36	FLT 457: ROBOT: MONITORING COMPRESSED AIR	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.36.1	FLT 477: ROBOT: CONTROL CABINET OVERTEMPERATURE	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.37	FLT 512: INFEED: EMERGENCY STOP FRONT ACTUATED	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.38	FLT 517: INFEED: GUARD OPEN	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				

No.	Test title	Acceptance criteria	Deviation (No.)	Results comply		
				Test (yes/no)	Retest (yes/no)	Date/Signature
10.39	FLT 530: INFEED: BELT 1: OVERLOAD	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.40	FLT 541: INFEED: BELT 1: FAULT	<ul style="list-style-type: none"> Machine stops Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.41	FLT 551: INFEED: BELT 1: PRODUCT JAM	<ul style="list-style-type: none"> Machine stops Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.42	FLT 850: LEAFLET: NO ERROR CODE ACTIVE	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.43	FLT 851: LEAFLET: TURRET: NO ERROR CODE ACTIVE	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.44	FLT 852: LEAFLET: OPC-UA TIMEOUT COMMUNICATION	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				

No.	Test title	Acceptance criteria	Deviation (No.)	Results comply		
				Test (yes/no)	Retest (yes/no)	Date/Signature
10.45	FLT 853: LEAFLET: TURRET: OPC-UA TIMEOUT COMMUNICATION	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.45.1	FLT 1212: GUARD OPEN: COLLECTING CONTAINER 1	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.45.2	FLT 1213: CARTON EJECTION 1: OVERFILL GUARD COLLECTING CONTAINER	<ul style="list-style-type: none"> Machine stops Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.45.3	FLT 1219: CARTON BELT: UPPER POSITION NOT REACHED	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.45.4	FLT 1220: CARTON BELT: MONITORING CHECK VALVE 1V3	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.45.5	FLT 1221: CARTON BELT: MONITORING CHECK VALVE 1V4	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				

No.	Test title	Acceptance criteria	Deviation (No.)	Results comply		
				Test (yes/no)	Retest (yes/no)	Date/Signature
10.46	FLT 1246: CARTON: SENSOR MONITORING CHECK CODE	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.47	FLT 1248: CARTON: OPEN FLAP: SENSOR MONITORING FOURTH FLAP	<ul style="list-style-type: none"> Machine stops Machine cannot be started as long as fault is active 				
10.48	FLT 1249: CARTON: OPEN FLAP: CONSECUTIVE FAULT FOURTH FLAP	<ul style="list-style-type: none"> Machine stops Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.49	FLT 1416: ROBOT: EMERGENCY STOP REAR ACTUATED	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.50	FLT 1417: ROBOT: GUARD OPEN: REAR LEFT	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.51	FLT 1419: ROBOT: RANGE LIMIT REACHED	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				

No.	Test title	Acceptance criteria	Deviation (No.)	Results comply		
				Test (yes/no)	Retest (yes/no)	Date/Signature
10.52	FLT 1433: ROBOT: VACUUM MONITOR: SUCTION CUP 1	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.53	FLT 1434: ROBOT: VACUUM MONITOR: SUCTION CUP 2	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.54	FLT 1435: ROBOT: VACUUM MONITOR: SUCTION CUP 3	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.54.1	FLT 1530: INFEED: BELT 1: PRODUCT REJECT (INHALER): BIN OVERFILL	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.54.2	FLT 1531: INFEED: BELT 1: PRODUCT REJECT (INHALER): CROSS CHECK	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.55	FLT 1543: INFEED: CONTROL CABINET: VOLTAGE MONITORING IW257_F3084 IW257_F3090	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				

No.	Test title	Acceptance criteria	Deviation (No.)	Results comply		
				Test (yes/no)	Retest (yes/no)	Date/Signature
10.56	FLT 2004: INFEED: OVERHEAD CONVEYOR NOT IN LOWER POSITION	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.57	FLT 2005: CARTON REJECT 1: CROSS CHECK CARTON REJECTED	<ul style="list-style-type: none"> Machine stops Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.58	FLT 2006: CARTON REJECT 1: SENSOR MONITORING CROSS CHECK CARTON REJECTED	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.59	FLT 2007: INFEED: CONSECUTIVE FAULT CHECK POSITION INHALER	<ul style="list-style-type: none"> Machine stops Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.60	FLT 2008: INFEED: CHECK POSITION INHALER: DEVICE NOT READY	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				

No.	Test title	Acceptance criteria	Deviation (No.)	Results comply		
				Test (yes/no)	Retest (yes/no)	Date/Signature
10.61	FLT 2009: INFEED: CHECK POSITION INHALER: SENSOR MONITORING	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.62	FLT 2016: INFEED: CROSS CHECK EJECT BELT 1 (INHALER): SENSOR MONI- TORING	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.63	FLT 2018: INFEED: SENSING PRODUCT (INHALER): SENSOR MONI- TORING	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.64	FLT 2024: INFEED: OVERHEAD CONVEYOR NOT IN UPPER POSITION	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				

No.	Test title	Acceptance criteria	Deviation (No.)	Results comply		Date/Signature
				Test (yes/no)	Retest (yes/no)	
10.65	FLT 2024: INFEED: OVERHEAD CONVEYOR NOT IN UPPER POSITION	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				
10.65.1	FLT 2025: INFEED: OVERHEAD CONVEYOR: MONITORING CHECK VALVE 1V21	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active 				

7.3 Deviation sheet

After execution the filled in deviation sheets will be attached to this document and the final number of attached pages has to be documented.

Empty forms are in chapter 7.6 "Forms", page 70.

Number of attached pages: _____

7.4 Change control sheet

After execution the filled in change control sheets will be attached to this document and the final number of attached pages has to be documented.

Empty forms are in chapter 7.6 "Forms", page 70.

Number of attached pages: _____

7.5 SOP

7.5.1 SOP-AG-06.012e Qualification deviation procedure

SOP | Qualification Deviation Procedure

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SOP Qualification Deviation Procedure

SOP-AG-06.012e

Valid from

01.Nov.2016

Original: text in blue; uncontrolled copy: text completely black / no change control!

Function	Name	Position / Company	Signature	Date
Created by	A. Belková	Project Manager, Valicare s.r.o.		20.OCT.2016
Reviewed by	R. Rösch	Qualification Engineer, Bosch Packaging Technology		25.Oct.2016
Approved by	R. Bauer	Department Head, Bosch Packaging Technology		25.Oct.2016

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SOP | Qualification Deviation Procedure

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1 References

None

2 Introduction

This standard operation procedure (SOP) defines how deviations are treated during Qualification. Moreover it shall be ensured, that all deviations that are stated during a Qualification, are reported properly.

3 Scope

This SOP describes how to proceed when deficiencies or / and deviations are detected after the approval of a Qualification program.

4 Philosophy

4.1 Resources & Equipment

The following items shall be used during the execution of this procedure:

- Stamp for Qualification of the respective department (e.g. PA-PH / SVC)

4.2 Procedure

Attention: Execution of the procedure by trained personnel only!

The following steps shall be performed during the execution of this procedure:

- 4.2.1. During Installation Qualification and Input- / Output-Tests deviations shall be classified either into Deficiency for minor deviation or Deviation for major deviation.

If there is a risk for the function of the system the deviation has to be classified as major deviation - Deviation.

All other deviations e.g. in the documentation or labelling (BmKz, EMSR) shall be classified as minor deviation - Deficiency.

- 4.2.2. During all other Qualification activities e.g. Calibration, Operational Qualification, Alarm- and Function-Tests, OQ-CT and Performance Qualification only major deviations – Deviations - are classified.

- 4.2.3. Depending on the classification different deviation forms shall be used for the follow up of the deviations.

Deficiencies

- 4.2.4. In the appendix is the list form for stated Deficiencies requiring changes / completion of the documentation or at the machine.

SOP | Qualification Deviation Procedure

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4.2.5. For better allocation, the deficiencies (in the documentation and at the machine) on the list form are marked with the following system:

XX 100 to XX 999

The following letter code (XX) for the location of the Deficiency is to use:

Letter code	Reference to
AA	Assembly-, Handling- and Inspectionmachines from PADK
AD	Packaging Machines from PADK
AS	Sterilizer, Autoclave
AX	All other machines, which are not defined separately.
LA	Assembly machine, Automatic Bag and Automatic Tub Opening machine, Tray Loading machine, Tray- and Nesthandling machine
LB	Closing machine
LE	Labelling machine
LF	Filling and Closing machine
LH	Laminar Flow Hood
LI	Isolator
LL	Inspection machine for ampoules and vials
LR	Coding machine
LT	Sterilization and Depyrogenation tunnel
LV	Vision system
LW	Washing machine
SC	Cartoner
SP	Capsule filling machine
ST	Thermoforming machine
SW	Balance

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SOP | Qualification Deviation Procedure

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4.2.6. The list with the deficiencies (see appendix) is passed to the concerned department for further follow up.

The orderly execution of the corrections / completions will be confirmed with date and initials in the list form after a re-check.

The corrected documents will be checked, stamped (with the qualification stamp of the respective department), signed and put in the binder to the corresponding test (original). A copy of the re-test-results could be filed additionally with the list form in the corresponding chapter.

With date and initials the check of the execution of the deficiency will be confirmed in the list form and the deficiency will be closed.

Deviations

4.2.7. If Deviations are stated during the execution of qualification tests (e.g. IQ, OQ, PQ), a Deviation Sheet (see appendix) has to be filled in by a person involved in the test.

4.2.8. For better allocation the Deviations on the Deviation Sheet are marked with the following system:

XX 001 to XX 099

The following letter code (XX) for the location of the Deviation is to use:

Letter code	Reference to
AC	Calibration
AA	Assembly-, Handling- and Inspectionmachines from PADK
AD	Packaging Machines from PADK
AS	Sterilizer, Autoclave
AX	All other machines, which are not defined separately.
LA	Assembly machine, Automatic Bag and Automatic Tub Opening machine, Tray Loading machine, Tray- and Nesthandling machine
LB	Closing machine
LE	Labelling machine
LF	Filling and Closing machine
LH	Laminar Flow Hood
LI	Isolator

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Letter code	Reference to
LL	Inspection machine for ampoules and vials
LR	Coding machine
LT	Sterilization and Depyrogenation tunnel
LV	Vision system
LW	Washing machine
SC	Cartoner
SP	Capsule filling machine
ST	Thermoforming machine
SW	Balance

4.2.9. Fill in item No. I with a description of the Deviation (BOSCH). Subsequently a solution has to be proposed in item No. II (BOSCH).

Now the Deviation Sheet has to be handed over to the customer who shall comment the proposed solution (item No. III) with either acceptance or refusal.

4.2.10. If the customer does not answer within 5 working days, the proposed solution is regarded as accepted.

4.2.11. If the customer refuses the proposed solution, both parties (BOSCH / customer) have to agree on a further approach. A new deviation sheet has to be used.

4.2.12. Record in item No. IV the result of the proposed solution performed. The customer shall comment the result with either acceptance or refusal.

4.2.13. If the Deviation and its documentation is completely finished it shall be closed in item No. V with date and initials by the customer or BOSCH.

4.2.14. If a test must be done again because of a Deviation, the test data of the re-test (original) will be put to the corresponding test. A copy of the re-test-results could be filed additionally with the list form in the corresponding chapter.

4.2.15. Transition to the next qualification step (e.g. from IQ to OQ):

If not agreed otherwise all Deviations should be closed before starting the next qualification step. Deficiencies can be closed later.

The transition to the next step with an open deviation must be clearly indicated (e.g. in the qualification report).

4.3 Acceptance Criteria

Not applicable.

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4.4 Documentation

- The documentation sheets in the appendix are intended for a summary of the deficiencies / deviations and have to be completely filled in by hand.
- The filled in deviation and deficiency forms shall be filed in the corresponding binders of the Qualification in a separate chapter.

4.5 Deviation handling

Not applicable.

4.6 Responsibility

- The author of the SOP or the responsible person for the location is responsible for training personnel to execute the test.
- The test execution and documentation of results are in the responsibility of the person executing the SOP.
- The conception, the supervision and coordination of the complete test is the responsibility of the PA-PH/SVC function.

5 Glossary

None

6 Appendix

Appendix 1	Form for Deviations
Appendix 2	List for Deficiencies

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7.5.2 SOP-AG-23.006e Handwritten documentation for qualification

SOP | Handwritten Documentation for Qualification

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SOP
Handwritten Documentation for Qualification

SOP-AG-23.006e

Valid from

01.Nov.2016

Function	Name	Position / Company	Signature	Date
Created by	A. Belková	Project Manager, Valicare s.r.o.	<i>A. Belková</i>	<i>20. Oct. 2016</i>
Reviewed by	R. Rösch	Qualification Engineer, Bosch Packaging Technology	<i>R. Rösch</i>	<i>25. Oct. 2016</i>
Approved by	R. Bauer	Department Head, Bosch Packaging Technology	<i>R. Bauer</i>	<i>25. Oct. 2016</i>

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SOP | Handwritten Documentation for Qualification

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1 References

No.	Title
[1]	EC-Guideline for a good manufacturing practice, Hrsg. Gert Auterhoff, Aulendorf, 1998, page 49 ff.

2 Introduction

This standard operating procedure (SOP) defines how handwritten documentation for GMP conforming qualification and validation work shall be done.

3 Scope

This SOP is valid for all activities during GMP conforming qualification / validation.

4 Philosophy

4.1 Resources & Equipment

The following items should be used during the execution of this procedure:

- Indelible pens (ballpoint pen, blue or red Fineliner)
- Ruler
- Qualification stamp

4.2 Procedure

Attention: Execution of the procedure by trained personnel only!

The following steps should be performed during the execution of this procedure:

- 4.2.1. Format for all dates: DD.MMM.YYYY (e.g. 16.Nov.2006)
- 4.2.2. The standard writing colour is blue. A legible (readable) handwriting is required.
- 4.2.3. Deviations (acceptance criteria not fulfilled) during verification of documents (IQ) shall be written in red, other remarks in blue.
- 4.2.4. Every handwritten change in the qualification documents has to be signed with the date and initials.

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SOP | Handwritten Documentation for Qualification

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4.2.5. Errors in handwriting or errors in forms shall be crossed out once with a ruler (if available) and signed with the date and initials. If the reason for the correction is not clear it shall be written down.

4.2.6. Forms without a line for signatures will be stamped with the qualification stamp. The stamped mark shall be filled in with the date and initials.

4.2.7. If printouts of measuring devices will be attached to the data sheets (glued / taped) there has to be a sign across the data sheet and the printout with initials. If thermopaper is used a copy of the pages shall be attached to the document.

4.2.8. All empty spaces in documents shall be crossed out with a „Z“ (with a ruler) and signed with the date and initials. A reason why the empty space is crossed out, e.g. „n.a.“ (not applicable), not necessary, no remarks etc. shall be written.

○ 4.3 Acceptance Criteria

Not applicable.

4.4 Documentation

Not applicable.

4.5 Deviation handling

Not applicable.

4.6 Responsibility

- The author of the SOP or the responsible person for the location is responsible for training personnel to execute the test.
- The test execution and documentation of results are in the responsibility of the person executing the SOP.
- The conception, the supervision and coordination of the complete test is the responsibility of the PA-PH/SVC function.

5 Glossary

None

6 Appendix

None

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7.5.3 SOP-AG-24.005e Procedure for change control

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SOP
Procedure for change control

SOP-AG-24.005e

Valid from

01.Nov.2016

Function	Name	Position / Company	Signature	Date
Created by	A. Belková	Project Manager, Valicare s.r.o.	<i>A. Belková</i>	20.OCT.2016
Reviewed by	R. Rösch	Qualification Engineer, Bosch Packaging Technology	<i>R. Rösch</i>	25.Oct.2016
Approved by	R. Bauer	Department Head, Bosch Packaging Technology	<i>R. Bauer</i>	25.Oct.2016

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SOP | Procedure for Change Control

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1. References

None

2. Introduction

With the procedure for "Change Control" the controlled status of the equipment and of the documentation shall be maintained during the Qualification.

After completion of the Qualification by Bosch SVC, the customer is responsible for the "Change Control" and its follow up.

3. Scope

A "Change Control" shall be filed, if the following conditions are met:

- A change in approved Qualification plans before execution of the test. (e.g. different SOP, different acceptance criteria, different scope, etc.)
- Changes or modification steps on the equipment which are carried out before or after the end of the qualification.

4. Philosophy

4.1 Resources & Equipment

The following items shall be used during the execution of this procedure:

- Sheet for "Change Control"

4.2 Procedure

Attention: Execution of the procedure by trained personnel only!

The following steps shall be performed during the execution of this procedure:

- 4.2.1 Every "Change" shall be filed on a separate sheet.
- 4.2.2 These sheets are collected in a separate chapter in the Qualification binder.
- 4.2.3 If a Re-Qualification or an additional Qualification was executed, the documentation for this shall be attached to the respective test.
- 4.2.4 The sheet for "Change Control" contains the following points:

I) Description

The description consists the following:

- What is changed?
- Why is the change necessary?
- Where is the change executed?
- Is a Re-Qualification necessary?

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4.2.5 II) Customer's comment

- The customer shall sign the form.
- If the customer refuses the change this shall be explained (comment).

4.2.6 III) Follow up action

After the necessary activities are executed, they have to be confirmed.

4.2.7 IV) Review

It has to be ensured, that the entire "Change" with all its documentation is complete. The review shall be signed to confirm this.

4.2.8 Numbering of a "Change"

For better allocation, each change on the form "Change Control" (CC) is marked with the following system:

XX 001 CC

The following letter code (XX) for the location of the Change is to use:

Letter code	Reference to
AC	Calibration
AA	Assembly-, Handling- and Inspectionmachines from PADK
AD	Packaging Machines from PADK
AS	Sterilizer, Autoclave
AX	All other machines, which are not defined separately.
LA	Assembly machine, Automatic Bag and Automatic Tub Opening machine, Tray Loading machine, Tray- and Nesthandling machine
LB	Closing machine
LC	Line
LE	Labelling machine
LF	Filling and Closing machine
LH	Laminar Flow-Hood
LI	Isolator
LL	Inspection machine for ampoules and vials
LR	Coding machine
LT	Sterilization and Depyrogenation tunnel

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Letter code	Reference to
LV	Vision System
LW	Washing machine
SC	Cartoner
SP	Capsule filling machine
ST	Thermoforming machine
SW	Balance

4.3 Acceptance Criteria

Not applicable.

4.4 Documentation

Please refer to chapter 4.2.1 – 4.2.8.

4.5 Deviation handling

Not applicable.

4.6 Responsibility

- The author of the SOP or the responsible person for the location is responsible for training personnel to execute the test.
- The test execution and documentation of results are in the responsibility of the person executing the SOP.
- The conception, the supervision and coordination of the complete test is the responsibility of the PA-PH/SVC function.

5. Glossary

None

6. Appendix

Appendix 1	Sheet for Change Control
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Original: text in blue; uncontrolled copy: text completely black / no change control!

7.6 Forms

INFORMATION



Please use the following forms as master copies when a deviation sheet or a change control sheet is required.

Test phase: _____	Deviation sheet / Formular für Abweichungen	Deviation / Abweichung Nº _____
-----------------------------	--	--

Referring to test (binder/chapter) / dazugehöriger Test (Ordner/Kapitel):

<u>I) Description of the Deviation / Beschreibung der Abweichung (BOSCH):</u>		
Editor / Autor:	Date / Datum:	Initials / Handzeichen:

<u>II) Proposed solution / Vorgeschlagene Lösung (BOSCH):</u>		
Editor / Autor:	Date / Datum:	Initials / Handzeichen:

<u>III) Decision – follow up action (customer) / Entscheidung - weitere Aktion (Kunde):</u>		
<input type="checkbox"/> Proposed solution accepted / Vorgeschlagene Lösung akzeptiert	<input type="checkbox"/> NOT accepted / NICHT akzeptiert => <u>Comment / Kommentar:</u>	
Editor / Autor:	Date / Datum:	Initials / Handzeichen:

<u>IV) Result (customer) / Ergebnis (Kunde):</u>		
<input type="checkbox"/> Conform and accepted / konform und akzeptiert	<input type="checkbox"/> NOT conform and NOT accepted / NICHT konform und NICHT akzeptiert => <u>Comments / Kommentare:</u>	
Editor / Autor:	Date / Datum:	Initials / Handzeichen:

<u>V) Deviation closed (customer or BOSCH) / Abweichung vollständig bearbeitet (Kunde o. BOSCH):</u>		
Editor / Autor:	Date / Datum:	Initials / Handzeichen:

Test phase: _____	Deviation sheet / Formular für Abweichungen	Deviation / Abweichung Nº _____
-----------------------------	--	--

Referring to test (binder/chapter) / dazugehöriger Test (Ordner/Kapitel):

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Editor / Autor:	Date / Datum:	Initials / Handzeichen:

<u>V) Deviation closed (customer or BOSCH) / Abweichung vollständig bearbeitet (Kunde o. BOSCH):</u>		
Editor / Autor:	Date / Datum:	Initials / Handzeichen:

Change Control Sheet / Formular für Change Control

Change Control
Nº _____

Referring documentation (binder/chapter) / dazugehörige Dokumentation (Ordner/Kapitel):

I) Description / Beschreibung:

- Re-Qualification necessary, if yes, how? / Requalifizierung nötig, wenn ja, wie?

Editor / Autor:	Date / Datum:	Initials / Handzeichen:
-----------------	---------------	-------------------------

II) Customer's comments / Kommentar des Kunden:

- | | |
|---|-----------------------|
| <input type="checkbox"/> Change accepted /
Change akzeptiert | Comments / Kommentar: |
| <input type="checkbox"/> NOT accepted, see comments /
NICHT akzeptiert, siehe
Kommentar | |

Editor / Autor:	Date / Datum:	Initials / Handzeichen:
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III) Follow up action / Aktionsverfolgung:

- Re-Qualification executed / Requalifizierung durchgeführt

Editor / Autor:	Date / Datum:	Initials / Handzeichen:
-----------------	---------------	-------------------------

IV) Review:

Editor / Autor:	Date / Datum:	Initials / Handzeichen:
-----------------	---------------	-------------------------

Change Control Sheet / Formular für Change Control

Change Control
Nº _____

Refering documentation (binder/chapter) / dazugehörige Dokumentation (Ordner/Kapitel):

I) Description / Beschreibung:

- Re-Qualification necessary, if yes, how? / Requalifizierung nötig, wenn ja, wie?

Editor / Autor:	Date / Datum:	Initials / Handzeichen:
-----------------	---------------	-------------------------

II) Customer's comments / Kommentar des Kunden:

- | | |
|---|-----------------------|
| <input type="checkbox"/> Change accepted /
Change akzeptiert | Comments / Kommentar: |
| <input type="checkbox"/> NOT accepted, see comments /
NICHT akzeptiert, siehe
Kommentar | |

Editor / Autor:	Date / Datum:	Initials / Handzeichen:
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III) Follow up action / Aktionsverfolgung:

- Re-Qualification executed / Requalifizierung durchgeführt

Editor / Autor:	Date / Datum:	Initials / Handzeichen:
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IV) Review:

Editor / Autor:	Date / Datum:	Initials / Handzeichen:
-----------------	---------------	-------------------------

Alarm and Function Testing Execution

CUK 2060

Cartoning machine

752937

**Glaxo Wellcome Production
France**

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1 Important Information

The following table lists the fault messages, warning messages and messages which are displayed on the control panel but can be simulated only by program changes and are therefore not tested.

	WARNING
<p>To perform a test procedure, it may be necessary to start the machine while the doors are open and the door contact switches are bridged.</p> <p>Safety functions are non-activ.</p> <p>Severe injuries may result.</p> <ul style="list-style-type: none"> ? Only authorized/trained persons are allowed to run the machine. ? Special attention must be given and care taken when working in the danger zone without protection. 	

 Please note that some fault messages, warnings or messages may contain a variable which is generated e.g. from the servo drive or profibus and gives further information about this device. The variable depends on the actual fault and therefore may vary.

Message number	Message text
ME0106	MACHINE: SPEED HAS BEEN REDUCED
ME0161	MOTION CONTROL: WAIT UNTIL OPERATIONAL
ME0162	MOTION CONTROL: DATA TRANSMISSION TO MOTION DRIVES
ME0164	MOTION CONTROL: SYNCHRONIZING
ME0448	ROBOT: REFERENCE RUN

Warning number	Warning text
WA0015	CONTROL-PC: USED DISK SPACES EXCEEDS 80 %

Fault number	Fault text
FLT0008	HMI: FAULT COMMUNICATION TO CONTROL
FLT0012	MOTION CONTROLLER: 508: SERCOS RUN-UP-ERROR
FLT0013	MACHINE: REFERENCE NOT SET TO ZERO
FLT0015	CONTROL PC: USED DISK SPACE EXCEEDS 90%
FLT0026	CONTROL CABINET: COM ERROR SAFETY PLC
FLT0083	GUARD BASIC MACHINE: SAFETY CIRCUIT NOT ACTIVE
FLT0196	MOTION DRIVE MAIN DRIVE: FAULT
FLT0198	MOTION DRIVE MAIN DRIVE: 0 : NO ERROR CODE ACTIVE
FLT0299	PARAMETER FAULT CAM START >CARTON: OPEN FLAP: SIGN IN REGISTER < LATER THAN CAM START > CARTON: EJECTION 1<
FLT0380	MOTION DRIVE LEAFLET UNIT: 0 : NO ERROR CODE ACTIVE
FLT0382	MOTION DRIVE LEAFLET UNIT: FAULT
FLT0404	ROBOT: MOTION DRIVE: OVERLOAD POWER SUPPLY
FLT0455	ROBOT: COLLISION RANGE

Fault number	Fault text
FLT0478	ROBOT: MOTION CONTROL: FAULT
FLT0480	ROBOT: MOTION DRIVE AXIS A: FAULT
FLT0481	ROBOT: MOTION DRIVE AXIS B: FAULT
FLT0482	ROBOT: MOTION DRIVE AXIS C: FAULT
FLT0483	ROBOT: MOTION DRIVE ROTARY AXIS: FAULT
FLT0486	ROBOT: MOTION DRIVE AXIS A: 0 : NO ERROR CODE ACTIVE
FLT0487	ROBOT: MOTION DRIVE AXIS B: 0 : NO ERROR CODE ACTIVE
FLT0488	ROBOT: MOTION DRIVE AXIS C: 0 : NO ERROR CODE ACTIVE
FLT0489	ROBOT: MOTION DRIVE ROTARY AXIS: 0 : NO ERROR CODE ACTIVE
FLT0494	ROBOT: MOTION DRIVE INFEED BELT: FAULT
FLT0495	ROBOT: MOTION DRIVE INFEED BELT: 0: NO ERROR CODE ACTIVE
FLT1513	INFEED: REMOVE PRODUCT BEFORE REFERENCE/SYNCHRON RUN
FLT2014	INFEED: MOTION DRIVES OVERHEAD CONVEYOR: FAULT
FLT2015	INFEED: MOTION DRIVES OVERHEAD CONVEYOR: 0: NO ERROR CODE ACTIVE

2 Software version

Test objective	<ul style="list-style-type: none"> Documentation of software version used for test execution 				
Test procedure					
Required operations	<ul style="list-style-type: none"> Write down in table below the installed software version (Baseline) before execution of alarm and function testing. 				
<table border="1"> <thead> <tr> <th>Software/Firmware</th> <th>Version</th> </tr> </thead> <tbody> <tr> <td>Baseline</td> <td><input type="text"/></td> </tr> </tbody> </table>		Software/Firmware	Version	Baseline	<input type="text"/>
Software/Firmware	Version				
Baseline	<input type="text"/>				
Test result	yes/no				
Acceptance criteria	<ul style="list-style-type: none"> The software version is documented. <input type="text"/>				
Comments	<input type="text"/>				

Results comply	yes/no	Date/Initials
	<input type="text"/>	<input type="text"/>
Results approved	Date/Initials	
	<input type="text"/>	

3 Check HMI menu, buttons and switches

3.1 Spotcheck HMI

Test objective	<ul style="list-style-type: none"> • Menu check of HMI menu tree
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode • User Admin is logged in
Required operations	<ul style="list-style-type: none"> • Copy the menu tree from the operation manual chap. 5 • Select longest tree as example (or one of the longest trees) • Go step by step through the selected tree • Control the menu and the names of the page tabs • Attach the copy to this test
Comments	<ul style="list-style-type: none"> • This is a spotcheck test. Only the longest menu tree needs to be checked
Acknowledgement	<ul style="list-style-type: none"> • None
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • HMI menu and page tab spotcheck is OK
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

