



INSATLLATION QUALIFICATION (IQ)

Project No : EMG-20-036
Date : 11.01.2021
Document Ref Number : EMG-20-036.IQ

YOUR INOVATION SOLUTION PARTNER



		<p style="text-align: center;">INSTALLAATION QUALIFICATION (IQ)</p>					
EMG-20-036.IQ	Rev.No	01	Rev.Date	11. January.2021	Page No	2	

Protocol Document Approved

Prepared by

Name	Department/Function	Date	Sign



Approved by

Name	Department/Function	Date	Sign

Date of Revision



Rev.No.	Date	Prepared by	Description of Changement
01	11.01.2021		Initial Version



	Installation Qualification (IQ)					 Global Dış Ticaret ve Danışmanlık A.Ş.
EMG-20-036.IQ	Rev.No	01	Rev.Date	11.January.2020	Page No	3

1.	Purpose.....	4
2.	Scope.....	4
3.	Test Participant and Assignment.....	4
4.	Drawing.....	5
5.	Component List.....	6
6.	Critical Sensör List.....	10
7.	Assembling of Equipment.....	11
8.	IQ for Electrical and Control Cabine.....	12
9.	Hardware Setup Qualification.....	13
10.	Software Setup Qualification.....	14
11.	IQ Test Specifications.....	15
12.	Installation Qualification Test.....	16
13.	Additional Test.....	18
14.	Test Deviation Records /Deficiencies List.....	19
15.	Comments and Explanations.....	20
16.	Additions.....	21
17.	Release for OQ.....	22
18.	Test Report Acceptance.....	23



	<p style="text-align: center;">INSTALLAATION QUALIFICATION (IQ)</p>				 <small>Global Dış Ticaret ve Danışmanlık A.Ş.</small>	
EMG-20-036.IQ	Rev.No	01	Rev.Date	11. January.2021	Page No	4

1. Purpose

The purpose of this installation qualification document is to define the installation activities for the volumetric 8-nozzle filling machine and its components.

2. Scope

This installation qualification document is prepared for volumetric 8 nozzle filling machine automation system and related components



Equipment Name	Equipment Code	Equipment / Serial No
Volumetric Filling Machine	M-ODM-A05-CF	3842

3. Test Participant and Assignment

In installation qualification activities, the personnel specified in the following list will be employed and must be filled in manually with a blue ballpoint pen..

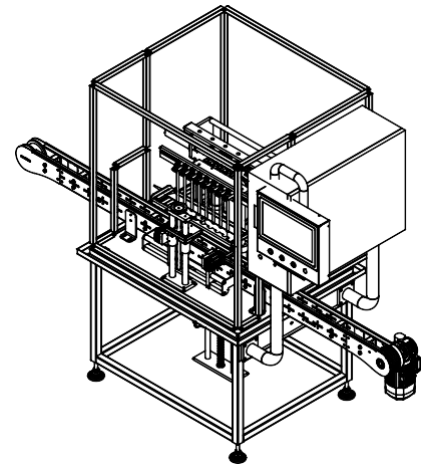
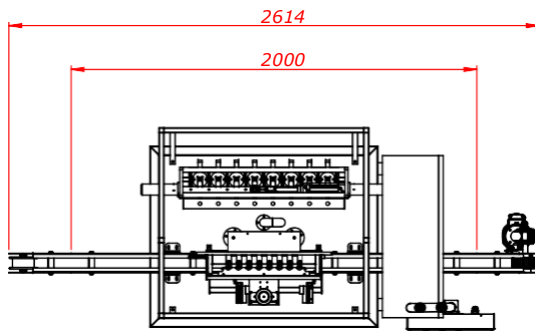
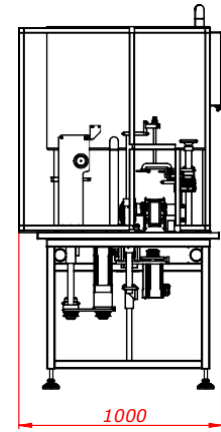
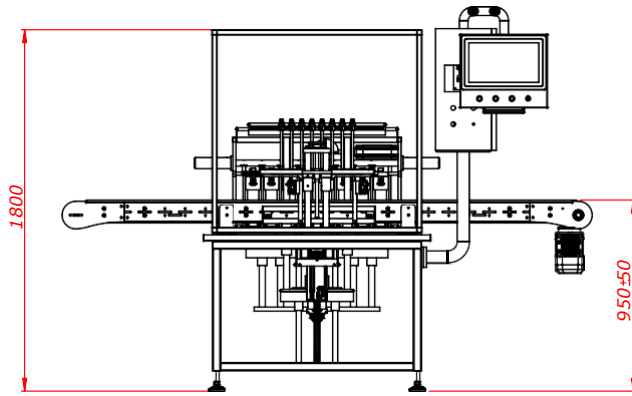
Name&Surname	Assignment	Date	Sign



