



## 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        |  |

| DATE/TIME           | STILER RPM   |                 | VOLTAGE<br>(STILLER) | VACUUM        |                  | CURRENT<br>(STILER) | PROCESS TIME |                 |              |                 | TEMPERATURE |                |
|---------------------|--------------|-----------------|----------------------|---------------|------------------|---------------------|--------------|-----------------|--------------|-----------------|-------------|----------------|
|                     | SET<br>(rpm) | ACTUAL<br>(rpm) | ACTUAL<br>(Volt)     | SET<br>(mmHg) | ACTUAL<br>(mmHg) | ACTUAL<br>(A)       | SET<br>(Min) | ACTUAL<br>(Sec) | SET<br>(Min) | ACTUAL<br>(Sec) | SET<br>(°C) | ACTUAL<br>(°C) |
| 2018-07-24 14:44:50 | 35           | 0               | 0.0                  | 500           | 715              | 0.0                 | 2            | 5               | 0            | 0               | 65          | 37             |
| 2018-07-30 10:35:27 | 55           | 0               | 0.0                  | 500           | 630              | 0.0                 | 10           | 55              | 7            | 25              | 70          | 48             |
| 2018-07-30 10:36:42 | 55           | 0               | 0.0                  | 500           | 630              | 0.0                 | 10           | 55              | 8            | 3               | 70          | 46             |
| 2018-07-30 10:37:42 | 55           | 55              | 425.0                | 500           | 630              | 3.0                 | 10           | 55              | 9            | 3               | 70          | 43             |
| 2018-07-30 10:38:42 | 55           | 55              | 424.0                | 500           | 630              | 3.0                 | 10           | 55              | 10           | 3               | 70          | 42             |
| 2018-07-30 11:09:04 | 55           | 0               | 0.0                  | 500           | 630              | 0.0                 | 10           | 55              | 10           | 26              | 70          | 58             |
| 2018-07-30 11:10:14 | 55           | 0               | 0.0                  | 500           | 630              | 0.0                 | 10           | 55              | 0            | 0               | 70          | 58             |
| 2018-07-30 11:11:14 | 55           | 55              | 417.0                | 500           | 630              | 5.0                 | 10           | 55              | 1            | 1               | 70          | 49             |
| 2018-07-30 11:12:14 | 55           | 55              | 414.0                | 500           | 630              | 5.0                 | 10           | 55              | 2            | 1               | 70          | 46             |
| 2018-07-30 11:13:14 | 55           | 55              | 414.0                | 500           | 630              | 5.0                 | 10           | 55              | 3            | 1               | 70          | 46             |
| 2018-07-30 12:13:56 | 55           | 0               | 0.0                  | 500           | 630              | 0.0                 | 10           | 55              | 3            | 3               | 70          | 66             |
| 2018-07-30 12:14:56 | 55           | 55              | 421.0                | 500           | 630              | 4.0                 | 10           | 55              | 4            | 4               | 70          | 64             |
| 2018-07-30 12:15:56 | 55           | 55              | 418.0                | 500           | 630              | 4.0                 | 10           | 55              | 5            | 4               | 70          | 58             |
| 2018-07-30 12:16:56 | 55           | 55              | 416.0                | 500           | 630              | 4.0                 | 10           | 55              | 6            | 4               | 70          | 56             |