4 Access protection

4.1 Create new User

Test objective	<ul style="list-style-type: none"> Create an new user with the user name "validation" 																																
Test procedure	<p>Required operations</p> <ul style="list-style-type: none"> Log in user "admin" Select the menu "Settings" Select the submenu "User management" Activate SWS "settings" In the submenu "Settings" select> "User Password" <p>Create following configuration:</p> <p>USER PASSWORD</p> <table border="1"> <tr> <td>User</td> <td></td> </tr> <tr> <td> <ul style="list-style-type: none"> Minimum length (characters) </td> <td>4</td> </tr> <tr> <td> <ul style="list-style-type: none"> Maximum length (characters) </td> <td>25</td> </tr> <tr> <td>Password</td> <td></td> </tr> <tr> <td> <ul style="list-style-type: none"> Minimum length (characters) </td> <td>4</td> </tr> <tr> <td> <ul style="list-style-type: none"> Maximum length (characters) </td> <td>12</td> </tr> <tr> <td> <ul style="list-style-type: none"> Different (characters) </td> <td>0</td> </tr> <tr> <td> <ul style="list-style-type: none"> Repetitive (characters) </td> <td>0</td> </tr> <tr> <td> <ul style="list-style-type: none"> Difference (characters) </td> <td>3</td> </tr> <tr> <td> <ul style="list-style-type: none"> Min. age of PW (days) </td> <td>0</td> </tr> <tr> <td> <ul style="list-style-type: none"> Old passwords (quantity) </td> <td>10</td> </tr> <tr> <td> <ul style="list-style-type: none"> PW must include alpha characters </td> <td>"checkmark"</td> </tr> <tr> <td> <ul style="list-style-type: none"> PW must include numeric characters </td> <td>"checkmark"</td> </tr> <tr> <td> <ul style="list-style-type: none"> PW must include special characters </td> <td>"checkmark"</td> </tr> <tr> <td> <ul style="list-style-type: none"> Prohibited passwords </td> <td>ROTZINGER; we35!</td> </tr> <tr> <td> <ul style="list-style-type: none"> Select the submenu "General" </td> <td></td> </tr> </table>	User		<ul style="list-style-type: none"> Minimum length (characters) 	4	<ul style="list-style-type: none"> Maximum length (characters) 	25	Password		<ul style="list-style-type: none"> Minimum length (characters) 	4	<ul style="list-style-type: none"> Maximum length (characters) 	12	<ul style="list-style-type: none"> Different (characters) 	0	<ul style="list-style-type: none"> Repetitive (characters) 	0	<ul style="list-style-type: none"> Difference (characters) 	3	<ul style="list-style-type: none"> Min. age of PW (days) 	0	<ul style="list-style-type: none"> Old passwords (quantity) 	10	<ul style="list-style-type: none"> PW must include alpha characters 	"checkmark"	<ul style="list-style-type: none"> PW must include numeric characters 	"checkmark"	<ul style="list-style-type: none"> PW must include special characters 	"checkmark"	<ul style="list-style-type: none"> Prohibited passwords 	ROTZINGER; we35!	<ul style="list-style-type: none"> Select the submenu "General" 	
User																																	
<ul style="list-style-type: none"> Minimum length (characters) 	4																																
<ul style="list-style-type: none"> Maximum length (characters) 	25																																
Password																																	
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<ul style="list-style-type: none"> Different (characters) 	0																																
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<ul style="list-style-type: none"> Prohibited passwords 	ROTZINGER; we35!																																
<ul style="list-style-type: none"> Select the submenu "General" 																																	

Test procedure	
Required operations	GENERAL
	Password
	<ul style="list-style-type: none"> • Maximum age (days) 30 • Hint (days) 25 • Failed attempts (quantity) 3
	User
	<ul style="list-style-type: none"> • Last log-in (days) 0 • Display last user (min.) 0 • Remove blocking (min.) 3 • Auto log-out (min.) 5
	<ul style="list-style-type: none"> • Select menu “settings” > select submenu “User management” • Press “User management” • Press “Add” • Add new user <ul style="list-style-type: none"> • User validation • Comment user for testing • New password AB12?! • Repeat new password AB12?! • Confirm user • In submenu “User management” select user “validation” • Press “Configure” • Switch off “Force password change” • Press “Group assignment” and select the group “Administrator” • Note the date of the configuration of user “validation” (DD.MMM.YYYY):(HH:mm)
	<ul style="list-style-type: none"> • Confirm twice with check mark • Check added user in Audit trail (Select submenu “Diagnostics” > press “Audit trail” >press “Audit trail viewer” >select “Display”)

Test procedure	
Consequence	<ul style="list-style-type: none"> • User settings are adjusted according to data of table • New user can be created • Added user is documented in Audit trail with correct date and time
Comments	<ul style="list-style-type: none"> • User “validation” has the same status as admin and is used for all other test • 21 CFR Part 11: §11.10(d,g), §11.200(a), §11.300(a,b,d) • GMP Vol.4 Annex 11: 12.3; 12.4
Test result yes/no	
Acceptance criteria	<ul style="list-style-type: none"> • User settings are adjusted according to data of table _____ • New user can be created _____ • Added user is documented in Audit trail with correct date and time _____
Comments	

Results comply	yes/no 	Date/Initials
Results approved	Date/Initials 	

4.2 Log-in

Test objective	<ul style="list-style-type: none"> • No action without logged in user • Checking the number of user log-in actions • Log-in requires the individual user name and password
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is operational • No user is logged in
Required operations	<ul style="list-style-type: none"> • Press "Reset" • Message "Please log in first!" is indicated and shown in display, no function can be actuated • Touch any function key • Help screen opens: "No user is logged in or no sufficient rights" • Call up function "Log on user" • Log in user "validation" (see configuration user for validation) • Call up function "Log on user" again • Information window "Log out user " is displayed • Confirm log out in order to log in another user
Consequence	<ul style="list-style-type: none"> • Only one user at a time can be logged in • Functions can only be actuated when a valid user is logged in
Comments	<ul style="list-style-type: none"> • Machine stop and Emergency stop can be activated without logged in user. • 21 CFR Part 11: §11.10(d,g), §11.200(a), §11.300(a,b,d) • GMP Vol.4 Annex 11: 12.3; 12.4
Acknowledgement	<ul style="list-style-type: none"> • None

Test result		yes/no
Acceptance criteria	• Only one user at a time can be logged in	<input type="text"/>
	• Functions can only be actuated when a valid user is logged in	<input type="text"/>
Comments	<input type="text"/>	

Results comply	yes/no <input type="text"/>	Date/Initials <input type="text"/>
Results approved	Date/Initials <input type="text"/>	

4.3 Password rules

Test objective	<ul style="list-style-type: none"> • Check of valid password rules
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • No user is logged in
Required operations	<ul style="list-style-type: none"> • Call up function “Log on user” • Enter user “validation” and press “Change Password” • Enter the origin password and check each password rule in the table “Change password” and “Successful password change” • Log in with the new password
Comments	<ul style="list-style-type: none"> • 21 CFR Part 11: §11.10(d,g), §11.200(a), §11.300(a,b,d) • GMP Vol.4 Annex 11: 12.3; 12.4
Acknowledgement	<ul style="list-style-type: none"> • Log in as “Admin” and reset the new password to the origin password (see user configuration validation, use the noted password)

Password change

Create new password	Password rule is indicated with a red dot	yes/no	Initials/Date
Enter the password “12AB??” “Password repetition has to be identical” in first line and enter password “13AB??” as repetition			
<input type="text"/>			
<input type="text"/>			
Enter a password with less than 4 characters	“Password has to be at least 4 characters long”		
<input type="text"/>			
Enter a password with more than 12 characters	“Password may be only 12 characters long”		
<input type="text"/>			
Enter the old password “AB12?!”	“Password is not in the list of old passwords”		
<input type="text"/>			
Enter a password without alpha characters	“Password must include alpha characters”		
<input type="text"/>			
Enter a password without special characters	“Password must include special characters”		
<input type="text"/>			

Create new password	Password rule is indicated with a red dot	yes/no	Initials/Date
Enter a password without digits	“Password must include numeric characters”	<input type="text"/>	<input type="text"/>
<input type="text"/>			
Enter a password with only one different character to the old password	“Password has at least 3 different characters between the old and the new password”	<input type="text"/>	<input type="text"/>
<input type="text"/>			
Enter a password of the prohibited list (create a new prohibited password which is conform with the other password rules)	“Password is not in the list of prohibited passwords”	<input type="text"/>	<input type="text"/>
Use the prohibited password “we35!”		<input type="text"/>	
<input type="text"/>			

Successful password change

- Apply all rules for one password

Create new password	Password rule is indicated with a green dot	yes/no	Initials/Date
Insert the same password again in the second line	“Password repetition has to be identical”	<input type="text"/>	<input type="text"/>
Use a password with min. 4 characters	“Password must be at least 4 characters long”	<input type="text"/>	<input type="text"/>
Use a password with max. 12 characters	“Password must not be longer than 12 characters”	<input type="text"/>	<input type="text"/>
Use a new password	“Password must not be in the list of old passwords”	<input type="text"/>	<input type="text"/>
Use a password with alpha characters	“Password must include alpha characters”	<input type="text"/>	<input type="text"/>
Use a password with special characters	“Password must include special characters”	<input type="text"/>	<input type="text"/>
Use a password with digits	“Password must include numeric characters”	<input type="text"/>	<input type="text"/>
Use a password with more than 3 different character to the old password	“Password has at least 3 different characters between the old and the new password”	<input type="text"/>	<input type="text"/>
Use a password that is not listed in the prohibited password	“Password is not in the list of prohibited passwords”	<input type="text"/>	<input type="text"/>

All rules are followed and the green “checkmark” is indicated and the new password:

<input type="text"/>	is created
----------------------	------------

Test result		yes/no
Acceptance criteria	• If not all rules are followed, the password can not be changed	<input type="button" value=""/>
	• If all rules are followed, the password can be changed	<input type="button" value=""/>
Comments	<input type="text"/>	

Results comply	yes/no <input type="button" value=""/>	Date/Initials <input type="button" value=""/>
Results approved	Date/Initials <input type="button" value=""/>	

4.4 Password validity

Test objective	<ul style="list-style-type: none"> Check of automatic password expiry
Test procedure	See *)
Test prerequisites	<ul style="list-style-type: none"> User "validation" is logged in No batch is active
Required operations	<ul style="list-style-type: none"> Note the configuration date of user "validation" <ul style="list-style-type: none"> Select menu "Settings" > select submenu "User management" > press "User management" > press "user management" > select user "validation" > press "Configure" > window "Configuration/validation" opens Password since <input type="text"/> Add up the date with $y = 25$ days: <ul style="list-style-type: none"> Calculated date <input type="text"/> Select submenu "Service", press "Change system time" and change the date ahead of the new calculated date Log out user "validation" Log in user "validation" Information window "The validity duration of the password will expire in x-y (5) days" is shown Add up the date (configuration date) with $x + 1 = 30 + 1$ days: <ul style="list-style-type: none"> Calculated date <input type="text"/> Select submenu "Service", press "Change system time" and change the date ahead of the new calculated date Log out user "validation" Log in user "validation" Information window "The validity duration of the password has been expired" is shown Press "OK" and change the password New password <input type="text"/>
Consequence	<ul style="list-style-type: none"> The user is informed y days before the password validity expires (default $y=25$) The password validity expires automatically after x days (default $x=30$)

Test procedure	See *)
Comments	<ul style="list-style-type: none"> • 21 CFR Part 11: §11.10(d,g), §11.200(a), §11.300(a,b,d) • GMP Vol.4 Annex 11: 12.3; 12.4 • *)Due to the audit trail entries we recommend to perform this test at the end.
Acknowledgement	<ul style="list-style-type: none"> • Set back Windows system date
Test result	yes/no

Acceptance criteria	<ul style="list-style-type: none"> • The user is informed y days before the password validity expires (default y= 25) <input type="text"/> • The password validity expires automatically after x days (default x= 30) <input type="text"/>
Comments	<input type="text"/>

Results comply	yes/no	Date/Initials
	<input type="text"/>	<input type="text"/>
Results approved	Date/Initials	
	<input type="text"/>	

4.5 Identical name: User and password

Test objective	<ul style="list-style-type: none"> Identical name of user and password
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> User "validation" is logged in User "validation" creates a new user with user name "Test01!" in menu "User Management" <p style="margin-left: 40px;">Password "abcd1234!"</p>
Required operations	<ul style="list-style-type: none"> Call up function "Log on user" Enter user name "Test01!" and password "abcd1234!" Information window "Log on user: The password received from the administrator has to be changed" is displayed Enter password "Test01!" (identical with user name) Try to confirm the new password
Consequence	<ul style="list-style-type: none"> Identical names for user and password are not possible Confirmation button is deactivated
Comments	<ul style="list-style-type: none"> Only the original password created by the admin user "validation" may be identical to the user name. After the first log-in with the original password, the user is forced to change the password which must be different. 21 CFR Part 11: §11.10(d,g), §11.200(a), §11.300(a,b,d) GMP Vol.4 Annex 11: 12.3; 12.4
Acknowledgement	<ul style="list-style-type: none"> None
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> Identical names for user and password are not possible
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

4.6 New password

Test objective	<ul style="list-style-type: none"> Check of properties of a new password
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> User "validation" is logged in
Required operations	<ul style="list-style-type: none"> In submenu "User management" press "Settings" In submenu "User password", deselect the "checkmark": <ul style="list-style-type: none"> Password must include alpha characters, Password must include digits, Password must include special characters Log out user "validation" Call up function "Log in user" Enter user "validation" Press "Change password" Change the password 10 times using various passwords which differ from the other passwords at least 3 characters <ul style="list-style-type: none"> Password 1 "1111" <input type="text"/> Password 2 "2222" <input type="text"/> Password 3 "3333" <input type="text"/> Password 4 "4444" <input type="text"/> Password 5 "5555" <input type="text"/> Password 6 "6666" <input type="text"/> Password 7 "7777" <input type="text"/> Password 8 "8888" <input type="text"/> Password 9 "9999" <input type="text"/> Password 10 "0000" <input type="text"/> Use password 1 as 11th trial "1111" <input type="text"/> Password rule: "Password is not in the list of old passwords" is indicated by a red dot. Its not possible to confirm the new password. <ul style="list-style-type: none"> Password 11 "5678" <input type="text"/> Change again the password and use password 1 "1111" <input type="text"/>

Test procedure	
Consequence	<ul style="list-style-type: none"> With last change of password it is possible to change it again to the first password Only the user "validation" can reset the password
Comments	<ul style="list-style-type: none"> 21 CFR Part 11: §11.10(d,g), §11.200(a), §11.300(a,b,d) GMP Vol.4 Annex 11: 12.3; 12.4
Acknowledgement	<ul style="list-style-type: none"> In submenu "User password", select the "checkmarks": <ul style="list-style-type: none"> Password must include alpha characters, Password must include digits, Password must include special characters
Test result yes/no	
Acceptance criteria	<ul style="list-style-type: none"> The last x passwords of the user are saved and disabled for reuse (default x = 10) <input type="text"/> As soon as x = 10 other passwords have been saved the first password can be used again <input type="text"/>
Comments	<input type="text"/>

Results comply	yes/no <input type="text"/>	Date/Initials <input type="text"/>
Results approved	Date/Initials <input type="text"/>	

4.7 Change of password

Test objective	<ul style="list-style-type: none"> Procedure for input of new password
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> Machine is operational No user is logged in
Required operations	<ul style="list-style-type: none"> Call up function “Log on user” Enter user name “validation” Press “Change password” Enter new password according to the password rules <ul style="list-style-type: none"> New password Confirm new password Call up function “Log on user” Enter user name “validation” and new password Select submenu “Diagnostics” -> Audit trail and press “Audit trail viewer” Press “Display” in windows “Audit trail viewer” Check audit trail: Correct entry of user, date, time and action of password change. The password itself is not shown Print out audit trail after completion of the tests
Consequence	<ul style="list-style-type: none"> New password is accepted Entry to audit trail correct Only the administrator can reset the password.
Comments	<ul style="list-style-type: none"> Attention! If you would like to set back the password to the original password, you have to change the Password settings: “Min age of password (days)” to 0 and “Old passwords (quantity)” to 0. 21 CFR Part 11: §11.10(d,g), §11.200(a), §11.300(a,b,d) GMP Vol.4 Annex 11: 12.1; 12.3
Acknowledgement	<ul style="list-style-type: none"> None

Test result		yes/no
Acceptance criteria	• New password is accepted	<input type="button" value=""/>
	• Entry to audit trail correct	<input type="button" value=""/>
Comments	<input type="text"/>	

Results comply	yes/no <input type="button" value=""/>	Date/Initials <input type="button" value=""/>
Results approved	Date/Initials <input type="button" value=""/>	

4.8 User-account locked (disable)

Test objective	<ul style="list-style-type: none"> Account disable after multiple failed log-in attempts
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> Machine is operational No user is logged in
Required operations	<ul style="list-style-type: none"> Call up function "Log on user" Enter user name "Test01!" (do not use the Admin account) Enter invalid password "3" times <ul style="list-style-type: none"> 1. attempt-time 2. attempt-time 3. attempt-time
Consequence	<ul style="list-style-type: none"> Error message is displayed The user account is locked (disabled)
Required operations	<ul style="list-style-type: none"> Call up function "Log on user" Log in with user "validation" Call up function "Audittrail viewer"
Consequence	<ul style="list-style-type: none"> User status changed Name Test01!, state previous: Activate, new: Locked
Required operations	<ul style="list-style-type: none"> Enable the user account by admin "validation" <ul style="list-style-type: none"> Select submenu "User Management" > press "User Management" > select Filter "Locked" > select disabled user "Test01!" > "press operation switch" "Configure" > deselect switch "Lock user" to disable user "Test01!" > confirm checkmark Call up function "Audittrail Viewer"
Consequence	<ul style="list-style-type: none"> User status changed User: Test01! Status previous: Locked → Status new: Active
Required operations	<ul style="list-style-type: none"> Check in audit trail the correct entry of user, date, time and action of disable Print out audit trail after completion of the test
Comments	<ul style="list-style-type: none"> User "Test01!" is automatically enabled after three minutes. Test must be done during three minutes 21 CFR Part 11: §11.10(d,g), §11.200(a), §11.300(a,b,d) GMP Vol.4 Annex 11: 12.1; 12.3
Acknowledgement	<ul style="list-style-type: none"> None

Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • After x invalid log-in attempts the user account is disabled and an entry concerning the unauthorized access attempt (default x= 3) is made to the audit trail • The disabled user account can be enabled by the administrator <input style="width: 150px; height: 25px; border-radius: 15px; border: 1px solid black; background-color: white; font-size: 10px; margin-top: 10px;" type="button" value=" "/>
Comments	<input style="width: 100%; height: 100px; border: 1px solid black; border-radius: 10px; margin-top: 10px;" type="text"/>

Results comply	yes/no <input style="width: 100px; height: 25px; border-radius: 15px; border: 1px solid black; background-color: white; font-size: 10px;" type="button" value=" "/>	Date/Initials <input style="width: 100%; height: 25px; border: 1px solid black; border-radius: 15px; margin-top: 5px;" type="text"/>
Results approved	Date/Initials <input style="width: 100%; height: 25px; border: 1px solid black; border-radius: 15px; margin-top: 5px;" type="text"/>	

4.9 Disable time

Test objective	<ul style="list-style-type: none"> • Disable time after multiple failed log-in attempts
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is operational • No user is logged in
Required operations	<ul style="list-style-type: none"> • Call up function "Log on user" • Enter user name "Test01!" - do not use the Admin account • Enter invalid password "3" times <ul style="list-style-type: none"> • 1. attempt-time • 2. attempt-time • 3. attempt-time
Consequence	<ul style="list-style-type: none"> • Error message is displayed • The user account is disabled
Required operations	<ul style="list-style-type: none"> • Wait aprox. 3 minutes • Call up function "Log on user" • Log in user "Test01!" • Log out user "Test01!" • Call up function "Log on user" • Log in user "validation" • Select submenu "Diagnostics">> press "Audittrail viewer">> press "Display" • Check in audit trail the correct entry of user, date, time and action of disable • Print out audit trail after completion of the test
Consequence	<ul style="list-style-type: none"> • After x invalid log-in attempts the system is disabled for y minutes and an entry concerning the unauthorized access attempt (default x= 3), (default y= 3 min) is made to the audit trail
Comments	<ul style="list-style-type: none"> • 21 CFR Part 11: §11.10(d,g), §11.200(a), §11.300(a,b,d) • GMP Vol.4 Annex 11: 12.1; 12.3
Acknowledgement	<ul style="list-style-type: none"> • None

Test result		yes/no
Acceptance criteria	<ul style="list-style-type: none"> • After x invalid log-in attempts the system is disabled for y minutes and an entry concerning the unauthorized access attempt (default x= 3), (default y= 3 min) is made to the audit trail <input type="text"/>	
Comments	<input type="text"/>	

Results comply	yes/no <input type="text"/>	Date/Initials <input type="text"/>
Results approved	Date/Initials <input type="text"/>	

4.10 Automatic log-out / log in again

Test objective	<ul style="list-style-type: none"> Access protection: Time log-out
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> Machine is operational
Required operations	<ul style="list-style-type: none"> Call up function "Log on user" Log in with user "validation" Select menu "System configuration">> select submenu "User management"> press "General settings" > select submenu "General" > set "Auto log-out (min.)" to "1" Log out user "validation" Call up function "Log on user" Log in with user "validation" Note time of log in: No action for "x = 1" minutes <ul style="list-style-type: none"> User is automatically logged out
Consequence	<ul style="list-style-type: none"> User is automatically logged out
Required operations	<ul style="list-style-type: none"> Call up function "Log on user" Log in again with the same user name and password Select submenu "Diagnostics">> press "Audittrail viewer" >press "Display" Check in audittrail the correct entry of user, date, time and action "Auto log-out" Print out audit trail after completion of the test
Consequence	<ul style="list-style-type: none"> Automatic log-out after x minutes Log in again with the same user and password is possible Action of Log out is recorded in audit trail Action of Log in is recorded in audit trail
Comments	<ul style="list-style-type: none"> 21 CFR Part 11: §11.10(d,g), §11.200(a), §11.300(a,b,d) GMP Vol.4 Annex 11: 12.1; 12.3
Acknowledgement	<ul style="list-style-type: none"> Set time for automatic log-out back to previous value (5 min)

Test result	yes/no	
Acceptance criteria	• Automatic log-out after x minutes	<input type="checkbox"/>
	• Log in again with the same user and password is possible	<input type="checkbox"/>
	• Action of Log out is recorded in audit trail	<input type="checkbox"/>
	• Action of Log in is recorded in audit trail	<input type="checkbox"/>
Comments	<input type="text"/>	

Results comply	yes/no <input type="checkbox"/>	Date/Initials <input type="text"/>
Results approved	Date/Initials <input type="text"/>	

5 Audit trail

5.1 Audit trail entries -time stamp

Test objective	<ul style="list-style-type: none"> All user actions related to process, quality and product as well as all parameter changes must be recorded in the audit trail 																
Test procedure																	
Test prerequisites	<ul style="list-style-type: none"> User “validation” is logged in Machine is ready in automatic mode Date and time are identical to external clock 																
Required operations	<ul style="list-style-type: none"> Start new batch called “Test audit trail” <table style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th style="text-align: right; padding-bottom: 5px;">Time code hr : min</th> <th style="text-align: right; padding-bottom: 5px;">Confirmation in audit trail</th> </tr> </thead> <tbody> <tr> <td style="text-align: right; padding-top: 5px;"><input checked="" type="checkbox"/></td> <td style="text-align: right; padding-top: 5px;"><input type="checkbox"/></td> </tr> <tr> <td style="text-align: right; padding-top: 5px;"><input type="checkbox"/></td> <td style="text-align: right; padding-top: 5px;"><input type="checkbox"/></td> </tr> <tr> <td style="text-align: right; padding-top: 5px;"><input type="checkbox"/></td> <td style="text-align: right; padding-top: 5px;"><input type="checkbox"/></td> </tr> <tr> <td style="text-align: right; padding-top: 5px;"><input type="checkbox"/></td> <td style="text-align: right; padding-top: 5px;"><input type="checkbox"/></td> </tr> <tr> <td style="text-align: right; padding-top: 5px;"><input type="checkbox"/></td> <td style="text-align: right; padding-top: 5px;"><input type="checkbox"/></td> </tr> <tr> <td style="text-align: right; padding-top: 5px;"><input type="checkbox"/></td> <td style="text-align: right; padding-top: 5px;"><input type="checkbox"/></td> </tr> </tbody> </table>			Time code hr : min	Confirmation in audit trail	<input checked="" type="checkbox"/>	<input type="checkbox"/>										
Time code hr : min	Confirmation in audit trail																
<input checked="" type="checkbox"/>	<input type="checkbox"/>																
<input type="checkbox"/>	<input type="checkbox"/>																
<input type="checkbox"/>	<input type="checkbox"/>																
<input type="checkbox"/>	<input type="checkbox"/>																
<input type="checkbox"/>	<input type="checkbox"/>																
<input type="checkbox"/>	<input type="checkbox"/>																
Comments	<ul style="list-style-type: none"> Software switch / Filter settings: Activate the filter “with advance“ and with “time period“ 21 CFR Part 11: §11.10(d,g), §11.200(a), §11.300(a,b,d) GMP Vol.4 Annex 11: 12.1; 12.3 																
Acknowledgement	<ul style="list-style-type: none"> None 																

Test result		yes/no
Acceptance criteria	<ul style="list-style-type: none">• All entries show the activity, user name, date and time correctly	
Comments		

Results comply	yes/no	Date/Initials
	<input type="button" value=""/>	<input type="button" value=""/>
Results approved	Date/Initials	
	<input type="button" value=""/>	

5.2 Audit trail entries

Test objective	<ul style="list-style-type: none"> Structure of entries
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> Machine is operational
Required operations	<ul style="list-style-type: none"> Log in user "admin" Log out user "admin" Log in user "validation" Log out user "validation" Log in user "validation" Call up function "Audittrail viewer" Select "All batches" Press "Filter setting" Select filter "User name" by activating the checkmark Press "Setting" within the filter setting "User name" Move one of the given users from field "All" to the field "Selected" (e.g. admin) Select filter "Time period" Press "Setting" within the filter setting "Time period" Adjust the time period to the last 10 minutes Confirm with the checkmark Close the menu "Filter setting" by using of the checkmark Press "Display" within the "Audittrail viewer" The corresponding audit view is displayed Call up function "Print" The audit trail printout displays the selected date and time Select filter settings button Select filter "Faults" Confirm with the checkmark Press "Refresh" The corresponding audit view is displayed Try to modify or delete last entry in audit trail Check the correct adjustment (AM/PM) Print out audit trail after completion of the tests
Consequence	<ul style="list-style-type: none"> All entries in the audit trail show the activity, user name, date and time The entries can be filtered and printed online based on various criteria (user, activity, date and time, batch) Entries can not be modified or deleted

Test procedure	
Comments	<ul style="list-style-type: none"> • Select an audit trail in “Audittrail viewer” within a time frame showing actions • 21 CFR Part 11: §11.10(d,g), §11.200(a), §11.300(a,b,d) • GMP Vol.4 Annex 11: 12.1; 12.3
Acknowledgement	<ul style="list-style-type: none"> • Remove “Filter setting” • Close “Audit trail viewer” • Several filter settings can be activated for the next start of the “Audittrail viewer”
Test result yes/no	
Acceptance criteria	<ul style="list-style-type: none"> • All entries in the audit trail show the activity, user name, date and time _____ • The entries can be filtered and printed online based on various criteria (user, activity, date and time, batch) _____ • Entries can not be modified or deleted _____
Comments	

Results comply	yes/no 	Date/Initials
Results approved	Date/Initials 	

6 Version management for recipe

6.1 Version management in case of new recipe (product version)

Test objective	<ul style="list-style-type: none"> All recipe data are managed in menu “Recipe” > submenu “Recipe management”
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> Machine is operational User “validation” is logged in
Required operations	<ul style="list-style-type: none"> Select menu “Recipe” > select submenu “Recipe management” Select one recipe and press “Versions” Select the current version and press “Create new recipe” Recipe version number “x” = <input type="text"/> is created Change the recipe name of recipe version “x” (e.g. “Validation A 500 mg”) Call up the new generated recipe in the window “recipe version” (e.g. “Validation A 500 mg”) Select a version and press “New draft version” A new version draft with count up number “y” = <input type="text"/> is created Select draft “y” and press “Enable” Confirm message Select the current recipe version in the window Press “Activate” In the overview “Current recipe” the recipe is shown (e.g. Validation A 500 mg) Version x.y = <input type="text"/> (e.g. 0002.0001) released
Comments	<ul style="list-style-type: none"> 21 CFR Part 11: §11.10 (b) GMP Vol.4 Annex 11: 8.1

Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> When creating a new recipe, it will be generated with the designation count up number "x"; a new version with count up number "y" After enabling the draft version (only) the status changes
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