	Installation Qualification (IQ)					 Global Dış Ticaret ve Danışmanlık A.Ş.
EMG-20-036.IQ	Rev.No	01	Rev.Date	11.January.2020	Page No	5

4. Drawing

Drawing No	Add.	Explanation
3842-ED.093-02.09.2020-01	PDF Dosyası	Volumetric Filling Machine Electric Scheme



Controlled by :	Sign :	Date :
Confirmed by :	Sign :	Date :





INSTALLATION QUALIFICATION (IQ)



EMG-20-036.IQ

Rev.No

01

Rev.Date

11. January.2021

Page No

6



5. Component List

Mechanic List

Mechanic List (VOLUMETRIC FILLING MACHINE-3842)

Stuck No	Stuck Name	QTY	Unity
5 MRED-VF44-P1-0,37KW/70	VF44-P1-20P71-B14 (0.37KW/70 dd.İ:20 MOT.REDÜKT.)	1	QTY
5 PLBM-130-25	130-Z21-25 CONV.BAND ROLL (1205 7N)	1	QTY
5 PLUP-3-B6-PE1000	B6 MATCHED Z PROFILE GREEN-PE1000 (ROCH-101358-ROCH)	14	METER
5 PLDP-82-K	82.6mm BROWN.PLAST.STR. PALLET (C0820K0325LFAA-N2)	6,56	METER
5 PLDP-82-K	82.6mm BROWN.PLAST.STR. PALLET (C0820K0325LFAA-N2)	0,94	METER
5 MRD-LC090103S450002	LC09015 STD 80A1 CD 19 KE REDÜKTÖR 1/5	1	QTY
5 PLVO-100-KATL-KOLLU	7307D345F-100V12X50 KATL.KOLLU ÇARK (VOLANT)	1	QTY
5 RZZX-6001	6001 BEARING (12-28-8)	1	QTY
5 RZZX-6005-KR	6005 PASL. BEARING (25-47-12)	2	QTY
5 RZZX-6203	6203 BEARING (17-40-12)	1	QTY
5 RZZX-30203	30203-J2 CONIC ROLL BEARING (17-40-12)	4	QTY
5 RYAT-LMEF-25LUU	LMEF-25 LUU (25-40-112) YUVARL.UZUN FLANŞ-SAMICK	2	QTY
5 RYAT-LMEK-30-LUU	LMEK-30 LUU KARE FLANŞ UZUN (30X47X123) SAMICK	4	QTY
5 POLY-HİWİN-10	R25/10 T3 FSI SOMUN (HİWİN)	1	QTY
5 POLY-HİWİN-25	R25/10 VİDALI MİL H-414mm (HİWİN)	1	QTY
5 POLY-HİWİN-10	R25/10 T3 FSI SOMUN (HİWİN)	1	QTY
5 POLY-HİWİN-11	R25/10 VİDALI MİL H-566mm (HİWİN)	1	QTY
5 SOMUN-NMZ-17X1	NMZ 17X1 (17X1 -28X10) KONTRA SOMUN) REXROTH	2	QTY
5 KZKA-5M-25-410	5M-25-410 ZAMAN KAYIŞI KAUCUK	1	QTY
5 KZKA-5M-15-525	5M-15-525 ZAMAN KAYIŞI	1	QTY
5 PNCL-4-TK	4" 114mm-A316-KLT.FERRULE+CLAMP+SİLİKON CONT.TK.	1	SET.
5 NEU-DİR-DN15-19X1,5/45	DN15-19X1,5mm PARL.DİRSEK 45c DIN11851 1.4404	8	QTY
5 NEUMO-DİR-DN15-19X1,5	DN15 (19X1,5mm POLY.KROM DİRSEK)	1	QTY
5 NEUMO-DİR-DN15-19X1,5	DN15 (19X1,5mm POLY.KROM DİRSEK)	8	QTY
5 KRDİ-42X1,5	42X1,5mm 316-KLT.POLY.KROM DİRSEK	2	QTY
5 KRDİ-42X1,5	42X1,5mm 316-KLT.POLY.KROM DİRSEK	2	QTY
5 KRDİ-60X1,5	60X1,5mm 304-KLT.POLY.KROM DİRSEK	2	QTY
5 NEUMO-DİR-DN32-34X1,5	DN32-(34X1,5mm POLY.KROM DİRSEK) DIN-11851-14404	2	QTY
5 PNBA-FESTO-1	PEV-W-KL-LED-GH BASINÇ ANAHTARI-152618 + 164597	1	QTY
5 PNDİ-M5-6	M5 -6 DİRSEK (130772)	1	QTY
5 PNKP-FESTO-50-100	DSBC50-100-PPVA-N3 KARE PİSTON (1366952)	1	QTY
5 RSADM-M16X1,5	M16X1,5 SAG DIŞI MAFSAL - KJ16D (SMC)	1	QTY
5 RNKE-30-40-5	K21-030/5-NBR (30-40-5) NUTRİNG KEÇE	2	QTY
5 İGUS-JUM-01-30	JUM-01-30 IGUS DRYLIN	2	QTY
5 İGUS-JUM-02-25	JUM-02-25 IGUS DRYLIN	4	QTY



