



INSTALLATION QULIFICATION (IQ)

Project No : EMG-20-040
Date : 24.02.2021
Document Ref Number : EMG-20-040.IQ

AUTOMATIC LINEAR SINGLE MODULE SELF TOP LABELING MACHINE

M-ETK-A04

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Protocol Document Approved

Prepared by



Name	Department/Function	Date	Sign

Approved by



Name	Department/Function	Date	Sign

Revizyon Tarihçesi

Rev.No.	Date	Prepared by	Description of Changement
01	24.02.2021		Initial Version

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1. Purpose

The purpose of this installation qualification document is to describe the installation activities of the Top Labeling Machine and its components.

2. Scope



This installation qualification document is prepared for Top Labelling Machine automation system and related components

Equipment Name	Equipment Code	Equipment No / Serial No
Top Labelling Machine	M-ETK-A02	3848

3. Test Participant and Assignment

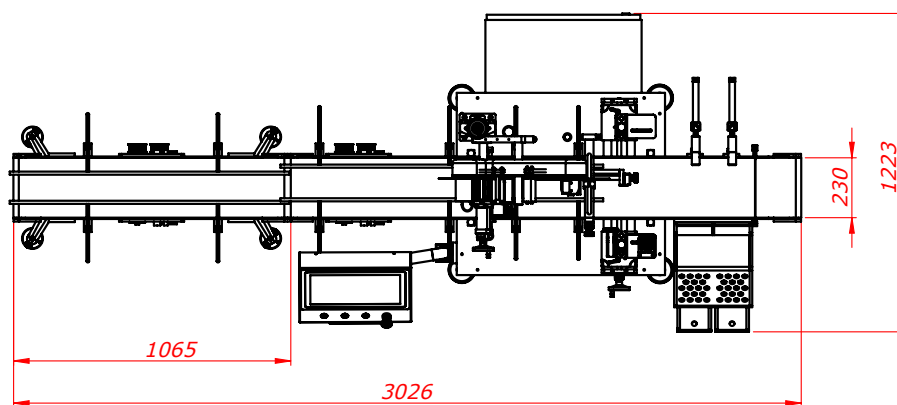
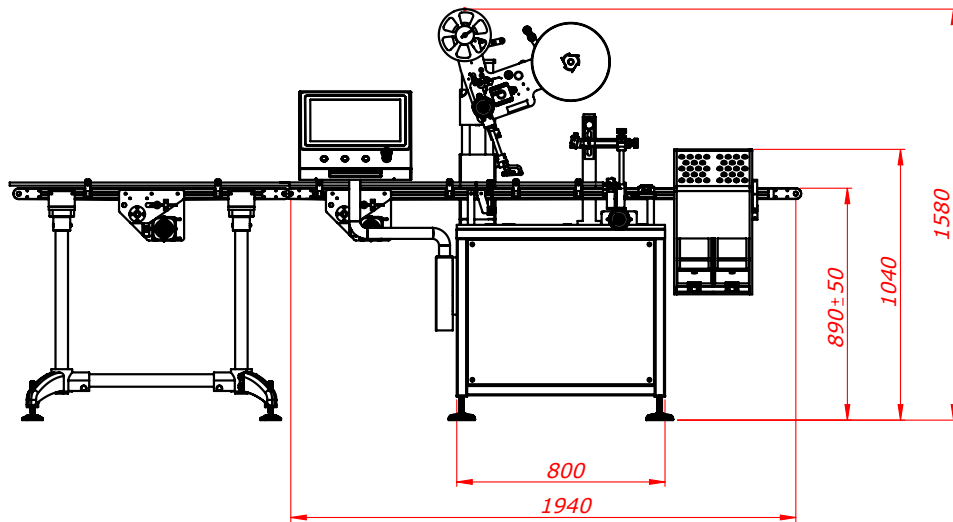
In installation qualification activities, the personnel specified in the following list will be employed and must be filled in manually with a blue ballpoint pen.