6.2 Disable version (product data)

Test objective	<ul style="list-style-type: none"> • Disable a version
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is operational • User “validation” is logged in
Test 1	Delete a version
Required operations	<ul style="list-style-type: none"> • Select menu “Recipe” > select submenu “Select recipe management” • Select the new recipe (e.g. Validation A 500 mg) • Press “Versions” • Create a new draft version • Select the new draft version • Press "Delete" and confirm (note time of action)  • Leave menu „Recipe versions product“ • Leave menu “Recipe list product” • Select menu “System configuration” > select submenu “Diagnostic” • Select “Audittrail viewer” • Select “Filter settings” • Activate checkmarks for “Function” • Select “Function setting” • Select “Size management” and change to selected • Select “Size management” and press “Events” • Select “Recipe deleted” and change to selected • Confirm tree times with “Checkmark” and press button “Display” • Check the entry in the audit trail • Print out audit trail after completion of the tests
Consequence	<ul style="list-style-type: none"> • Versions can be deleted • When the corresponding filters are selected, all existing versions are open for viewing • Entry to audit trail is correct
Comments	<ul style="list-style-type: none"> • If no active version is available create a “New draft version” • Inactive versions can be deleted by the Admin only • Enabled recipes can not be deleted
Acknowledgement	<ul style="list-style-type: none"> • None

Test procedure	
Test 2	Block a version
Required operations	<ul style="list-style-type: none"> • Select menu "Recipe" > select submenu "Recipe management" • Select the new recipe (e.g. Validation A 500 mg) • Press "Versions" • Create a new draft version of the draft version • Select the new draft version • Press "Disable" (note time of action) • Press filter "Disable" • Leave menu „Recipe versions product“ • Leave menu “Recipe list product” • Select menu “System configuration” > select submenu “Diagnostic” • Select “Audittrail viewer” • Select “Filter settings” • Activate checkmarks for “Function” • Select “Function setting” • Select “Size management” and change to selected • Select “Size management” and press “Events” • Select “Recipe disabled” and change to selected • Confirm tree times with “Checkmark” and press button “Display” • Check the entry in the audit trail • Print out audit trail after completion of the tests
Consequence	<ul style="list-style-type: none"> • Versions can be blocked • When the corresponding filters are selected, all existing versions are open for viewing • Entry to audit trail is correct
Comments	<ul style="list-style-type: none"> • If necessary create a “New draft version” to perform the test
Acknowledgement	<ul style="list-style-type: none"> • None

Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Versions can be deleted or disabled <input type="checkbox"/> • When the corresponding filters are selected, all existing versions are open for viewing <input type="checkbox"/> • Entry to audit trail is correct <input type="checkbox"/>
Comments	<input type="text"/>

Results comply	yes/no <input type="checkbox"/>	Date/Initials <input type="text"/>
Results approved	Date/Initials <input type="text"/>	

6.3 Enable version / batches for production

Test objective	<ul style="list-style-type: none"> Inactive, disabled and old batch numbers can not be enabled for production
Test procedure	
Test 1	Use a disabled version for production
Test prerequisites	<ul style="list-style-type: none"> Machine is operational User “validation” is logged in
Required operations	<ul style="list-style-type: none"> Select menu “Recipe” > select submenu “Recipe management” Select the recipe (e.g. Validation A 500mg) and press “Versions” Create a “New draft version” Select the created “Draft version” and press “Disable” Press filter “Disabled” Select the disabled version Try to press “Activate” and “Enable”
Comments	<ul style="list-style-type: none"> Disabled recipe versions can not be enabled for production
Test 2	Use an older batch number for production
Required operations	<ul style="list-style-type: none"> Select menu “Recipe” > select submenu “Recipe management” Select recipe and press “Versions” Create two new draft versions Select one of the new created draft versions Press “Enable” and “Activate” Select menu “Production” > select submenu “Production” Create a new batch with the batch number: 02FU03 12345_1 Start the batch and press “Complete” to complete it after some seconds Change to “Recipe Management” and press “Versions” and “Activate” for the second provided “Draft version” (now enabled) Enable the “Draft-Version” Change to “Production” again Create a new batch with the batch number: 02FU03 12345_1 Start the batch Warning message “Batch ID already used” appears

Test result		yes/no
Acceptance criteria	• Disabled recipe versions can not be enabled for production	<input type="button" value=""/>
	• Older batch numbers can not be enabled for production	<input type="button" value=""/>
Comments	<input type="text"/>	

Results comply	yes/no <input type="button" value=""/>	Date/Initials <input type="button" value=""/>
Results approved	Date/Initials <input type="button" value=""/>	

6.4 Create new recipe

Test objective	<ul style="list-style-type: none"> • Create new recipe
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is operational • User "validation" is logged in
Required operations	<ul style="list-style-type: none"> • Select menu "Recipe" > select submenu "Select recipe management" • Select one recipe and press "Versions" • Select the current version and press "Create new recipe"
Consequence	<ul style="list-style-type: none"> • Recipe version number "x" = <input type="text"/> is created • A new recipe can be created on the basis of an existing recipe version
Required operations	<ul style="list-style-type: none"> • Press "Change Recipe name", change the name of recipe version "x" (e.g. "Validation A 500 mg") • Call up the new generated recipe in the window "recipe version" (e.g. "Validation A 500 mg") • Select a version and press "New draft version"
Consequence	<ul style="list-style-type: none"> • A new version draft with count up number "y" = <input type="text"/> is created • A new draft version can be created on the basis of a current recipe version
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • A new recipe can be created on the basis of an existing recipe version <input type="text"/> • A new draft version can be created on the basis of a current recipe version <input type="text"/>
Comments	<input type="text"/>

Results comply	yes/no <input type="text"/>	Date/Initials <input type="text"/>
Results approved	Date/Initials <input type="text"/>	

6.5 Activate recipe

Test objective	<ul style="list-style-type: none"> Check that only recipe versions with status “Draft” or “Released” can be activated
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> User “Validation” is logged in Machine is ready in automatic mode Recipe “TEST AFT” is created “Recipe Version” is created as disabled “Recipe Version” is created as deleted “Recipe Version” is created as enabled version “Recipe Version” is created as draft version
Required operations	<ul style="list-style-type: none"> Select menu “recipe management” > select “recipe management” > SWS “recipe management” An overview of all recipes is displayed In overview window of recipes select recipe “TEST AFT” and press SWS “Versions” All filters are switched on Select a recipe version with status “Disabled” SWS “Activate” is not active
Consequence	<ul style="list-style-type: none"> Selected recipe version cannot be activated
Required operations	<ul style="list-style-type: none"> Select a recipe version with status “Deleted” SWS “Activate” is not active
Consequence	<ul style="list-style-type: none"> Selected recipe version cannot be activated
Required operations	<ul style="list-style-type: none"> Select a recipe version with status “Enabled” Press SWS “Activate”
Consequence	<ul style="list-style-type: none"> Activated version is highlighted in green All settings for this recipe are taken over by program
Required operations	<ul style="list-style-type: none"> Select a recipe version with status “Draft” Press SWS “Activate”
Consequence	<ul style="list-style-type: none"> Activated version is highlighted in green All settings for this recipe are taken over by program
Required operations	<ul style="list-style-type: none"> Press SWS “Print” and attach printout to the test *)
Comments	<ul style="list-style-type: none"> *) If no printer is available create pdf-file and print on an external printer
Acknowledgement	<ul style="list-style-type: none"> None

Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none">Only recipe versions with status “Draft” or “Enabled” can be activated
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

6.6 Block recipe version

Test objective	<ul style="list-style-type: none"> Check whether recipe version can be block
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> User Validation is logged in Machine is ready in automatic mode Recipe version is created as released Recipe version to be blocked is not active
Required operations	<ul style="list-style-type: none"> Select menu “recipe management” > select “recipe management” > SWS “recipe management” An overview of all recipes is displayed In window “Recipe Management” select recipe “TEST AFT” and press SWS “Versions” All filters are switched on Select a recipe version with status “Enabled” Press SWS “Disabled”
Consequence	<ul style="list-style-type: none"> Status of selected recipe version changes from “Enabled” to “Disabled” and cannot be released or activated
Comments	<ul style="list-style-type: none"> None
Acknowledgement	<ul style="list-style-type: none"> None

Test result		yes/no
Acceptance criteria	<ul style="list-style-type: none"> Status of selected recipe version changes from “Enabled” to “Disabled” and cannot be released or activated 	<input type="button" value=" "/>
Comments	<input type="text"/>	

Results comply	yes/no	Date/Initials
	<input type="button" value=" "/>	<input type="button" value=" "/>
Results approved	Date/Initials	
	<input type="button" value=" "/>	

6.7 Delete recipe version

Test objective	<ul style="list-style-type: none"> Check whether recipe version can be deleted
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> User Validation is logged in Machine is ready in automatic mode Recipe version is created als "Draft" Recipe version to be deleted is not active
Required operations	<ul style="list-style-type: none"> Select menu "recipe management" > select "recipe management" > SWS "recipe management" An overview of all recipes is displayed In overview window of recipes select recipe "TEST AFT" and press SWS "Versions" All filters are switched on Select a recipe version with status "Disabled" Press SWS "Delete" and confirm indicated message
Consequence	<ul style="list-style-type: none"> Status of selected recipe version changes to "Deleted" and can not be enabled or activated
Comments	<ul style="list-style-type: none"> None
Acknowledgement	<ul style="list-style-type: none"> None

Test result		yes/no
Acceptance criteria	<ul style="list-style-type: none"> Status of selected recipe version changes to "Deleted" 	<input type="text"/>
Acceptance criteria	<ul style="list-style-type: none"> Deleted recipe versions can no longer be released or activated 	<input type="text"/>
Comments	<input type="text"/>	

Results comply	yes/no	Date/Initials
	<input type="text"/>	<input type="text"/>
Results approved	Date/Initials	
	<input type="text"/>	

7 Batch Management

7.1 Create new batch

Test objective	<ul style="list-style-type: none"> Check whether new batch can be created
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> Recipe is enabled and active
Required operations	<ul style="list-style-type: none"> Select menu “production” > select submenu “production” Enter in window “Batch” number “123” and confirm <ul style="list-style-type: none"> New batch is created Press SWS “Start” to start new created batch and confirm indicated message Try to insert name and number for a new batch in window “Batch”
Consequence	<ul style="list-style-type: none"> Creation of new batch is not possible (Number and name are deactivated fields while the previous batch is activated)
Required operations	<ul style="list-style-type: none"> Press SWS “Complete” to complete the active batch and confirm indicated message Press SWS “X” to close window “Print batch data” and confirm indicated message Enter in window “Batch” number “1234” and confirm <ul style="list-style-type: none"> New batch is created
Consequence	<ul style="list-style-type: none"> A new batch can only be created if previous batch has been completed
Comments	<ul style="list-style-type: none"> None
Acknowledgement	<ul style="list-style-type: none"> None
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> A new batch can only be created if previous batch has been completed
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

7.2 Start batch

Test objective	<ul style="list-style-type: none"> Check whether batch can be started
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> A new batch has been created but not yet started
Required operations	<ul style="list-style-type: none"> Press SWS “Start” and confirm indicated message
Consequence	<ul style="list-style-type: none"> Status of created and started batches changes from “Completed” to “Started” Batch information is displayed in submenu “Production”, SWS “Show batch data” in window “Batch”
Comments	<ul style="list-style-type: none"> It is not possible to create or start a new batch
Acknowledgement	<ul style="list-style-type: none"> None
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> Only the new created batch can be started
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

7.3 Interrupt and resume batch

Test objective	<ul style="list-style-type: none"> Check whether batch can be interrupted and resumed again
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> A batch has been started
Required operations	<ul style="list-style-type: none"> Select menu “production” > select submenu “production” In window “Batch” press SWS “Interrupt” and confirm indicated message Press SWS “X” to close window “Print batch data”
Consequence	<ul style="list-style-type: none"> In overview Batch management status of active batch changes from “Started” to “Interrupted”
Required operations	<ul style="list-style-type: none"> Select menu “production” > select submenu “production” In window “Batch” press SWS “Resume” and confirm indicated message
Consequence	<ul style="list-style-type: none"> In overview Batch management status of active batch changes from “Interrupted” to “Resumed”
Comments	<ul style="list-style-type: none"> None
Acknowledgement	<ul style="list-style-type: none"> None

Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> Batch can be interrupted and resumed
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

7.4 Complete batch

Test objective	<ul style="list-style-type: none"> Check whether batch can be completed
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> A batch has been started or interrupted
Required operations	<ul style="list-style-type: none"> Select menu “production” > select submenu “production” In window “Batch” press SWS “Complete” and confirm indicated message Press SWS “X” to close window “Print batch data” and confirm indicated message
Consequence	<ul style="list-style-type: none"> In overview Batch management status of active batch changes to “Completed”
Required operations	<ul style="list-style-type: none"> Try to resume batch
Consequence	<ul style="list-style-type: none"> After batch is completed it cannot be resumed again
Comments	<ul style="list-style-type: none"> None
Acknowledgement	<ul style="list-style-type: none"> None
Test result	
Acceptance criteria	<ul style="list-style-type: none"> After batch is completed, batch data can be saved or printed and batch cannot be resumed again
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

7.5 Batch history

Test objective	<ul style="list-style-type: none"> Check whether batch history can be displayed
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> Batch is completed
Required operations	<ul style="list-style-type: none"> Select menu "Batch history" > select SWS "Batch management" Select a batch with status "Completed" and press SWS "Show" <ul style="list-style-type: none"> Window "Batch view" opens and batch information such as "Batch-ID.", "Batch name", "Batch size" and "Batch part size" as well as active recipe version are displayed Press SWS "History"
Consequence	<ul style="list-style-type: none"> "Batch history" displays when and by whom the status of the batch has been changed
Comments	<ul style="list-style-type: none"> None
Acknowledgement	<ul style="list-style-type: none"> None

Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> "Batch history" displays when and by whom status of batch has been changed
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

7.6 Store batch data

Test objective	<ul style="list-style-type: none"> Check whether batch data can be stored
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> A batch with status “Completed” is created
Required operations	<ul style="list-style-type: none"> Select menu “Batch History” > select SWS “Batch management” Select a batch with status “Completed” Batch-ID.: <input type="text"/> Press SWS “Store” Select a folder and press SWS “✓” <ul style="list-style-type: none"> “Message (“Store”)” “Do you want to delete the sources after batch storage is complete?” is displayed Press SWS “No” Confirm indicated message (“Store”) Close window In “Batch History” press SWS “Batch management” Choose the batch and press SWS “Show” Press SWS “History” Note time when .zip-file has been stored <input type="text"/>
Consequence	<ul style="list-style-type: none"> Batch is still listed in overview “Batch management” Status has changed from “Completed” to “Stored” Batch is stored in selected folder with file name: batch number + _Date + _Time?? + “.zip” Example: batch no.: 12345 file name: 12345_20140128_122935.zip

Test procedure	
Required operations	<ul style="list-style-type: none"> Select menu "Batch management" > select submenu "Batch history" > select SWS "Batch management" Select a batch with status "Completed" Batch-ID.: <input type="text"/> Press SWS "Store" Select a folder and press SWS "✓" <ul style="list-style-type: none"> Message ("Store") "The storage result is good. Do you want to delete the sources?" is displayed Press SWS "Yes" Confirm indicated message ("Store") Close window Press SWS "Batch management"
Consequence	<ul style="list-style-type: none"> Batch is no longer listed in overview
Comments	<ul style="list-style-type: none"> None
Acknowledgement	<ul style="list-style-type: none"> None

Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> Batches are stored as .zip-file in selected folder with correct name (+ date and time) <input type="text"/>
Comments	<input type="text"/>

Results comply	yes/no	Date/Initials
	<input type="text"/>	<input type="text"/>
Results approved	Date/Initials	
	<input type="text"/>	

7.7 Restore batch data

Test objective	<ul style="list-style-type: none"> Check whether stored batch data can be restored
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> A batch with status “Stored” is created
Required operations	<ul style="list-style-type: none"> Select menu “Batch management” > select submenu “Batch history” > select SWS “Batch management” Press SWS “Restore” Select a stored file Batch-ID.: <input type="text"/> Select a folder and press SWS “✓” <ul style="list-style-type: none"> Message (“Store”) “The target already exists. Do you really want to overwrite?” is displayed Press SWS “Yes” Select restored file in window “Batch management” and press SWS “Show” Press SWS “History”
Consequence	<ul style="list-style-type: none"> .zip-file is not deleted Batch is listed in overview with status “Restored” Existing data is replaced in overview
Required operations	<ul style="list-style-type: none"> Select menu “Batch management” > select submenu “Batch history” > select SWS “Batch management” Press SWS “Restore” Select same file as before and press SWS “✓” <ul style="list-style-type: none"> Message (“Store”) “The target already exists. Do you really want to overwrite?” is displayed Press SWS “No”
Consequence	<ul style="list-style-type: none"> Action is interrupted
Comments	<ul style="list-style-type: none"> None
Acknowledgement	<ul style="list-style-type: none"> None

Test result		yes/no
Acceptance criteria	<ul style="list-style-type: none">Batch is restored from .zip-file and listed in "Batch management" <input type="text"/>	
Comments	<input type="text"/>	

Results comply	yes/no <input type="text"/>	Date/Initials <input type="text"/>
Results approved	Date/Initials <input type="text"/>	

7.8 Delete batch data

Test objective	<ul style="list-style-type: none"> Check whether only stored batch data can be deleted
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> Batch with status “Stored”, “Restored” and “Completed” are created
Required operations	<ul style="list-style-type: none"> Select menu “Batch management” > select “Batch history” > Select SWS “Batch management” Select batch with status “Stored” Press SWS “Delete” <ul style="list-style-type: none"> Message (“Store”) “Do you really want to delete 1 batches?” is displayed Press SWS “Yes”
Consequence	<ul style="list-style-type: none"> Batch is no longer listed in overview
Required operations	<ul style="list-style-type: none"> Select batch with status “Restored” Press SWS “Delete” <ul style="list-style-type: none"> Message (“Store”) “Do you really want to delete 1 batches?” is displayed Press SWS “Yes”
Consequence	<ul style="list-style-type: none"> Batch is no longer listed in overview
Required operations	<ul style="list-style-type: none"> Select batch with status “Completed”
Consequence	<ul style="list-style-type: none"> SWS “Delete” is not active Batch cannot be deleted
Comments	<ul style="list-style-type: none"> None
Acknowledgement	<ul style="list-style-type: none"> None

Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Batches with status “Restored“ can be deleted from “Batch management“ <input type="button" value=" "/> • Batches with status “Stored“ can be deleted from “Batch management“ <input type="button" value=" "/> • Batches with status “Completed“ can not be deleted from “Batch management“ <input type="button" value=" "/>
Comments	<input type="button" value=" "/>

Results comply	yes/no <input type="button" value=" "/>	Date/Initials <input type="button" value=" "/>
Results approved	Date/Initials <input type="button" value=" "/>	

7.9 Print history of batch data

Test objective	<ul style="list-style-type: none"> Check whether history of batch data can be printed
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> Batch with status “Completed” is created
Required operations	<ul style="list-style-type: none"> Select menu “Batch management” > select submenu “Batch history” > select SWS “Batch management” Select batch with status “Completed” Press SWS “History” <ul style="list-style-type: none"> Message (“History”) “The <i>selected batch</i> was chosen for the history.” is displayed Press SWS “Ok” Select menu “Batch history” Recipe data and results can be viewed for the selected batch Press SWS “Print batch”
Consequence	<ul style="list-style-type: none"> Selected batch data can be printed as hard copy on connected printer or as pdf-file to be saved on a selected drive
Comments	<ul style="list-style-type: none"> None
Acknowledgement	<ul style="list-style-type: none"> None
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> Recipe data and results can be viewed and printed
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

7.10 Print batch data

Test objective	<ul style="list-style-type: none"> Print batch data
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> Machine is ready in automatic mode User "validation" is logged in
Required operations	<ul style="list-style-type: none"> Select menu "Batch management" > select submenu "Batch History" > select SWS "Batch management" Select batch with status "Completed" Press SWS "History" <ul style="list-style-type: none"> Message ("History") "The selected batch was chosen for the history" is displayed Press SWS "Ok" Change to submenu "History" Result and Recipe data can be viewed for the selected batch Press SWS "Print batch" Select pdf for "Result" and "Recipe data" Select printer for "Result" and "Recipe data" In "Configuration" select target File path for storage and printer Press SWS "✓"
Consequence	<ul style="list-style-type: none"> Result and recipe data are exported to selected folder as .pdf-file with file name "batch number + _Result.pdf" resp. "batch number + _RecipeData.pdf" (*) Recipe data are printed on connected printer
Required operations	<ul style="list-style-type: none"> Select menu "Production" > select submenu "Production" Create a new batch Start the new batch and confirm indicated message Complete the new batch <ul style="list-style-type: none"> Message "Do you really want to complete the batch?" is displayed Press SWS "OK" <ul style="list-style-type: none"> Message "Print batch data" is displayed Select pdf for "Alarms" and "Parameter change" Select printer for "Parameter change" In "Configuration" select target File path for storage and printer Press SWS "✓"
Consequence	<ul style="list-style-type: none"> Batch alarm list and parameter change are exported to selected folder as .pdf-files with file names "batch number + _Alarm.pdf" and "batch number + _Parameter.pdf" (*) Batch parameter change is printed on connected printer.

Test procedure		
Comments	<ul style="list-style-type: none"> • *) Date and time can be added in file name if needed 	
Acknowledgement	<ul style="list-style-type: none"> • None 	
Test result		yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Batch data can be printed when active batch is completed or after a batch has been selected for history • Batch data can be printed on connected printer • Batch data can be exported to a selected folder as .pdf-file 	
Comments	<div style="border: 1px solid black; height: 100px; width: 100%;"></div>	

Results comply	yes/no	Date/Initials
	<input type="button" value=""/>	<input type="button" value=""/>
Results approved	Date/Initials	
	<input type="button" value=""/>	

8 Reports and print outs

8.1 Recipe print out

Test objective	<ul style="list-style-type: none"> Check whether recipes can be printed
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> Machine is ready in automatic mode User is logged in *)
Required operations	<ul style="list-style-type: none"> Call up "Recipe" -> "Recipe Management" -> select a recipe and press "Print recipe data" You can choose between "print" or "Export" as PDF-File Choose "Export" as PDF-File on a USB-flash drive
Comments	<ul style="list-style-type: none"> Attach the printout to this test (can be done at the end of testing). *) Test can be done with every user group
Acknowledgement	<ul style="list-style-type: none"> None
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> It is possible to print or save the recipe data
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

8.2 User right print out

Test objective	<ul style="list-style-type: none"> Check whether list of user rights can be printed
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> Machine is ready in automatic mode User Admin is logged in
Required operations	<ul style="list-style-type: none"> Call up “Settings” -> page tab “User management” -> select “Group Management” Choose the user group “Admin customer” (or “Administrator”) and press “Configure” -> select “all rights” Press “Print”, and save as a PDF-File, and print it later.
Comments	<ul style="list-style-type: none"> Attach the printout to this test (can be done at the end of testing).
Acknowledgement	<ul style="list-style-type: none"> None
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> It is possible to print or save the user rights
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

9 Basic function

9.1 Boot IPC

Test objective	<ul style="list-style-type: none"> Check whether IPC can be booted
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> Machine is operational User Admin is logged in
Required operations	<ul style="list-style-type: none"> Call up "System configuration" -> "Service", press "Shut down" the HMI shuts down Shut down the IPC via the Windows Startmenu Switch off the machine via the main switch Insert the Recovery USB-flash drive in a free USB slot at the IPC in the control cabinet <ul style="list-style-type: none"> Only by authorized personell! Wait for 5 minutes Switch on the machine via the main switch The machine starts from the main drive from the IPC
Comments	<ul style="list-style-type: none"> If no Recovery USB-flash drive is available, the test shall be done after the installation of the machine at the customer's site.
Acknowledgement	<ul style="list-style-type: none"> None
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> IPC boots from the main drive of the system, and does not boot from the USB-flash drive
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

9.2 Service: Clean Display

Test objective	<ul style="list-style-type: none"> Check of the “Clean Display” function
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> Machine is ready in automatic mode User Admin is logged in
Required operations	<ul style="list-style-type: none"> Call up “Settings” -> “Service” and press “Clean Display” If you press the button, a dialog window appears, where you can choose “Ok” or “Cancel” With “Ok” the display turns grey and no touch inputs can be done, and the time of 30 seconds runs down and is shown on the display After 30 seconds the HMI appears again
Comments	<ul style="list-style-type: none"> None
Acknowledgement	<ul style="list-style-type: none"> None
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> Display turns grey and no touch input can be done
	<input type="checkbox"/>
	<input type="checkbox"/>
Comments	

Results comply	yes/no	Date/Initials
	<input type="checkbox"/>	<input type="checkbox"/>
Results approved	Date/Initials	
	<input type="checkbox"/>	

9.3 Service: Change system time

Test objective	<ul style="list-style-type: none"> Check whether system time can be changed
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> Machine is ready in automatic mode User Admin is logged in
Required operations	<ul style="list-style-type: none"> Call up “Settings” -> “Service” and press “Change system time” A new window appears to set the new system time
Comments	<ul style="list-style-type: none"> None
Acknowledgement	<ul style="list-style-type: none"> None
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> Change of the system time is possible
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

9.4 Alarmlists

Test objective	<ul style="list-style-type: none"> Availability of Alarmlists
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> Call up "Settings" -> "Documentation" and press "Alarm list" Lists of Faults, Warnings or Messages can be selected The complete lists of Faults, Warnings and Messages can be printed or saved as pdf
Comments	<ul style="list-style-type: none"> None
Acknowledgement	<ul style="list-style-type: none"> None
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> Lists of the Faults, Warnings and Messages can be selected Lists of Faults, Warnings and Messages can be printed or saved as pdf
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

9.5 Operating hours counter

Test objective	<ul style="list-style-type: none"> Display of Operating hours counter
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> Go to “System configuration” -> “Information” submenu “Machine” to see “Operating hours” On the display the operating hours counter is shown
Comments	<ul style="list-style-type: none"> None
Acknowledgement	<ul style="list-style-type: none"> None
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> Operating hours counter is shown <input type="button" value=" "/>
Comments	<div style="border: 1px solid black; height: 150px; width: 100%;"></div>

Results comply	yes/no	Date/Initials
	<input type="button" value=" "/>	<input type="button" value=" "/>
Results approved	Date/Initials	
	<input type="button" value=" "/>	

9.6 Parameter limits

Test objective	<ul style="list-style-type: none"> • Test of limitation of Parameter limits
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode • User Admin is logged in
Required operations	<ul style="list-style-type: none"> • Call up “Recipe Management” -> “Recipe Data” • Select Parameter [1] in “Speeds” : [1] Automatic • Click on value • Try to enter a value greater than the maximum limit of the machine speed • Try to enter a value smaller than the minimum limit of the machine speed • Enter a value within the limits
Comments	<ul style="list-style-type: none"> • Limit values are shown in window
Acknowledgement	<ul style="list-style-type: none"> • Enter original value

Test result		yes/no
Acceptance criteria	<ul style="list-style-type: none"> • A value greater than the maximum limit cannot be confirmed 	<input type="text"/>
	<ul style="list-style-type: none"> • A value smaller than the minimum limit cannot be confirmed 	<input type="text"/>
	<ul style="list-style-type: none"> • A value between the minimum and maximum limit can be confirmed 	<input type="text"/>
Comments		

Results comply	yes/no	Date/Initials
	<input type="text"/>	<input type="text"/>
Results approved	Date/Initials	
	<input type="text"/>	

9.7 HMI Language

Test objective	<ul style="list-style-type: none"> • Availability and change of HMI languages
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Call up "System configuration" -> "Language" and press "German" • After pressing the button "German", the complete HMI texts change into German • After pressing the button "English", the complete HMI texts change into English
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • None
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • The HMI language switches to the chosen language
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

9.8 Test protocols - Function tests software switches (SWS)

9.8.1 SWS 50: COVER RAIL

Test objective	<ul style="list-style-type: none"> Function test of software switch (SWS)
Test procedure	
TEST 1	
Test prerequisites	<ul style="list-style-type: none"> Machine is ready in automatic mode Guards/ guard doors are closed
Required operations	<ul style="list-style-type: none"> Activate SWS 50 “Cover rail” to open the cover rail
Consequence	<ul style="list-style-type: none"> Cover rail is lifted
Comments	<ul style="list-style-type: none"> Test is not possible with open guards/ guard doors Fault message is displayed on control panel
Acknowledgement	<ul style="list-style-type: none"> Press “Reset”
TEST 2	
Test prerequisites	<ul style="list-style-type: none"> Machine is ready in automatic mode Guards/ guard doors are closed Cover rail is lifted
Required operations	<ul style="list-style-type: none"> Deactivate SWS 50 “Cover rail” to close the cover rail
Consequence	<ul style="list-style-type: none"> Cover rail is lowered
Comments	<ul style="list-style-type: none"> Test is not possible with open guards/ guard doors Fault message is displayed on control panel
Acknowledgement	<ul style="list-style-type: none"> Press “Reset”

Test result		yes/no
Acceptance criteria	• Test 1: Cover rail is lifted	<input type="checkbox"/>
	• Test 2: Cover rail is lowered	<input type="checkbox"/>
Comments	<input type="text"/>	

Results comply	yes/no <input type="checkbox"/>	Date/Initials <input type="text"/>
Results approved	Date/Initials <input type="text"/>	