	Installation Qualification (IQ)					
EMG-20-036.IQ	Rev.No	01	Rev.Date	11.January.2020	Page No	7

Mechanic List (VOLUMETRIC FILLING MACHINE-3842)

Stok No	Stok Adı	Adet	Birim
5 İGUS-JUM-02-30	JUM-02-30 IGUS DRYLIN	4	QTY
5 PNYS-SMC-MGPM-16-50	MGPM-16-50 YATAKLI SİLİNDİR	2	QTY
5 PNYS-SMC-MGPM-25-20	MGPM-25-20 YATAKLI SİLİNDİR	1	QTY
5 SICK-RZC1-04ZUS-KUBS03	1073286 RZC1-04ZUS-KUBS03 2-TELLİ 5mt.PİST.SENSÖR	6	QTY
5 SICK-RZT7-03ZRS-KWB	1070853 RZT7-03ZRS-KWB PİSTON SENSÖRÜ 5mt.	2	QTY
5 PNRE-SMC-3/8	AW30-F03DE-B 3/8 FİLTRE REGÜLAT.OTOM.TAHL.	1	QTY
5 PNAK-SMC-3/2-3/8	3/2-3/8 VHS30-F03A MAND.AÇMA KAPAMA	1	QTY
5 PNRE-SMC-Y30T-A	Y30T-A 3/8 MOD.TESPİT ELEMANI SMC	1	QTY
5 PNRE-SMC-Y30T-A	Y30T-A 3/8 MOD.TESPİT ELEMANI SMC	1	QTY
5 PNVF-SMC-EAV3000-F03	EAV3000-F03-5DZ-Q 3/8-24V.DC YAVAŞ BAŞLATMA VALFİ	1	QTY
5 PNGV-572230-1/4-5-Lİ	1/4-5'Lİ GRUB VALF (VTUG-18-SK9R-S1T-G38L-DRT-G14S	1	QTY
5 PNCS-250cc	250cc CAM SİLİNDİR (Q45X5,1X200) SCHOTT	8	QTY
5 PLÇA-3	3 LÜ -48,3mm ÇATAL AYAK- (15084)	1	QTY
5 PLÇA-3	3 LÜ -48,3mm ÇATAL AYAK- (15084)	1	QTY
5 PLAY-80XM16X162	L00257093 (80XM16X162 M16 PASL.AYAK) MAFSALLI	6	QTY
5 PLYP-1	48,3mm KONV.AYAK YAN BAGL. 14748	2	QTY
5 PLTA-13764	13764 TRAB.KONSOL+TOPUZ (BRAKET) 31mm DF=12,5mm	6	QTY
5 PLTA-13764	13764 TRAB.KONSOL+TOPUZ (BRAKET) 31mm DF=12,5mm	4	QTY
5 PLMT-12	12 MİL TUTUCU (13114)	1	QTY
5 PLMT-12	12 MİL TUTUCU (13114)	1	QTY
5 PLFA-12	12 FOTESEL AYAĞI (13115)	6	QTY
5 ELBAK-13250	13250 DAMLALIK TUTUCU	8	QTY
5 PLKO-215-UKK-PA6	215-UKK-PA6 (KAPAK KOLU KENAR PLASTİĞİ) M8 OLMALI	10	QTY
5 PLMU-10	6mm ÇERÇEVE KELEPÇESİ-(767 000 006)	24	QTY
5 PLMU-11	PLASTİK MENTEŞE -49X49 (215.000.103)	10	QTY
5 PLMU-5	ÇERÇEVE MIKNATIZI- (689-000-101) RMCO18	10	QTY
5 PLMU-6	A1101-62586- 3 LÜ ÇATAL BAGL.	8	QTY
5 PLMU-7	A1108-62746- LE DÜZ ÇERÇEVE BAGL.	6	QTY
5 PLMU-9	A1101-673561- TE ÇERÇEVE BAGL.	4	QTY
5 PLKO-M8-1	M8 DİŞİ SUSTALI KOL SİYAH	4	QTY