| 2018-07-30 12:17:56 | 55           | 55              | 423.0                | 500           | 630              | 4.0                 | 10           | 55              | 7            | 4               | 70          | 55             |
| 2018-07-30 12:18:56 | 55           | 55              | 422.0                | 500           | 630              | 4.0                 | 10           | 55              | 8            | 4               | 70          | 55             |
| 2018-07-30 12:23:21 | 55           | 0               | 0.0                  | 500           | 630              | 0.0                 | 10           | 55              | 8            | 16              | 70          | 55             |
| 2018-07-30 12:24:21 | 55           | 55              | 430.0                | 500           | 630              | 3.0                 | 10           | 55              | 9            | 16              | 70          | 52             |
| 2018-07-30 12:25:21 | 55           | 55              | 430.0                | 500           | 630              | 3.0                 | 10           | 55              | 10           | 16              | 70          | 51             |
| 2018-07-30 13:24:48 | 55           | 0               | 0.0                  | 500           | 630              | 0.0                 | 10           | 55              | 0            | 0               | 70          | 75             |
| 2018-07-30 13:25:48 | 55           | 55              | 427.0                | 500           | 630              | 3.0                 | 10           | 55              | 1            | 1               | 70          | 69             |
| 2018-07-30 13:26:48 | 55           | 55              | 426.0                | 500           | 630              | 3.0                 | 10           | 55              | 2            | 1               | 70          | 65             |
| 2018-09-12 15:56:27 | 55           | 0               | 0.0                  | 500           | 0                | 0.0                 | 4            | 0               | 2            | 24              | 70          | 61             |
| 2018-09-12 15:57:27 | 55           | 55              | 427.0                | 500           | 0                | 3.0                 | 4            | 0               | 3            | 24              | 70          | 58             |
| 2018-09-12 15:58:23 | 55           | 0               | 0.0                  | 500           | 0                | 0.0                 | 6            | 0               | 0            | 0               | 70          | 56             |
| 2018-09-12 15:59:23 | 55           | 55              | 426.0                | 500           | 0                | 3.0                 | 6            | 0               | 1            | 0               | 70          | 54             |
| 2018-09-12 16:00:22 | 55           | 55              | 428.0                | 500           | 0                | 3.0                 | 6            | 0               | 2            | 0               | 70          | 54             |
| 2018-09-24 10:55:23 | 55           | 0               | 0.0                  | 500           | 0                | 0.0                 | 5            | 0               | 0            | 0               | 70          | 45             |
| 2018-09-24 10:56:23 | 55           | 55              | 429.0                | 500           | 0                | 3.0                 | 5            | 0               | 1            | 1               | 70          | 45             |
| 2018-09-24 10:57:23 | 55           | 55              | 430.0                | 500           | 0                | 3.0                 | 5            | 0               | 2            | 1               | 70          | 46             |
| 2018-09-24 10:58:23 | 55           | 55              | 427.0                | 500           | 0                | 3.0                 | 5            | 0               | 3            | 1               | 70          | 46             |
| 2018-09-24 10:59:23 | 55           | 55              | 428.0                | 500           | 0                | 3.0                 | 5            | 0               | 4            | 1               | 70          | 47             |
