

OPERATIONAL QUALIFICATION (OQ)

Project No : EMG-20-040
Date : 24.02.2021
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**AUTOMATIC LINEAR TYPE ROUND BOTTLE
SELF LABELLING MACHINE**

M-ETK-A02

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1. Purpose and Scope

The purpose of this operational qualification document is to provide evidence that the operational qualification work for the Round Bottle Labelling machine and its components has been completed.

Equipment Name	Equipment Code	Equipment / Serial No
Round Bottle Labelling Machine	M-ETK-A02	3845

2. OQ Test Specifications

Points to Consider in Test Protocols

- Fill all procedurs 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. Please do it date and parag.
- Test forms must be completed by authorized personnel simultaneously with the application. 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 / Erros

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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3. Operational Qualification Test

Customer Co.Name :	Equipment Serial No :	Test Applied No : 01
Test Name :Operational Test		
Purpose : proving that its functions work as designed		
Necessary Materials/Documents : Sample Products, packaging products		
Test Acceptance Criteria : Each of the operational qualification steps meet its own acceptance criteria		
Pre Condition : Completion Of Installation Qualification Work		

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Test No	Test Step	Acceptance Criteria	Has the Acceptance test met?	Applied Par./Date	Approver Par./Date
1.1	Open the Paco Switch	Energy must come to the machine and the HMI project must be opened.	Yes [] No []		
1.2	Reset the Alert if Exist	Reseting Alerts	Yes [] No []		
1.3	Open The Machine Door	The Automatic Functione mustnt be work.It must be shown on Alert menü.	Yes [] No []		
1.4	Check the enter photocell	The Helix must stop while the product is absent, and the machine must wait for the input to fill up.	Yes [] No []		
1.5	Check the exit Photocell	The Helix must stop while the product is exist, and the machine must wait for the input to fill up..	Yes [] No []		
1.6	Check the label finish photocell	it Should be stop working machine when output, stop machine should not work.	Yes [] No []		
1.7	Check the functionality of conveyor and side band. (Press the Green button)	If there is no red alarm, the conveyor and side band should work.	Yes [] No []		
1.8	Feed 1 bottle and press machine start button	Start photocell should give the label after seeing the product.	Yes [] No []		
1.9	Feed the conveyor with the bottle and see that the Helix separates the bottles.	Bottles must be separated from each other.	Yes [] No []		
1.10	Check whether the label is properly patted on the bottle.	The label should be patted properly.	Yes [] No []		

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Test No	Test Step	Acceptance Criteria	Has the Acceptance test met?	Applied Par./Date	Approver Par./Date
1.11	Give the machine 10 products and see that the coding is done	The desired encoding must be performed.	Yes [] No []		
1.12	Make the Machine see 1pcs. OCR incorrectly.	The bottle of the faulty label should be rejected.	Yes [] No []		
1.13	Make the Machine see 1pcs. PHC incorrectly.	The bottle of the faulty label should be rejected	Yes [] No []		
1.14	Make machine see 1 unlabeled bottle	Unlabeled bottles should be rejected..	Yes [] No []		
1.15	Make the Machine see faulty OCR 3 times in a consecutive.	Machine should be stop.	Yes [] No []		
1.16	Make the Machine see faulty PHC 3 times in a consecutive	Machine should be stop.	Yes [] No []		
1.17	Make the Machine see the bottle without label 3 times in a consecutive.	Machine should be stop.	Yes [] No []		
1.18	Finish/break the ribbon.	The machine must stop. " Coding off or defective " alarm you should give.	Yes [] No []		
1.19	Close the Markem.	The machine must stop. " Coding off or defective " alarm you should give.	Yes [] No []		
1.20	In the event of a power failure, show that the system has the ability to automatically stop other sources (air, vacuum, etc.) in the machine, allowing the operator to start the machine again.	In case of power failure, the system has the ability to automatically stop other sources (air, vacuum, etc.) in the machine, allowing the operator to start the machine again he should be able to recognize it.	Yes [] No []		

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4. 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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5. Alert Test

Test No	Test Step	Acceptance Criteria	Has the Acceptance test met?	Applied Par./Date	Approver Par./Date
A.1	Press the emergency stop button.	The "Emergency stop pressed" alarm should be given, the running machine should stop, and the machine should not run when the emergency stop is pressed.	Yes [] No []		
A.2	Leave the machine doors open.	'The "doors open" alarm should be given, the running machine should stop. When the alarm is active the machine should not work.	Yes [] No []		
A.3	Cut the air connection.	"There is no air" alarm should be given, the running machine should stop. When the alarm is active the machine should not be running.	Yes [] No []		
A.4	To empty to the enter conveyor.	The "Entry is empty" alarm should be given, and the machine should put itself into standby.	Yes [] No []		
A.5	Close the Markem unit from its panel. Rip off the ribbon.	It should give an alarm "Coding off or faulty" While in alarm, the machine should not work, the running machine should stop.	Yes [] No []		
A.6	To feed the exit conveyor	'The machine that should give the 'full output' alarm must put itself on hold.	Yes [] No []		
A.7	Finish the label of the module group	It should give the alarm "Label over".While in alarm, the machine should not work, the running machine should stop.	Yes [] No []		
A.8	Make the Machine see faulty OCR 3 times in a consecutive.	It should give the alarm "3 consecutive bad OCR" While in alarm, the machine should not work, the running machine should stop.	Yes [] No []		
A.9	Make the Machine see faulty PHC 3 times in a consecutive.	The machine should give a "3 consecutive wrong PHC "alarm and put itself on hold.	Yes [] No []		
A.10	Make the Machine see the bottle without label 3 times in a consecutive.	It should give an alarm "3 consecutive unlabeled bottles" While in alarm, the machine should not work, the running machine should stop.	Yes [] No []		
A.11	Take the machine into manual mode.	It should give the "manual mode active" alarm. While in alarm, the machine should not work, the running machine should stop.	Yes [] No []		
A.12	Feed with the overturned bottle	It should give an "overturned bottle" alarm. While in alarm, the machine should not work, the running machine should stop.	Yes [] No []		
A.13	Send reject until the pieces written in the HMI to the Eject box.	"Eject box full" alarm should give. While in alarm, the machine should not work, the running machine should stop.	Yes [] No []		

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6. Test Report Approved

Prepared by

Name	Department/Function	Date	Sign

Approved by

Name	Department/Function	Date	Sign

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7. Comments and Explanation