9.8.2 SWS 53: PERMANENT READING CODE

Test objective	<ul style="list-style-type: none"> Function test of software switch (SWS)
Test procedure	<p style="text-align: center;">TEST 1</p>
Test prerequisites	<ul style="list-style-type: none"> Machine is ready in setup mode
Required operations	<ul style="list-style-type: none"> Activate SWS 53 "Permanent reading code" Activate button "Laetus" and log in Within the Laetus menu select the active format Open "Production" Select "code reader, camera carton" In "wt-device" setup select "diagnose" Place carton / leaflet in front of reading head of carton / leaflet reader
Consequence	<ul style="list-style-type: none"> Code is displayed on control panel within the „Laetus-menu“ (blue frame) Code reading is active at standstill
	TEST 2
Test prerequisites	<ul style="list-style-type: none"> Code reading is active at standstill
Required operations	<ul style="list-style-type: none"> Deactivate SWS 53 "Permanent reading code"
Consequence	<ul style="list-style-type: none"> Code is not displayed on control panel within the „Laetus-menu“ (blue frame) Code reading is not active at standstill
Comments	<ul style="list-style-type: none"> During continuous code reading a lamp at the code reader carton is blinking
Acknowledgement	<ul style="list-style-type: none"> Deactivate SWS 53 "Permanent reading code"

Test result	yes/no	
Acceptance criteria	<ul style="list-style-type: none"> • Test 1: Code is displayed on control panel within the „Laetus-menu“ (blue frame) • Test 1: Code reading is active at standstill • Test 2: Code is not displayed on control panel within the „Laetus-menu“ (blue frame) • Test 2: Code reading is not active at standstill 	<input type="button" value=" "/> <input type="button" value=" "/> <input type="button" value=" "/> <input type="button" value=" "/>
Comments		

Results comply	yes/no	Date/Initials
	<input type="button" value=" "/>	<input type="button" value=" "/>
Results approved	Date/Initials	
	<input type="button" value=" "/>	

9.8.3 SWS 54: VACUUM

Test objective	<ul style="list-style-type: none">Function test of software switch (SWS)
Test procedure	
	TEST 1
Test prerequisites	<ul style="list-style-type: none">Machine is ready in setup mode
Required operations	<ul style="list-style-type: none">Activate SWS 208 "Continuous call carton"Activate SWS 54 "Vacuum"
Consequence	<ul style="list-style-type: none">Vacuum pump is running
Comments	<ul style="list-style-type: none">None
Acknowledgement	<ul style="list-style-type: none">None
TEST 2	
Test prerequisites	<ul style="list-style-type: none">Machine is ready in setup modeVacuum pump is running
Required operations	<ul style="list-style-type: none">Deactivate SWS 54 "Vacuum"
Consequence	<ul style="list-style-type: none">Vacuum pump is not running
Comments	<ul style="list-style-type: none">None
Acknowledgement	<ul style="list-style-type: none">None

Test result		yes/no
Acceptance criteria	<ul style="list-style-type: none">• Test 1: If SWS 54 "Vacuum" is activated, the vacuum pump is running• Test 2: If SWS 54 "Vacuum" is deactivated, the vacuum pump is not running	<input type="button" value=" "/>
Comments	<input type="text"/>	

Results comply	yes/no	Date/Initials <input type="text"/>
Results approved	Date/Initials <input type="text"/>	

9.8.4 SWS 56: MACHINE INSIDE LIGHT OFF

Test objective	<ul style="list-style-type: none"> Function test of software switch (SWS)
Test procedure	
	TEST 1
Test prerequisites	<ul style="list-style-type: none"> Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> Activate SWS 56 "Machine inside light off"
Consequence	<ul style="list-style-type: none"> Lamps in production room don't shine
Comments	<ul style="list-style-type: none"> None
Acknowledgement	<ul style="list-style-type: none"> None
	TEST 2
Test prerequisites	<ul style="list-style-type: none"> Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> Deactivate SWS 56 "Machine inside light off"
Consequence	<ul style="list-style-type: none"> Lamps in production room shine
Comments	<ul style="list-style-type: none"> None
Acknowledgement	<ul style="list-style-type: none"> None
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> Test 1: SWS 56 "Machine inside light off" is activated: Lamps in production room don't shine <input type="checkbox"/> Test 2: SWS 56 "Machine inside light off" is deactivated: Lamps in production room shine <input type="checkbox"/>
Comments	<input type="text"/>

Results comply	yes/no	Date/Initials
	<input type="checkbox"/>	<input type="text"/>
Results approved	Date/Initials	
	<input type="text"/>	

9.8.5 SWS 100: INSERT DEFECTIVE PRODUCT

Test objective	<ul style="list-style-type: none"> Function test of software switch (SWS)
Test procedure	
	TEST 1
Test prerequisites	<ul style="list-style-type: none"> Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> Activate SWS 100 "Insert defective product" Insert leaflet with faulty code in stack Insert some product in the infeed Press "Start" Call some products
Consequence	<ul style="list-style-type: none"> Carton with faulty leaflet is loaded but ejected on discharge belt
Comments	<ul style="list-style-type: none"> None
Acknowledgement	<ul style="list-style-type: none"> Press "Stop" Press "Reset"
	TEST 2
Test prerequisites	<ul style="list-style-type: none"> Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> Deactivate SWS 100 "Insert defective product" Insert leaflet with faulty code in stack Insert some product in the infeed Press "Start" Call some products
Consequence	<ul style="list-style-type: none"> Leaflet is ejected No carton call Product is ejected at insertion
Comments	<ul style="list-style-type: none"> None
Acknowledgement	<ul style="list-style-type: none"> Press "Stop" Press "Reset"

Test result		yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Test 1: SWS 100 is activated: In case of defective product or defective leaflet, carton will be loaded but rejected on discharge belt • Test 2: SWS 100 is deactivated: In case of defective product or defective leaflet, product will be rejected without loading 	<input type="checkbox"/> <input type="checkbox"/>
Comments		

Results comply	yes/no	Date/Initials
	<input type="checkbox"/>	<input type="text"/>
Results approved	Date/Initials	
	<input type="text"/>	

9.8.6 SWS 106: CONTINUOUS INSERTION

Test objective	<ul style="list-style-type: none"> Function test of software switch (SWS)
Test procedure	
	TEST 1
Test prerequisites	<ul style="list-style-type: none"> Machine is ready in setup mode
Required operations	<ul style="list-style-type: none"> Activate SWS 106 “Continuous insertion“ Press “Start”
Consequence	<ul style="list-style-type: none"> Insertion pushers are activated
Acknowledgement	<ul style="list-style-type: none"> Press “Stop” Press “Reset”
	TEST 2
Test prerequisites	<ul style="list-style-type: none"> Machine is ready in setup mode
Required operations	<ul style="list-style-type: none"> Deactivate SWS 106 “Continuous insertion“ Press “Start”
Consequence	<ul style="list-style-type: none"> Insertion pushers are deactivated
Comments	<ul style="list-style-type: none"> None
Acknowledgement	<ul style="list-style-type: none"> Press “Stop” Press “Reset”

Test result		yes/no
Acceptance criteria	• Test 1: Insertion pushers are activated	<input type="button" value=""/>
	• Test 2: Insertion pushers are deactivated	<input type="button" value=""/>
Comments	<input type="text"/>	

Results comply	yes/no <input type="button" value=""/>	Date/Initials <input type="button" value=""/>
Results approved	Date/Initials <input type="button" value=""/>	

9.8.7 SWS 107: RELEASE PUSHER GUIDE RAIL

Test objective	<ul style="list-style-type: none"> Function test of software switch (SWS)
Test procedure	
	TEST 1
Test prerequisites	<ul style="list-style-type: none"> Machine is ready in setup mode
Required operations	<ul style="list-style-type: none"> Activate SWS 106 "Continuous insertion" Press "Start" Press "Stop" when the guide rail pushers are within the pocket chain Activate SWS 107 "Release pusher guide rail"
Consequence	<ul style="list-style-type: none"> Insertion pushers are enabled Fault message is displayed on control panel (FLT 123 - Insertion: Overload)
Comments	<ul style="list-style-type: none"> None
Acknowledgement	<ul style="list-style-type: none"> Press "Reset"
	TEST 2
Test prerequisites	<ul style="list-style-type: none"> Machine is ready in setup mode
Test prerequisites	<ul style="list-style-type: none"> Insertion pushers are enabled
Required operations	<ul style="list-style-type: none"> Deactivate SWS 107 "Release pusher guide rail"
Consequence	<ul style="list-style-type: none"> Insertion pushers are disabled
Acknowledgement	<ul style="list-style-type: none"> None

Test result		yes/no
Acceptance criteria	• Test 1: Insertion pushers are enabled	<input type="button" value=""/>
	• Test 2: Insertion pushers are disabled	<input type="button" value=""/>
Comments	<input type="text"/>	

Results comply	yes/no <input type="button" value=""/>	Date/Initials <input type="button" value=""/>
Results approved	Date/Initials <input type="button" value=""/>	

9.8.8 SWS 200: CODE READER CARTON

Test objective	<ul style="list-style-type: none"> Function test of software switch (SWS)
Test procedure	TEST 1
Test prerequisites	<ul style="list-style-type: none"> Machine is ready in automatic mode Prepare two (2) cartons with wrong / manipulated carton code Product is available
Required operations	<ul style="list-style-type: none"> Insert cartons with wrong / manipulated code into magazine Activate SWS 200 "Code reader carton" Press "Start"
Consequence	<ul style="list-style-type: none"> Wrong or non-coded cartons are ejected
	TEST 2
Required operations	<ul style="list-style-type: none"> Insert cartons with wrong / manipulated code into magazine Deactivate SWS 200 "Code reader carton" Press "Start"
Consequence	<ul style="list-style-type: none"> Wrong or non-coded cartons are not recognized and ejected
Comments	<ul style="list-style-type: none"> None
Acknowledgement	<ul style="list-style-type: none"> Activate SWS 200 "Code reader carton" Press "Stop" Press "Reset"
Acknowledgement	<ul style="list-style-type: none"> Press "Stop" Press "Reset"

Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Test 1: SWS200 is activated: wrong or non-coded cartons are ejected • Test 2: SWS200 is deactivated: wrong or non-coded cartons are not recognized and ejected
Comments	<div style="border: 1px solid black; height: 100px; width: 100%;"></div>

Results comply	yes/no <input type="checkbox"/>	Date/Initials <input type="text"/>
Results approved	Date/Initials <input type="text"/>	

9.8.9 SWS 203: AIR BLAST CARTON

Test objective	<ul style="list-style-type: none"> Function test of software switch (SWS)
Test procedure	
	TEST 1
Test prerequisites	<ul style="list-style-type: none"> Machine is ready in automatic mode Folded cartons are available
Required operations	<ul style="list-style-type: none"> Activate SWS 203 "Air blast carton" Press "Start"
Consequence	<ul style="list-style-type: none"> Folding of the side flap is supported by blowing air
Comments	<ul style="list-style-type: none"> None
Acknowledgement	<ul style="list-style-type: none"> Press "Stop" Press "Reset"
	TEST 2
Test prerequisites	<ul style="list-style-type: none"> Machine is ready in automatic mode Folded cartons are available
Required operations	<ul style="list-style-type: none"> Deactivate SWS 203 "Air blast carton"
Consequence	<ul style="list-style-type: none"> Folding of the side flap is not supported by blowing air
Comments	<ul style="list-style-type: none"> None
Acknowledgement	<ul style="list-style-type: none"> Press "Stop" Press "Reset"

Test result		yes/no
Acceptance criteria	• Test 1: Folding of the side flap is supported by blowing air	<input type="button" value=""/>
	• Test 2: Folding of the side flap is not supported by blowing air	<input type="button" value=""/>
Comments	<input type="text"/>	

Results comply	yes/no <input type="button" value=""/>	Date/Initials <input type="button" value=""/>
Results approved	Date/Initials <input type="button" value=""/>	

9.8.10 SWS 204: GLUEING

Test objective	<ul style="list-style-type: none"> Function test of software switch (SWS)
Test procedure	
	TEST 1
Test prerequisites	<ul style="list-style-type: none"> Hotmelt unit is ready Hotmelt is available in supply tank Machine is ready in setup mode
Required operations	<ul style="list-style-type: none"> Activate SWS 204 "Glueing" Press "Start"
Consequence	<ul style="list-style-type: none"> Lower or upper flap are glued
Comments	<ul style="list-style-type: none"> None
Acknowledgement	<ul style="list-style-type: none"> Activate glueing for automatic mode
	TEST 2
Required operations	<ul style="list-style-type: none"> Deactivate SWS 204 "Glueing" Press "Start"
Consequence	<ul style="list-style-type: none"> No glueing is active
Comments	<ul style="list-style-type: none"> None
Acknowledgement	<ul style="list-style-type: none"> Activate glueing for automatic mode

Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none">• Test 1: If SWS 204 is activated, lower or upper flap are glued• Test 2: If SWS 204 is deactivated, no glueing is active
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

9.8.11 SWS 208: CONTINUOUS CALL CARTON

Test objective	<ul style="list-style-type: none"> Function test of software switch (SWS)
Test procedure	
	TEST 1
Test prerequisites	<ul style="list-style-type: none"> Machine is ready in setup mode Cartons are available
Required operations	<ul style="list-style-type: none"> Activate SWS 54 "Vacuum" (only with vacuum pump...) Activate SWS 208 "Continuous call carton" Press "Start"
Consequence	<ul style="list-style-type: none"> Folding cartons are drawn off and erected without product with each cycle
Comments	<ul style="list-style-type: none"> No packaged goods required for the function "Continuous call carton"
Acknowledgement	<ul style="list-style-type: none"> Press "Stop" Press "Reset"
	TEST 2
Test prerequisites	<ul style="list-style-type: none"> Machine is ready in setup mode Cartons are available
Required operations	<ul style="list-style-type: none"> Deactivate SWS 208 "Continuous call carton"
Consequence	<ul style="list-style-type: none"> Cartons are not drawn off and not erected without product with each cycle
Comments	<ul style="list-style-type: none"> No packaged goods required for the function "Continuous call carton"
Acknowledgement	<ul style="list-style-type: none"> Press "Stop" Press "Reset"

Test result		yes/no
Acceptance criteria	• Test 1: Folding cartons are drawn off and erected without product with each cycle	<input type="button" value=""/>
	• Test 2: Folding cartons are not drawn off and not erected without product with each cycle	<input type="button" value=""/>
Comments	<input type="text"/>	

Results comply	yes/no	Date/Initials <input type="text"/>
Results approved	Date/Initials <input type="text"/>	

9.8.12 SWS 257: CHECK CARTON OPEN SIDE FLAP

Test objective	<ul style="list-style-type: none"> Function test of software switch (SWS)
Test procedure	
	TEST 1
Test prerequisites	<ul style="list-style-type: none"> Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> Run the machine with product Deactivate SWS 257 "Check carton open side flap" Press "Stop" Manipulate one side flap of a carton that side flap is open (before sensors "=CAR1.B86-B03" and "CAR1.B86-B04") Press "Reset" Press "Start"
Consequence	<ul style="list-style-type: none"> Carton with open side flap is not rejected
Acknowledgement	<ul style="list-style-type: none"> None
	TEST 2
Test prerequisites	<ul style="list-style-type: none"> Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> Run the machine with product Activate SWS 257 "Check carton open side flap" Press "Stop" Manipulate one side flap of a carton that side flap is open (before sensors "=CAR1.B86-B03" and "CAR1.B86-B04") Press "Reset" Press "Start"
Consequence	<ul style="list-style-type: none"> Carton with open side flap is rejected Counter 257 "Carton: Fault open side flap" increases by one per manipulated carton
Acknowledgement	<ul style="list-style-type: none"> Press "Stop" Press "Reset"
Comments	<ul style="list-style-type: none"> None

Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Test 1: If SWS 257 is not active, carton with open side flap is not rejected <input type="checkbox"/> • Test 2: If SWS 257 is active, carton with open side flap is rejected <input type="checkbox"/> • Test 2: If SWS 257 is active, counter 257 "Carton: Fault open side flap" increases by one per manipulated carton <input type="checkbox"/>
Comments	<input type="text"/>

Results comply	yes/no <input type="checkbox"/>	Date/Initials <input type="text"/>
Results approved	Date/Initials <input type="text"/>	

9.8.13 SWS 300: LEAFLET DEVICE

Test objective	<ul style="list-style-type: none"> Function test of software switch (SWS)
Test procedure	
	TEST 1
Test prerequisites	<ul style="list-style-type: none"> Machine is ready in automatic mode with product
Required operations	<ul style="list-style-type: none"> Activate SWS 300 "Leaflet device" Press "Start"
Consequence	<ul style="list-style-type: none"> Leaflet device is active Leaflets are called
	TEST 2
Required operations	<ul style="list-style-type: none"> Deactivate SWS 300 "Leaflet device"
Consequence	<ul style="list-style-type: none"> Leaflet device is not active Leaflets are not called
Comments	<ul style="list-style-type: none"> None
Acknowledgement	<ul style="list-style-type: none"> Press "Stop" Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> Test 1: SWS 300 is activated: Leaflet device is active, leaflets are called <input type="button" value=" "/> Test 2: SWS 300 is deactivated: Leaflet device is not active, leaflets are not called <input type="button" value=" "/>
Comments	<input style="width: 100%; height: 100px; border: 1px solid black;" type="text"/>

Results comply	yes/no <input type="button" value=" "/>	Date/Initials <input type="button" value=" "/>
Results approved	Date/Initials <input type="button" value=" "/>	

9.8.14 SWS 302: CODE READER LEAFLET REAR

Test objective	<ul style="list-style-type: none"> Function test of software switch (SWS)
Test procedure	
TEST 1	
Test prerequisites	<ul style="list-style-type: none"> Machine is ready in automatic mode Prepare the leaflet with the manipulated code (e.g. use a black pen to draw an additional line in the code or combine two narrow lines to form a thick line).
Required operations	<ul style="list-style-type: none"> Activate SWS 300 "Leaflet device" Activate SWS 302 "Code reader leaflet rear" Insert leaflets with wrong or manipulated code (rear) Press "Start"
Consequence	<ul style="list-style-type: none"> All wrong or non-coded leaflets are ejected Counter "Code reader rear" increases by one per defective leaflet
Comments	<ul style="list-style-type: none"> Consecutive fault after repeated defective leaflets Leaflet ejection in leaflet unit
Acknowledgement	<ul style="list-style-type: none"> None
TEST 2	
Test prerequisites	<ul style="list-style-type: none"> Machine is ready in automatic mode Prepare the leaflet with the manipulated code (e.g. use a black pen to draw an additional line in the code or combine two narrow lines to form a thick line).
Required operations	<ul style="list-style-type: none"> Activate SWS 300 "Leaflet device" Deactivate SWS 302 "Code reader leaflet rear" Insert leaflets with wrong or manipulated code (rear) Press "Start"
Consequence	<ul style="list-style-type: none"> All wrong or non-coded leaflets are not ejected
Comments	<ul style="list-style-type: none"> Leaflet ejection in leaflet unit
Acknowledgement	<ul style="list-style-type: none"> None

Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Test 1: If SWS 302 "Code reader leaflet rear" is activated, all wrong or non-coded leaflets are not ejected <input type="checkbox"/> • Test 1: If SWS 302 "Code reader leaflet rear" is activated, counter "Code reader rear" increases by one per defective leaflet <input type="checkbox"/> • Test 2: If SWS 302 "Code reader leaflet rear" is deactivated, leaflets with wrong or missing code on rear side are not ejected <input type="checkbox"/>
Comments	<div style="border: 1px solid black; height: 100px; width: 100%;"></div>

Results comply	yes/no <input type="checkbox"/>	Date/Initials <input type="text"/>
Results approved	Date/Initials <input type="text"/>	

9.8.15 SWS 303: CHECK LEAFLET PRESENT

Test objective	<ul style="list-style-type: none"> Function test of software switch (SWS)
Test procedure	
	TEST 1
Test prerequisites	<ul style="list-style-type: none"> Machine is ready in automatic mode Run the machine with product
Required operations	<ul style="list-style-type: none"> Activate SWS 300 „Leaflet device“ Deactivate SWS 303 "Check Leaflet present" Press "Stop" Open guard and remove leaflet out of carton before leaflet sensor "=CAR1.B75-B04" Press "Reset" Press "Start"
Consequence	<ul style="list-style-type: none"> Carton without leaflet will not be ejected
Acknowledgement	<ul style="list-style-type: none"> None
	TEST 2
Test prerequisites	<ul style="list-style-type: none"> Machine is ready in automatic mode Run the machine with product
Required operations	<ul style="list-style-type: none"> Activate SWS 300 „Leaflet device“ Activate SWS 303 "Check Leaflet present" Press "Stop" Open guard and remove leaflet out of carton before leaflet sensor "=CAR1.B75-B04" Press "Reset" Press "Start"
Consequence	<ul style="list-style-type: none"> Carton without leaflet will be ejected Counter 315 "Leaflet: Fault cross check in carton" increases by one per defective leaflet
Acknowledgement	<ul style="list-style-type: none"> Press "Stop" Press "Reset"
Comments	<ul style="list-style-type: none"> None

Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Test 1: SWS 303 "Check Leaflet present" is deactivated: Carton without leaflet will not be ejected <input type="button" value=" "/> • Test 2: SWS 303 "Check Leaflet present" is activated: Carton without leaflet will be ejected <input type="button" value=" "/>
Comments	<input type="button" value=" "/>

Results comply	yes/no <input type="button" value=" "/>	Date/Initials <input type="button" value=" "/>
Results approved	Date/Initials <input type="button" value=" "/>	

9.8.16 SWS 307: CONTINUOUS CALL LEAFLET

Test objective	<ul style="list-style-type: none"> Function test of software switch (SWS)
Test procedure	
	TEST 1
Test prerequisites	<ul style="list-style-type: none"> Machine is ready in setup mode
Required operations	<ul style="list-style-type: none"> Activate SWS 300 "Leaflet device" Activate SWS 54 "Vacuum" (only with vacuum pump...) Activate SWS 307 "Continuous call leaflet" Press "Start"
Consequence	<ul style="list-style-type: none"> Leaflets are drawn off and folded without product with each cycle
Comments	<ul style="list-style-type: none"> None
Acknowledgement	<ul style="list-style-type: none"> Press "Stop" Press "Reset"
	TEST2
Test prerequisites	<ul style="list-style-type: none"> Machine is ready in setup mode
Required operations	<ul style="list-style-type: none"> Activate SWS 300 "Leaflet device" Activate SWS 54 "Vacuum" (only with vacuum pump...) Deactivate SWS 307 "Continuous call leaflet" Press "Start"
Consequence	<ul style="list-style-type: none"> Leaflets are not drawn off and folded without product with each cycle
Comments	<ul style="list-style-type: none"> None
Acknowledgement	<ul style="list-style-type: none"> Press "Stop" Press "Reset"

Test result	yes/no
Acceptance criteria	<input type="checkbox"/>
	<input type="checkbox"/>
Comments	<input type="text"/>

Results comply	yes/no <input type="checkbox"/>	Date/Initials <input type="text"/>
Results approved	Date/Initials <input type="text"/>	

9.9 Test protocols - Function tests software switches infeed (SWS)

9.9.1 SWS 400: ROBOT

Test objective	<ul style="list-style-type: none"> Function test of software switch (SWS)
Test procedure	
TEST 1	
Test prerequisites	<ul style="list-style-type: none"> Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> Activate SWS 400 "Robot" Press "Start"
Consequence	<ul style="list-style-type: none"> Robot is active
Comments	<ul style="list-style-type: none"> None
Acknowledgement	<ul style="list-style-type: none"> Press "Reset"
TEST 2	
Test prerequisites	<ul style="list-style-type: none"> Cartoning machine is running in automatic mode Robot is active
Required operations	<ul style="list-style-type: none"> Press "Stop" Deactivate SWS 400 "Robot" Press "Start"
Consequence	<ul style="list-style-type: none"> Robot stops and is not active
Comments	<ul style="list-style-type: none"> None
Acknowledgement	<ul style="list-style-type: none"> Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> Test 1: SWS 400 "Robot" is activated, Robot is active <input type="checkbox"/> Test 2: SWS 400 "Robot" is deactivated, Robot stops and is not active <input type="checkbox"/>
Comments	<input type="text"/>

Results comply	yes/no <input type="text"/>	Date/Initials <input type="text"/>
Results approved	Date/Initials <input type="text"/>	

9.9.2 SWS 2005: INFEED: CHECK POSITION INHALER

Test objective	<ul style="list-style-type: none"> Function test of software switch (SWS)
Test procedure	
	TEST 1
Test prerequisites	<ul style="list-style-type: none"> Machine is ready in setup mode Inhaler is selected as product
Required operations	<ul style="list-style-type: none"> Activate SWS 500 "Infeed" Activate SWS 2005 "Infeed: Check position inhaler" Put one inhaler in wrong position Press "Start"
Consequence	<ul style="list-style-type: none"> Position of inhaler is checked Inhaler with wrong position is rejected
	TEST 2
Test prerequisites	<ul style="list-style-type: none"> Machine is ready in setup mode
Required operations	<ul style="list-style-type: none"> Deactivate SWS 2005 "Infeed: Check position inhaler" Put one inhaler in wrong position Press "Start"
Consequence	<ul style="list-style-type: none"> Position of inhaler is not checked Inhaler with wrong position is not rejected
Comments	<ul style="list-style-type: none"> None
Acknowledgement	<ul style="list-style-type: none"> None
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> Test 1: If SWS 2005 "Infeed: Check position inhaler" is activated, position of inhaler is checked <input type="checkbox"/> Test 2: If SWS 2005 "Infeed: Check position inhaler" is deactivated, position of inhaler is not checked <input type="checkbox"/>
Comments	<input type="text"/>

Results comply	yes/no <input type="text"/>	Date/Initials <input type="text"/>
Results approved	Date/Initials <input type="text"/>	

9.9.3 SWS 500: INFEED

Test objective	<ul style="list-style-type: none"> Function test of software switch (SWS)
Test procedure	
	TEST 1
Test prerequisites	<ul style="list-style-type: none"> Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> Activate SWS 500 "Infeed" Press "Start"
Consequence	<ul style="list-style-type: none"> Infeed is active
Comments	<ul style="list-style-type: none"> None
Acknowledgement	<ul style="list-style-type: none"> Press "Reset"
	TEST 2
Test prerequisites	<ul style="list-style-type: none"> Cartoning machine is running in automatic mode Infeed is active
Required operations	<ul style="list-style-type: none"> Press "Stop" Deactivate SWS 500 "Infeed" Press "Start"
Consequence	<ul style="list-style-type: none"> Infeed stops and is not active
Comments	<ul style="list-style-type: none"> None
Acknowledgement	<ul style="list-style-type: none"> Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> Test 1: SWS 500 "Infeed" is activated, infeed is active Test 2: SWS 500 "Infeed" is deactivated, infeed stops and is not active
Comments	

Results comply	yes/no <input type="text"/>	Date/Initials <input type="text"/>
Results approved	Date/Initials <input type="text"/>	

9.9.4 SWS 501: INFEED: RUN EMPTY

Test objective	<ul style="list-style-type: none"> Function test of software switch (SWS)
Test procedure	
	TEST 1
Test prerequisites	<ul style="list-style-type: none"> Machine is ready in automatic mode SWS 500 "Infeed" is activated
Required operations	<ul style="list-style-type: none"> Activate SWS 501 "Infeed: Run empty" Press "Start"
Consequence	<ul style="list-style-type: none"> Cartoning machine starts operation and product on infeed belt runs empty Machine is running with predefined cycles
	TEST 2
Test prerequisites	<ul style="list-style-type: none"> Machine is ready in automatic mode SWS 500 "Infeed" is activated
Required operations	<ul style="list-style-type: none"> Deactivate SWS 501 "Infeed: Run empty" Press "Stop"
Consequence	<ul style="list-style-type: none"> Cartoning machine and infeed stopped
Comments	<ul style="list-style-type: none"> None
Acknowledgement	<ul style="list-style-type: none"> None

Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Test 1: SWS 501 "Infeed: Run empty" is activated, infeed belt runs empty and stops automatically after predefined cycles • Test 2: SWS 501 "Infeed: Run empty" is deactivated, cartoning machine and infeed stopped
Comments	

Results comply	yes/no	Date/Initials
	<input type="checkbox"/>	<input type="text"/>
Results approved	Date/Initials	
	<input type="text"/>	

9.9.5 SWS 505: INFEED: CALL PRODUCT

Test objective	<ul style="list-style-type: none"> Function test of software switch (SWS)
Test procedure	<p style="text-align: center;">TEST 1</p> <p>Test prerequisites</p> <ul style="list-style-type: none"> Machine is ready in automatic mode SWS 500 "Infeed" is activated <p>Required operations</p> <ul style="list-style-type: none"> Activate SWS 505 "Infeed: Call product" Press "Start" <p>Consequence</p> <ul style="list-style-type: none"> Cartoning machine is running and products are called at the infeed <p style="text-align: center;">TEST 2</p> <p>Required operations</p> <ul style="list-style-type: none"> Deactivate SWS 505 "Infeed: Call product" <p>Consequence</p> <ul style="list-style-type: none"> No products are called at infeed <p>Comments</p> <ul style="list-style-type: none"> None <p>Acknowledgement</p> <ul style="list-style-type: none"> None
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> Test 1: SWS 505 "Infeed: Call product" is activated, products are called at the infeed <input type="button" value=" "/> Test 2: SWS 505 "Infeed: Call product" is deactivated, no products are called at infeed belt <input type="button" value=" "/>
Comments	<input type="button" value="Large Comment Area"/>