Name Surname	Assignment	Date	Sign

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4. Drawings

Drawing No	Appendix	Explanation
3848-ED.126-22.12.2020-01	PDF File	Top Labelling Machine



Controlling :	Sign :	Date :
Approving :	Sign :	Date :



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5. Component List

MECHANICAL LIST

Mechanical List (Top Labelling Machine-3848)



Stock No	Stock Name	QTY	Unit
5 MRED-VF44-P1-0,37KW/41	VF44-P1-35P71-B14 (0.37KW/41 dd.İ:35 MOT.REDÜKT.)	1	QTY
5 PLBM-130-25	130-Z21-25 KONV.BANT MAKARASI (1205 7N)	1	QTY
5 MRED-VF30-P1-0,18KW/96	VF30-P1-15P63 B14 (0.18KW/96 dd.İ:15 MOT.REDÜKTÖR)	1	QTY
5 PLVO-100-KATL-KOLLU	7307D345F-100V12X50 KATL.KOLLU ÇARK (VOLANT)	1	QTY
5 RZZX-6001	6001 RULMAN (12-28-8)	3	QTY
5 RZZX-6004	6004 RULMAN (20-42-12)	1	QTY
5 RZZX-6005	6005 RULMAN (25-47-12)	2	QTY
5 RZZX-6005-KR	6005 PASL. RULMAN (25-47-12)	2	QTY
5 RZZX-16101	16101 RULMAN (12-30-8)	2	QTY
5 RZZX-16101	16101 RULMAN (12-30-8)	2	QTY
5 PLKO-M10-1	M10 DIŞI SUSTALI KOL SİYAH	1	QTY
5 PLKO-M8-1	M8 DIŞI SUSTALI KOL SİYAH	1	QTY
5 PLÜP-1	48,3mm KONV.AYAK ÜST BAGL.(14050)	2	QTY
5 PLKO-M8-1	M8 DIŞI SUSTALI KOL SİYAH	1	QTY
5 KRDİ-42X1,5	42X1,5mm 316-KLT.POLY.KROM DİRSEK	4	QTY
5 PLAY-124XM20X189	L00457145 (124XM20X189 M20 PASL.AYAK) MAFSALLI	4	QTY
8 CETVEL-15	15 cm. ÇELİK CETVEL ÇİFT TARAF FRANCE	2	QTY
5 PLVO-7302232-80X10X20	7302232- 80X10X20 ÇARK (VOLANT)	2	QTY
5 SANKO-SK0414-2-0I-12	SK0414-2.0I-12-ON İNDİKATÖR (SANKO)	3	QTY
5 SANKO-SK0412-2-0I-12	SK0412-2.0I-12-ON İNDİKATÖR (SANKO)	3	QTY
5 PLKO-M8-1	M8 DIŞI SUSTALI KOL SİYAH	3	QTY
5 RZZX-608	608 RULMAN (8-22-7)	2	QTY
5 RZZX-6001	6001 RULMAN (12-28-8)	2	QTY
5 RZZX-6002	6002 RULMAN (15-32-9)	8	QTY
5 PLÜP-1	48,3mm KONV.AYAK ÜST BAGL.(14050)	2	QTY
5 PLÇA-2	2 Lİ -48,3mm ÇATAL AYAK-15092	2	QTY
5 PLAY-80XM16X162	L00257093 (80XM16X162 M16 PASL.AYAK) MAFSALLI	4	QTY
5 RZZX-6002	6002 RULMAN (15-32-9)	5	QTY
5 KZKA-5M-15-410	5M-15-410 KAUÇUK ZAMAN KAYIŞI	2	QTY
5 MRD-F1610-140-10-17B-B	F1610-140-10-17B-B 140W.3X220VAC.MOT.REDÜKT. 1/10	2	QTY
5 PNVF-SMC-SY5120-5DZ	SY5120-5DZ-01F-Q 1/8-5/2 KONNEKT. LEDLİ VALF	1	QTY
5 RZZX-6000	6000 RULMAN (10-26-8)	6	QTY
5 RZZX-6001	6001 RULMAN (12-28-8)	1	QTY
5 RZZX-6002	6002 RULMAN (15-32-9)	7	QTY
5 RZZX-6003	6003 RULMAN (17-35-10)	3	QTY



