



MINUTES OF THE MEETING

**PRE BID MEETING FOR VIAL LABELLING MACHINE & SEMI-AUTOMATIC VIAL
INSPECTION MACHINE**

Document No.NPI/110729/EQP/TD/12

Venue: HLL, Ticel Biopark, Chennai

Project : **BCG Vaccine Manufacturing Facility, Chennai**

Date of the meeting : **26th August 2014**

Attendees : **See attached list of attendees**

Issued by : **CEO-HBL**

Issued on : **03th September 2014**

Agenda : **Pre bid Meeting – Tender for Supply, Installation &
commissioning of vial labelling machine & semi-automatic vial
inspection machine**



S. No.		Clarifications on queries				
Tender for Supply , Installation & commissioning of vial labelling machine & semi-automatic vial inspection machine						
A Discussion on Tender Enquiry Document: NPI/110729/EQP/ TD/12						
General Points						
1.	Separate Technical bid and price bid for each schedule super scribing tender reference no and schedule no along with EMD cover has to be placed into single envelope super scribing "TENDER FOR SUPPLY, INSTALLATION, COMMISSIONING AND VALIDATION OF SEMI-AUTOMATIC VIAL INSPECTION AND VIAL LABELLING MACHINE AT BCG VACCINE LABORATORY, GUINDY, CHENNAI" with Date of Opening and details of item quoted .					
2.	Time period of completion : <ul style="list-style-type: none"> The Supply should be completed within 4 months from the date of issue of LOA. Installation, Commissioning and validation should be completed within 2 Months from the date of Delivery at site 					
3.	There is no change in the terms & conditions of this tender Enquiry Document (NPI/110729/EQP/ TD/12)					
4.	The Last date for the tender submission has been extended till 22nd September,2014 @15:00 hrs and the tender opening will be at 15:30 hrs on 22nd September,2014.					
S.No		Clarifications on URSs				
B		URS/ FG – VLM 01				
Specific revision in the URS						
	URS Point number and excerpt / description of the specification		Point modified as / Comment			
	2.0 EQUIPMENT DESCRIPTION					
5.	1.	Vial infeed unit	Infeed tray and turn table along with infeed worm and conveyor	1.	Vial infeed unit	Inlet loading tray with minimum capacity of 2000 vials and feed worm screw for transferring vials from infeed tray to star wheel.
	2.	Buffer table	To hold the vials	2.	Buffer table	deleted
	4.	In feed sensor / eye mark sensor	To read the eye mark of label.	4.	In feed sensor / eye mark sensor	deleted
	8.	Elephant chute	For collecting labeled vials at the out feed tray and to avoid the breaking of vials	8.	Elephant chute	deleted
6.	3.1.3 Filled and sealed vials are loaded onto the infeed turn table with the help of tray loading system		3.1.3 Filled and sealed vials are loaded onto the infeed tray			
7.	3.2.1 Vials shall be loaded manually to the infeed turn table of vial labeling machine. And then vials are transferred with the help of infeed worm and conveyor system.		3.2.1 Vials shall be loaded manually to the infeed loading tray of vial labeling machine. And then vials are transferred with the help of infeed worm and conveyor system.			
8.	3.2.3 Eye Mark Sensing of the labels to ensure proper cutting of Labels.		Deleted			
6.4 Level of Instrumentation						
9.	Uniform Cutting of Label	To have Eye Mark to Eye Mark cutting of label	Eye Mark Sensor	Deleted		



S. No.	Clarifications on queries					
10.	6.7.10 An automatic rejection system shall be included into the system (arm deviator rejection system is recommended)			6.7.10 Pneumatic operated rejection system shall be included into the system		
	URS Point number and excerpt / description of the specification			Point modified as / Comment		
11.	6.7.12 Elephant chute to be provided to avoid vials braking after out feed			6.7.12 Out feed tray of the vial labelling machine has to be integrated with the turn table of existing VVM machine of capacity 120 vials /min		
12.	6.7.17 Industrial PLC + touch screen HMI (10 inches at least) to be provided			6.7.17 Industrial PLC + touch screen HMI (8 inches at least) to be provided		
13.	6.7.19 Make of servo based mechanism shall be Allen Bradley / Siemens			Deleted		
14.	6.7.20 Make of sensors shall be SICK / P&F.			Deleted		
15.	6.7.27 In feed worm should be constructed of Delrin/ USFDA material.			6.7.27 In feed worm should be constructed of Derlin/ USFDA material.		
16.	S.No	Description	Make	S.No	Description	Make
	1	Proximity sensors	Contrinex/Rockwell/Omron	1	Proximity sensors	Leuze/Rockwell/Omron
	2	Eye Mark sensors	Vendor to specify	2	Eye Mark sensors	Deleted
	3	Camera	Imaging source – Germany/Baumer-Germany	3	Camera	Imaging source – Germany/ Baumer-Germany/ Cognex
	4	Variable Frequency Drive	Delta/Allen Bradly	4	Variable Frequency Drive	Delta/Allen Bradly/ABB
	6	PLC+ touch screen HMI	Mitsubishi/ Allen Bradly/Siemens	6	PLC+ touch screen HMI	Mitsubishi/ Allen Bradly/Siemens /Fatek PLC