Results comply	yes/no <input type="button" value=" "/>	Date/Initials <input type="button" value=" "/>
Results approved	Date/Initials <input type="button" value=" "/>	

9.10 Test protocols - Function tests software switches operation mode (SWSOPM)

9.10.1 SWSOPM 1: AUTOMATIC

Test objective	<ul style="list-style-type: none"> Function test of operating mode switch (SWSOPM)
Test procedure	
	TEST 1
Test prerequisites	<ul style="list-style-type: none"> Machine is ready in setup mode
Required operations	<ul style="list-style-type: none"> Activate SWSOPM 1 "Automatic" Press "Reset" Press "Start"
Consequence	<ul style="list-style-type: none"> Message is displayed on control panel (ME40 "Operating mode: Automatic")
Comments	<ul style="list-style-type: none"> Test can be done together with test of ME 40
Acknowledgement	<ul style="list-style-type: none"> Press "Stop" Press "Reset"
	TEST 2
Test prerequisites	<ul style="list-style-type: none"> Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> Activate SWSOPM 2 "Setup" Press "Reset" Press "Start"
Consequence	<ul style="list-style-type: none"> Message is displayed on control panel (ME41 "Operating mode: Setup")
Comments	<ul style="list-style-type: none"> Test can be done together with test of ME 40
Acknowledgement	<ul style="list-style-type: none"> Press "Stop" Press "Reset"

Test result		yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Test 1: SWSOPM 1 “Automatic” is activated, Operating mode „Automatic“ is active • Test 1: SWSOPM 1 “Automatic” is activated, Message is displayed on control panel (ME 40) • Test 2: SWSOPM 2 “Setup“ is activated, Operating mode „Automatic“ is not active • Test 2: SWSOPM 2 “Setup“ is activated, Message is displayed on control panel (ME41) 	<input type="button" value=" "/>
Comments		<input type="button" value=" "/>

Results comply	yes/no <input type="button" value=" "/>	Date/Initials <input type="button" value=" "/>
Results approved	Date/Initials <input type="button" value=" "/>	

9.10.2 SWSOPM 2: SETUP

Test objective	<ul style="list-style-type: none"> Function test of operating mode switch (SWSOPM)
Test procedure	
	TEST 1
Test prerequisites	<ul style="list-style-type: none"> Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> Activate SWSOPM 2 “Setup” Press “Reset” Press “Start”
Consequence	<ul style="list-style-type: none"> Message is displayed on control panel (ME41 “Operating mode: Setup”)
Comments	<ul style="list-style-type: none"> Test can be done together with test of ME 41
Acknowledgement	<ul style="list-style-type: none"> Press “Stop” Press “Reset”
	TEST 2
Test prerequisites	<ul style="list-style-type: none"> Machine is ready in setup mode
Required operations	<ul style="list-style-type: none"> Activate SWSOPM 1 “Automatic” Press “Reset” Press “Start”
Consequence	<ul style="list-style-type: none"> Message is displayed on control panel (ME40 “Operating mode: Automatic”)
Comments	<ul style="list-style-type: none"> Test can be done together with test of ME 41
Acknowledgement	<ul style="list-style-type: none"> Press “Stop” Press “Reset”

Test result		yes/no
Acceptance criteria	• Test 1: SWSOPM 2 "Setup" is activated, Operating mode „Setup“ is active	<input type="checkbox"/>
	• Test 1: SWSOPM 2 "Setup" is activated, Message is displayed on control panel (ME 41)	<input type="checkbox"/>
	• Test 2: SWSOPM 1 "Automatic" is activated, Operating mode „Setup“ is not active	<input type="checkbox"/>
	• Test 2: SWSOPM 1 "Automatic" is activated, Message is displayed on control panel (ME 40)	<input type="checkbox"/>
Comments	<input type="text"/>	

Results comply	yes/no <input type="checkbox"/>	Date/Initials <input type="text"/>
Results approved	Date/Initials <input type="text"/>	

9.10.3 SWSOPM 3: INCHING PANEL

Test objective	<ul style="list-style-type: none"> Function test of operating mode switch (SWSOPM)
Test procedure	
	TEST 1
Test prerequisites	<ul style="list-style-type: none"> Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> Activate SWSOPM 3 “Inching panel” Press “Reset” Press “Start” and hold the button “Start”
Consequence	<ul style="list-style-type: none"> Message is displayed on control panel (ME42 “Operating mode: Inching mode panel”) Operating mode “Inching panel“ is active
Comments	<ul style="list-style-type: none"> Test can be done together with test of ME 42
Acknowledgement	<ul style="list-style-type: none"> Press “Stop” Press “Reset”
	TEST 2
Test prerequisites	<ul style="list-style-type: none"> Machine is ready in inching mode panel
Required operations	<ul style="list-style-type: none"> Activate SWSOPM 1 “Automatic” Press “Reset” Press “Start”
Consequence	<ul style="list-style-type: none"> Message is displayed on control panel (ME40 “Operating mode: Automatic”) Operating mode “Inching panel“ is not active
Comments	<ul style="list-style-type: none"> Test can be done together with test of ME 40
Acknowledgement	<ul style="list-style-type: none"> Press “Stop” Press “Reset”

Test result		yes/no
Acceptance criteria	• Test 1: SWSOPM 3 “Inching panel” is activated, Operating mode „Inching panel“ is active	<input type="button" value=" "/>
	• Test 1: SWSOPM 3 “Inching panel” is activated, Message is displayed on control panel (ME 42)	<input type="button" value=" "/>
	• Test 2: SWSOPM 1 “Automatic” is activated, Operating mode „Inching panel“ is not active	<input type="button" value=" "/>
	• Test2: SWSOPM 1 “Automatic” is activated, Message is displayed on control panel (ME 40)	<input type="button" value=" "/>
Comments	<input type="text"/>	

Results comply	yes/no <input type="button" value=" "/>	Date/Initials <input type="text"/>
Results approved	Date/Initials <input type="text"/>	

9.10.4 SWSOPM 4: INCHING CABLE

Test objective	<ul style="list-style-type: none"> Function test of operating mode switch (SWSOPM)
Test procedure	
TEST 1	
Test prerequisites	<ul style="list-style-type: none"> Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> Plug in inching cable front Activate SWSOPM 4 “Inching cable” Run the machine with inching cable
Consequence	<ul style="list-style-type: none"> Message is displayed on control panel (ME 43 “Operating mode: Inching mode cable front”) Operating mode “Inching cable” is active
Comments	<ul style="list-style-type: none"> Test can be done together with test of ME 43
Acknowledgement	<ul style="list-style-type: none"> None
TEST 2	
Test prerequisites	<ul style="list-style-type: none"> Machine is ready in inching mode cable
Required operations	<ul style="list-style-type: none"> Remove inching cable Press “Reset” Activate SWSOPM 1 “Automatic” Press “Reset” Press “Start”
Consequence	<ul style="list-style-type: none"> Message is displayed on control panel (ME 40 “Operating mode: Automatic”) Operating mode “Inching cable” is not active
Comments	<ul style="list-style-type: none"> Test can be done together with test of ME 43
Acknowledgement	<ul style="list-style-type: none"> Press “Stop” Press “Reset”

Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Test 1: SWSOPM 4 “Inching cable“ is activated, Operating mode „Inching cable“ is active • Test 1: SWSOPM 4 “Inching cable“ is activated, Message is displayed on control panel (ME 43) • Test 2: SWSOPM 1 “Automatic“ is activated, Operating mode „Inching cable“ is not active • Test 2: SWSOPM 1 “Automatic“ is activated, Message is displayed on control panel (ME 40)
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

9.10.5 SWSOPM 6: OPEN STOP BRAKE

Test objective	<ul style="list-style-type: none"> Function test of operating mode switch (SWSOPM)
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> Machine is ready in inching mode
Required operations	<ul style="list-style-type: none"> Activate SWSOPM 6 “Open stop brake” Select one of the drives (e.g. 1015 “Main drive”, 1055 “Robot”)
Consequence	<ul style="list-style-type: none"> Chosen drive can be moved manually Warning is displayed on control panel (WA 198: Machine: Drive brake(s) opened)
Comments	<ul style="list-style-type: none"> Test can be done together with test of WA 198
Acknowledgement	<ul style="list-style-type: none"> None
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> SWSOPM 6 “Open stop brake” is activated, Chosen drive can be moved manually <input type="button" value=" "/> SWSOPM 6 “Open stop brake” is activated, Warning is displayed on control panel (WA 198: Machine: Drive brake(s) opened) <input type="button" value=" "/>
Comments	<input type="button" value=" "/>

Results comply	yes/no <input type="button" value=" "/>	Date/Initials <input type="button" value=" "/>
Results approved	Date/Initials <input type="button" value=" "/>	

9.10.6 SWSOPM 7: ZERO DRIVE

Test objective	<ul style="list-style-type: none"> Function test of operating mode switch (SWSOPM)
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> Machine is ready in setup mode Servo drives are set to zero position
Required operations	<ul style="list-style-type: none"> Activate SWSOPM 7 “Zero drive” Choose one of the drives Confirm indicated message
Consequence	<ul style="list-style-type: none"> Drive is zeroed
Comments	<ul style="list-style-type: none"> None
Acknowledgement	<ul style="list-style-type: none"> None
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> SWSOPM 7 “Zero drive” is activated, Drive is zeroed <input type="button" value=" "/>
Comments	<div style="border: 1px solid black; height: 100px; width: 100%;"></div>

Results comply	yes/no	Date/Initials
	<input type="button" value=" "/>	<input type="button" value=" "/>
Results approved	Date/Initials	
	<input type="button" value=" "/>	

9.10.7 SWSOPM 8: INCHING SINGLE AXIS

Test objective	<ul style="list-style-type: none"> Function test of operating mode switch (SWSOPM)
Test procedure	
	TEST 1
Test prerequisites	<ul style="list-style-type: none"> Machine is ready in inching mode
Required operations	<ul style="list-style-type: none"> Activate SWSOPM 8 “Inching single axis” Select one of the robot axis Press “Start” and hold the button “Start”
Consequence	<ul style="list-style-type: none"> Message is displayed on control panel (ME47: “Operating mode: Inching mode single axis”) Operating mode “Inching single axis” is active
	TEST 2
Test prerequisites	<ul style="list-style-type: none"> Machine is ready in inching mode single axis
Required operations	<ul style="list-style-type: none"> Activate SWSOPM 1 “Automatic” Press “Reset” Press “Start”
Consequence	<ul style="list-style-type: none"> Message is displayed on control panel (ME40 “Operating mode: Automatic”) Operating mode “Inching single axis” is not active
Comments	<ul style="list-style-type: none"> None
Acknowledgement	<ul style="list-style-type: none"> Press “Stop” Press “Reset”

Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Test 1: Operating mode „Inching single axis“ is active • Test 1: Message is displayed on control panel (ME 47) • Test 2: Operating mode „Inching single axis“ is not active • Test 2: Message is displayed on control panel (ME 40)
Comments	

Results comply	yes/no	Date/Initials
	<input type="checkbox"/>	<input type="text"/>
Results approved	Date/Initials	
	<input type="text"/>	

9.10.8 SWSOPM 9: ROBOT: REFERENCE RUN

Test objective	<ul style="list-style-type: none"> Function test of operating mode switch (SWSOPM)
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> Machine is ready in automatic mode Robot arm is not installed
Required operations	<ul style="list-style-type: none"> Activate SWSOPM 9 "Robot: Reference run" Confirm indicated message Press "Start"
Consequence	<ul style="list-style-type: none"> Message is displayed on control panel (ME448 "Robot: Reference run") Reference run of robot is performed
Comments	<ul style="list-style-type: none"> Test can be done together with test of ME 448
Acknowledgement	<ul style="list-style-type: none"> Reference run needs to be confirmed
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> Message is displayed on control panel (ME448 "Robot: Reference run") when SWSOPM 9 is activated Reference run of robot is performed
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

9.10.9 SWSOPM 60: LINE MODE DOWNSTREAM EQUIPMENT

Test objective	<ul style="list-style-type: none"> Function test of operating mode switch (SWSOPM)
Test procedure	
	TEST 1
Test prerequisites	<ul style="list-style-type: none"> Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> Activate SWSOPM 60 “Line mode downstream equipment” Press “Start” Create fault at downstream machine
Consequence	<ul style="list-style-type: none"> Machine stops Fault message is displayed on control panel
Comments	<ul style="list-style-type: none"> None
Acknowledgement	<ul style="list-style-type: none"> Press “Stop” Press “Reset”
	TEST 2
Test prerequisites	<ul style="list-style-type: none"> Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> Deactivate SWSOPM 60 “Line mode downstream equipment” Press “Start” Try to create fault at downstream machine
Consequence	<ul style="list-style-type: none"> Machine is running in automatic mode Fault message is not displayed in control panel
Comments	<ul style="list-style-type: none"> None
Acknowledgement	<ul style="list-style-type: none"> Press “Stop” Press “Reset”

Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Test 1: SWSOPM 60 “Line mode downstream equipment” is activated: Machine is in line mode. In case of faults fault message will be displayed on control panel and machine stops. • Test 2: SWSOPM 60 “Line mode downstream equipment” is deactivated: Machine is not in line mode. In case of faults fault message is not displayed on control panel and no machine stop.
Comments	

Results comply	yes/no	Date/Initials
	<input type="checkbox"/>	<input type="text"/>
Results approved	Date/Initials	
	<input type="text"/>	

9.10.10 SWSOPM 62: MACHINE: AUTOMATIC RESTART

Test objective	<ul style="list-style-type: none"> Function test of operating mode switch (SWSOPM)
Test procedure	
	TEST 1
Test prerequisites	<ul style="list-style-type: none"> Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> Activate SWSOPM 60 „Line mode downstream equipment“ Activate SWSOPM 62 “Machine: Automatic restart” Create FLT 201 „Downstream: Stop from machine 1“ Acknowledge FLT 201 Press “Reset”
Consequence	<ul style="list-style-type: none"> Fault message is displayed on control panel (FLT 201 “Downstream: Stop from Machine 1“) Machine restarts automatically after acknowledgement of FLT 201
Comments	<ul style="list-style-type: none"> None
Acknowledgement	<ul style="list-style-type: none"> None
	TEST 2
Test prerequisites	<ul style="list-style-type: none"> Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> Deactivate SWSOPM 62 “Machine: Automatic restart” Create FLT 201 “Downstream: Stop from machine 1“ Acknowledge FLT 201 Press “Reset”
Consequence	<ul style="list-style-type: none"> Fault message is displayed on control panel (FLT 201 “Downstream: Stop from Machine 1“) Machine does not restart automatically after acknowledgement of FLT 201
Comments	<ul style="list-style-type: none"> None
Acknowledgement	<ul style="list-style-type: none"> None

Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Test 1: SWSOPM 62 "Machine: Automatic restart" is activated, Machine restarts automatically <input type="button" value=" "/> • Test 2: SWSOPM 62 "Machine: Automatic restart" is deactivated, Machine does not restart automatically <input type="button" value=" "/>
Comments	<input type="text"/>

Results comply	yes/no <input type="button" value=" "/>	Date/Initials <input type="text"/>
Results approved	Date/Initials <input type="text"/>	

9.10.11 SWSOPM 63: LINE MODE UPSTREAM EQUIPMENT

Test objective	<ul style="list-style-type: none"> Function test of operating mode switch (SWSOPM)
Test procedure	
	TEST 1
Test prerequisites	<ul style="list-style-type: none"> Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> Activate SWSOPM 63 "Line mode upstream equipment" Activate SWS 500 "Infeed" Press "Start"
Consequence	<ul style="list-style-type: none"> Machine is running in line mode
Comments	<ul style="list-style-type: none"> None
Acknowledgement	<ul style="list-style-type: none"> None
	TEST 2
Test prerequisites	<ul style="list-style-type: none"> Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> Deactivate SWSOPM 63 "Line mode upstream equipment" Deactivate SWS 500 "Infeed" Press "Start"
Consequence	<ul style="list-style-type: none"> Machine is running without infeed belt
Comments	<ul style="list-style-type: none"> None
Acknowledgement	<ul style="list-style-type: none"> None

Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Test 1: SWSOPM 63 "Line mode upstream equipment" is activated, Machine is running with infeed. • Test 2: SWSOPM 63 "Line mode upstream equipment" is deactivated, Machine is running without infeed
Comments	

Results comply	yes/no <input type="checkbox"/>	Date/Initials <input type="text"/>
Results approved	Date/Initials <input type="text"/>	

9.11 Test protocols - Function tests software switches operation mode drive (SWSOPM_DRV)

9.11.1 SWSOPM_DRV 1015: MAIN DRIVE

Test objective	<ul style="list-style-type: none"> Function test of operating mode drive (SWSOPM_DRV)
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> Machine is ready in setup mode
Required operations	<ul style="list-style-type: none"> Set drive mechanically to position "zero" Close guard door Press "Reset" Activate SWSOPM 7 "Zero drive" Activate SWSOPM_DRV_DRV 1015 "Main drive"
Consequence	<ul style="list-style-type: none"> Message is displayed on control panel "Do you really want to set drive to zero"
Comments	<ul style="list-style-type: none"> The position of the drive should not be adjusted, as it has already been adjusted.
Acknowledgement	<ul style="list-style-type: none"> Message "Do you really want to set drive to zero" - Cancel input Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> SWSOPM_DRV 1015 "Main drive" is activated, Message is displayed on control panel "Do you really want to set drive to zero"
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

9.11.2 SWSOPM_DRV 1054: ROBOT: DRILL AXIS

Test objective	<ul style="list-style-type: none"> Function test of operating mode switch (SWSOPM) Drive
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> Machine is ready in inching mode
Required operations	<ul style="list-style-type: none"> Activate SWSOPM 6 “Open stop brake” Select Drive 1054: “Robot: Drill axis”
Consequence	<ul style="list-style-type: none"> Robot drive drill axis can be moved by hand Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> None
Acknowledgement	<ul style="list-style-type: none"> Activate SWSOPM 3 “Inching panel” Drive is disabled; machine can be started
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> Robot drive drill axis can be moved by hand <input type="button" value=" "/>
Comments	<div style="border: 1px solid black; height: 100px; width: 100%;"></div>

Results comply	yes/no	Date/Initials
	<input type="button" value=" "/>	<input type="button" value=" "/>
Results approved	Date/Initials	
	<input type="button" value=" "/>	

9.11.3 SWSOPM_DRV 1055: ROBOT

Test objective	<ul style="list-style-type: none"> Function test of operating mode switch (SWSOPM) Drive
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> Machine is ready in inching mode
Required operations	<ul style="list-style-type: none"> Activate SWSOPM 6 “Open stop brake” Select Drive 1055: “Robot:”
Consequence	<ul style="list-style-type: none"> Robot drive can be moved by hand Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> None
Acknowledgement	<ul style="list-style-type: none"> Activate SWSOPM 3 “Inching panel” Drive is disabled; machine can be started
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> Robot drive can be moved by hand <input type="button" value=" "/>
Comments	<div style="border: 1px solid black; height: 100px; width: 100%;"></div>

Results comply	yes/no	Date/Initials
	<input type="button" value=" "/>	<input type="button" value=" "/>
Results approved	Date/Initials	
	<input type="button" value=" "/>	

9.11.4 SWSOPM_DRV 1063: ROBOT: INFEED BELT

Test objective	<ul style="list-style-type: none"> Function test of operating mode switch (SWSOPM) Drive
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> Machine is ready in inching mode
Required operations	<ul style="list-style-type: none"> Activate SWSOPM 6 “Open stop brake” Select Drive 1063: “Robot: Infeed belt”
Consequence	<ul style="list-style-type: none"> Drive of infeed belt robot can be moved by hand Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> None
Acknowledgement	<ul style="list-style-type: none"> Activate SWSOPM 3 “Inching panel” Drive is disabled; machine can be started
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> Drive of infeed belt robot can be moved by hand <input type="button" value=" "/>
Comments	<div style="border: 1px solid black; height: 100px; width: 100%;"></div>

Results comply	yes/no	Date/Initials
	<input type="button" value=" "/>	<input type="button" value=" "/>
Results approved	Date/Initials	
	<input type="button" value=" "/>	

9.11.5 SWSOPM_DRV 1075: INFEED: OVERHEAD CONVEYOR

Test objective	<ul style="list-style-type: none"> Function test of operating mode switch (SWSOPM) Drive
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> Machine is ready in inching mode
Required operations	<ul style="list-style-type: none"> Activate SWSOPM 6 “Open stop brake” Select Drive 1075: “Infeed: Overhead conveyor”
Consequence	<ul style="list-style-type: none"> Drive of infeed overhead conveyor can be moved by hand Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> None
Acknowledgement	<ul style="list-style-type: none"> Activate SWSOPM 3 “Inching panel” Drive is disabled; machine can be started
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> Drive of infeed: overhead conveyor can be moved by hand <input type="button" value=" "/>
Comments	<div style="border: 1px solid black; height: 100px; width: 100%;"></div>

Results comply	yes/no	Date/Initials
	<input type="button" value=" "/>	<input type="button" value=" "/>
Results approved	Date/Initials	
	<input type="button" value=" "/>	

10 Test protocols - Messages (ME)

10.1 ME 25: BATCH CONTROL: BATCH IS INTERRUPTED

Test objective	<ul style="list-style-type: none"> • Test whether correct message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode • A released recipe is active • A new batch has been created but not started
Required operations	<ul style="list-style-type: none"> • Start batch • Press “Interrupt” on “Batch control”
Consequence	<ul style="list-style-type: none"> • Message is displayed on control panel
Comments	<ul style="list-style-type: none"> • Test can be done together with test of ME 27
Acknowledgement	<ul style="list-style-type: none"> • Press “Interrupt” button and confirm indicated message to activate the batch again
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Message is displayed on control panel <input type="button" value=" "/>
Comments	<div style="border: 1px solid black; height: 150px; width: 100%;"></div>

Results comply	yes/no	Date/Initials
	<input type="button" value=" "/>	<input type="button" value=" "/>
Results approved	Date/Initials	
	<input type="button" value=" "/>	

10.2 ME 26: BATCH CONTROL: BATCH IS NOT ACTIVE

Test objective	<ul style="list-style-type: none"> • Test whether correct message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Release a recipe
Consequence	<ul style="list-style-type: none"> • Message is displayed on control panel
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • None
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Message is displayed on control panel <input type="button" value=" "/>
Comments	<div style="border: 1px solid black; height: 150px; width: 100%;"></div>

Results comply	yes/no	Date/Initials
	<input type="button" value=" "/>	<input type="button" value=" "/>
Results approved	Date/Initials	
	<input type="button" value=" "/>	

10.3 ME 27: BATCH CONTROL: BATCH IS ACTIVE

Test objective	<ul style="list-style-type: none"> • Test whether correct message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode • A released recipe is active • A new batch has been created
Required operations	<ul style="list-style-type: none"> • Start batch
Consequence	<ul style="list-style-type: none"> • Message is displayed on control panel
Comments	<ul style="list-style-type: none"> • Test can be done together with test of ME 25 and ME 26
Acknowledgement	<ul style="list-style-type: none"> • Press "finish" on "Batch control" and confirm indicated message
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Message is displayed on control panel <input type="button" value=" "/>
Comments	<div style="border: 1px solid black; height: 100px; width: 100%;"></div>

Results comply	yes/no	Date/Initials
	<input type="button" value=" "/>	<input type="button" value=" "/>
Results approved	Date/Initials	
	<input type="button" value=" "/>	

10.3.1 ME 40: OPERATING MODE: AUTOMATIC

Test objective	<ul style="list-style-type: none"> • Test whether correct message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in setup mode
Required operations	<ul style="list-style-type: none"> • Activate SWSOPM 1 "Automatic" • Press "Reset" • Press "Start"
Consequence	<ul style="list-style-type: none"> • Message is displayed on control panel
Comments	<ul style="list-style-type: none"> • Test can be done together with test of SWSOPM 1
Acknowledgement	<ul style="list-style-type: none"> • None
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Message is displayed on control panel <input type="button" value=" "/>
Comments	<div style="border: 1px solid black; height: 100px; width: 100%;"></div>

Results comply	yes/no	Date/Initials
	<input type="button" value=" "/>	<input type="button" value=" "/>
Results approved	Date/Initials	
	<input type="button" value=" "/>	

10.3.2 ME 41: OPERATING MODE: SETUP

Test objective	<ul style="list-style-type: none"> • Test whether correct message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Activate SWSOPM 2 "Setup" • Press "Reset" • Press "Start"
Consequence	<ul style="list-style-type: none"> • Message is displayed on control panel
Comments	<ul style="list-style-type: none"> • Test can be done together with test of SWSOPM 2
Acknowledgement	<ul style="list-style-type: none"> • None
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Message is displayed on control panel <input type="button" value=" "/>
Comments	<div style="border: 1px solid black; height: 100px; width: 100%;"></div>

Results comply	yes/no	Date/Initials
	<input type="button" value=" "/>	<input type="button" value=" "/>
Results approved	Date/Initials	
	<input type="button" value=" "/>	

10.3.3 ME 42: OPERATING MODE: INCHING MODE PANEL

Test objective	<ul style="list-style-type: none"> • Test whether correct message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Activate SWSOPM 3 "Inching panel" • Close all guard doors • Press "Reset" • Press "Start" and hold the button "Start"
Consequence	<ul style="list-style-type: none"> • Message is displayed on control panel as long as the button "Start" is pressed"
Comments	<ul style="list-style-type: none"> • Test can be done together with test of SWSOPM 3
Acknowledgement	<ul style="list-style-type: none"> • None
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Message is displayed on control panel <input type="button" value=" "/>
Comments	<div style="border: 1px solid black; height: 100px; width: 100%;"></div>

Results comply	yes/no <input type="button" value=" "/>	Date/Initials <input type="button" value=" "/>
Results approved	Date/Initials <input type="button" value=" "/>	

10.3.4 ME 43: OPERATING MODE: INCHING MODE CABLE FRONT

Test objective	<ul style="list-style-type: none"> • Test whether correct message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in inching mode
Required operations	<ul style="list-style-type: none"> • Plug in “inching cable front” • Activate SWSOPM 4 “Inching cable” • Close all guard doors • Press “Reset” • Press button on “inching cable front”
Consequence	<ul style="list-style-type: none"> • Message is displayed on control panel as long as the button on inching cable is pressed“
Comments	<ul style="list-style-type: none"> • Test can be done together with test of SWSOPM 4
Acknowledgement	<ul style="list-style-type: none"> • None
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Message is displayed on control panel
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

10.4 ME 47: OPERATING MODE: INCHING MODE SINGLE AXES

Test objective	<ul style="list-style-type: none"> • Test whether correct message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in inching mode
Required operations	<ul style="list-style-type: none"> • Activate SWS 400 "Robot" • Activate SWSOPM 8 "Inching single axis" • Press "Start" and hold the button "Start"
Consequence	<ul style="list-style-type: none"> • Single axis starts inching forward • Message is displayed on control panel
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Press "Stop" • Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Message is displayed on control panel <input type="button" value=" "/>
Comments	<div style="border: 1px solid black; height: 100px; width: 100%;"></div>

Results comply	yes/no	Date/Initials
	<input type="button" value=" "/>	<input type="button" value=" "/>
Results approved	Date/Initials	
	<input type="button" value=" "/>	

10.4.1 ME 48: OPERATING MODE: INCHING MODE CABLE BACK

Test objective	<ul style="list-style-type: none"> • Test whether correct message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Plug in inching cable back • Activate SWSOPM 4 "Inching cable"
Consequence	<ul style="list-style-type: none"> • Message is displayed on control panel
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • None
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Message is displayed on control panel <input type="checkbox"/>
Comments	<div style="border: 1px solid black; height: 100px; width: 100%;"></div>

Results comply	yes/no <input type="checkbox"/>	Date/Initials <input type="text"/>
Results approved	Date/Initials <input type="text"/>	

10.4.2 ME 160: MACHINE: OPERATIONAL

Test objective	<ul style="list-style-type: none"> • Test whether correct message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode • No fault messages pending
Required operations	<ul style="list-style-type: none"> • Press “Reset” in case of pending fault messages
Consequence	<ul style="list-style-type: none"> • Message is displayed on control panel
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • None
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Message is displayed on control panel <input type="button" value=" "/>
Comments	<div style="border: 1px solid black; height: 100px; width: 100%;"></div>

Results comply	yes/no <input type="button" value=" "/>	Date/Initials <input type="button" value=" "/>
Results approved	Date/Initials <input type="button" value=" "/>	

