



Akums Drugs & Pharmaceuticals Ltd.

Gelatin Process Report

| | | | |
|------------------|--------|-----------------|--|
| NAME OF OPERATOR | rakesh | NAME OF PRODUCT | |
| BATCH NO. | | BATCH SIZE | |
| MFG Date | | EXP. Date | |
| LOT NO. | | LOT SIZE | |

| STILER RPM | | VOLTAGE (STILER) | VACUUM | | CURRENT (STILER) | PROCESS TIME | | TEMPERATURE | |
|------------|-------|---------------------|--------|--------|---------------------|--------------|------------|-------------|--------|
| DATE/TIME | SET | ACTUAL | SET | ACTUAL | ACTUAL | SET | ACTUAL | SET | ACTUAL |
| (rpm) | (rpm) | (Volt) | (mmHg) | (mmHg) | (A) | (Min)(Sec) | (Min)(Sec) | (°C) | (°C) |
| 35 | 0 | 0.0 | 500 | 715 | 0.0 | 2 5 | 0 0 | 65 | 37 |
| 55 | 0 | 0.0 | 500 | 630 | 0.0 | 10 55 | 7 25 | 70 | 48 |
| 55 | 0 | 0.0 | 500 | 630 | 0.0 | 10 55 | 8 3 | 70 | 46 |
| 55 | 55 | 425.0 | 500 | 630 | 3.0 | 10 55 | 9 3 | 70 | 43 |
| 55 | 55 | 424.0 | 500 | 630 | 3.0 | 10 55 | 10 3 | 70 | 42 |
| 55 | 0 | 0.0 | 500 | 630 | 0.0 | 10 55 | 10 26 | 70 | 58 |
| 55 | 0 | 0.0 | 500 | 630 | 0.0 | 10 55 | 0 0 | 70 | 58 |
| 55 | 55 | 417.0 | 500 | 630 | 5.0 | 10 55 | 1 1 | 70 | 49 |
| 55 | 55 | 414.0 | 500 | 630 | 5.0 | 10 55 | 2 1 | 70 | 46 |
| 55 | 55 | 414.0 | 500 | 630 | 5.0 | 10 55 | 3 1 | 70 | 46 |
| 55 | 0 | 0.0 | 500 | 630 | 0.0 | 10 55 | 3 3 | 70 | 66 |
| 55 | 55 | 421.0 | 500 | 630 | 4.0 | 10 55 | 4 4 | 70 | 64 |
| 55 | 55 | 418.0 | 500 | 630 | 4.0 | 10 55 | 5 4 | 70 | 58 |
| 55 | 55 | 416.0 | 500 | 630 | 4.0 | 10 55 | 6 4 | 70 | 56 |
| 55 | 55 | 423.0 | 500 | 630 | 4.0 | 10 55 | 7 4 | 70 | 55 |
| 55 | 55 | 422.0 | 500 | 630 | 4.0 | 10 55 | 8 4 | 70 | 55 |
| 55 | 0 | 0.0 | 500 | 630 | 0.0 | 10 55 | 8 16 | 70 | 55 |
| 55 | 55 | 430.0 | 500 | 630 | 3.0 | 10 55 | 9 16 | 70 | 52 |
| 55 | 55 | 430.0 | 500 | 630 | 3.0 | 10 55 | 10 16 | 70 | 51 |
| 55 | 0 | 0.0 | 500 | 630 | 0.0 | 10 55 | 0 0 | 70 | 75 |
| 55 | 55 | 427.0 | 500 | 630 | 3.0 | 10 55 | 1 1 | 70 | 69 |