Elektronik List

Elektronik (VOLUMETRIC FILLING MACHINE-3842)

Stuck No	Stuck Name	QTY	UNITY
5 EPPA-800X600X300-ÇKPL	SSET-800X600X300 304-PASL.ÇİFT KAPILI İSPANY.KİLİT	1	QTY
5 EFFİ-150X150-FAN	PFB2000-150X150mm 230V.FANLI FİLTRE (TF2000)	1	QTY
5 EFFİ-150X150-FİLTRE	PFA-2000-150X150X27mm FİLTRE IZGARA (TFA2000)	1	QTY
5 ETERM-KTS011	KTS011-0-60c TERMOSTAT (STEGO)01141.0-00	1	QTY
5 EFLA-SNT-74-B-RGB	SNT-74-B-RGB 12-24V.DC 4-RENK BAZIRLI İKAZ LAMBASI	1	QTY
5 EKPS-ONKA-7160	7160 ONKA PANO PRİZİ	1	QTY
5 PHCENIX-1206421	1206421 NS35/7,5 ZN PERF2000mm DEL.W.OTOM.RAYI 2mt	2	METER
5 EDKK-40-80	40X80 GRİ DELİKLİ KABLO KANALI (2mtX36mt.)	2	METER
5 EDKK-60-80	60X80 DELİKLİ KABLO KANALI (2mt.X24 mt.)	2	METER
5 EHKO-3G3MX2-AB004E-ECT	0,4/0,55 KW. HIZ KONTROL (3G3MX2-AB004-E-ECT)	1	QTY
5 EGKA-S8VK-C12024	S8VK-C12024 (24V.DC 5-A.120W. GÜÇ KAYNAĞI)	1	QTY
5 TMK-A9K24110-10AX1	10AX1 W.OTOM.SİGORTA (A9K24110) TMK	1	QTY
5 TMK-A9K24106-6AX1	6AX1 W.OTOM.SİGORTA (A9K24106) TMK	1	QTY
5 TMK-24351	24351- 20AX3 OTOM.SİGORTA (A9K24320)	1	QTY
5 BİLG-TPC1507C	15,6" TPC1507C 1920X1080 HDMI+DVI+VGA CAPACİTİVE	1	QTY
5 BECK-CX5130-0122	CX5130-0122 BASİC CPU MODULE CX5130 MICROSOFT	1	QTY
5 BECK-CX2900-0038	CX2900-0038 30 GB CFAST CARD 3D FLASH EXTENDED	1	QTY
5 BECK-ZK1090-9191-0010	ZK1090-9191-0010 ETHER CAT KABLOSU 1mt BECKHOFF	1	QTY
5 BECK-ZK1090-9191-0050	ZK1090-9191-0050 ETHER CAT KABLOSU 5mt BECKHOFF	1	QTY
5 BECK-EL1008	EL1008- 8 KANAL 24VDC 3.0 ms FİLTR.DİGİTAL GİR.TER	1	QTY
5 BECK-EL1809	EL1809 (16-CHANNEL DİGİTAL İNPUT TERMİNAL	1	QTY
5 BECK-EL2809	EL2809 (16-CHANNEL DİGİTAL OUTPUT TERMİNAL	1	QTY
5 BECK-EL3051	EL3051 (1-KANAL ANALOG GÜÇ TERMİNALİ 4..20 mA 12	1	QTY
5 BECK-EL9011	EL9011 (SONLANDIRICI PLAKA)	1	QTY
5 BECK-AX5203-0000-0200	AX5203-0000-0200 (ETHERCAT SÜRÜCÜ 2X3A V2)	1	QTY
5 BECK-AM8043-OE10	AM8043-OE10-0000 (SERVO MOTOR) BECKHOFF	1	QTY
5 BECK-AM8043-OE11	AM8043-OE11 SERVO MOTOR 400V.AC	1	QTY
5 BECK-ZK4500-8003-0030	ZK4500-8003-0030 (SERVO MOT.GÜÇ KABLOSU 3m)	2	QTY
5 TMK-VCF-0	VCF-0 - 25A ENMİYET ŞALTERİ	1	QTY
5 TMK-XB5-AS542	XB5-AS8442 ACİL DURDURMA BUTONU	1	QTY
5 ETİKET-28113	EMERGENCY ETİKETİ -800F-15YSE112 (ALLEN BRADLEY)	1	QTY
5 TMK-XB5-AW31B5	XB5-AW31B5 BEYAZ LEDLİ BUTON	1	QTY
5 TMK-XB5-AW33B5	XB5-AW33B5 YEŞİL LEDLİ BUTON	1	QTY
5 TMK-XB5-AW36B5	XB5-AW36B5 MAVİ LEDLİ BUTON	1	QTY
5 ERÖ-K8AK-PM2	K8AK-PM2 KONTROL RÖLESİ (OMRON)	1	QTY
5 EM-KONT-DILEM-10-220V	DILEM-10 (4 KW.220V.AC KONTAKTÖR (MOELLER)	1	QTY



