**Square Pharmaceuticals Ltd.**

**Parameter Report**

User Name: Pika  
Printed Date: 13/8/2020 0:00:00

**Product Parameter**

Product Information

|  |  |  |  |
| --- | --- | --- | --- |
| Starting No.: | 1 | End No.: | 10 |

**Product No.1**

|  |  |  |  |
| --- | --- | --- | --- |
| 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 |  |  |
|  |  |  |  |
| 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  High alarm | 0.2 bar | Left FFU Diff. Pressure  High alarm | 0.2 bar |
| Right FFU Diff. Pressure  Low alarm | 0.1 bar | Right FFU Diff. Pressure  Low alarm | 0.1 bar |

**Product No.2**

|  |  |  |  |
| --- | --- | --- | --- |
| 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 |  |  |
|  |  |  |  |
| 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  High alarm | 0.2 bar | Left FFU Diff. Pressure  High alarm | 0.2 bar |
| Right FFU Diff. Pressure  Low alarm | 0.1 bar | Right FFU Diff. Pressure  Low alarm | 0.1 bar |

**Product No.3**

|  |  |  |  |
| --- | --- | --- | --- |
| 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 |  |  |
|  |  |  |  |
| 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  High alarm | 0.2 bar | Left FFU Diff. Pressure  High alarm | 0.2 bar |
| Right FFU Diff. Pressure  Low alarm | 0.1 bar | Right FFU Diff. Pressure  Low alarm | 0.1 bar |

|  |
| --- |
| End of Report |

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