| 55 | 55 | 426.0 | 500 | 630 | 3.0 | 10 55 | 2 1 | 70 | 65 |
| 55 | 0 | 0.0 | 500 | 0 | 0.0 | 4 0 | 2 24 | 70 | 61 |
| 55 | 55 | 427.0 | 500 | 0 | 3.0 | 4 0 | 3 24 | 70 | 58 |
| 55 | 0 | 0.0 | 500 | 0 | 0.0 | 6 0 | 0 0 | 70 | 56 |
| 55 | 55 | 426.0 | 500 | 0 | 3.0 | 6 0 | 1 0 | 70 | 54 |
| 55 | 55 | 428.0 | 500 | 0 | 3.0 | 6 0 | 2 0 | 70 | 54 |
| 55 | 0 | 0.0 | 500 | 0 | 0.0 | 5 0 | 0 0 | 70 | 45 |
| 55 | 55 | 429.0 | 500 | 0 | 3.0 | 5 0 | 1 1 | 70 | 45 |
| 55 | 55 | 430.0 | 500 | 0 | 3.0 | 5 0 | 2 1 | 70 | 46 |
| 55 | 55 | 427.0 | 500 | 0 | 3.0 | 5 0 | 3 1 | 70 | 46 |
| 55 | 55 | 428.0 | 500 | 0 | 3.0 | 5 0 | 4 1 | 70 | 47 |
| 55 | 0 | 0.0 | 500 | 0 | 0.0 | 4 0 | 0 1 | 70 | 47 |
| 55 | 0 | 0.0 | 500 | 0 | 0.0 | 4 0 | 0 24 | 70 | 44 |
| 55 | 11 | 118.0 | 500 | 0 | 6.0 | 4 0 | 1 15 | 70 | 42 |
| 55 | 55 | 427.0 | 500 | 0 | 3.0 | 4 0 | 2 15 | 70 | 42 |
| 55 | 55 | 426.0 | 500 | 0 | 3.0 | 4 0 | 3 15 | 70 | 42 |
| 55 | 0 | 0.0 | 500 | 0 | 0.0 | 8 0 | 0 0 | 70 | 56 |
| 55 | 0 | 0.0 | 500 | 0 | 0.0 | 8 0 | 0 2 | 70 | 56 |
| 55 | 0 | 0.0 | 500 | 0 | 0.0 | 8 0 | 0 4 | 70 | 54 |

| STILER RPM | | | VOLTAGE (STILLER) | VACUUM | CURRENT (STILER) | | PROCESS TIME | | | TEMPERATURE | |
|------------|----|-------|----------------------|--------|---------------------|----|--------------|---|----|-------------|----|
| 55 | 55 | 426.0 | 500 | 0 | 4.0 | 8 | 0 | 1 | 4 | 70 | 63 |
| 55 | 55 | 426.0 | 500 | 0 | 3.0 | 8 | 0 | 2 | 4 | 70 | 59 |
| 55 | 55 | 427.0 | 500 | 0 | 4.0 | 8 | 0 | 3 | 4 | 70 | 58 |
| 55 | 55 | 425.0 | 500 | 0 | 4.0 | 8 | 0 | 4 | 4 | 70 | 58 |
| 55 | 55 | 426.0 | 500 | 0 | 4.0 | 8 | 0 | 5 | 4 | 70 | 58 |
| 55 | 55 | 423.0 | 500 | 0 | 4.0 | 8 | 0 | 6 | 4 | 70 | 58 |
| 55 | 55 | 425.0 | 500 | 0 | 4.0 | 8 | 0 | 7 | 4 | 70 | 58 |
| 55 | 0 | 0.0 | 500 | 0 | 0.0 | 4 | 0 | 0 | 1 | 70 | 59 |
| 55 | 55 | 427.0 | 500 | 0 | 4.0 | 4 | 0 | 1 | 1 | 70 | 54 |
| 55 | 55 | 430.0 | 500 | 0 | 4.0 | 4 | 0 | 2 | 1 | 70 | 52 |
