

	Standard Operating Procedure		SOP Number B-613	Revision 4
	Heat Tunnel		Effective Date 11/10/22	Page Page 1 of 3
Written by/ Date MBurns 10/17/22		Reviewed by/ Date Janice Mueller 10/17/22		Approved by/ Date MBurns 10/24/22
Title: Manufacturing Engineer		Title: Maintenance Manager		Title: Quality Assurance Director

1.0 Purpose

The purpose of this procedure is to define the process for the setup, operation, and cleaning of the Heat Tunnel.

2.0 Scope

This procedure applies to all heat tunnels in operation at Ion Labs, Inc.

3.0 Responsibility

- 3.1 It is the responsibility of Production (Packaging) personnel to follow this procedure.
- 3.2 It is the responsibility of Production Management to implement this procedure and to ensure that the process is being followed.

4.0 Definitions

None

5.0 References

- 5.1 B-111, SOP, Cleaning of Manufacturing/Production Areas and Equipment

6.0 Procedure

- 6.1 Setup
 - 6.1.1 Before startup of the heat tunnel, while the unit is still cool, check the inside of the tunnel to ensure that bottles have not become lodged inside.

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6.1.2 Keep hands, arms and exposed skin out of the inside of the tunnel and off of the outside surface of the unit during warm up and use.

6.2 Operation

6.2.1 Turn the heat on, making sure to start the feed conveyor at the same time. This will allow any bottles to move through the tunnel.

6.2.2 Allow the heat tunnel to reach the desired temperature.

6.2.3 Adjust the temperature setting on the heat tunnel until the plastic neckband or body sleeve shrinks without burning.

6.2.4 Continue allowing product to pass through the tunnel with neckbands or body sleeves on the containers.

6.2.5 If the conveyor is stopped for any reason, ensure that no containers are still inside the heat tunnel.

6.3 Cleaning

Note: Allow the heat tunnel to cool down for at least 30 minutes before cleaning.

6.3.1 Remove all product and paperwork from the previous batch.

6.3.2 Refer to SOP B-111 Cleaning of Manufacturing/Production Areas and Equipment to follow the cleaning procedure applicable to this type of equipment.

6.3.3 Document cleaning as outlined in SOP B-111 Cleaning of Manufacturing/Production Areas and Equipment.

7.0 Revision History

Revision	Date	Description of Changes	CCR #	By
0	08/17/10	New procedure.	-	-
1	05/01/13	Updated SOP format.	13-299	B. Mosall
2	01/27/16	Scheduled review: Changed the SOP format.	15-0942	P. Zittere
3	01/22/19	Scheduled review: Removed obsolete definitions. Added reference to SOP B-111. Revised section 6.3.	19-0077	K. Burris
4	10/17/22	Scheduled review: Updated to include all current heat tunnels. Changed logo.	CC-22-0214	M. Busse