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Stock No	Stock Name	QTY	Unit
5 RZZX-608	608 RULMAN (8-22-7)	6	QTY
5 RZZX-626	626 RULMAN (6-19-6)	6	QTY
5 RYAT-S-UCFL205-KR	S UCFL205 PASL.PLASTİK YATAKLI RULMAN MRS	1	QTY
5 KZKA-5M-15-300	5M-15-300 KAUÇUK ZAMAN KAYIŞI	1	QTY
5 SANKO-SK0412-2-0I-12	SK0412-2.0I-12-ON İNDİKATÖR (SANKO)	1	QTY
5 PLMU-6	A1101-62586- 3 LÜ ÇATAL BAGL.	8	QTY
5 PLMU-7	A1108-62746- LE DÜZ ÇERÇEVE BAGL.	8	QTY
230X4100 BASKI BANT KAYIŞI (KD2LB1302-P9/A/BL) MAVİ	230X4100 BASKI BANT KAYIŞI (KD2LB1302-P9/A/BL) MAVİ	1	QTY
230X2295 BASKI BANT KAYIŞI (KD2LB1302-P9/A/BL) MAVİ	230X2295 BASKI BANT KAYIŞI (KD2LB1302-P9/A/BL) MAVİ	1	QTY
5 PLMU-11	PLASTİK MENTEŞE -49X49 (215.000.103)	8	QTY
5 PLMU-5	ÇERÇEVE MIKNATIZI- (689-000-101) RMCO18	8	QTY
5 PLKO-215-UKK-PA6	215-UKK-PA6 (KAPAK KOLU KENAR PLASTİĞİ) M8 OLMALI	8	QTY
5 PNKS-SMC-20-125	CM2RA20-125 KALEM SİLİNDİR (SMC)	2	QTY
5 PLET-M6-K	M6-KEL.KÜÇ.ERKEK TOPUZ (Q30 M6X20 PASL.SAPL)	8	QTY
5 PLMU-5	ÇERÇEVE MIKNATIZI- (689-000-101) RMCO18	6	QTY
5 PLÇA-3	3 LÜ -48,3mm ÇATAL AYAK- (15084)	1	QTY
5 PLAY-80XM16X162	L00257093 (80XM16X162 M16 PASL.AYAK) MAFSALLI	3	QTY
5 PLYP-1	48,3mm KONV.AYAK YAN BAGL. 14748	1	QTY
5 PLMU-10	6mm ÇERÇEVE KELEPÇESİ-(767 000 006)	22	QTY
5 PLTA-13764	13764 TRAB.KONSOL+TOPUZ (BRAKET) 31mm DF=12,5mm	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 DIŞI SUSTALI KOL SİYAH	4	QTY

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ELECTRONICAL LIST

Electronic List (Top Labelling Machine-3848)