| 55 | 55 | 429.0 | 500 | 0 | 3.0 | 4 | 0 | 3 | 1 | 70 | 51 |
| 55 | 0 | 0.0 | 500 | 0 | 0.0 | 10 | 0 | 0 | 0 | 70 | 68 |
| 55 | 55 | 436.0 | 500 | 0 | 3.0 | 10 | 0 | 1 | 0 | 70 | 69 |
| 55 | 55 | 435.0 | 500 | 0 | 3.0 | 10 | 0 | 2 | 0 | 70 | 64 |
| 55 | 55 | 432.0 | 500 | 0 | 3.0 | 10 | 0 | 3 | 0 | 70 | 64 |
| 55 | 55 | 431.0 | 500 | 0 | 3.0 | 10 | 0 | 4 | 0 | 70 | 64 |
| 55 | 55 | 433.0 | 500 | 0 | 3.0 | 10 | 0 | 5 | 0 | 70 | 64 |
| 55 | 55 | 436.0 | 500 | 0 | 3.0 | 10 | 0 | 6 | 0 | 70 | 64 |
| 55 | 55 | 436.0 | 500 | 0 | 3.0 | 10 | 0 | 7 | 0 | 70 | 64 |
| 55 | 55 | 431.0 | 500 | 0 | 3.0 | 10 | 0 | 8 | 0 | 70 | 64 |
| 55 | 55 | 431.0 | 500 | 0 | 3.0 | 10 | 0 | 9 | 0 | 70 | 64 |
| 55 | 0 | 0.0 | 500 | 0 | 0.0 | 5 | 0 | 0 | 0 | 70 | 62 |
| 55 | 55 | 438.0 | 500 | 0 | 3.0 | 5 | 0 | 1 | 0 | 70 | 62 |
| 55 | 55 | 438.0 | 500 | 0 | 3.0 | 5 | 0 | 2 | 0 | 70 | 61 |
| 55 | 55 | 438.0 | 500 | 0 | 3.0 | 5 | 0 | 3 | 0 | 70 | 60 |
| 55 | 55 | 438.0 | 500 | 0 | 3.0 | 5 | 0 | 4 | 0 | 70 | 60 |
| 55 | 0 | 0.0 | 500 | 0 | 0.0 | 4 | 0 | 0 | 0 | 70 | 57 |
| 55 | 0 | 0.0 | 500 | 0 | 0.0 | 4 | 0 | 0 | 19 | 70 | 55 |
| 55 | 0 | 0.0 | 500 | 0 | 0.0 | 4 | 0 | 0 | 42 | 70 | 54 |
| 55 | 55 | 435.0 | 500 | 0 | 3.0 | 4 | 0 | 1 | 42 | 70 | 50 |
| 55 | 55 | 435.0 | 500 | 0 | 3.0 | 4 | 0 | 2 | 42 | 70 | 50 |
| 55 | 55 | 434.0 | 500 | 0 | 3.0 | 4 | 0 | 3 | 42 | 70 | 54 |
| 55 | 0 | 0.0 | 500 | 0 | 0.0 | 8 | 0 | 0 | 0 | 70 | 69 |
| 55 | 55 | 434.0 | 500 | 0 | 3.0 | 8 | 0 | 1 | 1 | 70 | 70 |
| 55 | 55 | 432.0 | 500 | 0 | 3.0 | 8 | 0 | 2 | 1 | 70 | 66 |
| 55 | 55 | 433.0 | 500 | 0 | 3.0 | 8 | 0 | 3 | 1 | 70 | 63 |
| 55 | 55 | 432.0 | 500 | 0 | 4.0 | 8 | 0 | 4 | 1 | 70 | 63 |
| 55 | 55 | 431.0 | 500 | 0 | 4.0 | 8 | 0 | 5 | 1 | 70 | 62 |
| 55 | 0 | 0.0 | 500 | 0 | 0.0 | 8 | 0 | 5 | 9 | 70 | 67 |
| 55 | 55 | 431.0 | 500 | 0 | 3.0 | 8 | 0 | 6 | 10 | 70 | 68 |
| 55 | 55 | 429.0 | 500 | 0 | 4.0 | 8 | 0 | 7 | 10 | 70 | 66 |
| 55 | 0 | 0.0 | 500 | 0 | 0.0 | 4 | 0 | 0 | 1 | 70 | 66 |