	INSTALLAATION QUALIFICATION (IQ)					 NOYEM Global Dış Ticaret ve Danışmanlık A.Ş.
EMG-20-036.IQ	Rev.No	01	Rev.Date	11. January.2021	Page No	9

Elektronik (VOLUMETRIC FILLING MACHINE-3842)

Stuck No	Stuck Name	QTY	UNITY
5 EM-POT-M22R10K	M22-R10K POTANSİYOMETRE (MOELLER)	1	QTY
5 ERÖ-CMS-E-ER-099182	CMS-E-ER 099182 DEGERL.ÜNİTESİ (EMNİY.RÖLESİ)	1	QTY
5 TMK-XCS-DMC5905	XCS-DMC 5905 EMNİYET NİHAYET ŞALTERİ-TMK	5	QTY
5 ERÖL-MY4IN-24DC-S	MY4IN-24DC (S) MİNİK RÖLE (OMRON)	1	QTY
5 ERSO-PYF14A-N	PYF14A-N MY4-RÖLE SOKETİ (OMRON)	1	QTY
5 SICK-P250-F	P250-F REFLEKTÖR (5308843) SICK	2	QTY
5 SICK-P250-F	P250-F REFLEKTÖR (5308843) SICK	2	QTY
5 SICK-WLG4S-3F2234	WLG4S-3F2234 REF.ŞEFFAF ŞİŞE FOTOSELİ SICK-1042084	3	QTY
5 SICK-LFV200-XXTGBT	LFV200-XXTGBTPV G3/4 ÇATAL SEVİYE SENSÖRÜ 6040915	1	QTY
5 SICK-UM18-218126111	UM18-218126111 ULTRASONİK SENSÖR+DOL-1205-G05M	1	QTY
8 BİLG-SLX-310	SLX-310 1,5mt. HDMI+DVI CABLE (S-LINK)	1	QTY







