

Square Pharmaceuticals Ltd.

Production Batch Report

User Name: Pika

Printed Date: 13/8/2020 0:00:00

Product Information

Recipe No.: 12
Product Name: Test Product
Batch No.: AB12583

Production Summary

Time Information

Starting Time: 13/8/2020 0:00:00

End Time: 13/8/2020 0:00:00

Vial Produced

Total: 100 Pcs

Good: 99 Pcs

Rejected: 1 Pcs

Over Weight: 0 Pcs

Under Weight: 0 Pcs

No Plug: 0 Pcs

No Cap: 0 Pcs

Empty Reject: 0 Pcs

Weight

	Empty Weight	Filled Weight	Filling Weight	Filling Time
Max.	7.950 g	7.950 g	7.950 g	1.553 sec
Average	7.900 g	7.900 g	7.900 g	1.543 sec
Min.	7.800 g	7.800 g	7.800 g	1.533 sec
SD	1.000 g	1.000 g	1.000 g	1.003 sec

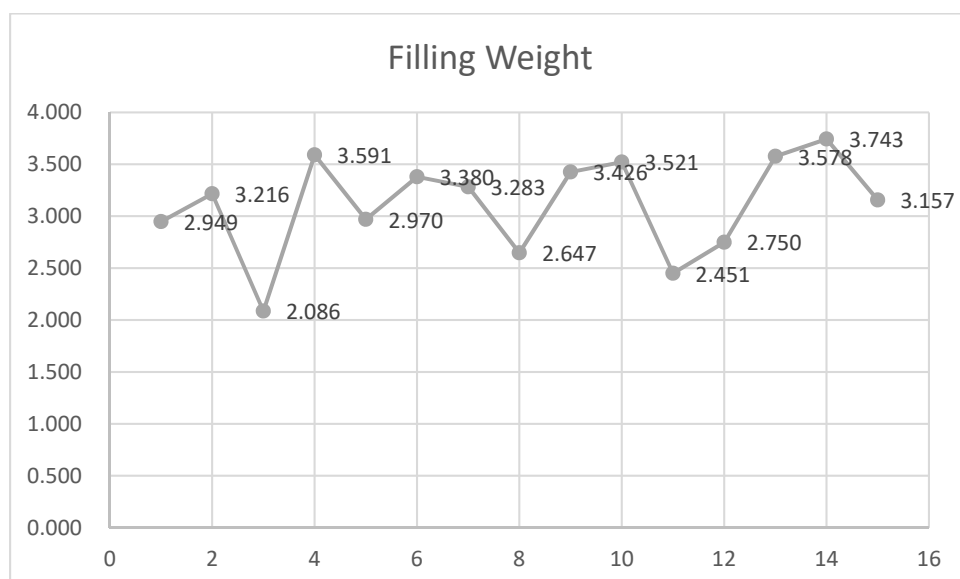
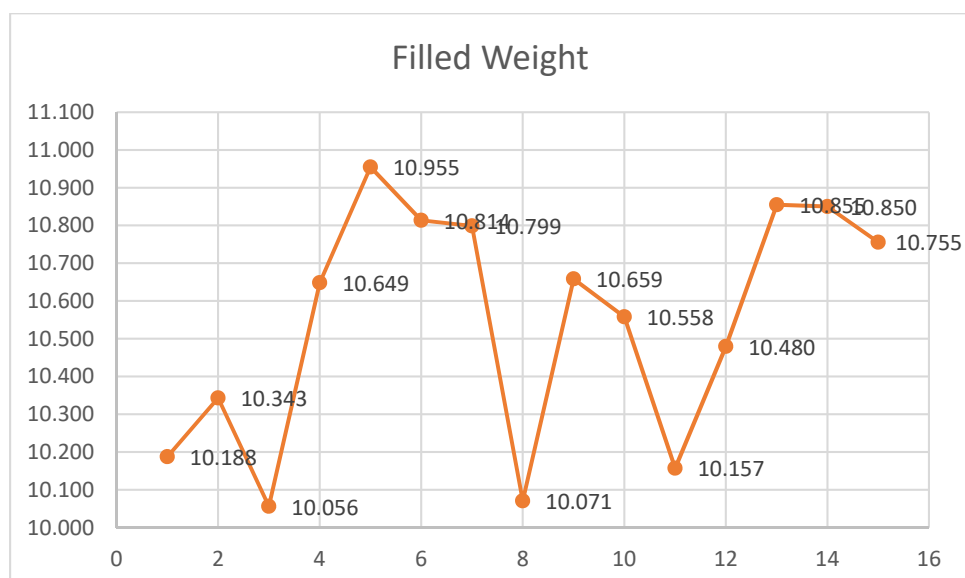
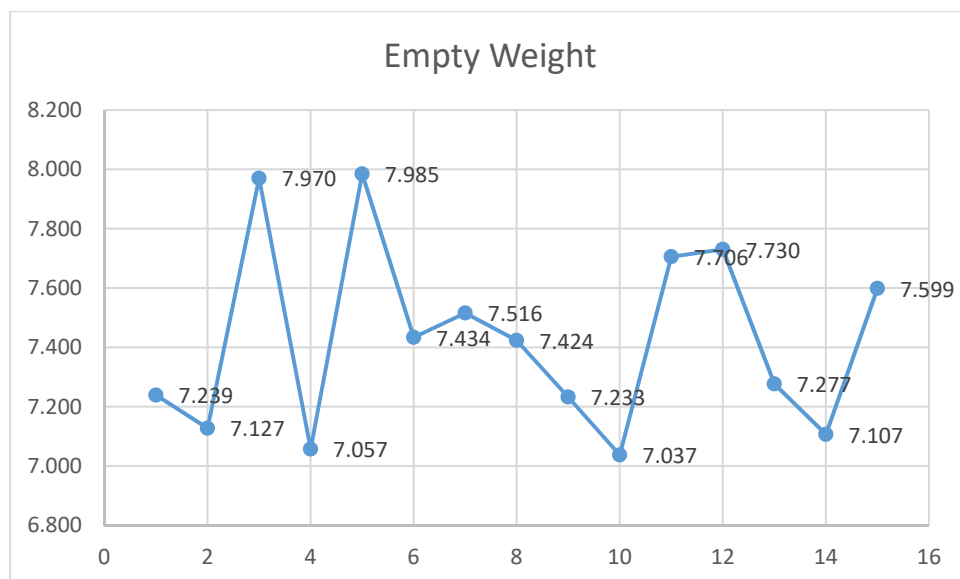
	Filling Weight
Hi Limit	8.033 g
Target Weight	7.633 g
Lo Limit	7.033 g
Sampling Time	2 sec