| 55 | 55 | 432.0 | 500 | 0 | 4.0 | 4 | 0 | 1 | 1 | 70 | 60 |
| 55 | 55 | 432.0 | 500 | 0 | 3.0 | 4 | 0 | 2 | 1 | 70 | 57 |
| 55 | 55 | 433.0 | 500 | 0 | 3.0 | 4 | 0 | 3 | 1 | 70 | 58 |
| 55 | 0 | 0.0 | 500 | 0 | 0.0 | 10 | 0 | 0 | 0 | 70 | 70 |
| 55 | 55 | 426.0 | 500 | 0 | 3.0 | 10 | 0 | 1 | 1 | 70 | 69 |
| 55 | 55 | 427.0 | 500 | 0 | 3.0 | 10 | 0 | 2 | 1 | 70 | 67 |
| 55 | 55 | 431.0 | 500 | 0 | 3.0 | 10 | 0 | 3 | 1 | 70 | 67 |
| 55 | 55 | 428.0 | 500 | 0 | 3.0 | 10 | 0 | 4 | 1 | 70 | 66 |
| 55 | 55 | 427.0 | 500 | 0 | 3.0 | 10 | 0 | 5 | 1 | 70 | 66 |
| 55 | 55 | 428.0 | 500 | 0 | 3.0 | 10 | 0 | 6 | 1 | 70 | 66 |
| 55 | 55 | 427.0 | 500 | 0 | 3.0 | 10 | 0 | 7 | 1 | 70 | 66 |
| 55 | 55 | 429.0 | 500 | 0 | 3.0 | 10 | 0 | 8 | 1 | 70 | 68 |
| 55 | 55 | 428.0 | 500 | 0 | 3.0 | 10 | 0 | 9 | 1 | 70 | 69 |

| STILER RPM | | VOLTAGE (STILLER) | VACUUM | CURRENT (STILER) | PROCESS TIME | TEMPERATURE |
|------------|--|----------------------|--------|---------------------|--------------|-------------|
|------------|--|----------------------|--------|---------------------|--------------|-------------|

| | | | | | | | | | | | |
|----|----|-------|-----|---|-----|----|---|---|----|----|----|
| 55 | 0 | 0.0 | 500 | 0 | 0.0 | 5 | 0 | 0 | 0 | 70 | 57 |
| 55 | 0 | 32.0 | 500 | 0 | 7.0 | 5 | 0 | 0 | 19 | 70 | 56 |
| 55 | 17 | 171.0 | 500 | 0 | 5.0 | 5 | 0 | 0 | 41 | 70 | 54 |
| 55 | 55 | 430.0 | 500 | 0 | 3.0 | 5 | 0 | 1 | 41 | 70 | 51 |
| 55 | 55 | 431.0 | 500 | 0 | 3.0 | 5 | 0 | 2 | 41 | 70 | 49 |
| 55 | 55 | 428.0 | 500 | 0 | 3.0 | 5 | 0 | 3 | 41 | 70 | 50 |
| 55 | 55 | 426.0 | 500 | 0 | 3.0 | 5 | 0 | 4 | 41 | 70 | 51 |
| 55 | 0 | 0.0 | 500 | 0 | 0.0 | 4 | 0 | 0 | 1 | 70 | 67 |
| 55 | 55 | 429.0 | 500 | 0 | 3.0 | 4 | 0 | 1 | 1 | 70 | 67 |
| 55 | 55 | 429.0 | 500 | 0 | 3.0 | 4 | 0 | 2 | 1 | 70 | 62 |
| 55 | 55 | 432.0 | 500 | 0 | 3.0 | 4 | 0 | 3 | 1 | 70 | 58 |
| 55 | 0 | 0.0 | 500 | 0 | 0.0 | 8 | 0 | 0 | 1 | 70 | 69 |