6. Critical Sensor List

Critical Sensor List (VOLUMETRIC FILLING MACHINE-3842)

Stok No	Stok Adı	QTY	UNIT
5 SICK-WLG4S-3F2234	WLG4S-3F2234 REF.ŞEFFAF ŞİŞE FOTOSELİ SICK-1042084	3	QTY
5 SICK-LFV200-XXTGBT	LFV200-XXTGBTPV G3/4 ÇATAL SEVİYE SENSÖRÜ 6040915	1	QTY
5 SICK-UM18-218126111	UM18-218126111 ULTRASONİK SENSÖR+DOL-1205-G05M	1	QTY

Tested By :	Sign :	Date :
Checked By :	Sign :	Date :
Approved By :	Sign :	Date :



	<p style="text-align: center;">INSTALLAATION QUALIFICATION (IQ)</p>				 <small>Global Dış Ticaret ve Danışmanlık A.Ş.</small>	
EMG-20-036.IQ	Rev.No	01	Rev.Date	11. January.2021	Page No	11



7. Equipment Assignment

The identification plate, position, orientation and fixation of the equipment are checked after equipment installation. These controls apply to all equipment on the line. This work covers the entire line.

Test Control	Is it Proper ?	
	Yes	No
Is the identification plate (equipment no) on the equipment?		
According to the layout drawings, was the equipment installed in the correct position?		
Check the alignment of the equipment with the water gage . Is the alignment of the equipment appropriate?		
Is it appropriate to fix the equipment?		
Is the equipment undamaged?		

Tested By :	Sign :	Date :
Checked By :	Sign :	Date :
Approved By :	Sign :	Date :



	<p style="text-align: center;">INSTALLAATION QUALIFICATION (IQ)</p>				 <small>Global Dış Ticaret ve Danışmanlık A.Ş.</small>	
EMG-20-036.IQ	Rev.No	01	Rev.Date	11. January.2021	Page No	12



8. IQ For Electrical and Control Cabine

This table applies to all line equipment. Situations that make a difference are indicated in the" comments " section.

Test Control	Is it Proper ?		
	Yes	No	N/A
Is the order complete?			
Is manufacturer documentation available?			
Do the cabin doors open and close properly?			
Are cautionary and informative signs appropriate??			
Is it connected to the protection earth of all doors, doors and metal sheets?			
Feed mono phase			
Feeding rated frequency 50Hz			
All emergency stop circuits have been tested and are they suitable?			

Tested By :	Sign :	Date :
Checked By:	Sign:	Date:
Approved By :	Sign :	Date :



	INSTALLAATION QUALIFICATION (IQ)					 Global Dış Ticaret ve Danışmanlık A.Ş.
EMG-20-036.IQ	Rev.No	01	Rev.Date	11. January.2021	Page No	13



9. Hardware Setup Qualification

IQ for PLC Controller

Equipment Code	Equipment Name	QTY.	Pro.
5 BECK-EL1008	EL1008- 8 KANAL 24VDC 3.0 ms FİLTR.DİĞİTAL GİR.TER	1	QTY
5 BECK-EL1809	EL1809 (16-CHANNEL DİĞİTAL İNPUT TERMİNAL	1	QTY
5 BECK-EL2809	EL2809 (16-CHANNEL DİĞİTAL OUTPUT TERMİNAL	1	QTY
5 BECK-EL3051	EL3051 (1-KANAL ANALOG GÜÇ TERMİNALİ 4..20 mA 12	1	QTY

Controller	Yes / No / NA	Date	Sign
PLC / controller construction in accordance with specifications			



	INSTALLAATION QUALIFICATION (IQ)					 Global Dış Ticaret ve Danışmanlık A.Ş.
EMG-20-036.IQ	Rev.No	01	Rev.Date	11. January.2021	Page No	14

10. Software Setup Qualification



System Description	
System / Machinery Name	Volumetric 8 Nozzle Filling Machine
Serial Number	M-ODM-A05-CF
Manufacturer	ELEKTROMAG
System / Device Design Purpose	HMI
Software Platformu	TWİNCAT