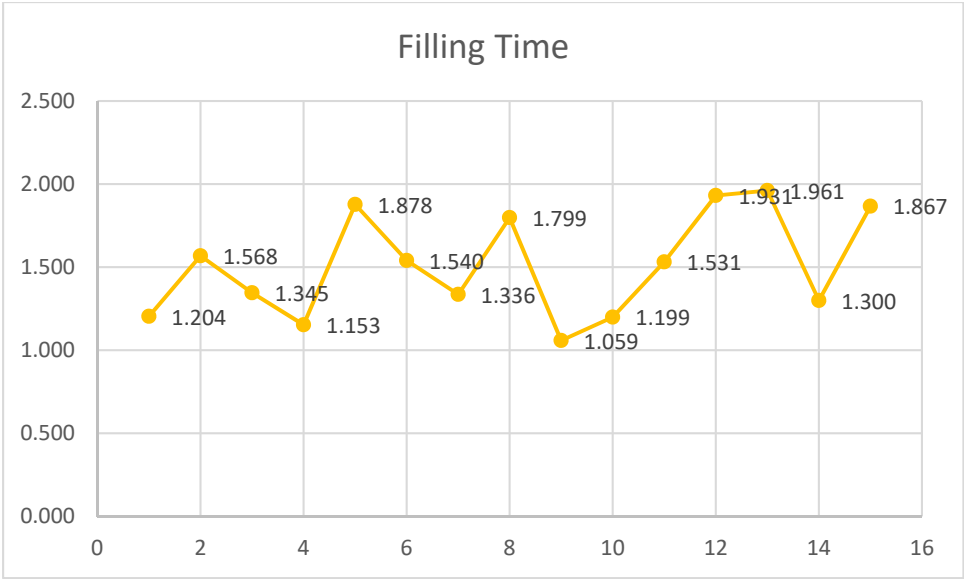
Production Record

No.	Start Time Empty Weight(g)	End Time Filled Weight(g)	Filling Time(s) Filling Weight(g)	Status	Comment
1	13/8/2020 0:00:00.333 7.890	13/8/2020 0:00:00.333 10.980	00.111 2.310	Good	
2	13/8/2020 0:00:00.333 7.890	13/8/2020 0:00:00.333 10.980	00.111 2.310	Reject	No Cap
3	13/8/2020 0:00:00.333 7.890	13/8/2020 0:00:00.333 10.980	00.111 2.310	Good	
4	13/8/2020 0:00:00.333 7.890	13/8/2020 0:00:00.333 10.980	00.111 2.310	Reject	Under Value
5	13/8/2020 0:00:00.333 7.890	13/8/2020 0:00:00.333 10.980	00.111 2.310	Good	
6	13/8/2020 0:00:00.333 7.890	13/8/2020 0:00:00.333 10.980	00.111 2.310	Good	Max. Weight
7	13/8/2020 0:00:00.333 7.890	13/8/2020 0:00:00.333 10.980	00.111 2.310	Reject	
8	13/8/2020 0:00:00.333 7.890	13/8/2020 0:00:00.333 10.980	00.111 2.310	Good	Min. Weight



Record Chart





Product Parameter

Parameter Name	Value	Parameter Name	Value
Product No.:	111		
Product Name:	Test Product		
Batch No.:	AB33211		
In-Feed Station			
In-Feed Turn Table Speed	123 RPM		
N2 Pre-Filling Station			
Filling Time	2 sec		
Weighing Station			
Target Weight:	7.225 g	Hi Limit:	7.555 g
Sampling Time:	2 sec	Lo Limit:	6.655 g
Filling Station			
Filling Volume	10 mL	Filling Pump Distance	3231mm
Filling Stroke No.1 Position	0.00mm	Filling Stroke No.1 Speed	15RPM
		Filling Pump RPM	100RPM
Filling Stroke No.2 Position	-10.00mm	Filling Stroke No.2 Speed	15RPM
		Filling Pump RPM	100RPM
Filling Stroke No.3 Position	-8.00mm	Filling Stroke No.3 Speed	15RPM
		Filling Pump RPM	100RPM
Filling Stroke No.4 Position	-6.00mm	Filling Stroke No.4 Speed	15RPM
		Filling Pump RPM	100RPM
Filling Stroke No.5 Position	-2.00mm	Filling Stroke No.5 Speed	15RPM
		Filling Pump RPM	100RPM
Bottle Clamper On Time:	2 sec		
N2 Post-Filling Station			
Filling Time	2 sec		
Plugging Station			
Plugging Motor Speed	12 RPM		
Plug Pick-up Angle	120°	Plug Pick-up Speed	100RPM
Pick-up Vacuum On Time:	2 sec		
Plug Place Angle	90°	Plug Place Speed	100RPM
Place Vacuum On Time:	2 sec		



Parameter Name	Value	Parameter Name	Value
Capping Station			
Capping Motor Speed	12 RPM		
Cap Pick-up Angle	120°	Cap Pick-up Speed	100RPM
Pick-up Vacuum On Time:	2 sec		
Cap Place Angle	90°	Cap Place Speed	100RPM
Place Vacuum On Time:	2 sec		
Cap Sealing Station			
Capping Blade ON Time:	2 sec		
Capping Motor Speed:	200 RPM	Braking On Delay time:	2 sec
		Clutch On Delay time:	2 sec
Reject Station			
Reject On time:	2 sec	Reject Off time:	2 sec
LAF			
Left FFU Fan Speed	200 RPM	Right FFU Fan Speed	200 RPM
Left FFU Diff. Pressure	0.2 bar	Left FFU Diff. Pressure	0.2 bar
High alarm		High alarm	
Right FFU Diff. Pressure	0.1 bar	Right FFU Diff. Pressure	0.1 bar
Low alarm		Low alarm	

Alarm Record

No.	Start Time	End Time	Acknowledge Time
Alarm Message			
1	13/8/2020 0:00:00	13/8/2020 0:00:00	13/8/2020 0:00:00
	Low Air Pressure		
1	13/8/2020 0:00:00	13/8/2020 0:00:00	13/8/2020 0:00:00
	Production Pause		
1	13/8/2020 0:00:00	13/8/2020 0:00:00	13/8/2020 0:00:00
	Production Start		
1	13/8/2020 0:00:00	13/8/2020 0:00:00	13/8/2020 0:00:00
	Emergency STOP		

End of Report

Operator Name:	Pika	Supervisor Name:	Pika Boss
Signature:		Signature:	
Date & Time:		Date & Time:	