E		URS/ FG-VIM 01																			
Specific revision in the URS																					
URS Point number and excerpt / description of the specification		Point modified as / Comment																			
17.	2.0 Equipment Description:		2.0 Equipment Description:																		
	2.	Buffer table	To hold at for one hour operation																		
	4.	Screw feed conveyor	To move the vial at particular interval (Two numbers)																		
	5.	Pause, Reject and Pass Buttons	Manual reject chute shall be provided with collection bin to avoid faulty vials in good vials																		
17.	2.	Buffer table	Deleted																		
	4.	Screw feed conveyor	Deleted																		
	5.	Pause, Reject and Pass Buttons	Rejection Bin will be provided for each operator. Pause and Pass button options are deleted.																		
18.	3.2.1 Vials will be fed on in feed tray to turntable which will singularize the vials and transport the vials on screw conveyor (Two numbers of conveyors)		3.2.1 Vials will be fed on in feed tray to turntable which will singularize the vials and transport.																		
19.	3.2.2 Vials on screw conveyor will be transported further on inspection hood with particular space intervals		3.2.2 Vials will be transported further on inspection hood with particular space intervals(minimum 60 mm with spacer /suitable arrangement)																		
20.	3.2.3 Note: Two persons shall inspect the vials which are coming from two different conveyors by sitting opposite to each other.		3.2.3 Note: Double track/Single track conveyor will be provided and it should ensure their will be no mix-up with inspected vials and non-inspected vials .3-4 visual inspection hood to be provided on either side.																		
21.	3.2.4 The inspection of vial will be controlled by 3 buttons-Pause, Reject and pass buttons		Deleted																		
22.	3.2.6 Operator will manually pick the defected vials and transport it to the reject ion chute to collect it separately in rejection bin		3.2.6 Operator will manually pick the defected vials and collect it separately in rejection bin																		
23.	6.7.3 The buffer table in the in-feed should be able to hold at for one hour operation and vial should automatically move in to the conveyor with help of the guiding arm.		Deleted																		
24.	6.7.5 Transfer arrangement i.e. screw conveyor shall be provided with intermittent motion		Deleted																		
25.	6.7.9 Rejection chute along with collection bin shall be provided		6.7.9 Lockable Rejection bin shall be provided																		
26.	<table border="1"> <thead> <tr> <th>S.No</th> <th>Description</th> <th>Make</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>Proximity sensors</td> <td>Contrinex/Rockwell/Omron</td> </tr> <tr> <td>2</td> <td>Variable Frequency Drive</td> <td>Delta/Allen Bradley</td> </tr> </tbody> </table>		S.No	Description	Make	1	Proximity sensors	Contrinex/Rockwell/Omron	2	Variable Frequency Drive	Delta/Allen Bradley	<table border="1"> <thead> <tr> <th>S.No</th> <th>Description</th> <th>Make</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>Proximity sensors</td> <td>Leuze/Rockwell/Omron</td> </tr> <tr> <td>2</td> <td>Variable Frequency Drive</td> <td>Delta/Allen Bradley/ABB</td> </tr> </tbody> </table>	S.No	Description	Make	1	Proximity sensors	Leuze/Rockwell/Omron	2	Variable Frequency Drive	Delta/Allen Bradley/ABB
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For HLL Lifecare Limited

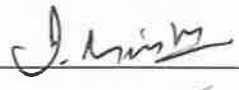

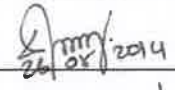

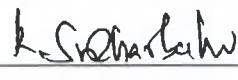
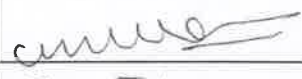
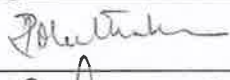
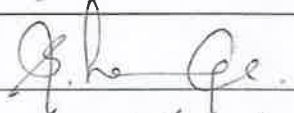

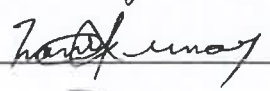
Chief Executive Officer - HBL

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NNE Pharmaplan India Limited, #12, Achiah Shetty Layout, RMV extrn, Bangalore – 80, INDIA

List of Attendees

Date: 26 August 2014
Client: M/s. HLL Lifecare Limited, Chennai
Venue: HLL Lifecare Limited, Chennai
Project: REVIVAL OF BCG VACCINE LABORATORY, GUINDY, CHENNAI
Subject: Pre-Bid Meeting

Name	Company or E-mail Id.	Signature
D. RAVICHANDRAN	PARLE GLOBAL TECHNOLOGY dravinichandran@parleglobal.com	
R. MADESH	Maharshi UDYOG, south@maharshi.com	
DIYANASEKARAN. C	FABTECH TECHNOLOGIES	
VIGNESHKARAN.T	HLL LIFECARE LTD	
K. SRIDHAR BABU	NNE Pharmaplan	
R. Alexander	BCCVL	
R. Muthukrishnan	HLL BIOTECH LTD	
S. Lavanya	HBL	
A. Anto Felix	HLL	
K. Anil Kumar	HBL	
Philomin	Bhagwati Mechtca	