10.4.3 ME 551: INFEED: PREMACHINE: NOT READY

Test objective	<ul style="list-style-type: none"> • Test whether correct message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode • Batch is active
Required operations	<ul style="list-style-type: none"> • Activate SWS 500 "Infeed" • Activate SWS 505 "Infeed: Call product" • If inhaler is selected: Disconnect input "=.W257-KI00:9"
Consequence	<ul style="list-style-type: none"> • Message is displayed on control panel
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Reconnect input "=.W257-KI00:9"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Message is displayed on control panel <input type="button" value=" "/>
Comments	<div style="border: 1px solid black; height: 150px; width: 100%;"></div>

Results comply	yes/no	Date/Initials
	<input type="button" value=" "/>	<input type="button" value=" "/>
Results approved	Date/Initials	
	<input type="button" value=" "/>	

10.4.4 ME 2003: LEAFLET: CHECK CODE :FAULT

Test objective	<ul style="list-style-type: none"> • Test whether correct message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Activate SWS 300 "Leaflet device" • Activate SWS 302 "Code reader leaflet rear" • Prepare one leaflet with wrong code and place it into the machine • Press "Start"
Consequence	<ul style="list-style-type: none"> • Message is displayed on control panel
Comments	<ul style="list-style-type: none"> • Machine doesn't stop
Acknowledgement	<ul style="list-style-type: none"> • Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Message is displayed on control panel <input type="button" value=" "/>
Comments	<div style="border: 1px solid black; height: 100px; width: 100%;"></div>

Results comply	yes/no <input type="button" value=" "/>	Date/Initials <input type="button" value=" "/>
Results approved	Date/Initials <input type="button" value=" "/>	

10.4.5 ME 2004: CARTON: CHECK CODE :FAULT

Test objective	<ul style="list-style-type: none"> • Test whether correct message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Activate SWS 200 "Code reader carton" • Activate SWS 300 "Leaflet device" • Prepare one carton with wrong code and place it into the machine • Press "Start"
Consequence	<ul style="list-style-type: none"> • Message is displayed on control panel
Comments	<ul style="list-style-type: none"> • Machine doesn't stop
Acknowledgement	<ul style="list-style-type: none"> • Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Message is displayed on control panel <input type="button" value=" "/>
Comments	<div style="border: 1px solid black; height: 150px; width: 100%;"></div>

Results comply	yes/no <input type="button" value=" "/>	Date/Initials <input type="button" value=" "/>
Results approved	Date/Initials <input type="button" value=" "/>	

10.4.6 ME 2006: CARTON: CHECK OPEN SIDE FLAP, SLIDE IN: FAULT

Test objective	<ul style="list-style-type: none"> • Test whether correct message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Activate SWS 257 "Check carton open side flap" • Produce some cartons and stop the machine • Open a flap at the slide in side position • Press "Start"
Consequence	<ul style="list-style-type: none"> • Message is displayed on control panel
Comments	<ul style="list-style-type: none"> • Machine doesn't stop
Acknowledgement	<ul style="list-style-type: none"> • Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Message is displayed on control panel <input type="button" value=" "/>
Comments	<div style="border: 1px solid black; height: 100px; width: 100%;"></div>

Results comply	yes/no <input type="button" value=" "/>	Date/Initials <input type="button" value=" "/>
Results approved	Date/Initials <input type="button" value=" "/>	

10.4.7 ME 2007: CARTON: CHECK OPEN SIDE FLAP, OPPOSITE SLIDE IN: FAULT

Test objective	<ul style="list-style-type: none"> • Test whether correct message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Activate SWS 257 "Check carton open side flap" • Produce some cartons and stop the machine • Open a flap at the opposite slide in position (flap on the rear side) • Press "Start"
Consequence	<ul style="list-style-type: none"> • Message is displayed on control panel
Comments	<ul style="list-style-type: none"> • Machine doesn't stop
Acknowledgement	<ul style="list-style-type: none"> • Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Message is displayed on control panel <input type="button" value=" "/>
Comments	<div style="border: 1px solid black; height: 150px; width: 100%;"></div>

Results comply	yes/no <input type="button" value=" "/>	Date/Initials <input type="button" value=" "/>
Results approved	Date/Initials <input type="button" value=" "/>	

10.4.8 ME 2008: CARTON: CHECK OPEN FOURTH FLAP: FAULT

Test objective	<ul style="list-style-type: none"> • Test whether correct message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Activate SWS 257 "Check carton open side flap" • Produce some cartons and stop the machine • Tear the fourth flap off • Press "Start"
Consequence	<ul style="list-style-type: none"> • Message is displayed on control panel
Comments	<ul style="list-style-type: none"> • Machine doesn't stop
Acknowledgement	<ul style="list-style-type: none"> • Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Message is displayed on control panel <input type="button" value=" "/>
Comments	<div style="border: 1px solid black; height: 100px; width: 100%;"></div>

Results comply	yes/no <input type="button" value=" "/>	Date/Initials <input type="button" value=" "/>
Results approved	Date/Initials <input type="button" value=" "/>	

10.5 Test protocols - Warnings (WA)

10.5.1 WA 27: CONTROL-PC: M-GUARD ENABLED

Test objective	<ul style="list-style-type: none"> • Test whether correct warning message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Turn key at control cabinet to "I" to enable M-Guard
Consequence	<ul style="list-style-type: none"> • Warning is displayed on control panel
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Switch off key
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Warning is displayed on control panel
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

10.5.2 WA 28: CONTROL-PC: REMOTE MAINTENANCE ENABLED

Test objective	<ul style="list-style-type: none"> • Test whether correct warning message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Enable M-Guard with key at control cabinet • In menu “Setup” activate button “Service” and following “Remote control” • Activate “Remote control”
Consequence	<ul style="list-style-type: none"> • A window with “Remote control software successful started!” opens
Required operations	<ul style="list-style-type: none"> • Press “ok”
Consequence	<ul style="list-style-type: none"> • Warning is displayed on control panel
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Switch off “Remote control” • Disable M-Guard with key at control cabinet
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Warning is displayed on control panel <input type="button" value=" "/>
Comments	<input type="button" value=" "/>

Results comply	yes/no	Date/Initials
	<input type="button" value=" "/>	<input type="button" value=" "/>
Results approved	Date/Initials	<input type="button" value=" "/>

10.5.3 WA 45: CONTROL CABINET: UPS NOT READY

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Switch off the machine at the main switch • Wait until all LED lamps on the display of the USV are off completely • Remove USV (XUSB in) • Switch on the machine • Log in a user
Consequence	<ul style="list-style-type: none"> • Warning is displayed on control panel
Comments	<ul style="list-style-type: none"> • Together with the warning message FLT 45 "CONTROLCABINET: UPS NOT READY" is displayed on control panel • In order to acknowledge the fault message follow: menu "system configuration" > submenu "diagnostic" > Button "device diagnostic" > submenu "diagnostic USV" > Press button "Monitoring USV off" • The simulation of the warning WA "45" can be done together with fault message FLT "45"
Acknowledgement	<ul style="list-style-type: none"> • Close the HMI and shut down the IPC • Switch off the main switch • Reconnect the USV • Switch on the main switch • Log in a user
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Warning is displayed on control panel <input type="button" value=" "/>
Comments	<div style="border: 1px solid black; height: 150px; width: 100%;"></div>

Results comply	yes/no	Date/Initials
	<input type="button" value=" "/>	<input type="button" value=" "/>
Results approved	Date/Initials	
	<input type="button" value=" "/>	

10.5.4 WA 198: MACHINE: DRIVE BRAKE(S) RELEASED

Test objective	<ul style="list-style-type: none"> • Test whether correct warning message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in inching mode
Required operations	<ul style="list-style-type: none"> • Activate SWSOPM 6 "Open stop brake"
Consequence	<ul style="list-style-type: none"> • Warning is displayed on control panel
Comments	<ul style="list-style-type: none"> • Test can be done together with test of SWSOPM 7 "Zero drive"
Acknowledgement	<ul style="list-style-type: none"> • Activate SWSOPM 1 "Automatic"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Warning is displayed on control panel <input type="button" value=" "/>
Comments	<div style="border: 1px solid black; height: 100px; width: 100%;"></div>

Results comply	yes/no	Date/Initials
	<input type="button" value=" "/>	<input type="button" value=" "/>
Results approved	Date/Initials	
	<input type="button" value=" "/>	

10.5.5 WA 220: CARTON: PREWARNING LOW STOCK

Test objective	<ul style="list-style-type: none"> • Test whether correct warning message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Remove folding cartons from the magazine until sensor “=CAR1.B32-B01“ is uncovered
Consequence	<ul style="list-style-type: none"> • Warning is displayed on control panel
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Fill cartons into magazine
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Warning is displayed on control panel
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

10.5.6 WA 232: GLUE UNIT: PREWARNING LOW GLUE LEVEL

Test objective	<ul style="list-style-type: none"> • Test whether correct warning message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode • SWS 204 "Carton glueing" is activated
Required operations	<ul style="list-style-type: none"> • Simulate low level at glueing station (Connect 24V to input "=.K00-KI02:11")
Consequence	<ul style="list-style-type: none"> • Warning is displayed on control panel
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Reconnect 24V to input "=.K00-KI02:11"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Warning is displayed on control panel <input type="button" value=" "/>
Comments	<div style="border: 1px solid black; height: 100px; width: 100%;"></div>

Results comply	yes/no <input type="button" value=" "/>	Date/Initials <input type="button" value=" "/>
Results approved	Date/Initials <input type="button" value=" "/>	

10.6 WA 300: LEAFLET: PREWARNING LOW STOCK

Test objective	<ul style="list-style-type: none"> • Test whether correct warning message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode • SWS 300 "Leaflet device" is activated
Required operations	<ul style="list-style-type: none"> • Take away leaflets before sensor -12B2 of rontech lealet feeder
Consequence	<ul style="list-style-type: none"> • Warning is displayed on control panel
Comments	<ul style="list-style-type: none"> • Disconnect input "=.K00-KI18:10" if sensor cannot be released to simulate warning message
Acknowledgement	<ul style="list-style-type: none"> • Fill up leaflet stack
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Warning is displayed on control panel
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

10.7 WA 380: TURRET MAGAZINE: MINIMAL SUPPLY

Test objective	<ul style="list-style-type: none"> • Test whether correct warning message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode • SWS 300 "Leaflet device" is activated
Required operations	<ul style="list-style-type: none"> • Disconnect input ".K00-KI20:6"
Consequence	<ul style="list-style-type: none"> • Warning is displayed on control panel
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Reconnect input ".K00-KI20:6"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Warning is displayed on control panel <input type="button" value=" "/>
Comments	<div style="border: 1px solid black; height: 100px; width: 100%;"></div>

Results comply	yes/no	Date/Initials
	<input type="button" value=" "/>	<input type="button" value=" "/>
Results approved	Date/Initials	
	<input type="button" value=" "/>	

10.8 WA 381: TURRET MAGAZINE: NOT IN OPERATION MODE

Test objective	<ul style="list-style-type: none"> • Test whether correct warning message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode • SWS 300 "Leaflet device" is activated
Required operations	<ul style="list-style-type: none"> • Disconnect input "=.K00-KI20:7"
Consequence	<ul style="list-style-type: none"> • Warning is displayed on control panel
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Reconnect input "=.K00-KI20:7"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Warning is displayed on control panel <input type="button" value=" "/>
Comments	<div style="border: 1px solid black; height: 100px; width: 100%;"></div>

Results comply	yes/no	Date/Initials
	<input type="button" value=" "/>	<input type="button" value=" "/>
Results approved	Date/Initials	
	<input type="button" value=" "/>	

10.9 WA 480: ROBOT: DRIVE AXIS X POSITION LIMIT +

Test objective	<ul style="list-style-type: none"> • Test whether correct warning message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in inching mode
Required operations	<ul style="list-style-type: none"> • Activate SWS 400 "Robot" • Activate SWSOPM 8 "Inching single axis" • Activate SWSDRV 1055 "Robot" • Turn safety switch "Stop brake" (=CAR1.W150-S20P) to position "1" • Move manually the robot arm (axis X, position +) to the end position
Consequence	<ul style="list-style-type: none"> • Warning is displayed on control panel as soon as limit position is reached
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Warning is displayed on control panel as soon as limit position is reached
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

10.10 WA 481: ROBOT: DRIVE AXIS X POSITION LIMIT -

Test objective	<ul style="list-style-type: none"> • Test whether correct warning message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in inching mode
Required operations	<ul style="list-style-type: none"> • Activate SWS 400 "Robot" • Activate SWSOPM 8 "Inching single axis" • Activate SWSDRV 1055 "Robot" • Turn safety switch "Stop brake" (=CAR1.W150-S20P) to position "1" • Move manually the robot arm (axis X, position -) to the end position
Consequence	<ul style="list-style-type: none"> • Warning is displayed on control panel as soon as limit position is reached
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Warning is displayed on control panel as soon as limit position is reached
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

10.11 WA 482: ROBOT: DRIVE AXIS Y POSITION LIMIT +

Test objective	<ul style="list-style-type: none"> • Test whether correct warning message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in inching mode
Required operations	<ul style="list-style-type: none"> • Activate SWS 400 "Robot" • Activate SWSOPM 8 "Inching single axis" • Activate SWSDRV 1055 "Robot" • Turn safety switch "Stop brake" (=CAR1.W150-S20P) to position "1" • Move manually the robot arm (axis Y, position +) to the end position
Consequence	<ul style="list-style-type: none"> • Warning is displayed on control panel as soon as limit position is reached
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Warning is displayed on control panel as soon as limit position is reached
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

10.12 WA 483: ROBOT: DRIVE AXIS Y POSITION LIMIT -

Test objective	<ul style="list-style-type: none"> • Test whether correct warning message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in inching mode
Required operations	<ul style="list-style-type: none"> • Activate SWS 400 "Robot" • Activate SWSOPM 8 "Inching single axis" • Activate SWSDRV 1055 "Robot" • Turn safety switch "Stop brake" (=CAR1.W150-S20P) to position "1" • Move manually the robot arm (axis Y, position -) to the end position
Consequence	<ul style="list-style-type: none"> • Warning is displayed on control panel as soon as limit position is reached
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Warning is displayed on control panel as soon as limit position is reached
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

10.13 WA 484: ROBOT: DRIVE AXIS Z POSITION LIMIT +

Test objective	<ul style="list-style-type: none"> • Test whether correct warning message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in inching mode
Required operations	<ul style="list-style-type: none"> • Activate SWS 400 "Robot" • Activate SWSOPM 8 "Inching single axis" • Activate SWSDRV 1055 "Robot" • Turn safety switch "Stop brake" (=CAR1.W150-S20P) to position "1" • Move manually the robot arm (axis Z, position +) to the end position
Consequence	<ul style="list-style-type: none"> • Warning is displayed on control panel as soon as limit position is reached
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Warning is displayed on control panel as soon as limit position is reached
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

10.14 WA 485: ROBOT: DRIVE AXIS Z POSITION LIMIT -

Test objective	<ul style="list-style-type: none"> • Test whether correct warning message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in inching mode
Required operations	<ul style="list-style-type: none"> • Activate SWS 400 "Robot" • Activate SWSOPM 8 "Inching single axis" • Activate SWSDRV 1055 "Robot" • Turn safety switch "Stop brake" (=CAR1.W150-S20P) to position "1" • Move manually the robot arm (axis Z, position -) to the end position
Consequence	<ul style="list-style-type: none"> • Warning is displayed on control panel as soon as limit position is reached
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Warning is displayed on control panel as soon as limit position is reached
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

10.15 Test protocols - Faults (FLT)

10.15.1 FLT 3: OPERATOR: NORMAL STOP ACTUATED

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Press "Stop"
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Fault message is displayed on control panel
	<input type="checkbox"/>
	<ul style="list-style-type: none"> • Machine cannot be started as long as fault is active
Comments	

Results comply	yes/no	Date/Initials
	<input type="checkbox"/>	<input type="checkbox"/>
Results approved	Date/Initials	
	<input type="checkbox"/>	

10.15.2 FLT 4: OPERATOR: INCORRECT OPERATING MODE SELECTED

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in setup mode
Required operations	<ul style="list-style-type: none"> • Activate SWSOPM 4 “Inching cable”
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Activate SWSOPM 2 “Setup” • Press “Reset”
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Fault message is displayed on control panel <input type="button" value=" "/>
	<ul style="list-style-type: none"> • Machine cannot be started as long as fault is active <input type="button" value=" "/>
Comments	<div style="border: 1px solid black; height: 100px; width: 100%;"></div>

Results comply	yes/no	Date/Initials
	<input type="button" value=" "/>	<input type="button" value=" "/>
Results approved	Date/Initials	
	<input type="button" value=" "/>	

10.15.3 FLT 5: COMPRESSED AIR: MONITORING INLET PRESSURE

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Close the compressed air supply
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Open the compressed air supply • Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Fault message is displayed on control panel <input type="button" value=" "/>
	<ul style="list-style-type: none"> • Machine cannot be started as long as fault is active <input type="button" value=" "/>
Comments	<input type="button" value=" "/>

Results comply	yes/no	Date/Initials
	<input type="button" value=" "/>	<input type="button" value=" "/>
Results approved	Date/Initials	
	<input type="button" value=" "/>	

10.15.4 FLT 6: ETHERCAT: FAULT

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Disconnect ethernet plug
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • Observe without fail! Control Cabinet door is open! • Additionally other fault messages are displayed on control panel • The variable contains further information about ethercat connection e.g. "K00-KI (EK1100 NoCommToSlave)"
Acknowledgement	<ul style="list-style-type: none"> • Reconnect ethernet plug • Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Fault message is displayed on control panel
	<input type="button" value=" "/>
	<ul style="list-style-type: none"> • Machine cannot be started as long as fault is active
Comments	

Results comply	yes/no	Date/Initials
	<input type="button" value=" "/>	<input type="button" value=" "/>
Results approved	Date/Initials	
	<input type="button" value=" "/>	

10.15.5 FLT 7: COMPRESSED AIR: MONITORING SAFE SHUTDOWN

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Disconnect “=CAR1.G95-Q01V1“
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Reconnect sensor “=CAR1.G95-Q01V1“
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Fault message is displayed on control panel <input type="button" value=" "/>
	<ul style="list-style-type: none"> • Machine cannot be started as long as fault is active <input type="button" value=" "/>
Comments	<input type="button" value=" "/>

Results comply	yes/no	Date/Initials
	<input type="button" value=" "/>	<input type="button" value=" "/>
Results approved	Date/Initials	
	<input type="button" value=" "/>	

10.15.6 FLT 11: MOTION DRIVES: OVERLOAD POWER SUPPLY

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Disconnect input “=.K00-KI04:10“
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Reconnect input
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Fault message is displayed on control panel <input type="button" value=" "/>
	<ul style="list-style-type: none"> • Machine cannot be started as long as fault is active <input type="button" value=" "/>
Comments	<div style="border: 1px solid black; height: 100px; width: 100%;"></div>

Results comply	yes/no	Date/Initials
	<input type="button" value=" "/>	<input type="button" value=" "/>
Results approved	Date/Initials	
	<input type="button" value=" "/>	

10.15.7 FLT 16: MACHINE: HANDWHEEL IS ENGAGED

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in setup mode
Required operations	<ul style="list-style-type: none"> • Pull out the handwheel and turn until end position is reached
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Push in the handwheel
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Fault message is displayed on control panel <input type="button" value=" "/>
	<ul style="list-style-type: none"> • Machine cannot be started as long as fault is active <input type="button" value=" "/>
Comments	<input type="button" value=" "/>

Results comply	yes/no	Date/Initials
	<input type="button" value=" "/>	<input type="button" value=" "/>
Results approved	Date/Initials	
	<input type="button" value=" "/>	

10.15.8 FLT 17: OPERATOR: OPERATING MODE CHANGE

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Change over to setup mode
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Fault message is displayed on control panel <input type="button" value=" "/>
	<ul style="list-style-type: none"> • Machine cannot be started as long as fault is active <input type="button" value=" "/>
Comments	<div style="border: 1px solid black; height: 100px; width: 100%;"></div>

Results comply	yes/no	Date/Initials
	<input type="button" value=" "/>	<input type="button" value=" "/>
Results approved	Date/Initials	
	<input type="button" value=" "/>	

10.16 FLT 20: BATCH CONTROL: PARTIAL BATCH OBTAINED

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Partial batch is defined and started • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Press "Start"
Consequence	<ul style="list-style-type: none"> • The machine produces until its partial batch count • Machine stops until the defined quantity of good products of the partial batch is obtained • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Press "Reset"

Test result		yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Machine stops until the defined quantity of good products of the partial batch is obtained • Fault message is displayed on control panel • Machine cannot be started as long as fault is active 	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>
Comments	<input type="text"/>	

Results comply	yes/no	Date/Initials
	<input type="checkbox"/>	<input type="text"/>
Results approved	Date/Initials	
	<input type="text"/>	

10.17 FLT 21: BATCH CONTROL: COMPLETE BATCH OBTAINED

Test objective	<ul style="list-style-type: none"> Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> Complete batch is defined and started Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> Press "Start"
Consequence	<ul style="list-style-type: none"> The machine produces until its complete batch count Machine stops when the defined quantity of good products of the batch size is obtained Fault message is displayed on control panel Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> None
Acknowledgement	<ul style="list-style-type: none"> Press "Reset"

Test result		yes/no
Acceptance criteria	<ul style="list-style-type: none"> Machine stops when the defined quantity of good products of the batch size is obtained Fault message is displayed on control panel Machine cannot be started as long as fault is active 	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>
Comments		<div style="border: 1px solid black; height: 150px; width: 100%;"></div>

Results comply	yes/no	Date/Initials
	<input type="checkbox"/>	<input type="text"/>
Results approved	Date/Initials	
	<input type="text"/>	

10.17.1 FLT 22: VACUUM: OVERLOAD PUMP

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Switch off protective motor switch “=CAR1.G05-Q10”
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Switch on protective motor switch “=CAR1.G05-Q10” • Press “Reset”
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Fault message is displayed on control panel <input type="button" value=" "/>
	<ul style="list-style-type: none"> • Machine cannot be started as long as fault is active <input type="button" value=" "/>
Comments	<div style="border: 1px solid black; height: 100px; width: 100%;"></div>

Results comply	yes/no	Date/Initials
	<input type="button" value=" "/>	<input type="button" value=" "/>
Results approved	Date/Initials	
	<input type="button" value=" "/>	

10.17.2 FLT 23: VACUUM: MONITORING NEGATIVE PRESSURE

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is running in automatic mode
Required operations	<ul style="list-style-type: none"> • Activate SWS 54 "Vacuum" • Disconnect sensor "=CAR1.G05-B80" • Press "Start"
Consequence	<ul style="list-style-type: none"> • Machine stops • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Reconnect sensor "=CAR1.G05-B80" • Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Machine stops • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

10.17.3 FLT 28: CONTROL CABINET: MONITORING SAFETY PLC

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Disconnect input ".K00-KIS01:7" (One plug of emergency stop)
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Reconnect input ".K00-KIS01:7" • Press "Reset"
Test result yes/no	
Acceptance criteria	<ul style="list-style-type: none"> • Fault message is displayed on control panel <input style="width: 150px; height: 20px; border: 1px solid black; margin-left: 10px;" type="text"/>
	<ul style="list-style-type: none"> • Machine cannot be started as long as fault is active <input style="width: 150px; height: 20px; border: 1px solid black; margin-left: 10px;" type="text"/>
Comments	<input style="width: 800px; height: 150px; border: 1px solid black;" type="text"/>

Results comply	yes/no	Date/Initials
	<input style="width: 150px; height: 20px; border: 1px solid black;" type="text"/>	<input style="width: 650px; height: 20px; border: 1px solid black;" type="text"/>
Results approved	Date/Initials	
	<input style="width: 800px; height: 50px; border: 1px solid black;" type="text"/>	

10.17.4 FLT 30: MACHINE: WAS RACED BACKWARDS

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Turn handwheel backwards
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Fault message is displayed on control panel <input type="button" value=" "/>
	<ul style="list-style-type: none"> • Machine cannot be started as long as fault is active <input type="button" value=" "/>
Comments	<input type="button" value=" "/>

Results comply	yes/no	Date/Initials
	<input type="button" value=" "/>	<input type="button" value=" "/>
Results approved	Date/Initials	
	<input type="button" value=" "/>	

10.17.5 FLT 34: MACHINE: REPAIR SWITCH DRIVES SWITCHED OFF

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Switch off the repair switch
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Switch on the repair switch • Press "Reset"
Test result yes/no	
Acceptance criteria	<ul style="list-style-type: none"> • Fault message is displayed on control panel <input style="width: 150px; height: 20px; border: 1px solid black; margin-left: 10px;" type="text"/>
	<ul style="list-style-type: none"> • Machine cannot be started as long as fault is active <input style="width: 150px; height: 20px; border: 1px solid black; margin-left: 10px;" type="text"/>
Comments	<div style="border: 1px solid black; width: 100%; height: 100px; margin-top: 10px;"></div>

Results comply	yes/no	Date/Initials
	<input style="width: 100px; height: 20px; border: 1px solid black;" type="text"/>	<input style="width: 300px; height: 20px; border: 1px solid black;" type="text"/>
Results approved	Date/Initials	
	<input style="width: 300px; height: 20px; border: 1px solid black;" type="text"/>	

10.17.6 FLT 35: CONTROL CABINET: MONITORING MAIN SWITCH

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Switch off main switch and switch on immediately
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Fault message is displayed on control panel <input type="button" value=" "/>
	<ul style="list-style-type: none"> • Machine cannot be started as long as fault is active <input type="button" value=" "/>
Comments	<div style="border: 1px solid black; height: 100px; width: 100%;"></div>

Results comply	yes/no	Date/Initials
	<input type="button" value=" "/>	<input type="button" value=" "/>
Results approved	Date/Initials	
	<input type="button" value=" "/>	

10.17.7 FLT 41: CONTROL CABINET S2: OVERTEMPERATURE

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Adjust value of temperature controller (Control cabinet S2) "=CAR1.W00-B11" less than the actual temperature in the control cabinet
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Set temperature controller "=CAR1.W00-B11" back to previous value of 45 °C • Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Fault message is displayed on control panel
	<input type="button" value=" "/>
	<ul style="list-style-type: none"> • Machine cannot be started as long as fault is active
Comments	

Results comply	yes/no	Date/Initials
	<input type="button" value=" "/>	<input type="button" value=" "/>
Results approved	Date/Initials	
	<input type="button" value=" "/>	

10.17.8 FLT 42: CONTROL CABINET S1: OVERTEMPERATURE

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Adjust value of temperature controller (Control cabinet S1) "=CAR1.W00-B13" less than the actual temperature in the control cabinet
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Set temperature controller "=CAR1.W00-B13" back to previous value of 45 °C • Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Fault message is displayed on control panel
	<input type="button" value=" "/>
	<ul style="list-style-type: none"> • Machine cannot be started as long as fault is active
Comments	

Results comply	yes/no	Date/Initials
		<input type="button" value=" "/>
Results approved	Date/Initials	
	<input type="button" value=" "/>	

10.17.9 FLT 43: CONTROL CABINET: VOLTAGE MONITORING I IW00F2051 | IW00F3052 | IW00F3081 | IW00F3082 | IW00F3085 | IW00F3086 | **IW00F3087**

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Disconnect input “=CAR1.K00-KI06:9”
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • Depending on the disconnected input of each individual fuse the alarm text varied. Fault 43 is one number for different fuses.
Acknowledgement	<ul style="list-style-type: none"> • Reconnect input “=CAR1.K00-KI06:9” • Press “Reset”
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Fault message is displayed on control panel
	<input type="button" value=" "/>
	<ul style="list-style-type: none"> • Machine cannot be started as long as fault is active
Comments	

Results comply	yes/no	Date/Initials
	<input type="button" value=" "/>	<input type="button" value=" "/>
Results approved	Date/Initials	<input type="button" value=" "/>

10.17.10 FLT 45: CONTROL CABINET: UPS NOT READY

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Disconnect USB cable from UPS “=CAR1.K00-C02”
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Switch off the main switch and restart the machine • Press “Reset”
Test result yes/no	
Acceptance criteria	<ul style="list-style-type: none"> • Fault message is displayed on control panel <input style="width: 150px; height: 20px; border: 1px solid black; margin-left: 10px;" type="text"/>
	<ul style="list-style-type: none"> • Machine cannot be started as long as fault is active <input style="width: 150px; height: 20px; border: 1px solid black; margin-left: 10px;" type="text"/>
Comments	<input style="width: 800px; height: 150px; border: 1px solid black;" type="text"/>

Results comply	yes/no	Date/Initials
	<input style="width: 150px; height: 20px; border: 1px solid black;" type="text"/>	<input style="width: 300px; height: 20px; border: 1px solid black;" type="text"/>
Results approved	Date/Initials	
	<input style="width: 300px; height: 20px; border: 1px solid black;" type="text"/>	

10.17.11 FLT 327: LEAFLET: SENSOR MONITORING CROSS CHECK IN LEAFLET UNIT

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Cover sensor "=CAR1.A20-B02" • Press "Start"
Consequence	<ul style="list-style-type: none"> • Machine stops • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Uncover sensor "=CAR1.A20-B02" • Press "Reset"