| 55 | 55 | 430.0 | 500 | 0 | 3.0 | 8 | 0 | 1 | 1 | 70 | 68 |
| 55 | 55 | 432.0 | 500 | 0 | 3.0 | 8 | 0 | 2 | 1 | 70 | 64 |
| 55 | 55 | 430.0 | 500 | 0 | 3.0 | 8 | 0 | 3 | 1 | 70 | 63 |
| 55 | 55 | 430.0 | 500 | 0 | 3.0 | 8 | 0 | 4 | 1 | 70 | 63 |
| 55 | 55 | 431.0 | 500 | 0 | 3.0 | 8 | 0 | 5 | 1 | 70 | 63 |
| 55 | 55 | 430.0 | 500 | 0 | 3.0 | 8 | 0 | 6 | 1 | 70 | 63 |
| 55 | 55 | 429.0 | 500 | 0 | 3.0 | 8 | 0 | 7 | 1 | 70 | 63 |
| 55 | 0 | 0.0 | 500 | 0 | 0.0 | 4 | 0 | 0 | 0 | 70 | 61 |
| 55 | 55 | 432.0 | 500 | 0 | 3.0 | 4 | 0 | 1 | 0 | 70 | 57 |
| 55 | 55 | 431.0 | 500 | 0 | 3.0 | 4 | 0 | 2 | 0 | 70 | 55 |
| 55 | 55 | 434.0 | 500 | 0 | 3.0 | 4 | 0 | 3 | 0 | 70 | 54 |
| 55 | 0 | 0.0 | 500 | 0 | 0.0 | 10 | 0 | 0 | 1 | 70 | 70 |
| 55 | 55 | 427.0 | 500 | 0 | 3.0 | 10 | 0 | 1 | 1 | 70 | 70 |
| 55 | 55 | 429.0 | 500 | 0 | 3.0 | 10 | 0 | 2 | 1 | 70 | 68 |
| 55 | 55 | 432.0 | 500 | 0 | 3.0 | 10 | 0 | 3 | 1 | 70 | 68 |
| 55 | 55 | 435.0 | 500 | 0 | 3.0 | 10 | 0 | 4 | 1 | 70 | 67 |
| 55 | 55 | 433.0 | 500 | 0 | 3.0 | 10 | 0 | 5 | 1 | 70 | 67 |
| 55 | 55 | 435.0 | 500 | 0 | 3.0 | 10 | 0 | 6 | 1 | 70 | 68 |
| 55 | 55 | 435.0 | 500 | 0 | 3.0 | 10 | 0 | 7 | 1 | 70 | 70 |
| 55 | 55 | 431.0 | 500 | 0 | 3.0 | 10 | 0 | 8 | 1 | 70 | 70 |
| 55 | 55 | 433.0 | 500 | 0 | 3.0 | 10 | 0 | 9 | 1 | 70 | 71 |
| 55 | 0 | 0.0 | 500 | 0 | 0.0 | 5 | 0 | 0 | 0 | 70 | 53 |
| 55 | 0 | 0.0 | 500 | 0 | 0.0 | 5 | 0 | 0 | 24 | 70 | 50 |
| 55 | 17 | 171.0 | 500 | 0 | 5.0 | 5 | 0 | 0 | 50 | 70 | 49 |
| 55 | 55 | 430.0 | 500 | 0 | 3.0 | 5 | 0 | 1 | 50 | 70 | 46 |
| 55 | 55 | 429.0 | 500 | 0 | 3.0 | 5 | 0 | 2 | 50 | 70 | 47 |
| 55 | 55 | 428.0 | 500 | 0 | 3.0 | 5 | 0 | 3 | 50 | 70 | 49 |
| 55 | 55 | 431.0 | 500 | 0 | 3.0 | 5 | 0 | 4 | 50 | 70 | 50 |
| 55 | 0 | 0.0 | 500 | 0 | 0.0 | 4 | 0 | 0 | 0 | 70 | 64 |
| 55 | 55 | 428.0 | 500 | 0 | 3.0 | 4 | 0 | 1 | 0 | 70 | 62 |
| 55 | 55 | 426.0 | 500 | 0 | 3.0 | 4 | 0 | 2 | 0 | 70 | 55 |
| 55 | 55 | 425.0 | 500 | 0 | 4.0 | 4 | 0 | 3 | 0 | 70 | 54 |