| 2018-09-24 11:01:56 | 55           | 0               | 0.0                  | 500           | 0                | 0.0                 | 4            | 0               | 0            | 1               | 70          | 47             |
| 2018-09-24 11:02:40 | 55           | 0               | 0.0                  | 500           | 0                | 0.0                 | 4            | 0               | 0            | 24              | 70          | 44             |
| 2018-09-24 11:03:40 | 55           | 11              | 118.0                | 500           | 0                | 6.0                 | 4            | 0               | 1            | 15              | 70          | 42             |
| 2018-09-24 11:04:40 | 55           | 55              | 427.0                | 500           | 0                | 3.0                 | 4            | 0               | 2            | 15              | 70          | 42             |
| 2018-09-24 11:05:40 | 55           | 55              | 426.0                | 500           | 0                | 3.0                 | 4            | 0               | 3            | 15              | 70          | 42             |
| 2018-09-24 11:45:34 | 55           | 0               | 0.0                  | 500           | 0                | 0.0                 | 8            | 0               | 0            | 0               | 70          | 56             |
| 2018-09-24 11:45:40 | 55           | 0               | 0.0                  | 500           | 0                | 0.0                 | 8            | 0               | 0            | 2               | 70          | 56             |

|                     | STILER RPM VOLTAGE (STILLER) |    |       | VACUUM |   | CURRENT (STILER) |    | PROCESS TIME |   |    | TEMPARATURE |    |
|---------------------|------------------------------|----|-------|--------|---|------------------|----|--------------|---|----|-------------|----|
| 2018-09-24 11:46:14 | 55                           | 0  | 0.0   | 500    | 0 | 0.0              | 8  | 0            | 0 | 4  | 70          | 54 |
| 2018-09-24 11:47:14 | 55                           | 55 | 426.0 | 500    | 0 | 4.0              | 8  | 0            | 1 | 4  | 70          | 63 |
| 2018-09-24 11:48:14 | 55                           | 55 | 426.0 | 500    | 0 | 3.0              | 8  | 0            | 2 | 4  | 70          | 59 |
| 2018-09-24 11:49:14 | 55                           | 55 | 427.0 | 500    | 0 | 4.0              | 8  | 0            | 3 | 4  | 70          | 58 |
| 2018-09-24 11:50:14 | 55                           | 55 | 425.0 | 500    | 0 | 4.0              | 8  | 0            | 4 | 4  | 70          | 58 |
| 2018-09-24 11:51:14 | 55                           | 55 | 426.0 | 500    | 0 | 4.0              | 8  | 0            | 5 | 4  | 70          | 58 |
| 2018-09-24 11:52:14 | 55                           | 55 | 423.0 | 500    | 0 | 4.0              | 8  | 0            | 6 | 4  | 70          | 58 |
| 2018-09-24 11:53:14 | 55                           | 55 | 425.0 | 500    | 0 | 4.0              | 8  | 0            | 7 | 4  | 70          | 58 |
| 2018-09-24 11:59:37 | 55                           | 0  | 0.0   | 500    | 0 | 0.0              | 4  | 0            | 0 | 1  | 70          | 59 |
| 2018-09-24 12:00:36 | 55                           | 55 | 427.0 | 500    | 0 | 4.0              | 4  | 0            | 1 | 1  | 70          | 54 |
| 2018-09-24 12:01:36 | 55                           | 55 | 430.0 | 500    | 0 | 4.0              | 4  | 0            | 2 | 1  | 70          | 52 |
| 2018-09-24 12:02:36 | 55                           | 55 | 429.0 | 500    | 0 | 3.0              | 4  | 0            | 3 | 1  | 70          | 51 |
| 2018-09-24 12:57:14 | 55                           | 0  | 0.0   | 500    | 0 | 0.0              | 10 | 0            | 0 | 0  | 70          | 68 |
| 2018-09-24 12:58:14 | 55                           | 55 | 436.0 | 500    | 0 | 3.0              | 10 | 0            | 1 | 0  | 70          | 69 |
| 2018-09-24 12:59:14 | 55                           | 55 | 435.0 | 500    | 0 | 3.0              | 10 | 0            | 2 | 0  | 70          | 64 |
