OPERATION QUALIFICATION (OQ)

Project No   : EMG-20-036

Date   : 11.01.2021

Document Ref. Number   : EMG-20-036.OQ

AUTOMATIC VOLUMETRIC 8 NOZZLES FILLING MACHINE

M-ODM-A05-CF

YOUR INOVATION SOLUTION PARTNER

1. Purpose and Scope

The purpose of this operational qualification document is to provide evidence that the operational qualification work for the volumetric 8-nozzle filling machine and its components has been completed.

Equipment Name	Equipment Code	Equipment / Serial No
Volumetric 8 Nozzles Filling Machine	M-ODM-A05-CF	3842

2. OQ Test Specifications

Considerations in The 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 paragh.
- 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

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 : Tüm operasyonel kalifikasyonu adımlarının her birinin kendi kabul kriterini karşılaması

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	Do Machine Home Position.	The machine group should g oto home pos.	Yes [ ]	No [ ]		
1.4	Open The Machine Door	The Automatic Functione mustnt be work.It must be shown on Alert menü.	Yes [ ]	No [ ]		
1.6	Check if the enter photocell seen the product	The input empty alarm should come while the product is absent and the machine should not work.	Yes [ ]	No [ ]		
1.6	Check if the bottle falling sensor is working.	Check that the machine stops when the bottle falling.	Yes [ ]	No [ ]		
1.7	Check if the exit photocell seen the product	The exit full alarm should come while the product exists and the machine should not work	Yes [ ]	No [ ]		
1.8	Check if the cutter photocell seen the product	The cutter should signal when it sees the photocell product. Cutters must work according to this photocell.	Yes [ ]	No [ ]		
1.9	Press the Conveyor Start Button	Conveyor should be work	Yes [ ]	No [ ]		

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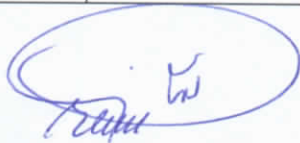| Test No	Test Step	Acceptance Criteria	Has the Acceptance test met?		Applied Par./Date	Approver Par./Date
1.10	Do empty on the enter conveyor and press machine start button.	Not start the Filling Process	Yes [ ]	No [ ]		
1.11	Do full on the exit conveyor and press machine start button	Not start the Filling Process	Yes [ ]	No [ ]		
1.12	Feeding enter conveyor by bottle and do it empty exit.Press filling start button	Not start the Filling Process	Yes [ ]	No [ ]		
1.13	Check with your eye that the product that will be filled into the machine is coming.	It should be seen that the product comes to the hoses.	Yes [ ]	No [ ]		
1.14	See if the nozzles go up when the filling is done.	When the filling is finished, the nozzles should rise up.	Yes [ ]	No [ ]		
1.15	See that the output cutter is opened when the nozzles are raised, and the input cutter is also opened with delay.	Should be open both.	Yes [ ]	No [ ]		
1.16	When finish the last full bottle by cutter photocell, Check exit cutter closed	When you finish seeing the bottle, the cutter should close.	Yes [ ]	No [ ]		
1.17	Open the door during the machine is working.	The machine must be stop by the emergency switch.	Yes [ ]	No [ ]		
1.18	Press the emergecny stop during the machine is working.	Machine must be stop.	Yes [ ]	No [ ]		
1.19	Fill the product to the exit conveyor during the machine is working.	The machine put itself on hold and give the alert.	Yes [ ]	No [ ]		
1.20	To empty enter conveyor during the machine is working.	The machine put itself on hold and give the alert.	Yes [ ]	No [ ]		

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Test No	Test Step	Acceptance Criteria	Has the Acceptance test met?	Applied Par./Date	Approver Par./Date
1.21	Put the machine in cleaning mode.	Cleaning should begin with the entered data.	Yes [ ] No [ ]		
1.22	Check that the receipt records, alarms are recorded in the system.	Receipt records and alarm logs should be stored in the system and should not be deleted.	Yes [ ] No [ ]		
1.23	Check the filling volume.	Filling volume should be ± 0.3	Yes [ ] No [ ]		
1.24	Show automatic adjustment of filling volume and speed from display.	The filling volume and speed should be adjusted automatically from the display.	Yes [ ] No [ ]		
1.25	On the Home screen, process parameters, set points, alarms, parameter values (Time, Speed, etc.) show that you can enter a prescription with properties during the operation.	On the Home screen, process parameters, set points, alarms, parameter values (Time, Speed, etc.) it should be prescribed during the operation.	Yes [ ] No [ ]		
1.26	Show that the machine has jog mode, the machine can work in jog mode when the covers are open.	The machine should have jog mode. The machine should be able to operate in jog mode when the covers are open.	Yes [ ] No [ ]		
1.27	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 the event of a power failure, the system should be able to automatically stop other sources (air, vacuum, etc.) in the machine and allow the operator to start the machine again.	Yes [ ] No [ ]		
1.28	Show that the machine can fill glass and plastic bottles.	The machine should be able to fill glass and plastic bottles.	Yes [ ] No [ ]		

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 should alarm when pressed, the working machine should stop, the machine should not work when the emergency stop is pressed.	Yes [ ] No [ ]		
A.2	Leave the machine doors open.	Give door open alert, the machine stop. The machine not working when alert active.	Yes [ ] No [ ]]		
A.3	Cut the air connection.	Give no air alert,The machine stop. The machine not working when alert active.	Yes [ ] No [ ]		
A.4	To empty to the enter conveyor.	Give enter empty alert, the machine should put itself on hold.	Yes [ ] No [ ]		
A.5	Feed overturn bottle to the enter conveyor.	Give overturn bottle alert,machine stop. The machine should not work when the Alarm is active.	Yes [ ] No [ ]		
A.6	To fill to the exit conveyor by the bottle.	Give exit full alert, the machine should put itself on hold..	Yes [ ] No [ ]		
A.7	Make enter cutter go forward.	It give that the enter cutter didnt come back alert. (Ask machine response)	Yes [ ] No [ ]		
A.8	Make exit cutter go forward.	It give that the exit cutter didnt come back alert. (Ask machine response)	Yes [ ] No [ ]		
A.9	Make neckled group go forward	It give that the neckled piston didnt come back alert. (Ask machine response)	Yes [ ] No [ ]		

6. Test Report Confirmation

Prepared by

Name	Department/Function	Date	Sign

Accepted by

Name	Department/Function	Date	Sign

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7. **Comments and Explanation**