Installation Info

Operating System	
Operating System	WİNDOWS 7 Embedded

PLC Software	
Controller	BECKHOFF
Network Connection	ETHERCAT
Operator Panel	MOVİCON
Programming and Configuration Device	TWİNCAT
Comments	



	INSTALLAATION QUALIFICATION (IQ)					 Global Dış Ticaret ve Danışmanlık A.Ş.
EMG-20-036.IQ	Rev.No	01	Rev.Date	11. January.2021	Page No	15

11. IQ Test Specification



Considerations In Test Protocols

- Fill all procedures used with a blue ballpoint pen, never use a course pen.
- Never delete or doodle incorrect entries or typos. Just draw the wrong entry and type the correct entry. Do it Date and Paragh.
- Test forms must be completed by authorized personnel simultaneously with the application. It must be approved by authorized personnel..
- All supporting documents used and created during the implementation of tests are considered part of the qualification package and must be added to the end of the test.
- All protocols must be approved by the customer. All tests must be given the latest approval by the customer.

Deviation / Error

- Errors/deviations encountered during tests should include the following information;
- Reference information to the test where deviation/error is seen,,
- Estimates for deviation/error,
- Prescribed corrective action for deviation/error
- Signature and date information of the person who detected the deviation/error
- Confirmation information provided by customer regarding deviation / error



	INSTALLAATION QUALIFICATION (IQ)					 Global Dış Ticaret ve Danışmanlık A.Ş.
EMG-20-036.IQ	Rev.No	01	Rev.Date	11. January.2021	Page No	16

12. Installation Qualification Test

Volumetric 8 Nozzles Filling Machine

Test No	Test Step	Acceptance Criteria	Has the Acceptance Criteria been met??	Applied by Paragh/Date	Confirmed by Paragh/Date
1.1	Check the electric connections.	5.5 kw monophase power line must be drawn.	Yes [] No []		
1.2	Check the air connection.	4-6 bar air line should be connect to the machine	Yes [] No []		
1.3	Check the gorunding.	Machine grounding should be made.	Yes [] No []		
1.4	Check by eye that the filling machine does not have any defects in its visual controls. (dents, scratches, cracks, etc.)	The machine should not have any defects.	Yes [] No []		
1.5	Check the model and serial number of the machine.	The definition plate must be installed on the machine together with the brand model and serial number.	Yes [] No []		
1.6	Check the conveyor group.	The conveyor should be assembled.	Yes [] No []		
1.7	Check the conveyor barrier width.	The width should be adjusted according to the length of the bottle being studied.	Yes [] No []		
1.8	Check what corresponds to what is specified in the electrical diagram of the filling machine's electrical system labeling.	The electrical system is correctly labeled.	Yes [] No []		
1.9	Filling unit design control	It should be 8s linear filling machine.	Yes [] No []		
1.10	Check the nozzles group.	Nozzles should be suitable for bottle.	Yes [] No []		
1.11	Check the cylinder group.	The cylinder group must be adjusted so that it does not miss fluid.	Yes [] No []		
1.12	Check the neckled group.	The bottle should be fitted with the appropriate strangling apparatus. Height adjustment should be made according to the bottle to be worked.	Yes [] No []		





INSTALLATION QUALIFICATION (IQ)



EMG-20-036.IQ

Rev.No

01

Rev.Date

11. January.2021

Page No

17

Test No	Test Step	Acceptance Criteria	Has the Acceptance Criteria been met??	Applied by Paragh/Date	Confirmed by Paragh/Date
1.13	Check the Cutter Group.	Cutter group must be set according to the format to be worked.	Yes [] No []		
1.14	Check the Machine user panel and check software language.	Machine user panel language should both English and Turkish	Yes [] No []		
1.15	Check the door.	Doors and safety finally switches should be installed.	Yes [] No []		
1.16	Check the enter photocell.	Enter photocell should be set to see the product.	Yes [] No []		
1.17	Check the overturned bottle photocell.	It should be adjusted according to the bottle to be worked on.	Yes [] No []		
1.18	Check the exit photocell.	It should be adjusted according to the bottle to be worked on.	Yes [] No []		
1.19	Check the exit full photocell.	It should be adjusted according to the bottle to be worked on.	Yes [] No []		
1.20	Format Control	Suitable filling system should be available for specified formats.	Yes [] No []		
1.21	Product touchable parts check	All compressed air contact parts must be SS 316 or FDA approved materials.	Yes [] No []		
1.22	Control Unit	Control type should be PLC+HMI.	Yes [] No []		
1.23	Product Cleaning Safety Check	The entire filling system must be closed.	Yes [] No []		
1.24	Manuel mod check	Should be jog mode on the machine	Yes [] No []		
1.25	Emergency button check	Should be emergency button.	Yes [] No []		
1.26	Check the filling tank-rotary valve transfer pipe connection.	Pipes must be installed in tank and rotary valve records.	Yes [] No []		
1.27	Check the transfer pipe connection between Rotary valve and nozzle.	Pipes must be installed in tank and rotary valve records.	Yes [] No []		