Test result		yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Machine stops 	<input type="checkbox"/>
	<ul style="list-style-type: none"> • Fault message is displayed on control panel 	<input type="checkbox"/>
	<ul style="list-style-type: none"> • Machine cannot be started as long as fault is active 	<input type="checkbox"/>
Comments		

Results comply	yes/no	Date/Initials
	<input type="checkbox"/>	<input type="checkbox"/>
Results approved	Date/Initials	
	<input type="checkbox"/>	

10.17.12 FLT 77: MACHINE: FAULT MONITORING CONTACTORS DROPPED AWAY

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Disconnect input “CAR1.K00-Q11:A1”
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Reconnect input “CAR1.K00-Q11:A1” • Press “Reset”
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Fault message is displayed on control panel <input type="button" value=" "/>
	<ul style="list-style-type: none"> • Machine cannot be started as long as fault is active <input type="button" value=" "/>
Comments	<div style="border: 1px solid black; height: 100px; width: 100%;"></div>

Results comply	yes/no	Date/Initials
	<input type="button" value=" "/>	<input type="button" value=" "/>
Results approved	Date/Initials	
	<input type="button" value=" "/>	

10.18 FLT 79: LINE EMERGENCY STOP ACTUATED

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Press “EMERGENCY STOP” strike button of upstream machine / infeed
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Unlock “EMERGENCY STOP” strike button of upstream machine / infeed • Press “Reset”
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Fault message is displayed on control panel
	<input type="button" value=" "/>
	<ul style="list-style-type: none"> • Machine cannot be started as long as fault is active
Comments	

Results comply	yes/no	Date/Initials
	<input type="button" value=" "/>	<input type="button" value=" "/>
Results approved	Date/Initials	
	<input type="button" value=" "/>	

10.18.1 FLT 81: EMERGENCY STOP ACTUATED: OPERATING PANEL

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Press “EMERGENCY STOP” strike button at operating panel
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Unlock “EMERGENCY STOP” strike button at operating panel • Press “Reset”
Test result yes/no	
Acceptance criteria	<ul style="list-style-type: none"> • Fault message is displayed on control panel <input style="width: 150px; height: 20px; border: 1px solid black; margin-left: 10px;" type="text"/>
	<ul style="list-style-type: none"> • Machine cannot be started as long as fault is active <input style="width: 150px; height: 20px; border: 1px solid black; margin-left: 10px;" type="text"/>
Comments	<input style="width: 800px; height: 150px; border: 1px solid black;" type="text"/>

Results comply	yes/no	Date/Initials
	<input style="width: 150px; height: 20px; border: 1px solid black;" type="text"/>	<input style="width: 300px; height: 20px; border: 1px solid black;" type="text"/>
Results approved	Date/Initials	
	<input style="width: 300px; height: 20px; border: 1px solid black;" type="text"/>	

10.18.2 FLT 87: GUARD OPEN: CARTON BELT

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Open guard door front carton belt
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • Test can only be performed at standstill, because guard is locked while running
Acknowledgement	<ul style="list-style-type: none"> • Close guard door front carton belt • Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Fault message is displayed on control panel <input type="button" value=" "/>
	<ul style="list-style-type: none"> • Machine cannot be started as long as fault is active <input type="button" value=" "/>
Comments	<input type="button" value=" "/>

Results comply	yes/no	Date/Initials
	<input type="button" value=" "/>	<input type="button" value=" "/>
Results approved	Date/Initials	
	<input type="button" value=" "/>	

10.18.3 FLT 89: GUARD OPEN: DISCHARGE FRONT

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Open guard door discharge front
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • Test can only be performed at standstill, because guard is locked while running
Acknowledgement	<ul style="list-style-type: none"> • Close guard door discharge front • Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Fault message is displayed on control panel <input type="button" value=" "/>
	<ul style="list-style-type: none"> • Machine cannot be started as long as fault is active <input type="button" value=" "/>
Comments	<input type="button" value=" "/>

Results comply	yes/no	Date/Initials
	<input type="button" value=" "/>	<input type="button" value=" "/>
Results approved	Date/Initials	
	<input type="button" value=" "/>	

10.18.4 FLT 90: GUARD OPEN: CONTROL CABINET SWIVELED OFF LEFT

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Open guard door control cabinet rear left
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • Test can only be performed at standstill, because guard door is locked while running
Acknowledgement	<ul style="list-style-type: none"> • Close guard door control cabinet rear left • Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Fault message is displayed on control panel <input type="button" value=" "/>
	<ul style="list-style-type: none"> • Machine cannot be started as long as fault is active <input type="button" value=" "/>
Comments	<input type="button" value=" "/>

Results comply	yes/no	Date/Initials
	<input type="button" value=" "/>	<input type="button" value=" "/>
Results approved	Date/Initials	
	<input type="button" value=" "/>	

10.18.5 FLT 91: GUARD OPEN: CONTROL CABINET SWIVELED OFF RIGHT

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Open guard door control cabinet rear right
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • Test can only be performed at standstill, because guard door is locked while running
Acknowledgement	<ul style="list-style-type: none"> • Close guard door control cabinet rear right • Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Fault message is displayed on control panel <input type="button" value=" "/>
	<ul style="list-style-type: none"> • Machine cannot be started as long as fault is active <input type="button" value=" "/>
Comments	<input type="button" value=" "/>

Results comply	yes/no	Date/Initials
	<input type="button" value=" "/>	<input type="button" value=" "/>
Results approved	Date/Initials	
	<input type="button" value=" "/>	

10.18.6 FLT 96: GUARD OPEN: HANDWHEEL

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Open guard door handwheel
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • Test can only be performed at standstill, because guard is locked while running
Acknowledgement	<ul style="list-style-type: none"> • Close guard door handwheel • Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Fault message is displayed on control panel <input type="button" value=" "/>
	<ul style="list-style-type: none"> • Machine cannot be started as long as fault is active <input type="button" value=" "/>
Comments	<input type="button" value=" "/>

Results comply	yes/no	Date/Initials
	<input type="button" value=" "/>	<input type="button" value=" "/>
Results approved	Date/Initials	
	<input type="button" value=" "/>	

10.19 FLT 100: GUARD OPEN: PRODUCT CHAIN 1

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Open guard door product chain 1
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • Test can only be performed at standstill, because guard is locked while running
Acknowledgement	<ul style="list-style-type: none"> • Close guard door product chain 1 • Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

10.20 FLT 104: GUARD OPEN: INFEED

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Open guard door infeed front
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • Test can only be performed at standstill, because guard is locked while running
Acknowledgement	<ul style="list-style-type: none"> • Close guard door infeed front • Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

10.21 FLT 110: PRODUCT SENSING: CONSECUTIVE FAULT EXCESS HEIGHT

Test objective	<ul style="list-style-type: none"> Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> Machine is ready in automatic mode Prepare three inhalers which are too high Product is available
Required operations	<ul style="list-style-type: none"> Counter 131 "Product: consecutive fault sensing excess height" is set to 3 Press "Start" and call product Press "Stop" in front of sensor "=CAR1.B10-B02" Open guard door Put the three inhaler successively in front of "=CAR1.B10-B02" Close guard door Press "Reset" Press "Start"
Consequence	<ul style="list-style-type: none"> Machine stops Fault message is displayed on control panel Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> None
Acknowledgement	<ul style="list-style-type: none"> Remove the manipulated products Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> Machine stops <input type="checkbox"/> Fault message is displayed on control panel <input type="checkbox"/> Machine cannot be started as long as fault is active <input type="checkbox"/>
Comments	<input type="text"/>

Results comply	yes/no <input type="text"/>	Date/Initials <input type="text"/>
Results approved	Date/Initials <input type="text"/>	

10.21.1 FLT 112: PRODUCT SENSING: SENSOR MONITORING

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Cover sensor "=CAR1.B10-B01" permanently • Press "Start"
Consequence	<ul style="list-style-type: none"> • Machine stops • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Uncover sensor "=CAR1.B10-B01" • Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Machine stops • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

10.21.2 FLT 113: PRODUCT SENSING: SENSOR MONITORING EXCESS HEIGHT

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Cover sensor “=CAR1.B10-B02“ permanently • Press “Start”
Consequence	<ul style="list-style-type: none"> • Machine stops • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Uncover sensor “=CAR1.B10-B02“ • Press “Reset”
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Machine stops • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

10.22 FLT 120: INSERTION: SAFETY SENSOR

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Disconnect sensor “=CAR1.B36-B01” • Press “Start” with product
Consequence	<ul style="list-style-type: none"> • Machine stops • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Reconnect sensor “=CAR1.B36-B01” • Press “Reset”
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Machine stops • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

10.23 FLT 123: INSERTION: OVERLOAD

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Open guard door at insertion • Simulate overload at sensor “=CAR1.W40-B01“ (pull guide)
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Press “Reset”
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Fault message is displayed on control panel <input type="button" value=" "/>
	<ul style="list-style-type: none"> • Machine cannot be started as long as fault is active <input type="button" value=" "/>
Comments	<input type="text"/>

Results comply	yes/no	Date/Initials
	<input type="button" value=" "/>	<input type="button" value=" "/>
Results approved	Date/Initials	
	<input type="button" value=" "/>	

10.24 FLT 124: GUARD OPEN: SLIDE IN

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Open guard door slide in
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • Test can only be performed at standstill, because guard is locked while running
Acknowledgement	<ul style="list-style-type: none"> • Close guard door slide in • Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

10.24.1 FLT 129: INSERTION: MONITORING SENSOR SAFETY SENSOR

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Disconnect sensor “=CAR1.B36-B01”
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Reconnect sensor “=CAR1.B36-B01” • Press “Reset”
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Fault message is displayed on control panel <input type="button" value=" "/>
	<ul style="list-style-type: none"> • Machine cannot be started as long as fault is active <input type="button" value=" "/>
Comments	<div style="border: 1px solid black; height: 100px; width: 100%;"></div>

Results comply	yes/no	Date/Initials
	<input type="button" value=" "/>	<input type="button" value=" "/>
Results approved	Date/Initials	
	<input type="button" value=" "/>	

10.24.2 FLT 134: GUARD OPEN: BELOW SLIDE IN

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Open guard door below slide in
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • Test can only be performed at standstill, because guard door is locked while running
Acknowledgement	<ul style="list-style-type: none"> • Close guard door below slide in • Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Fault message is displayed on control panel <input type="button" value=" "/>
	<ul style="list-style-type: none"> • Machine cannot be started as long as fault is active <input type="button" value=" "/>
Comments	<input type="button" value=" "/>

Results comply	yes/no	Date/Initials
	<input type="button" value=" "/>	<input type="button" value=" "/>
Results approved	Date/Initials	
	<input type="button" value=" "/>	

10.24.3 FLT 200: MACHINE: JAM AT DISCHARGE

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Cover sensor "=CAR1.X85-B01"
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • Fault message is displayed after app. 2 seconds
Acknowledgement	<ul style="list-style-type: none"> • Uncover sensor "=CAR1.X85-B01" • Press "Reset"
Test result yes/no	
Acceptance criteria	<ul style="list-style-type: none"> • Fault message is displayed on control panel <input type="checkbox"/>
	<ul style="list-style-type: none"> • Machine cannot be started as long as fault is active <input type="checkbox"/>
Comments	<input type="text"/>

Results comply	yes/no	Date/Initials
	<input type="checkbox"/>	<input type="text"/>
Results approved	Date/Initials	
	<input type="text"/>	

10.24.4 FLT 201: DOWNSTREAM: STOP FROM MACHINE 1

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Activate SWSOPM 60 "Line mode downstream equipment" • Press "Start" • Press "Stop" at downstream machine
Consequence	<ul style="list-style-type: none"> • Machine stops (downstream machine and cartoning line) • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • Disconnect input "=.K00-KI08:10" to simulate the fault message if no downstream equipment is available • If required remove jumper
Acknowledgement	<ul style="list-style-type: none"> • Press "Start" at downstream machine • Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Machine stops • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

10.24.5 FLT 203: DOWNSTREAM: STOP FROM MACHINE 2

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Activate SWSOPM 60 "Line mode downstream equipment" • Press "Start" • Press "Stop" at downstream machine 2
Consequence	<ul style="list-style-type: none"> • Machine stops (downstream machine 2 and cartoning line) • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • Disconnect input "=.K00-KI08:11" to simulate the fault message if no downstream equipment is available • If required remove jumper
Acknowledgement	<ul style="list-style-type: none"> • Press "Start" at downstream machine • Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Machine stops <input type="checkbox"/>
	<ul style="list-style-type: none"> • Fault message is displayed on control panel <input type="checkbox"/>
	<ul style="list-style-type: none"> • Machine cannot be started as long as fault is active <input type="checkbox"/>
Comments	<div style="border: 1px solid black; height: 150px; width: 100%;"></div>

Results comply	yes/no	Date/Initials
		<input type="text"/>
Results approved	Date/Initials	
	<input type="text"/>	

10.24.6 FLT 210: GUARD OPEN: CARTON MAGAZINE

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Open guard door carton magazine
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • Test can only be performed at standstill, because guard is locked while running
Acknowledgement	<ul style="list-style-type: none"> • Close guard door carton magazine • Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Fault message is displayed on control panel <input type="button" value=" "/>
	<ul style="list-style-type: none"> • Machine cannot be started as long as fault is active <input type="button" value=" "/>
Comments	<input type="button" value=" "/>

Results comply	yes/no	Date/Initials
	<input type="button" value=" "/>	<input type="button" value=" "/>
Results approved	Date/Initials	
	<input type="button" value=" "/>	

10.24.7 FLT 212: GUARD OPEN: DISCHARGE TOP

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Open guard door discharge top
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • Test can only be performed at standstill, because guard is locked while running
Acknowledgement	<ul style="list-style-type: none"> • Close guard door discharge top • Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Fault message is displayed on control panel <input type="button" value=" "/>
	<ul style="list-style-type: none"> • Machine cannot be started as long as fault is active <input type="button" value=" "/>
Comments	<input type="button" value=" "/>

Results comply	yes/no	Date/Initials
	<input type="button" value=" "/>	<input type="button" value=" "/>
Results approved	Date/Initials	
	<input type="button" value=" "/>	

10.24.8 FLT 213: CARTON: OVERLOAD SIDE FLAP FOLDER

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Open guard door of cartoner • Simulate overload at sensor “=CAR1.B37-B01“ (pull guide)
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Press “Reset”
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Fault message is displayed on control panel <input type="button" value=" "/>
	<ul style="list-style-type: none"> • Machine cannot be started as long as fault is active <input type="button" value=" "/>
Comments	<div style="border: 1px solid black; height: 100px; width: 100%;"></div>

Results comply	yes/no	Date/Initials
	<input type="button" value=" "/>	<input type="button" value=" "/>
Results approved	Date/Initials	
	<input type="button" value=" "/>	

10.24.9 FLT 219: CARTON BELT: LOWER POSITION NOT REACHED

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Open guard door carton magazine top • Open guard door carton belt • Lift carton belt up ("=CAR1.W31-B53" is not activated)
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Lower carton belt • Close guard door carton magazine top • Close guard door carton belt • Press "Reset"

Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Fault message is displayed on control panel <input type="button" value=" "/>
	<ul style="list-style-type: none"> • Machine cannot be started as long as fault is active <input type="button" value=" "/>
Comments	<input type="text"/>

Results comply	yes/no	Date/Initials
	<input type="button" value=" "/>	<input type="text"/>
Results approved	Date/Initials	
	<input type="text"/>	

10.24.10 FLT 220: CARTON: STOCK AT THE END

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Empty carton magazine nearly to sensor “=CAR1.A30-B02”
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Fill up carton magazine • Press “Reset”
Test result yes/no	
Acceptance criteria	<ul style="list-style-type: none"> • Fault message is displayed on control panel <input style="width: 150px; height: 20px; border: 1px solid black; margin-left: 10px;" type="text"/>
	<ul style="list-style-type: none"> • Machine cannot be started as long as fault is active <input style="width: 150px; height: 20px; border: 1px solid black; margin-left: 10px;" type="text"/>
Comments	<input style="width: 800px; height: 150px; border: 1px solid black;" type="text"/>

Results comply	yes/no	Date/Initials
	<input style="width: 150px; height: 20px; border: 1px solid black;" type="text"/>	<input style="width: 300px; height: 20px; border: 1px solid black;" type="text"/>
Results approved	Date/Initials	
	<input style="width: 300px; height: 20px; border: 1px solid black;" type="text"/>	

10.24.11 FLT 221: MACHINE: COVER RAIL OPEN

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode • Guard doors are closed
Required operations	<ul style="list-style-type: none"> • Activate SWS 50 "Cover rail" and lift up the cover rail
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Lower cover rail • Deactivate SWS 50 "Cover rail" • Press „Reset“
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

10.24.12 FLT 222: CARTON: CONSECUTIVE FAULT CROSSCHECK

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode • Counter consecutive fault carton crosscheck is set to 3
Required operations	<ul style="list-style-type: none"> • Counter 210 "Carton: Fault cross check" is set to 3 • Counter 240 "Carton: Fault code reading" is set to 5 • Cover sensor "=CAR1.B32-B01" • Cover sensor "=CAR1.A30-B02" • Remove cartons from carton magazine in front of sensor "=CAR1.A30-B01" one after the other • Press "Start" with product
Consequence	<ul style="list-style-type: none"> • After 3 undetected cartons machine stops • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Uncover sensor "=CAR1.B32-B01" • Uncover sensor "=CAR1.A30-B02" • Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • After 3 undetected cartons machine stops • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	

Results comply	yes/no <input type="text"/>	Date/Initials <input type="text"/>
Results approved	Date/Initials <input type="text"/>	

10.24.13 FLT 223: CARTON: PICKUP CHECK

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in setup mode
Required operations	<ul style="list-style-type: none"> • Cover sensor “=CAR1.A30-B04” • Press “Start”
Consequence	<ul style="list-style-type: none"> • Machine stops • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Uncover sensor “=CAR1.A30-B04” • Press “Reset”
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Machine stops • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

10.24.14 FLT 224: CARTON BELT: OVERLOAD

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Switch off protective motor switch “=CAR1.W31-Q10”
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Switch on protective motor switch “=CAR1.W31-Q10” • Press “Reset”
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Fault message is displayed on control panel <input type="button" value=" "/>
	<ul style="list-style-type: none"> • Machine cannot be started as long as fault is active <input type="button" value=" "/>
Comments	<input type="button" value=" "/>

Results comply	yes/no	Date/Initials
	<input type="button" value=" "/>	<input type="button" value=" "/>
Results approved	Date/Initials	
	<input type="button" value=" "/>	

10.24.15 FLT 225: CARTON: CONSECUTIVE FAULT CODE READER

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode with product • Counter 240 "Carton: fault code reading" is set to 3
Required operations	<ul style="list-style-type: none"> • Place 3 cartons without or with wrong code in the carton magazine • Press "Start"
Consequence	<ul style="list-style-type: none"> • Machine stops • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Machine stops • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

10.25 FLT 226: CARTON:\ FAULT CODE READER

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode • SWS 200 "Code reader carton" is activated
Required operations	<ul style="list-style-type: none"> • Disconnect input "=.K00-KI04:12"
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Reconnect input "=.K00-KI04:12" • Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

10.25.1 FLT 227: CARTON: SENSOR MONITORING CROSSCHECK

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Cover sensor "=CAR1-A30-B01" • Run machine more than 1 cycle
Consequence	<ul style="list-style-type: none"> • Machine stops • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Uncover sensor "=CAR1-A30-B01" • Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Machine stops • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

10.25.2 FLT 230: GLUE UNIT: OPERATING TEMPERATURE NOT REACHED

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode • SWS 204 "Carton glueing" is activated
Required operations	<ul style="list-style-type: none"> • Switch off glue unit and wait app. five (5) minutes
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Switch on glue unit and wait until the required temperature is reached • Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

10.25.3 FLT 231: GLUE UNIT: DEVICE NOT READY

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode • SWS 204 "Carton glueing" is activated
Required operations	<ul style="list-style-type: none"> • Switch off glueing unit
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Switch on glueing unit • Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

10.25.4 FLT 232: GLUE LEVEL IS TOO LOW

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode • SWS 204 "Carton glueing" is activated
Required operations	<ul style="list-style-type: none"> • Simulate low glue in glueing device (run glue empty or connect 24V to input "=.K00-KI02:11") • Press "Start" and proceed one (1) carton in case of simulation
Consequence	<ul style="list-style-type: none"> • Machine stops • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • Machine stopps when teh carton is glued
Acknowledgement	<ul style="list-style-type: none"> • Fill up glue or reconnect 24V from input "=.K00-KI02:11" • Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Machine stops • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

10.25.5 FLT 233: GLUE STATION 1: CONSECUTIVE FAULT CARTON SENSING

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Disconnect sensor “CAR1.A43-B01” • Press “Start” and produce three (3) cartons
Consequence	<ul style="list-style-type: none"> • Machine stops • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Reconnect sensor • Press “Reset”
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Machine stops • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

10.25.6 FLT 235: GLUE STATION 1: SENSOR MONITORING CARTON SENSING

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode • SWS 204 "Carton glueing" is activated
Required operations	<ul style="list-style-type: none"> • Cover sensor "=CAR1.A43-B01" • Press "Start"
Consequence	<ul style="list-style-type: none"> • Machine stops • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Uncover sensor "=CAR1.A43-B01" • Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Machine stops • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

10.25.7 FLT 237: CARTON: SENSOR MONITORING PICKUP CHECK

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Cover sensor “=CAR1.A30-B04” • Put 24 V to input “=CAR1.K00-KI08:7” • Press “Start”
Consequence	<ul style="list-style-type: none"> • Machine stops • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Uncover sensor “=CAR1.A30-B04” • Remove the 24 V from input “=CAR1.K00-KI08:7” • Press “Reset”

Test result		yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Machine stops • Fault message is displayed on control panel • Machine cannot be started as long as fault is active 	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>
Comments		<div style="border: 1px solid black; height: 150px; width: 100%;"></div>

Results comply	yes/no	Date/Initials
	<input type="checkbox"/>	<input type="text"/>
Results approved	Date/Initials	
	<input type="text"/>	

10.25.8 FLT 250: CARTON EJECTION 1: OVERFILL COLLECTING CONTAINER

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Cover sensor "=CAR1.Q82-B03"
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Uncover sensor "=CAR1.Q82-B03" • Press "Reset"
Test result yes/no	
Acceptance criteria	<ul style="list-style-type: none"> • Fault message is displayed on control panel <input style="width: 150px; height: 20px; border: 1px solid black; margin-left: 10px;" type="text"/>
	<ul style="list-style-type: none"> • Machine cannot be started as long as fault is active <input style="width: 150px; height: 20px; border: 1px solid black; margin-left: 10px;" type="text"/>
Comments	<input style="width: 800px; height: 150px; border: 1px solid black;" type="text"/>

Results comply	yes/no	Date/Initials
	<input style="width: 150px; height: 20px; border: 1px solid black;" type="text"/>	<input style="width: 300px; height: 20px; border: 1px solid black;" type="text"/>
Results approved	Date/Initials	
	<input style="width: 300px; height: 20px; border: 1px solid black;" type="text"/>	

10.25.9 FLT 251: CARTON EJECTION 1: CROSS CHECK

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Cover sensor “=CAR1.Q82-B01“
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Uncover sensor “=CAR1.Q82-B01“ • Press “Reset”
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Fault message is displayed on control panel <input type="button" value=" "/>
	<ul style="list-style-type: none"> • Machine cannot be started as long as fault is active <input type="button" value=" "/>
Comments	<input type="text"/>

Results comply	yes/no	Date/Initials
	<input type="button" value=" "/>	<input type="button" value=" "/>
Results approved	Date/Initials	
	<input type="button" value=" "/>	

10.25.10 FLT 254: CARTON EJECTION 1: SENSOR MONITORING CROSS CHECK

Test objective	<ul style="list-style-type: none"> • Test whether correct warning message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Open guard door discharge top • Press "Start" • Disconnect sensor "=CAR1.Q82-B01"
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Reconnect sensor "=CAR1.Q82-B01" • Close guard door discharge top • Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

10.26 FLT 272: CARTON: OPEN FLAP: SENSOR MONITORING SIDE FLAP REAR

Test objective	<ul style="list-style-type: none"> • Test whether correct warning message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode • SWS 257 "Check carton open side flap" is activated
Required operations	<ul style="list-style-type: none"> • Disconnect sensor "=CAR1.B86-B03"
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Reconnect sensor "=CAR1.B86-B03" • Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

10.27 FLT 273: CARTON: OPEN FLAP: SENSOR MONITORING SIDE FLAP FRONT

Test objective	<ul style="list-style-type: none"> • Test whether correct warning message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode • SWS 275 "Check carton open side flap" is activated
Required operations	<ul style="list-style-type: none"> • Disconnect sensor "=CAR1.B86-B04"
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Reconnect sensor "=CAR1.B86-B04" • Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

10.28 FLT 294: CARTON: OPEN FLAP: CONSECUTIVE FAULT SIDE FLAP

Test objective	<ul style="list-style-type: none"> Test whether correct warning message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> Machine is ready in automatic mode Counter 257 "Carton: fault open flap side" is set to 1
Required operations	<ul style="list-style-type: none"> Place one carton with open side flap into machine Press "Start"
Consequence	<ul style="list-style-type: none"> Machine stops Fault message is displayed on control panel Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> None
Acknowledgement	<ul style="list-style-type: none"> Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> Machine stops Fault message is displayed on control panel Machine cannot be started as long as fault is active
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

10.28.1 FLT 301: LEAFLET: CONSECUTIVE FAULT CROSS CHECK IN PRODUCT CHAIN

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode • Product is available
Required operations	<ul style="list-style-type: none"> • Activate SWS 300 "Leaflet device" • Press "Start" with product until leaflet gripper chain is filled up • Press "Stop" • Open guard door leaflet device • Remove leaflet before sensor "=CAR1.X161-B10" • Close guard door leaflet device • Press "Reset" • Press "Start"
Consequence	<ul style="list-style-type: none"> • Machine stops • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Machine stops • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

10.28.2 FLT 302: LEAFLET: CROSS CHECK REJECT

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Cover sensor “=CAR1.X161-B12” • Press “Start”
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Uncover sensor “=CAR1.X161-B12” • Press “Reset”
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

10.28.3 FLT 304: LEAFLET: CONSECUTIVE FAULT CROSS CHECK IN UNIT

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode • Counter 310 "Leaflet: consecutive fault cross check in device" is set to 3
Required operations	<ul style="list-style-type: none"> • Activate SWS 300 "Leaflet device" • Remove a leaflet before sensor "=CAR1.X161-B11" • Press "Start" (with product, with cover plate)
Consequence	<ul style="list-style-type: none"> • Machine stops • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Press "Reset"

Test result		yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Machine stops 	<input type="checkbox"/>
	<ul style="list-style-type: none"> • Fault message is displayed on control panel 	<input type="checkbox"/>
	<ul style="list-style-type: none"> • Machine cannot be started as long as fault is active 	<input type="checkbox"/>
Comments		

Results comply	yes/no	Date/Initials
	<input type="checkbox"/>	<input type="checkbox"/>
Results approved	Date/Initials	
	<input type="checkbox"/>	

10.28.4 FLT 311: GUARD OPEN: LEAFLET UNIT TOP

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Open guard door leaflet unit top
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • Test can only be performed at standstill, because guard is locked while running
Acknowledgement	<ul style="list-style-type: none"> • Close guard door leaflet unit top • Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Fault message is displayed on control panel <input type="checkbox"/>
	<ul style="list-style-type: none"> • Machine cannot be started as long as fault is active <input type="checkbox"/>
Comments	<input type="text"/>

Results comply	yes/no	Date/Initials
	<input type="checkbox"/>	<input type="text"/>
Results approved	Date/Initials	
	<input type="text"/>	

10.28.5 FLT 312: GUARD OPEN: LEAFLET UNIT REAR

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Open guard door leaflet unit rear
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • Test can only be performed at standstill, because guard is locked while running
Acknowledgement	<ul style="list-style-type: none"> • Close guard door leaflet unit rear • Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Fault message is displayed on control panel <input type="button" value=" "/>
	<ul style="list-style-type: none"> • Machine cannot be started as long as fault is active <input type="button" value=" "/>
Comments	<input type="button" value=" "/>

Results comply	yes/no	Date/Initials
	<input type="button" value=" "/>	<input type="button" value=" "/>
Results approved	Date/Initials	
	<input type="button" value=" "/>	

10.28.6 FLT 321: LEAFLET: CONSECUTIVE FAULT CODE READER REAR

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode • Counter 302 "Leaflet: fault code reading rear" is set to 3
Required operations	<ul style="list-style-type: none"> • Prepare 3 leaflets with no or wrong code • Activate SWS 300 "Leaflet device" • Deactivate SWS 100 "Insert defective product" • Activate SWS 302 "Code reader leaflet rear" • Insert 3 leaflets with no or wrong code in leaflet stack • Press "Start" with product
Consequence	<ul style="list-style-type: none"> • Leaflets with wrong or missing code will be ejected • After 3 defective leaflets machine stops • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • To manipulate the code of the leaflet use a black felt-tip pen (e.g. Edding)
Acknowledgement	<ul style="list-style-type: none"> • Press "Reset"