Stock No	Stock Name	QTY	Unit
5 EPPA-660X620X280-P	660X620X280 PASL.PANO	1,00	QTY
5 EFFİ-150X150-FAN	PFB2000-150X150mm 230V.FANLI FİLTRE (TF2000)	1,00	QTY
5 EFFİ-150X150-FİLTRE	PFA-2000-150X150X27mm FİLTRE IZGARA (TFA2000)	1,00	QTY
5 ETERM-KTS011	KTS011-0-60c TERMOSTAT (STEGO)01141.0-00	1,00	QTY
5 EFLA-SNT-74-B-RGB	SNT-74-B-RGB 12-24V.DC 4-RENK BAZIRLI İKAZ LAMBASI	1,00	QTY
5 EHKO-3G3MX2-AB004E-ECT	0,4/0,55 KW. HIZ KONTROL (3G3MX2-AB004-E-ECT)	2,00	QTY
5 EHKO-3G3MX2-AB004E-ECT	0,4/0,55 KW. HIZ KONTROL (3G3MX2-AB004-E-ECT)	1,00	QTY
5 DELTA-NDR-480-48	NDR-480-48 (48VDC.10A.GÜÇ KAYNAĞI) MEAN WELL	1,00	QTY
5 EGKA-S8VK-C12024	S8VK-C12024 (24V.DC 5-A.120W. GÜÇ KAYNAĞI)	1,00	QTY
5 TMK-A9K24110-10AX1	10AX1 W.OTOM.SİGORTA (A9K24110) TMK	2,00	QTY
5 TMK-A9K24110-10AX1	10AX1 W.OTOM.SİGORTA (A9K24110) TMK	1,00	QTY
5 TMK-A9K24106-6AX1	6AX1 W.OTOM.SİGORTA (A9K24106) TMK	1,00	QTY
5 TMK-A9K24106-6AX1	6AX1 W.OTOM.SİGORTA (A9K24106) TMK	1,00	QTY
5 TMK-VCF-01	VCF-01- 20A EMNİYET ŞALTERİ	1,00	QTY
5 TMK-XB5-AS542	XB5-AS8442 ACİL DURDURMA BUTONU	1,00	QTY
5 ETİKET-28113	EMERGENCY ETİKETİ -800F-15YSE112 (ALLEN BRADLEY)	1,00	QTY
5 TMK-XB5-AW33B5	XB5-AW33B5 YEŞİL LEDLİ BUTON	2,00	QTY
5 EFOT-087797-OBT500	087797 OBT500-18GM60-E5-V1 (SOK.CİSİMD.YANS.FOT.)	1,00	QTY
5 ESOK-4-E-4012-PG7	ELWIST 4012-PG7 (4 LÜ ERK.FOT.KONNEKT.)	2,00	QTY
5 SICK-WF2-40B410	WF2-40B410 ÇATAL FOTOSEL SICK-6028428	1,00	QTY
5 BECK-C6030-0060	C6030-0060 ULTRA-COMPACT İNDUSTRIAL PC	1,00	QTY
5 BECK-C9900-C611	C9900-C611 PROCESSOR 6TH GENERATION İNTEL	1,00	QTY
5 BECK-C9900-R270	C9900-R270 MEMORY EXTENSION TO 8 GB DDR4 RAM	1,00	QTY
5 BECK-C9900-S479	C9900-S479 MİCRASOFT WİNDOWS 10 LOT ENTERPRİSE	1,00	QTY
5 BECK-TC1250-OV50	5 BECK-TC1250-ov50 twincat-3 NC LİSANS BECKHOFF	1,00	QTY
5 BECK-EK1100	EK1100 ETHERCAT COUPLER FOR E-BUS TERMİNAL	1,00	QTY
5 BECK-EL1809	EL1809 (16-CHANNEL DİGİTAL İNPUT TERMİNAL	1,00	QTY
5 BECK-EL2809	EL2809 (16-CHANNEL DİGİTAL OUTPUT TERMİNAL	1,00	QTY
5 BECK-EL7221-9014	EL7221-9014 SERVO MOT.TERMİNAL 50VDC.7...8A	1,00	QTY
5 BECK-EL9011	EL9011 (SONLANDIRICI PLAKA)	1,00	QTY
5 BECK-EL9576	EL9576 FREN DİRENCİ ANAHTARLAMA TERMİNALİ	1,00	QTY
5 BECK-ZB8500	ZB8500 (EKTRAN BAĞL.VİDA SIKMA KELEBÇESİ 11mmX8mm)	1,00	QTY
5 BECK-ZB8511	ZB8511 (EKTRANLAMA BARASI 10X3mm	1,00	QTY
5 BECK-ZB8610	ZB8610 FAN CATRİDGE FOR ETHER CAT AND BUS TERMİNAL	1,00	QTY
5 BECK-AM8132-1J10	AM8132-1J10 (SERVO MOTOR) KAMALI BECKHOFF	1,00	QTY
5 BECK-ZK4704-0421-2030	ZK4704-0421-2030 (MOTOR GÜÇ KABLOSU-3mt.)	1,00	QTY