| 55 | 0 | 0.0 | 500 | 0 | 0.0 | 8 | 0 | 0 | 0 | 70 | 68 |
| 55 | 55 | 427.0 | 500 | 0 | 3.0 | 8 | 0 | 1 | 0 | 70 | 67 |
| 55 | 55 | 426.0 | 500 | 0 | 3.0 | 8 | 0 | 2 | 0 | 70 | 62 |
| 55 | 55 | 430.0 | 500 | 0 | 3.0 | 8 | 0 | 3 | 0 | 70 | 61 |
| 55 | 55 | 426.0 | 500 | 0 | 3.0 | 8 | 0 | 4 | 0 | 70 | 61 |
| 55 | 55 | 428.0 | 500 | 0 | 3.0 | 8 | 0 | 5 | 0 | 70 | 61 |
| 55 | 55 | 431.0 | 500 | 0 | 3.0 | 8 | 0 | 6 | 0 | 70 | 61 |
| 55 | 55 | 430.0 | 500 | 0 | 3.0 | 8 | 0 | 7 | 0 | 70 | 62 |
| 55 | 0 | 0.0 | 500 | 0 | 0.0 | 4 | 0 | 0 | 1 | 70 | 63 |
| 55 | 55 | 436.0 | 500 | 0 | 3.0 | 4 | 0 | 1 | 1 | 70 | 58 |

| STILER RPM | | VOLTAGE (STILLER) | VACUUM | CURRENT (STILER) | PROCESS TIME | TEMPERATURE |
|------------|--|----------------------|--------|---------------------|--------------|-------------|
|------------|--|----------------------|--------|---------------------|--------------|-------------|

| | | | | | | | | | | | |
|----|----|-------|-----|---|-----|----|---|---|---|----|----|
| 55 | 55 | 431.0 | 500 | 0 | 3.0 | 4 | 0 | 2 | 1 | 70 | 55 |
| 55 | 55 | 430.0 | 500 | 0 | 3.0 | 4 | 0 | 3 | 1 | 70 | 55 |
| 55 | 0 | 0.0 | 500 | 0 | 0.0 | 10 | 0 | 0 | 0 | 70 | 64 |
| 55 | 0 | 0.0 | 500 | 0 | 0.0 | 10 | 0 | 0 | 2 | 70 | 63 |
| 55 | 55 | 428.0 | 500 | 0 | 3.0 | 10 | 0 | 1 | 2 | 70 | 67 |
| 55 | 55 | 428.0 | 500 | 0 | 3.0 | 10 | 0 | 2 | 2 | 70 | 66 |
| 55 | 55 | 429.0 | 500 | 0 | 3.0 | 10 | 0 | 3 | 2 | 70 | 65 |
| 55 | 55 | 429.0 | 500 | 0 | 3.0 | 10 | 0 | 4 | 2 | 70 | 67 |
| 55 | 55 | 428.0 | 500 | 0 | 3.0 | 10 | 0 | 5 | 2 | 70 | 68 |
| 55 | 55 | 429.0 | 500 | 0 | 3.0 | 10 | 0 | 6 | 2 | 70 | 68 |
| 55 | 55 | 432.0 | 500 | 0 | 3.0 | 10 | 0 | 7 | 2 | 70 | 68 |
| 55 | 55 | 429.0 | 500 | 0 | 3.0 | 10 | 0 | 8 | 2 | 70 | 67 |
| 55 | 55 | 429.0 | 500 | 0 | 3.0 | 10 | 0 | 9 | 2 | 70 | 67 |

| | | | |
|-------------------------|--|--------------------|--|
| SIGN/DATE | | SIGN/DATE | |
| Checked by (production) | | Verified by (IPQA) | |