| 2018-09-24 13:00:14 | 55                           | 55 | 432.0 | 500    | 0 | 3.0              | 10 | 0            | 3 | 0  | 70          | 64 |
| 2018-09-24 13:01:14 | 55                           | 55 | 431.0 | 500    | 0 | 3.0              | 10 | 0            | 4 | 0  | 70          | 64 |
| 2018-09-24 13:02:14 | 55                           | 55 | 433.0 | 500    | 0 | 3.0              | 10 | 0            | 5 | 0  | 70          | 64 |
| 2018-09-24 13:03:14 | 55                           | 55 | 436.0 | 500    | 0 | 3.0              | 10 | 0            | 6 | 0  | 70          | 64 |
| 2018-09-24 13:04:14 | 55                           | 55 | 436.0 | 500    | 0 | 3.0              | 10 | 0            | 7 | 0  | 70          | 64 |
| 2018-09-24 13:05:14 | 55                           | 55 | 431.0 | 500    | 0 | 3.0              | 10 | 0            | 8 | 0  | 70          | 64 |
| 2018-09-24 13:06:14 | 55                           | 55 | 431.0 | 500    | 0 | 3.0              | 10 | 0            | 9 | 0  | 70          | 64 |
| 2018-09-24 15:56:07 | 55                           | 0  | 0.0   | 500    | 0 | 0.0              | 5  | 0            | 0 | 0  | 70          | 62 |
| 2018-09-24 15:57:07 | 55                           | 55 | 438.0 | 500    | 0 | 3.0              | 5  | 0            | 1 | 0  | 70          | 62 |
| 2018-09-24 15:58:07 | 55                           | 55 | 438.0 | 500    | 0 | 3.0              | 5  | 0            | 2 | 0  | 70          | 61 |
| 2018-09-24 15:59:07 | 55                           | 55 | 438.0 | 500    | 0 | 3.0              | 5  | 0            | 3 | 0  | 70          | 60 |
| 2018-09-24 16:00:06 | 55                           | 55 | 438.0 | 500    | 0 | 3.0              | 5  | 0            | 4 | 0  | 70          | 60 |
| 2018-09-24 16:02:41 | 55                           | 0  | 0.0   | 500    | 0 | 0.0              | 4  | 0            | 0 | 0  | 70          | 57 |
| 2018-09-24 16:03:30 | 55                           | 0  | 0.0   | 500    | 0 | 0.0              | 4  | 0            | 0 | 19 | 70          | 55 |
| 2018-09-24 16:04:08 | 55                           | 0  | 0.0   | 500    | 0 | 0.0              | 4  | 0            | 0 | 42 | 70          | 54 |
| 2018-09-24 16:05:08 | 55                           | 55 | 435.0 | 500    | 0 | 3.0              | 4  | 0            | 1 | 42 | 70          | 50 |
| 2018-09-24 16:06:08 | 55                           | 55 | 435.0 | 500    | 0 | 3.0              | 4  | 0            | 2 | 42 | 70          | 50 |
| 2018-09-24 16:07:08 | 55                           | 55 | 434.0 | 500    | 0 | 3.0              | 4  | 0            | 3 | 42 | 70          | 54 |
| 2018-09-24 16:35:57 | 55                           | 0  | 0.0   | 500    | 0 | 0.0              | 8  | 0            | 0 | 0  | 70          | 69 |
| 2018-09-24 16:36:57 | 55                           | 55 | 434.0 | 500    | 0 | 3.0              | 8  | 0            | 1 | 1  | 70          | 70 |
| 2018-09-24 16:37:57 | 55                           | 55 | 432.0 | 500    | 0 | 3.0              | 8  | 0            | 2 | 1  | 70          | 66 |
| 2018-09-24 16:38:57 | 55                           | 55 | 433.0 | 500    | 0 | 3.0              | 8  | 0            | 3 | 1  | 70          | 63 |
| 2018-09-24 16:39:57 | 55                           | 55 | 432.0 | 500    | 0 | 4.0              | 8  | 0            | 4 | 1  | 70          | 63 |
| 2018-09-24 16:40:57 | 55                           | 55 | 431.0 | 500    | 0 | 4.0              | 8  | 0            | 5 | 1  | 70          | 62 |
| 2018-09-24 17:39:58 | 55                           | 0  | 0.0   | 500    | 0 | 0.0              | 8  | 0            | 5 | 9  | 70          | 67 |
| 2018-09-24 17:40:58 | 55                           | 55 | 431.0 | 500    | 0 | 3.0              | 8  | 0            | 6 | 10 | 70          | 68 |
| 2018-09-24 17:41:58 | 55                           | 55 | 429.0 | 500    | 0 | 4.0              | 8  | 0            | 7 | 10 | 70          | 66 |
| 2018-09-24 17:48:16 | 55                           | 0  | 0.0   | 500    | 0 | 0.0              | 4  | 0            | 0 | 1  | 70          | 66 |