INSTALLAATION QUALIFICATION (IQ)



EMG-20-036.IQ

Rev.No

01

Rev.Date

11. January.2021



Page No

18

13. Additional Tests

Test No	Test Step	Acceptance Criteria	Has the Acceptance Criteria been met??	Applied by Paragh/Date	Confirmed by Paragh/Date
			Yes [] No []		
			Yes [] No []		
			Yes [] No []		
			Yes [] No []		



	<p style="text-align: center;">INSTALLAATION QUALIFICATION (IQ)</p>				 <small>Global Dış Ticaret ve Danışmanlık A.Ş.</small>	
EMG-20-036.IQ	Rev.No	01	Rev.Date	11. January.2021	Page No	19

14. Test Deviation Records / Deficiencies List

Deviations are recorded and identified in this list. This page can be used by



Working No:

No	Reference	Test Deviation / Deficiencies	Classification (A,B,C)	Date / Sign	Measures/Actions/Notes/Reason

A: About GMP and critical, It must be solved before finisg the IQ
B: About GMP, but not critical ,ex; missing documentation
C: Other deviations



Applied by :	Date :	Sign :
Checked by :	Date :	Sign :
Confirmed after completed :	Date :	Sign :



	INSTALLAATION QUALIFICATION (IQ)					 Global Dış Ticaret ve Danışmanlık A.Ş.
EMG-20-036.IQ	Rev.No	01	Rev.Date	11. January.2021	Page No	20

15. Comments and Explanations





	<p style="text-align: center;">INSTALLAATION QUALIFICATION (IQ)</p>				<p style="text-align: center;">  NOYEM <small>Global Dış Ticaret ve Danışmanlık A.Ş.</small> </p>	
EMG-20-036.IQ	Rev.No	01	Rev.Date	11.January.2021	Page No	21

16. Additions

Drawing No	Addition	Explanation
3842-ED.093-02.09.2020-01	PDF Dosyası	Volumetric Filling Machine Electric Scheme



	INSTALLAATION QUALIFICATION (IQ)					 Global Dış Ticaret ve Danışmanlık A.Ş.
EMG-20-036.IQ	Rev.No	01	Rev.Date	11.January.2021	Page No	22

17. Release for OQ



Deficiencies are present

- [] Cannot proceed to OQ stage / critical
Deviations/errors occurred during installation qualification work. After removal of open substances, installation Qualification Work will be repeated. Actions and responsibilities related to open substances are listed below.
- [] Not critical / Deficiencies can be completed during OQ stage.
Deficiencies occurred during the installation qualification. These deficiencies are mentioned in the descriptions section of the tests. If there is a corrective/preventive action to be taken regarding these deficiencies, below belirtilmiştir.IQ it has been accepted with existing deviations.
- [] No deficiencies about the GMP. Proceed to the OQ stage with the current deficiencies.
- [] Proceed to the OQ stage without any deficiencies.

Installation qualification studies met all acceptance criteria and no deviation/ error occurred during the studies.

According to the approval of this report, IQ (installation qualification) has been completed and passed to the OQ (operational qualification) phase.



		<p style="text-align: center;">INSTALLAATION QUALIFICATION (IQ)</p>					
EMG-20-036.IQ	Rev.No	01	Rev.Date	11.January.2021	Page No	23	

18. Test Report Acceptance

Prepared by

Name	Department/Function	Date	Sign

Approved by

Name	Department/Function	Date	Sign

