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Batch Manufacturing Record

Section 9.0: In-Process Quality Control (IPQC) Checks for Compression

Product: Aspirin Tablets 325mg

Batch No.: ASP-25-001

Sampling Frequency: Every 60 minutes, take 10 tablets for weight/hardness/thickness and enough for friability.

	≡ Specification	≡ Target
1	Average Weight:	436.5 mg – 463.5 mg
2	Hardness:	5.0 – 8.0 kp
3	Thickness:	3.7 mm – 4.3 mm
4	Friability:	NMT 1.0%

	≡ Time of Check	≡ 11:00	≡ 12:00	≡ 13:00	≡ 14:00	≡ 15:00	≡ 16:00
1	Appearance	Complies	Complies	Complies	Complies	Complies	Complies
2	---	---	---	---	---	---	---
3	Individual Wt. 1 (mg)	450	451	452	450	451	451
4	Individual Wt. 2 (mg)	452	450	453	449	452	450
5	Individual Wt. 3 (mg)	451	452	451	448	453	452
6	Individual Wt. 4 (mg)	453	449	452	451	450	449
7	Individual Wt. 5 (mg)	450	451	453	452	451	451

8	Minimum Weight (mg)	450	449	451	448	450	449
9	Maximum Weight (mg)	453	452	453	452	453	452
10	Average Weight (mg)	451.2	450.8	452.1	449.9	451.5	450.6
11	---	---	---	---	---	---	---
12	Hardness 1 (kp)	6.7	6.6	7.0	7.2	6.8	7.1
13	Hardness 2 (kp)	6.9	6.4	6.8	7.0	6.6	6.9
14	Hardness 3 (kp)	6.8	6.5	6.9	7.1	6.7	7.0
15	Average Hardness (kp)	6.8	6.5	6.9	7.1	6.7	7.0
16	---	---	---	---	---	---	---
17	Thickness 1 (mm)	4.1	4.0	4.1	4.2	4.1	4.1
18	Thickness 2 (mm)	4.2	4.1	4.2	4.3	4.2	4.0
19	Thickness 3 (mm)	4.0	3.9	4.0	4.1	4.0	4.2
20	Average Thickness (mm)	4.1	4.0	4.1	4.2	4.1	4.1
21	---	---	---	---	---	---	---
22	Friability (%)	0.31%	0.35%	0.33%	0.30%	0.34%	0.32%
23	---	---	---	---	---	---	---
24	Machine Adjustments Made	None	None	None	None	None	None
25	Performed By (Initials)	AS	AS	AS	AS	AS	AS

### Conclusion of IPQC Monitoring

**Comments:** All in-process checks performed during the compression run are consistently within the predefined specifications. The process is in a state of control.

Reviewed By (Supervisor):

- **Name:** Sunil Verma
- **Signature:** *Sunil Verma*
- **Date:** 18-Feb-2025