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Stock No	Stock Name	QTY	Unit
5 BECK-ZK1090-9191-0001	ZK1090-9191-0001 (ETHERCAT KABLOSU 0.17m) BECKHOF	2,00	QTY
5 BECK-ZK1090-9191-0005	ZK1090-9191-0005 ETHER CAT KABLOSU 0,50mt	1,00	QTY
5 BECK-ZK1090-9191-0010	ZK1090-9191-0010 ETHER CAT KABLOSU 1mt BECKHOFF	1,00	QTY
5 EMFİ	1X16A. MONOF.TOPR. ERKEK DÜZ FİŞ-3201-301-0300	1,00	QTY
5 BİLG-TPC1507C	15,6" TPC1507C 1920X1080 HDMI+DVI+VGA CAPACİTİVE	1	QTY
5 TMK-XB5-AW31B5	XB5-AW31B5 BEYAZ LEDLİ BUTON	1	QTY
5 TMK-XB5-AW36B5	XB5-AW36B5 MAVİ LEDLİ BUTON	1	QTY
5 KEYENCE-IV-150MA	IV-150MA GÖRÜNTÜ SENSÖRÜ (KAMERA)	1	QTY
5 KEYENCE-IV-M30	IV-M30 KAMERA SENSÖR İÇİN DOKUNM.EKRAN	1	QTY
5 KEYENCE-OP-87441	OP-87441 IV KAMERA SENSÖR KABLOSU 5mt.	1	QTY
5 KEYENCE-OP-87451	OP-87451 IV DOKUNM.EKRAN İLE KAMERA KABLOSU 2mt	1	QTY
5 OMRO-7412-2000-2103	7412-2000-2103 BAR CODE READERS/SMART CAMERAS	1	QTY
5 OMRO-V430-W8-5M	V430-W8-5M M12-12pin SOCKET	1	QTY
5 OMRO-V430-WE-5M	V430-WE-5M M12-8pin SOCKET	1	QTY
5 ESOK-MURR-7000-12721	MURR-7000-12721 M12 5pin ERKEK KONNEKTÖR (MURR)	1	QTY
5 ESOK-MURR-7000-12921	MURR-7000-12921 M12 5pin DİŞİ KONNEKTÖR (MURR)	1	QTY
5 SICK-WL8G-P2131	WL8G-P2131-0.3m REFL.TRANS.CİSİMD.YANS.FOT.6033186	2	QTY
5 SICK-YF8U13-050VA1XLEA	YF8U13-050VA1XLEAX-M8-3pin 5mt (CİS.YAN.FOT.KAB.)	2	QTY
5 OMRO-XS6W-6LSZH8SS200C	XS6W-6LSZH8SS200CM-Y ETHERNET CAT-6 KABLO 2mt.	1	QTY





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6. Critical Sensor List

Critical Sensör List (Top Labelling Machine-3848)

Stock No	Stock Name	QTY	Unit
5 KEYENCE-IV-150MA	IV-150MA GÖRÜNTÜ SENSÖRÜ (KAMERA)	1	QTY
5 SICK-WL8G-P2131	WL8G-P2131-0.3m REFL.TRANS.CİSİMD.YANS.FOT.6033186	2	QTY
5 EFOT-087797-OBT500	087797 OBT500-18GM60-E5-V1 (SOK.CİSİMD.YANS.FOT.)	1	QTY

Testing :	Sign :	Date :
Controlling :	Sign :	Date :
Approving :	Sign :	Date :



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7. Assembling of the Equipment

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?		

Testing :	Sign :	Date :
Controlling :	Sign :	Date :
Approving :	Sign :	Date :



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8. IQ For Electrical and Control Cabinet

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?			