| 2018-09-24 17:49:16 | 55                           | 55 | 432.0 | 500    | 0 | 4.0              | 4  | 0            | 1 | 1  | 70          | 60 |
| 2018-09-24 17:50:16 | 55                           | 55 | 432.0 | 500    | 0 | 3.0              | 4  | 0            | 2 | 1  | 70          | 57 |
| 2018-09-24 17:51:16 | 55                           | 55 | 433.0 | 500    | 0 | 3.0              | 4  | 0            | 3 | 1  | 70          | 58 |
| 2018-09-24 18:28:35 | 55                           | 0  | 0.0   | 500    | 0 | 0.0              | 10 | 0            | 0 | 0  | 70          | 70 |
| 2018-09-24 18:29:35 | 55                           | 55 | 426.0 | 500    | 0 | 3.0              | 10 | 0            | 1 | 1  | 70          | 69 |
| 2018-09-24 18:30:35 | 55                           | 55 | 427.0 | 500    | 0 | 3.0              | 10 | 0            | 2 | 1  | 70          | 67 |
| 2018-09-24 18:31:35 | 55                           | 55 | 431.0 | 500    | 0 | 3.0              | 10 | 0            | 3 | 1  | 70          | 67 |
| 2018-09-24 18:32:35 | 55                           | 55 | 428.0 | 500    | 0 | 3.0              | 10 | 0            | 4 | 1  | 70          | 66 |
| 2018-09-24 18:33:35 | 55                           | 55 | 427.0 | 500    | 0 | 3.0              | 10 | 0            | 5 | 1  | 70          | 66 |
| 2018-09-24 18:34:35 | 55                           | 55 | 428.0 | 500    | 0 | 3.0              | 10 | 0            | 6 | 1  | 70          | 66 |
| 2018-09-24 18:35:35 | 55                           | 55 | 427.0 | 500    | 0 | 3.0              | 10 | 0            | 7 | 1  | 70          | 66 |

|                     |    | STILER RPM | VOLTAGE<br>(STILLER) | VACUUM | CURRENT<br>(STILER) | PROCESS TIME |    |   |   | TEMPARATURE |    |    |
|---------------------|----|------------|----------------------|--------|---------------------|--------------|----|---|---|-------------|----|----|
| 2018-09-24 18:36:35 | 55 | 55         | 429.0                | 500    | 0                   | 3.0          | 10 | 0 | 8 | 1           | 70 | 68 |
| 2018-09-24 18:37:35 | 55 | 55         | 428.0                | 500    | 0                   | 3.0          | 10 | 0 | 9 | 1           | 70 | 69 |
| 2018-09-25 10:11:12 | 55 | 0          | 0.0                  | 500    | 0                   | 0.0          | 5  | 0 | 0 | 0           | 70 | 57 |
| 2018-09-25 10:11:41 | 55 | 0          | 32.0                 | 500    | 0                   | 7.0          | 5  | 0 | 0 | 19          | 70 | 56 |
| 2018-09-25 10:12:10 | 55 | 17         | 171.0                | 500    | 0                   | 5.0          | 5  | 0 | 0 | 41          | 70 | 54 |
| 2018-09-25 10:13:10 | 55 | 55         | 430.0                | 500    | 0                   | 3.0          | 5  | 0 | 1 | 41          | 70 | 51 |
| 2018-09-25 10:14:10 | 55 | 55         | 431.0                | 500    | 0                   | 3.0          | 5  | 0 | 2 | 41          | 70 | 49 |
| 2018-09-25 10:15:10 | 55 | 55         | 428.0                | 500    | 0                   | 3.0          | 5  | 0 | 3 | 41          | 70 | 50 |
| 2018-09-25 10:16:10 | 55 | 55         | 426.0                | 500    | 0                   | 3.0          | 5  | 0 | 4 | 41          | 70 | 51 |
| 2018-09-25 10:54:53 | 55 | 0          | 0.0                  | 500    | 0                   | 0.0          | 4  | 0 | 0 | 1           | 70 | 67 |
| 2018-09-25 10:55:53 | 55 | 55         | 429.0                | 500    | 0                   | 3.0          | 4  | 0 | 1 | 1           | 70 | 67 |
| 2018-09-25 10:56:53 | 55 | 55         | 429.0                | 500    | 0                   | 3.0          | 4  | 0 | 2 | 1           | 70 | 62 |
| 2018-09-25 10:57:53 | 55 | 55         | 432.0                | 500    | 0                   | 3.0          | 4  | 0 | 3 | 1           | 70 | 58 |
| 2018-09-25 11:48:52 | 55 | 0          | 0.0                  | 500    | 0                   | 0.0          | 8  | 0 | 0 | 1           | 70 | 69 |
| 2018-09-25 11:49:52 | 55 | 55         | 430.0                | 500    | 0                   | 3.0          | 8  | 0 | 1 | 1           | 70 | 68 |