Test result		yes/no
Acceptance criteria	• Leaflets with wrong / missing code will be ejected	<input type="checkbox"/>
	• After 3 defective leaflets machine stops	<input type="checkbox"/>
	• Fault message is displayed on control panel	<input type="checkbox"/>
	• Machine cannot be started as long as fault is active	<input type="checkbox"/>
Comments		
<input type="text"/>		

Results comply	yes/no <input type="checkbox"/>	Date/Initials <input type="text"/>
Results approved	Date/Initials <input type="text"/>	

10.28.7 FLT 322: LEAFLET: CONSECUTIVE FAULT CROSS CHECK IN CARTON

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode • Counter 315 "Leaflet: Fault cross check in carton" is set to 3
Required operations	<ul style="list-style-type: none"> • Activate SWS 300 "Leaflet device" • Activate SWS 303 "Check leaflet present" • Press "Start" with product • Press "Stop" before sensor "=CAR1.B75-B04" • Open guard door • Remove 3x leaflet before sensor "=CAR1.B75-B04" • Close guard door • Press "Reset" • Press "Start" with product
Consequence	<ul style="list-style-type: none"> • After 3 missing leaflets machine stops • Fault message is displayed on control panel • Machine cannot be started as long as fault is active • Cartons without leaflets will be ejected
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Press "Reset"

Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • After 3 missing leaflets machine stops • Fault message is displayed on control panel • Machine cannot be started as long as fault is active • Cartons without leaflets will be ejected
Comments	<div style="border: 1px solid black; height: 100px; width: 100%;"></div>

Results comply	yes/no <input type="checkbox"/>	Date/Initials <input type="text"/>
Results approved	Date/Initials <input type="text"/>	

10.28.8 FLT 325: LEAFLET: SENSOR MONITORING CROSS CHECK IN CARTON

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Cover sensor “=CAR1.B75-B04“ with a leaflet • Press “Start”
Consequence	<ul style="list-style-type: none"> • Machine stops • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Uncover sensor “=CAR1.B75-B04“ • Press “Reset”
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Machine stops • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

10.28.9 FLT 326: LEAFLET: SENSOR MONITORING CROSS CHECK IN PRODUCT CHAIN

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Cover sensor "=CAR1.X161-B10" • Press "Start"
Consequence	<ul style="list-style-type: none"> • Machine stops • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Uncover sensor "=CAR1.X161-B10" • Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Machine stops <input type="checkbox"/> • Fault message is displayed on control panel <input type="checkbox"/> • Machine cannot be started as long as fault is active <input type="checkbox"/>
Comments	<input type="text"/>

Results comply	yes/no <input type="checkbox"/>	Date/Initials <input type="text"/>
Results approved	Date/Initials <input type="text"/>	

10.28.10 FLT 327: LEAFLET: SENSOR MONITORING CROSS CHECK IN LEAFLET UNIT

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Cover sensor "=CAR1.X161-B11" • Press "Start"
Consequence	<ul style="list-style-type: none"> • Machine stops • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Uncover sensor "=CAR1.X161-B11" • Press "Reset"

Test result		yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Machine stops 	<input type="checkbox"/>
	<ul style="list-style-type: none"> • Fault message is displayed on control panel 	<input type="checkbox"/>
	<ul style="list-style-type: none"> • Machine cannot be started as long as fault is active 	<input type="checkbox"/>
Comments		

Results comply	yes/no	Date/Initials
	<input type="checkbox"/>	<input type="text"/>
Results approved	Date/Initials	
	<input type="text"/>	

10.28.11 FLT 347: LEAFLET: SENSOR MONITORING CODE READER REAR

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Put 24 V to input “=CAR1.K00-KI001:4“ permanently
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Remove 24 V from input “=CAR1.K00-KI001:4“ • Press “Reset”
Test result	yes/no
	<ul style="list-style-type: none"> • Fault message is displayed on control panel <input type="button" value=" "/>
	<ul style="list-style-type: none"> • Machine cannot be started as long as fault is active <input type="button" value=" "/>
Comments	<div style="border: 1px solid black; height: 100px; width: 100%;"></div>

Results comply	yes/no	Date/Initials
	<input type="button" value=" "/>	<input type="button" value=" "/>
Results approved	Date/Initials	
	<input type="button" value=" "/>	

10.29 FLT 410: ROBOT: GUARD OPEN: BELT 1

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Open guard door robot belt 1
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • Test can only be performed at standstill, because guard is locked while running
Acknowledgement	<ul style="list-style-type: none"> • Close guard door robot belt 1 • Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

10.30 FLT 412: ROBOT: EMERGENCY STOP FRONT ACTUATED

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode • SWSOPM 63 "Line mode upstream equipment" is activated
Required operations	<ul style="list-style-type: none"> • Activate SWS 400 "Robot" • Press "Emergency stop" front at robot
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Enable "Emergency stop" front at robot • Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

10.31 FLT 414: ROBOT: GUARD OPEN: PRODUCT CHAIN

Test objective	<ul style="list-style-type: none"> Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> Activate SWS 400 "Robot" Open guard door at robot product chain
Consequence	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> Test can only be performed at standstill, because guard is locked while running
Acknowledgement	<ul style="list-style-type: none"> Close guard door at robot product chain Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

10.32 FLT 417: ROBOT: GUARD OPEN: TURN AROUND PRODUCT CHAIN

Test objective	<ul style="list-style-type: none"> Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> Activate SWS 400 "Robot" Open guard door at robot turn around product chain
Consequence	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> Test can only be performed at standstill, because guard is locked while running
Acknowledgement	<ul style="list-style-type: none"> Close guard door at robot turn around product chain Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

10.33 FLT 421: ROBOT: GUARD OPEN: FRONT LEFT

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Activate SWS 400 "Robot" • Open guard door robot front left
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • Test can only be performed at standstill, because guard is locked while running
Acknowledgement	<ul style="list-style-type: none"> • Close guard door robot front left • Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Fault message is displayed on control panel

	<ul style="list-style-type: none"> • Machine cannot be started as long as fault is active
Comments	

Results comply	yes/no	Date/Initials
	_____	_____
Results approved	Date/Initials	

10.34 FLT 422: ROBOT: GUARD OPEN: FRONT RIGHT

Test objective	<ul style="list-style-type: none"> Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> Activate SWS 400 "Robot" Open guard door robot front right
Consequence	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> Test can only be performed at standstill, because guard is locked while running
Acknowledgement	<ul style="list-style-type: none"> Close guard door robot front right Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

10.35 FLT 436: ROBOT: GUARD OPEN: CYCLE BELT

Test objective	<ul style="list-style-type: none"> Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> Activate SWS 400 "Robot" Open guard door at robot cycle belt
Consequence	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> Test can only be performed at standstill, because guard is locked while running
Acknowledgement	<ul style="list-style-type: none"> Close guard door at robot cycle belt Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

10.36 FLT 457: ROBOT: MONITORING COMPRESSED AIR

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Activate SWS 400 "Robot" • Disconnect sensor "CAR1.W150-B80"
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • Observe without fail! Guard door is open!
Acknowledgement	<ul style="list-style-type: none"> • Reconnect sensor "CAR1.W150-B80" • Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Fault message is displayed on control panel
	<input type="button" value=" "/>
	<ul style="list-style-type: none"> • Machine cannot be started as long as fault is active
Comments	

Results comply	yes/no	Date/Initials
	<input type="button" value=" "/>	<input type="button" value=" "/>
Results approved	Date/Initials	
	<input type="button" value=" "/>	

10.36.1 FLT 477: ROBOT: CONTROL CABINET OVERTEMPERATURE

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Adjust value of temperature controller "=CAR1.W150-B19" less than the actual temperature in the control cabinet
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Set temperature controller "=CAR1.W150-B19" back to previous value of 45 °C • Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Fault message is displayed on control panel
	<input type="button" value=" "/>
	<ul style="list-style-type: none"> • Machine cannot be started as long as fault is active
Comments	

Results comply	yes/no	Date/Initials
	<input type="button" value=" "/>	<input type="button" value=" "/>
Results approved	Date/Initials	
	<input type="button" value=" "/>	

10.37 FLT 512: INFEED: EMERGENCY STOP FRONT ACTUATED

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Press “Emergency stop” at infeed front
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Enable “Emergency stop” at infeed front • Press “Reset”
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

10.38 FLT 517: INFEED: GUARD OPEN

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Open guard door (cover overhead conveyor)
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • Test can only be performed at standstill, because guard is locked while running
Acknowledgement	<ul style="list-style-type: none"> • Close guard door (cover overhead conveyor) • Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

10.39 FLT 530: INFEED: BELT 1: OVERLOAD

Test objective	<ul style="list-style-type: none"> Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> Switch off protective motor switch "W257-Q50"
Consequence	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> None
Acknowledgement	<ul style="list-style-type: none"> Switch on protective motor switch "W257-Q50" Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

10.40 FLT 541: INFEED: BELT 1: FAULT

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode • SWS 500 "Infeed" is activated • Inhaler is selected as product
Required operations	<ul style="list-style-type: none"> • Press "Start" • Switch off protective motor switch "W257-Q50"
Consequence	<ul style="list-style-type: none"> • Machine stops • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Switch on protective motor switch "W257-Q50" • Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Machine stops • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

10.4.1 FLT 551: INFEED: BELT 1: PRODUCT JAM

Test objective	<ul style="list-style-type: none"> Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> Machine is ready in automatic mode SWS 500 "Infeed" is activated Inhaler is selected as product
Required operations	<ul style="list-style-type: none"> Cover sensor "W257-B60" (e.g. with a tape) Press "Start"
Consequence	<ul style="list-style-type: none"> Machine stops Fault message is displayed on control panel Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> None
Acknowledgement	<ul style="list-style-type: none"> Uncover sensor "W257-B60" Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> Machine stops Fault message is displayed on control panel Machine cannot be started as long as fault is active
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

10.42 FLT 850: LEAFLET: NO ERROR CODE ACTIVE

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode • SWS 500 “Infeed” is activated
Required operations	<ul style="list-style-type: none"> • Disconnect input “=CAR1.K00-KIS004:2”
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Reconnect input “=CAR1.K00-KIS004:2” • Press “Reset”
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Fault message is displayed on control panel
	<input type="button" value=" "/>
	<ul style="list-style-type: none"> • Machine cannot be started as long as fault is active
Comments	

Results comply	yes/no	Date/Initials
	<input type="button" value=" "/>	<input type="button" value=" "/>
Results approved	Date/Initials	
	<input type="button" value=" "/>	

10.43 FLT 851: LEAFLET: TURRET: NO ERROR CODE ACTIVE

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode • SWS 500 "Infeed" is activated
Required operations	<ul style="list-style-type: none"> • Disconnect input "=CAR1.K00-KIS004:2"
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Reconnect input "=CAR1.K00-KIS004:2" • Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

10.44 FLT 852: LEAFLET: OPC-UA TIMEOUT COMMUNICATION

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode • SWS 500 “Infeed” is activated • Line is ready for production
Required operations	<ul style="list-style-type: none"> • Switch off the main switch at the leaflet feeder • Press “Start”
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Switch on the main switch at the leaflet feeder • Press “Reset”
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

10.45 FLT 853: LEAFLET: TURRET: OPC-UA TIMEOUT COMMUNICATION

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode • SWS 500 "Infeed" is activated • Line is ready for production
Required operations	<ul style="list-style-type: none"> • Switch off the main switch at the turret of leaflet feeder • Press "Start"
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Switch on the main switch at the turret of leaflet feeder • Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

10.45.1 FLT 1212: GUARD OPEN: COLLECTING CONTAINER 1

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Open guard door "Guard ejector" (=CAR1.Q82-B802) but not completely • Remove collecting box
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • Sensor "=CAR1.Q82-B801" must not be covered
Acknowledgement	<ul style="list-style-type: none"> • Put back the collecting box • Close guard door "Guard ejector" (=CAR1.Q82-B802) complete • Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

10.45.2 FLT 1213: CARTON EJECTION 1: OVERFILL GUARD COLLECTING CONTAINER

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode • Counter 214 for "Carton ejection 1: Overfill guard collecting container" is set to one (1)
Required operations	<ul style="list-style-type: none"> • Create 1 defective item (e. g. incorrect code) • Open guard door "=CAR1.Q82-B802" (Open and move the guard into a position so that sensor "=CAR1.Q82-B802" is not covered) • Close the opening below the ejection and above the collecting bin with sliding guard • Remove the collecting box • Press "Start"
Consequence	<ul style="list-style-type: none"> • Machine stops • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Remove packaged product and close the sliding guard so that the packaged product is able to drop into the collecting box • Close guard door • Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Machine stops • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	

Results comply	yes/no <input type="text"/>	Date/Initials <input type="text"/>
Results approved	Date/Initials <input type="text"/>	

10.45.3 FLT 1219: CARTON BELT: UPPER POSITION NOT REACHED

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Lift up carton belt not completely
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • Guard carton belt and guard carton magazine must be open
Acknowledgement	<ul style="list-style-type: none"> • Move the carton belt to the original position • Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Fault message is displayed on control panel <input type="button" value=" "/>
	<ul style="list-style-type: none"> • Machine cannot be started as long as fault is active <input type="button" value=" "/>
Comments	<input type="text"/>

Results comply	yes/no	Date/Initials
	<input type="button" value=" "/>	<input type="button" value=" "/>
Results approved	Date/Initials	
	<input type="button" value=" "/>	

10.45.4 FLT 1220: CARTON BELT: MONITORING CHECK VALVE 1V3

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Disconnect input “=CAR1.K00-KI16:15”
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Reconnect input “=CAR1.K00-KI16:15” • Press “Reset”
Test result yes/no	
Acceptance criteria	<ul style="list-style-type: none"> • Fault message is displayed on control panel <input style="width: 150px; height: 20px; border: 1px solid black; margin-left: 10px;" type="text"/>
	<ul style="list-style-type: none"> • Machine cannot be started as long as fault is active <input style="width: 150px; height: 20px; border: 1px solid black; margin-left: 10px;" type="text"/>
Comments	<div style="border: 1px solid black; width: 100%; height: 100px; margin-top: 10px;"></div>

Results comply	yes/no	Date/Initials
	<input style="width: 150px; height: 20px; border: 1px solid black;" type="text"/>	<input style="width: 300px; height: 20px; border: 1px solid black;" type="text"/>
Results approved	Date/Initials	
	<input style="width: 300px; height: 20px; border: 1px solid black;" type="text"/>	

10.45.5 FLT 1221: CARTON BELT: MONITORING CHECK VALVE 1V4

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Disconnect input “=CAR1.K00-KI16:16”
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Reconnect input “=CAR1.K00-KI16:16” • Press “Reset”
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Fault message is displayed on control panel <input type="button" value=" "/>
	<ul style="list-style-type: none"> • Machine cannot be started as long as fault is active <input type="button" value=" "/>
Comments	<input type="button" value=" "/>

Results comply	yes/no	Date/Initials
	<input type="button" value=" "/>	<input type="button" value=" "/>
Results approved	Date/Initials	
	<input type="button" value=" "/>	

10.46 FLT 1246: CARTON: SENSOR MONITORING CHECK CODE

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Activate SWS 200: "Code reader carton" • Switch off machine (main switch) • Disconnect sensor "=CAR1.B75-B01" • Switch on main switch
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Reconnect sensor "=CAR1.B75-B01" • Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

10.47 FLT 1248: CARTON: OPEN FLAP: SENSOR MONITORING FOURTH FLAP

Test objective	<ul style="list-style-type: none"> Test whether correct warning message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> Activate SWS 257 "Check carton open fourth flap" Cover sensor "=CAR1.B86-B05" Press "Start"
Consequence	<ul style="list-style-type: none"> Machine stops Fault message is displayed on control panel Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> None
Acknowledgement	<ul style="list-style-type: none"> Uncover sensor "=CAR1.B86-B05" Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> Machine stops Fault message is displayed on control panel Machine cannot be started as long as fault is active
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

10.48 FLT 1249: CARTON: OPEN FLAP: CONSECUTIVE FAULT FOURTH FLAP

Test objective	<ul style="list-style-type: none"> Test whether correct warning message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> Machine is ready in automatic mode Counter 258 "Carton: fault open flap fourth" is set to 1
Required operations	<ul style="list-style-type: none"> Place one carton with open fourth flap into machine Press "Start"
Consequence	<ul style="list-style-type: none"> Machine stops Fault message is displayed on control panel Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> None
Acknowledgement	<ul style="list-style-type: none"> Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> Machine stops Fault message is displayed on control panel Machine cannot be started as long as fault is active
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

10.49 FLT 1416: ROBOT: EMERGENCY STOP REAR ACTUATED

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode • SWSOPM 63 "Line mode upstream equipment" is activated
Required operations	<ul style="list-style-type: none"> • Activate SWS 400 "Robot" • Press "Emergency stop" rear at robot
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Enable "Emergency stop" rear at robot • Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Fault message is displayed on control panel
	<input type="button" value=" "/>
	<ul style="list-style-type: none"> • Machine cannot be started as long as fault is active
Comments	

Results comply	yes/no	Date/Initials
	<input type="button" value=" "/>	<input type="button" value=" "/>
Results approved	Date/Initials	
	<input type="button" value=" "/>	

10.50 FLT 1417: ROBOT: GUARD OPEN: REAR LEFT

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Activate SWS 400 "Robot" • Open guard door robot rear left
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • Test can only be performed at standstill, because guard is locked while running
Acknowledgement	<ul style="list-style-type: none"> • Close guard door robot rear left • Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

10.51 FLT 1419: ROBOT: RANGE LIMIT REACHED

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Activate SWS 400 "Robot" • Turn safety switch "Stop break" (=CAR1.W150-S20) to position "1" • Move the robot arm outside the operational limit by hand manually • Turn safety switch "Stop break" (=CAR1.W150-S20) to position "0" • Close the guard doors from robot • Press "Reset"
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Move the robot arm to the initial position by hand manually • Press "Reset"

Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Fault message is displayed on control panel <input type="button" value=" "/>
	<ul style="list-style-type: none"> • Machine cannot be started as long as fault is active <input type="button" value=" "/>
Comments	<input type="text"/>

Results comply	yes/no	Date/Initials
	<input type="button" value=" "/>	<input type="button" value=" "/>
Results approved	Date/Initials	
	<input type="button" value=" "/>	

10.52 FLT 1433: ROBOT: VACUUM MONITOR: SUCTION CUP 1

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Activate SWS 400 "Robot" • Switch off ejector "=CAR1.W150-Q30" • Press "Start"
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Switch on ejector "=CAR1.W150-Q30" • Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Fault message is displayed on control panel <input type="checkbox"/>
	<ul style="list-style-type: none"> • Machine cannot be started as long as fault is active <input type="checkbox"/>
Comments	<div style="border: 1px solid black; height: 100px; width: 100%;"></div>

Results comply	yes/no	Date/Initials
	<input type="checkbox"/>	<input type="text"/>
Results approved	Date/Initials	
	<input type="text"/>	

10.53 FLT 1434: ROBOT: VACUUM MONITOR: SUCTION CUP 2

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Activate SWS 400 "Robot" • Switch off ejector "=CAR1.W150-Q31" • Press "Start"
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Switch on ejector "=CAR1.W150-Q31" • Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Fault message is displayed on control panel
	<input type="checkbox"/>
	<ul style="list-style-type: none"> • Machine cannot be started as long as fault is active
Comments	

Results comply	yes/no	Date/Initials
	<input type="checkbox"/>	<input type="text"/>
Results approved	Date/Initials	
	<input type="text"/>	

10.54 FLT 1435: ROBOT: VACUUM MONITOR: SUCTION CUP 3

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Activate SWS 400 "Robot" • Switch off ejector "=CAR1.W150-Q32" • Press "Start"
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Switch on ejector "=CAR1.W150-Q32" • Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Fault message is displayed on control panel <input type="checkbox"/>
	<ul style="list-style-type: none"> • Machine cannot be started as long as fault is active <input type="checkbox"/>
Comments	<input type="text"/>

Results comply	yes/no	Date/Initials
	<input type="checkbox"/>	<input type="text"/>
Results approved	Date/Initials	
	<input type="text"/>	

10.54.1 FLT 1530: INFEED: BELT 1: PRODUCT REJECT (INHALER): BIN OVERFILL

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Cover sensor "=CAR1.W257-B62"
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Uncover sensor "=CAR1.W257-B62" • Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Fault message is displayed on control panel <input type="button" value=" "/>
	<ul style="list-style-type: none"> • Machine cannot be started as long as fault is active <input type="button" value=" "/>
Comments	<div style="border: 1px solid black; height: 100px; width: 100%;"></div>

Results comply	yes/no	Date/Initials
	<input type="button" value=" "/>	<input type="button" value=" "/>
Results approved	Date/Initials	
	<input type="button" value=" "/>	

10.54.2 FLT 1531: INFEED: BELT 1: PRODUCT REJECT (INHALER): CROSS CHECK

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Cover sensor "=CAR1.W257-B01" • Insert a fail product into the infeed belt 1 (e.g. wrong position of inhaler) • Remove air pressure connection so that the inhaler can not be rejected • Press "Start"
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Uncover sensor "=CAR1.W257-B01" • Reconnect the air pressure • Press "Reset"

Test result		yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active 	<input type="text"/> <input type="text"/>
Comments	<input type="text"/>	

Results comply	yes/no	Date/Initials
	<input type="text"/>	<input type="text"/>
Results approved	Date/Initials	
	<input type="text"/>	

10.55 FLT 1543: INFEED: CONTROL CABINET: VOLTAGE MONITORING
IW257_F3084 | IW257_F3090

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Switch off fuse “=CAR1.W257-F3052”
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Switch on fuse “=CAR1.W257-F3052” • Press “Reset”
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

10.56 FLT 2004: INFEED: OVERHEAD CONVEYOR NOT IN LOWER POSITION

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode • Inhaler is selected as product
Required operations	<ul style="list-style-type: none"> • Activate SWS 500 "Infeed" • Lift up the overhead conveyor slightly • Press "Reset"
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Lift the overhead conveyor down to the initial position • Press "Reset"

Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

10.57 FLT 2005: CARTON REJECT 1: CROSS CHECK CARTON REJECTED

Test objective	<ul style="list-style-type: none"> Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> Machine is ready in automatic mode Prepare carton ejection that sensor will not detect ejected carton (e.g. put a metal sheet above sensor that carton will fall besides sensor)
Required operations	<ul style="list-style-type: none"> Simulate a manipulated carton (e.g. Carton with wrong code) Press "Start"
Consequence	<ul style="list-style-type: none"> Carton is ejected but sensor "=CAR1.Q82-B10" does not see ejected carton Machine stops Fault message is displayed on control panel Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> None
Acknowledgement	<ul style="list-style-type: none"> Press "Reset"

Test result		yes/no
Acceptance criteria	<ul style="list-style-type: none"> Machine stops Fault message is displayed on control panel Machine cannot be started as long as fault is active 	<input type="button" value=" "/>
Comments		<input type="button" value=" "/>

Results comply	yes/no	Date/Initials
	<input type="button" value=" "/>	<input type="button" value=" "/>
Results approved	Date/Initials	
	<input type="button" value=" "/>	

10.58 FLT 2006: CARTON REJECT 1: SENSOR MONITORING CROSS CHECK CARTON REJECTED

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Disconnect sensor “=CAR1.Q82-B10”
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Reconnect sensor “=CAR1.Q82-B10” • Press “Reset”
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Fault message is displayed on control panel
	<input type="button" value=" "/>
	<ul style="list-style-type: none"> • Machine cannot be started as long as fault is active
Comments	<input type="text"/>

Results comply	yes/no	Date/Initials
	<input type="button" value=" "/>	<input type="button" value=" "/>
Results approved	Date/Initials	
	<input type="button" value=" "/>	

10.59 FLT 2007: INFEED: CONSECUTIVE FAULT CHECK POSITION INHALER

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Check if counter 2003 "Infeed: Fault check position inhaler" is set to 1 • Turn one inhaler in wrong position before infeed • Press "Start"
Consequence	<ul style="list-style-type: none"> • Machine stops • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Machine stops
	<input type="checkbox"/>
	<ul style="list-style-type: none"> • Fault message is displayed on control panel
	<input type="checkbox"/>
	<ul style="list-style-type: none"> • Machine cannot be started as long as fault is active
Comments	

Results comply	yes/no	Date/Initials
	<input type="checkbox"/>	<input type="text"/>
Results approved	Date/Initials	
	<input type="text"/>	

10.60 FLT 2008: INFEED: CHECK POSITION INHALER: DEVICE NOT READY

Test objective	<ul style="list-style-type: none"> Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> Activate SWS 2005 "Infeed: Check position inhaler" Disconnect camera "position check inhaler"
Consequence	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> None
Acknowledgement	<ul style="list-style-type: none"> Reconnect camera "position check inhaler" Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

10.61 FLT 2009: INFEED: CHECK POSITION INHALER: SENSOR MONITORING

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Activate SWS 2005 "Infeed: Check position inhaler" • Switch off machine (main switch) • Disconnect sensor "=CAR1.B75-A15" • Switch on machine (main switch)
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Reconnect sensor "=CAR1.B75-A15" • Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

10.62 FLT 2016: INFEED: CROSS CHECK EJECT BELT 1 (INHALER): SENSOR MONITORING

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode • Inhaler is selected as product
Required operations	<ul style="list-style-type: none"> • Disconnect sensor “=CAR1.W257-B01”
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Reconnect sensor “=CAR1.W257-B01” • Press “Reset”
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

10.63 FLT 2018: INFEED: SENSING PRODUCT (INHALER): SENSOR MONITORING

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode • Inhaler is selected as product
Required operations	<ul style="list-style-type: none"> • Disconnect sensor “=CAR1.W257-B05”
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Reconnect sensor “=CAR1.W257-B05” • Press “Reset”
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

10.64 FLT 2024: INFEED: OVERHEAD CONVEYOR NOT IN UPPER POSITION

Test objective	<ul style="list-style-type: none"> Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> Machine is ready in automatic mode Inhaler is selected as product
Required operations	<ul style="list-style-type: none"> Activate SWS 500 "Infeed" Lift down the overhead conveyor slightly Press "Reset"
Consequence	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> None
Acknowledgement	<ul style="list-style-type: none"> Lift the overhead conveyor up to the initial position Press "Reset"

Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

10.65 FLT 2024: INFEED: OVERHEAD CONVEYOR NOT IN UPPER POSITION

Test objective	<ul style="list-style-type: none"> Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> Machine is ready in automatic mode Inhaler is selected as product SWS 500 "Infeed" is activated
Required operations	<ul style="list-style-type: none"> Disconnect input "=.W257-KI00:16"
Consequence	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> None
Acknowledgement	<ul style="list-style-type: none"> Reconnect input "=.W257-KI00:16" Press "Reset"
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> Fault message is displayed on control panel Machine cannot be started as long as fault is active
Comments	

Results comply	yes/no	Date/Initials
Results approved	Date/Initials	

10.65.1 FLT 2025: INFEED: OVERHEAD CONVEYOR: MONITORING CHECK VALVE 1V21

Test objective	<ul style="list-style-type: none"> • Test whether correct fault message is displayed on control panel
Test procedure	
Test prerequisites	<ul style="list-style-type: none"> • Machine is ready in automatic mode
Required operations	<ul style="list-style-type: none"> • Disconnect input “=CAR1.W257-KI02:1”
Consequence	<ul style="list-style-type: none"> • Fault message is displayed on control panel • Machine cannot be started as long as fault is active
Comments	<ul style="list-style-type: none"> • None
Acknowledgement	<ul style="list-style-type: none"> • Reconnect input “=CAR1.W257-KI02:1” • Press “Reset”
Test result	yes/no
Acceptance criteria	<ul style="list-style-type: none"> • Fault message is displayed on control panel <input type="button" value=" "/>
	<ul style="list-style-type: none"> • Machine cannot be started as long as fault is active <input type="button" value=" "/>
Comments	<input type="text"/>

Results comply	yes/no	Date/Initials
	<input type="button" value=" "/>	<input type="button" value=" "/>
Results approved	Date/Initials	
	<input type="button" value=" "/>	

11 Notes

Alarm and Function Testing Report

CUK 2060

Cartoning machine

752937

**Glaxo Wellcome Production
France**

Alarm and Function Testing Report approval by RPP (after execution)

Function	Name	Position/Company	Signature	Date
Approved by				
Approved by				

The AFT was performed in _____ from _____ until _____.

Summary result	yes/no
The test execution has shown that, ...	
the AFT has been completed successfully without deviations.	

the AFT has been performed with deviations. A deviation report has been created and follow up actions have been defined.

Final conclusion	yes/no
The next qualification step can be started.	
Before starting the next qualification step, the deviations must be closed.	

Alarm and Function Testing Report approval by Glaxo Wellcome Production (after execution)

Function	Name	Position/Company	Signature	Date
Approved by				
Approved by				
Approved by				

Document history:

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Rev.	Date	Description	Author