Testing :	Sign :	Date :
Controlling :	Sign :	Date :
Approving :	Sign :	Date :



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9. Hardware Setup Qualification

IQ for PLC Controller

Equipment Code	Equipment Name	QTY	Unit
5 BECK-EK1100	EK1100 ETHERCAT COUPLER FOR E-BUS TERMINALS	1	QTY
5 BECK-EL1809	EL1809 (16-CHANNEL DIGITAL INPUT TERMINAL	1	QTY
5 BECK-EL2809	EL2809 (16-CHANNEL DIGITAL OUTPUT TERMINAL	1	QTY
5 BECK-EL7221-9014	EL7221-9014 SERVO MOT.TERMINAL 50VDC.7...8A	1	QTY
5 BECK-EL9576	EL9576 FREN DİRENCİ ANAHTARLAMA TERMİNALİ	1	QTY
5 BECK-ZB8610	ZB8610 FAN CATRİDGE FOR ETHER CAT AND BUS TERMİNAL	1	QTY

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

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10. Software Installation Qualifications

System Description	
System / Machinery Name	Top Labelling Machine
Serial Number	M-ETK-A02
Manufacturer	ELEKTROMAG
System / Device Design Purpose	HMI
Software Platform	TWINCAT

Installation Info

Operating System	
Operating System	WINDOWS 7 Embedded

PLC Software	
Controller	BECKHOFF
Network Connection	ETHERCAT
Operator Panel	MOVICON
Programming and Configuration Device	TWINCAT
Comments	

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11. IQ Test Specifications

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

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12. Kurulum Kalifikasyon Testleri

Üstten Etiketleme Makinesi

Test No	Test Step	Acceptance Criteria	Has the Acceptance test met?	Applied Par./Date	Approver Par./Date
1.1	Check the electric connections	1.5 kw mono phase 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 labelling 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 what corresponds to what is specified in the electrical diagram of the labeling machine's electrical system.	The electrical system is correctly labeled.	Yes [] No []		
1.6	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 []		
1.7	Check the conveyor group.	The conveyor should be assembled.	Yes [] No []		
1.8	Check the Control Unit	Control type PLC +HMI .	Yes [] No []		
1.9	Check the reject group.	Connections must be made appropriately.	Yes [] No []		
1.10	Check that the enclosure door used in the faulty product basket is closed with a key lock.	it can close enclosure door used in faulty product basket with key lock	Yes [] No []		
1.11	Check module height adjustment	It must beconfigured	Yes [] No []		



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Test No	Test Step	Acceptance Criteria	Has the Acceptance test met?	Applied Par./Date	Approver Par./Date
1.12	Check that the label stretch sheets are closed.	The label tensioning sheet must be closed.	Yes [] No []		
1.13	Check the settings of Videojet Unit.	The videojet unit must be set according to the label to work with.	Yes [] No []		
1.14	Check the Label Cam Settings.	The camera unit must be set according to the label to work with.	Yes [] No []		
1.15	Check the enter photocell.	The enter photocell must be connected.	Yes [] No []		
1.16	Check the exit photocell.	The exit photocell must be connected.	Yes [] No []		
1.17	Check the start photocell	The start photocell must be connected.	Yes [] No []		
1.18	Check the label finish photocells.	The label finish photocell must be connected.	Yes [] No []		
1.19	Check the label stop photocells	The label stop photocell must be connected.	Yes [] No []		
1.20	Check the carton cam. settings	The camera must be set to see the OCR.	Yes [] No []		
1.21	Emergency button check	Should be emergency button.	Yes [] No []		

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13. Additional Test

Test No	Test Step	Acceptance Criteria	Has the Acceptance test met?	Applied Par./Date	Approver Par./Date
			Yes [] No []		
			Yes [] No []		
			Yes [] No []		
			Yes [] No []		

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14. Test Deviation Record/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 finishing 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 :

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15. Comments and Explanation



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16. Appendix

Drawing No	Add	Explanation
3848-ED.126-22.12.2020-01	PDF File	Top Labelling Machine Electric Scheme



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17. Release For OQ

There are shortcomings

- [] 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.

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18. Test Report Acceptance

Prepared by

Name	Department/Function	Date	Sign

Approved by

Name	Department/Function	Date	Sign