| 2018-09-25 11:50:52 | 55 | 55         | 432.0                | 500    | 0                   | 3.0          | 8  | 0 | 2 | 1           | 70 | 64 |
| 2018-09-25 11:51:52 | 55 | 55         | 430.0                | 500    | 0                   | 3.0          | 8  | 0 | 3 | 1           | 70 | 63 |
| 2018-09-25 11:52:52 | 55 | 55         | 430.0                | 500    | 0                   | 3.0          | 8  | 0 | 4 | 1           | 70 | 63 |
| 2018-09-25 11:53:52 | 55 | 55         | 431.0                | 500    | 0                   | 3.0          | 8  | 0 | 5 | 1           | 70 | 63 |
| 2018-09-25 11:54:52 | 55 | 55         | 430.0                | 500    | 0                   | 3.0          | 8  | 0 | 6 | 1           | 70 | 63 |
| 2018-09-25 11:55:52 | 55 | 55         | 429.0                | 500    | 0                   | 3.0          | 8  | 0 | 7 | 1           | 70 | 63 |
| 2018-09-25 12:00:47 | 55 | 0          | 0.0                  | 500    | 0                   | 0.0          | 4  | 0 | 0 | 0           | 70 | 61 |
| 2018-09-25 12:01:47 | 55 | 55         | 432.0                | 500    | 0                   | 3.0          | 4  | 0 | 1 | 0           | 70 | 57 |
| 2018-09-25 12:02:47 | 55 | 55         | 431.0                | 500    | 0                   | 3.0          | 4  | 0 | 2 | 0           | 70 | 55 |
| 2018-09-25 12:03:47 | 55 | 55         | 434.0                | 500    | 0                   | 3.0          | 4  | 0 | 3 | 0           | 70 | 54 |
| 2018-09-25 12:56:06 | 55 | 0          | 0.0                  | 500    | 0                   | 0.0          | 10 | 0 | 0 | 1           | 70 | 70 |
| 2018-09-25 12:57:06 | 55 | 55         | 427.0                | 500    | 0                   | 3.0          | 10 | 0 | 1 | 1           | 70 | 70 |
| 2018-09-25 12:58:06 | 55 | 55         | 429.0                | 500    | 0                   | 3.0          | 10 | 0 | 2 | 1           | 70 | 68 |
| 2018-09-25 12:59:06 | 55 | 55         | 432.0                | 500    | 0                   | 3.0          | 10 | 0 | 3 | 1           | 70 | 68 |
| 2018-09-25 13:00:06 | 55 | 55         | 435.0                | 500    | 0                   | 3.0          | 10 | 0 | 4 | 1           | 70 | 67 |
| 2018-09-25 13:01:06 | 55 | 55         | 433.0                | 500    | 0                   | 3.0          | 10 | 0 | 5 | 1           | 70 | 67 |
| 2018-09-25 13:02:06 | 55 | 55         | 435.0                | 500    | 0                   | 3.0          | 10 | 0 | 6 | 1           | 70 | 68 |
| 2018-09-25 13:03:06 | 55 | 55         | 435.0                | 500    | 0                   | 3.0          | 10 | 0 | 7 | 1           | 70 | 70 |
| 2018-09-25 13:04:06 | 55 | 55         | 431.0                | 500    | 0                   | 3.0          | 10 | 0 | 8 | 1           | 70 | 70 |
| 2018-09-25 13:05:06 | 55 | 55         | 433.0                | 500    | 0                   | 3.0          | 10 | 0 | 9 | 1           | 70 | 71 |
| 2018-09-25 15:26:30 | 55 | 0          | 0.0                  | 500    | 0                   | 0.0          | 5  | 0 | 0 | 0           | 70 | 53 |
| 2018-09-25 15:27:19 | 55 | 0          | 0.0                  | 500    | 0                   | 0.0          | 5  | 0 | 0 | 24          | 70 | 50 |
| 2018-09-25 15:27:52 | 55 | 17         | 171.0                | 500    | 0                   | 5.0          | 5  | 0 | 0 | 50          | 70 | 49 |
| 2018-09-25 15:28:52 | 55 | 55         | 430.0                | 500    | 0                   | 3.0          | 5  | 0 | 1 | 50          | 70 | 46 |
| 2018-09-25 15:29:52 | 55 | 55         | 429.0                | 500    | 0                   | 3.0          | 5  | 0 | 2 | 50          | 70 | 47 |
| 2018-09-25 15:30:52 | 55 | 55         | 428.0                | 500    | 0                   | 3.0          | 5  | 0 | 3 | 50          | 70 | 49 |
| 2018-09-25 15:31:52 | 55 | 55         | 431.0                | 500    | 0                   | 3.0          | 5  | 0 | 4 | 50          | 70 | 50 |
| 2018-09-25 15:59:26 | 55 | 0          | 0.0                  | 500    | 0                   | 0.0          | 4  | 0 | 0 | 0           | 70 | 64 |
