

	Standard Operating Procedure		SOP Number B-802	Revision 0
	<b>Gummy Counter</b>		Effective Date 09/21/23	Page Page 1 of 4
Written by/ Date <i>Ben C. Haring</i> 09-12-23		Reviewed by/ Date <i>M. M.</i> 09-12-23		Approved by/ Date <i>[Signature]</i> 09-12-23
Title: Gummy Production Manager		Title: Director of Operations		Title: VP of Quality & Regulatory Affairs

## 1.0 Purpose

This procedure defines the process of setup, operation, and cleaning of the gummy counter.

## 2.0 Scope

This procedure applies to the gummy counter used during gummy packaging at Ion Nutritional Labs.

## 3.0 Responsibility

- 3.1 It is the responsibility of Production (Gummy) personnel to follow this procedure.
- 3.2 It is the responsibility of the Department Manager/Supervisor to implement this procedure and to ensure that it is being followed.
- 3.3 It is the responsibility of Gummy Management and/or Maintenance & Engineering personnel to keep this procedure aligned with current practices.
- 3.4 It is the responsibility of Maintenance personnel to ensure that PMs are completed per the schedule set in Asset Essentials.

## 4.0 Definitions

None

## 5.0 References

- 5.1 B-111, SOP, Cleaning of Manufacturing/Production Areas and Equipment
- 5.2 B-105, SOP, Preparation of Cleaning and Sanitizing Chemicals for Production

## 6.0 Setup Instructions

- 6.1 Mount vibratory feeders cover.

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- 6.2 Mount Chute covers.
- 6.3 Supply products into a bulk hopper.
- 6.4 Adjust the vibratory feeder speed.
- 6.5 Adjust the belt speed.
- 6.6 Try manual operation once to supply products into the counter hopper.
- 6.7 Press the AUTORUN button.

## **7.0 Startup**

- 7.1 Supply bottles to the filling positions on the conveyor.
- 7.2 Supply compressed air.
- 7.3 Turn on the main power switch.
- 7.4 Enter the password when the screen displays and sign-in is requested.
- 7.5 Make sure that the funnel height is set correctly.
  - 7.5.1 Raise the counter head considerably and lower it slowly so that the funnels reach 5mm higher than the top of the bottle.
- 7.6 Ensure that conveyor guide rails and gating arms are appropriately set.
- 7.7 Adjust the positioning of bottle sensors to detect bottles properly.
- 7.8 Go to Drive mode and press the MANUAL button.
- 7.9 Test conveyors, feeders, sensors, cylinders, etc.
- 7.10 Exit Manual Mode.
- 7.11 Press Start.

## **8.0 Program**

- 8.1 Creating a New Product Program
  - 8.1.1 Go to Setting.
  - 8.1.2 When sign-in is requested, enter the password.

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- 8.1.3 Set the parameters in the Settings screen.
- 8.1.4 Go back to Drive mode.
- 8.1.5 Set the parameters in the Drive screen.
- 8.1.6 Enter the name of the product and program number.
- 8.1.7 Save all of the settings.
- 8.1.8 Press the START button to go for operation.
- 8.1.9 Adjust every necessary speed by using the arrow keys.
- 8.1.10 Observe the filling process and, if necessary, adjust Shutter Delay and Gate Delay.
- 8.1.11 Continue operation.
- 8.1.12 Save the settings.

## 8.2 Using Existing Product Program

- 8.2.1 Select the operation program using the arrow keys in the Product Setting box.
- 8.2.2 Start the operation by pressing the START button.

## 8.3 Stop Operation

- 8.3.1 Press the Stop button.
- 8.3.2 Save the operation data if necessary.
- 8.3.3 Turn off the Power switch from the counter panel.
- 8.3.4 Press the Power button off.

## 9.0 Cleaning

- 9.1 Prepare cleaning agents as outlined in SOP B- 105 Preparation of Cleaning and Sanitizing Chemicals for Production.
- 9.2 Follow SOP B-111 cleaning of Manufacturing/Production Areas and Equipment to ensure proper cleaning and sanitation are performed for this type of equipment and that these activities are adequately documented.

- 9.3 The following disassembly steps are required before cleaning:
- 9.3.1 Remove the vibratory feeder cover.
  - 9.3.2 Remove the chute cover.
  - 9.3.3 Remove the elevator from the counter.
- 9.4 Inspect the equipment to ensure that no gummies remain prior to reassembling the equipment.

### 10.0 Revision History

Revision	Date	Description of Changes	CCR #	By
0	09/11/23	New procedure.	N/A	J. Ramirez