| 2018-09-25 16:00:26 | 55 | 55         | 428.0                | 500    | 0                   | 3.0          | 4  | 0 | 1 | 0           | 70 | 62 |
| 2018-09-25 16:01:27 | 55 | 55         | 426.0                | 500    | 0                   | 3.0          | 4  | 0 | 2 | 0           | 70 | 55 |
| 2018-09-25 16:02:27 | 55 | 55         | 425.0                | 500    | 0                   | 4.0          | 4  | 0 | 3 | 0           | 70 | 54 |
| 2018-09-25 16:59:45 | 55 | 0          | 0.0                  | 500    | 0                   | 0.0          | 8  | 0 | 0 | 0           | 70 | 68 |
| 2018-09-25 17:00:45 | 55 | 55         | 427.0                | 500    | 0                   | 3.0          | 8  | 0 | 1 | 0           | 70 | 67 |
| 2018-09-25 17:01:45 | 55 | 55         | 426.0                | 500    | 0                   | 3.0          | 8  | 0 | 2 | 0           | 70 | 62 |
| 2018-09-25 17:02:45 | 55 | 55         | 430.0                | 500    | 0                   | 3.0          | 8  | 0 | 3 | 0           | 70 | 61 |
| 2018-09-25 17:03:45 | 55 | 55         | 426.0                | 500    | 0                   | 3.0          | 8  | 0 | 4 | 0           | 70 | 61 |
| 2018-09-25 17:04:45 | 55 | 55         | 428.0                | 500    | 0                   | 3.0          | 8  | 0 | 5 | 0           | 70 | 61 |
| 2018-09-25 17:05:45 | 55 | 55         | 431.0                | 500    | 0                   | 3.0          | 8  | 0 | 6 | 0           | 70 | 61 |
| 2018-09-25 17:06:45 | 55 | 55         | 430.0                | 500    | 0                   | 3.0          | 8  | 0 | 7 | 0           | 70 | 62 |

| STILER RPM          |    |    | VOLTAGE<br>(STILLER) | VACUUM | CURRENT<br>(STILER) | PROCESS TIME |    |   | TEMPERATURE |   |    |    |
|---------------------|----|----|----------------------|--------|---------------------|--------------|----|---|-------------|---|----|----|
| 2018-09-25 17:11:18 | 55 | 0  | 0.0                  | 500    | 0                   | 0.0          | 4  | 0 | 0           | 1 | 70 | 63 |
| 2018-09-25 17:12:18 | 55 | 55 | 436.0                | 500    | 0                   | 3.0          | 4  | 0 | 1           | 1 | 70 | 58 |
| 2018-09-25 17:13:18 | 55 | 55 | 431.0                | 500    | 0                   | 3.0          | 4  | 0 | 2           | 1 | 70 | 55 |
| 2018-09-25 17:14:18 | 55 | 55 | 430.0                | 500    | 0                   | 3.0          | 4  | 0 | 3           | 1 | 70 | 55 |
| 2018-09-25 17:21:35 | 55 | 0  | 0.0                  | 500    | 0                   | 0.0          | 10 | 0 | 0           | 0 | 70 | 64 |
| 2018-09-25 18:13:49 | 55 | 0  | 0.0                  | 500    | 0                   | 0.0          | 10 | 0 | 0           | 2 | 70 | 63 |
| 2018-09-25 18:14:49 | 55 | 55 | 428.0                | 500    | 0                   | 3.0          | 10 | 0 | 1           | 2 | 70 | 67 |
| 2018-09-25 18:15:49 | 55 | 55 | 428.0                | 500    | 0                   | 3.0          | 10 | 0 | 2           | 2 | 70 | 66 |
| 2018-09-25 18:16:49 | 55 | 55 | 429.0                | 500    | 0                   | 3.0          | 10 | 0 | 3           | 2 | 70 | 65 |
| 2018-09-25 18:17:49 | 55 | 55 | 429.0                | 500    | 0                   | 3.0          | 10 | 0 | 4           | 2 | 70 | 67 |
| 2018-09-25 18:18:49 | 55 | 55 | 428.0                | 500    | 0                   | 3.0          | 10 | 0 | 5           | 2 | 70 | 68 |
| 2018-09-25 18:19:49 | 55 | 55 | 429.0                | 500    | 0                   | 3.0          | 10 | 0 | 6           | 2 | 70 | 68 |
| 2018-09-25 18:20:49 | 55 | 55 | 432.0                | 500    | 0                   | 3.0          | 10 | 0 | 7           | 2 | 70 | 68 |
| 2018-09-25 18:21:49 | 55 | 55 | 429.0                | 500    | 0                   | 3.0          | 10 | 0 | 8           | 2 | 70 | 67 |
| 2018-09-25 18:22:49 | 55 | 55 | 429.0                | 500    | 0                   | 3.0          | 10 | 0 | 9           | 2 | 70 | 67 |

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