IS YOUR RETORT ROOM UNDER CONTROL?

SOLUTIONS WILL GET YOU THERE!

DESIGNED FOR THE OPERATOR
The ALLVIEW Human Machine Interface Platform was developed to provide a comprehensive user friendly interface for production managers, operators, and technicians in the retort room. ALLVIEW uses touch screen operation through the Allen Bradley line of products along with a mature screen design development customized for plant personnel.

TOTAL CONTROL AT YOUR FINGERTIPS
ALLVIEW combines basic operator entry functionality with password access to more complex functions including:
♦ PID Loop tuning for each loop, step, recipe, and retort.
♦ Manual Override functions for both analog and discrete control
♦ Preventative maintenance management through Allpax “Maintainer” software.
♦ Retort Process Step Overrides
♦ Manual and Semi-automatic routines for automation modules
♦ Dynamic trending of retort critical parameters for enhanced troubleshooting.

SUPPORT – ALLPAX CAN BE AT YOUR FINGERTIPS IN SECONDS
Supporting the ALLVIEW HMI is handled via high speed virtual private networking through the internet manned by Allpax software engineers. This fast access allows our technicians to view, control and modify your HMI or PLC code on the fly. This valuable lifeline is available around the clock, dramatically reduces downtime, and removes the frustration of troubleshooting over the phone between technicians.

ALLVIEW SYSTEM FEATURES
Available with new Allpax retorts, or as a retrofit to an existing retort.

☑ ALLVIEW hardware takes advantage of the Allen Bradley line of products including PanelView and Versaview for off-the-shelf access, and open design platforms.

☑ ALLVIEW software utilizes non-proprietary platforms including Visual Basic, Wonderware, and RSView.

☑ Robust security password access complete with HMI transaction logs created to track operator actions.

☑ Centralized HMI options for single source operation with functional access to all equipment in the Retort room.

☑ Standard Allen Bradley Control Logix family of products for an open architecture PLC based interface to ALLVIEW.

☑ HMI equipment validation checks through Allpax “Challenger” software.

☑ Basket tracking control at the HMI complete with visual schematic of all baskets in the system through Allpax “ALLTRACK” software.
MONITOR SYSTEM FEATURES
Available with new Allpax retorts, or as a retrofit to an existing retort.

MONITOR software utilizes Microsoft’s SQL Server for centralized data persistence allowing for the scheduling of complete database backups.

Unlimited recipe scheduling to retorts with

- Up to 50 configurable recipe segments per process with segment editing features for user friendly recipe creation.
- Comprehensive Reporting for batch logs, deviations, alarms, recipes, and trends.
- Robust electronic data fingerprinting.
- Security configurations with privileges explicitly assigned to each user.
- All Host transactions are tracked per user with transaction logs and reports created.
- Multiple pens selectable for trending critical factors of each batch process.
- Process data can be archived to streamline retrievals with immediate central access.

DESIGNED BY FOOD SCIENTISTS
The Allpax MONITOR system was developed by the food scientists and food process professionals at Allpax for the purpose of ensuring that each of our customer’s products are processed to exact sterilization specifications. The system uses a host computer (a Dell PC) that stores product-configurable recipes. These recipes define the process parameters to be followed, with settings to automatically correct for process deviations. [The system accommodates process calculation methods for determining process times, including Ball Formula, numerical methods, and the table-lookup method.]

ACCEPTED BY FDA & USDA
The Allpax Retort Control System has been reviewed and accepted by both U.S. regulatory agencies. It meets or exceeds the requirements of 21CFR Part 11 including electronic data fingerprinting, audit trails, and secure operator access restrictions.

STEP-BY-STEP - ALL PROCESSES
The MONITOR system is parameter driven. The recipe parameters are configured for each processing step (come-up, cook, pressure cool, etc.) to control all valves automatically. Each processing step is defined by the time in the process step and the critical factor set-points. The Allpax MONITOR system approach gives the processor total flexibility to ramp or stair-step temperatures and pressures during the process.

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Allpax Products is committed to providing our customers with the highest quality equipment in the marketplace. In addition to our line of Retort Room products, Allpax takes great pride in our superior customer support. AllCheck is a validation support package which ensures that plants have all bases covered in the Retort Room by providing safe processes and product tracking.

Food industry plants today have a scattered array of control systems that are responsible for consumer food safety. Due to some recent large scale recalls, U.S. regulatory agencies are taking proactive steps in conducting wide scale audit visits to ensure that product safety laws and procedures are being met. Allpax AllCheck is designed to challenge, validate and document a plant’s Retort Room operation following standards and protocols outlined in NFPA, bulletin #43L.
What will AllCheck do for your plant?

STEP 1  RETORT ROOM AUDIT
An on-site audit performed by an Allpax validation coordinator who will develop a Validation Plan Overview based on production operations and management including:

- Creating a validation team and review scope
- Reviewing on site macro user requirement, functional, and installation specifications
- Reviewing current installation, operation, and performance qualifications and procedures used at the plant
- Define the validation responsibilities of operators, shift supervisors, quality operation, maintenance and the system administrator

STEP 2  DEVELOP THE VALIDATION PACKAGE
Allpax will develop the required documentation to implement the validation as per NFPA 43L guidelines including:

User Requirement Specifications
- Process requirements
- Responsibilities
- Operational requirements

Functional Specifications
- Functional description
- Control system description
- Project configuration (software and hardware)
- Process description
- Safety features
- Critical control points

Design Specifications
- Electrical drawings and diagrams
- Mechanical drawings
- P&ID

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STEP 3  PERFORM THE QUALIFICATIONS
Allpax personnel will conduct both simulated software and on-site challenges to validate the system, including:

**Installation Qualification**
- Hardware verification
- Software verification
- Host verification

**Operational Qualification**
- Process flow
- Operator data entry
- HMI verification
- Batch file and log verification

**Performance Qualification**
- Critical factor challenges
- Batch log accuracy
- Process recipe accuracy
- Alarm challenges
- Safety processes

STEP 4  ON-GOING SYSTEM INTEGRITY
An Allpax validation does not end after the Performance Qualification. Throughout the process, several procedures are implemented to ensure that the validation is maintained properly for the future, including:

**Change Control Procedures**
- Documentation requirements
- Security requirements
- Revision history

**Optional Yearly Audits**
- Allpax on-site system audit
THE ALLPAX ADVANTAGE... ONE STEP FURTHER

The Allpax team of software engineers has developed an automated method for challenging our process control system’s critical factors. This software coupled with our ALLCHECK validation package provide your plant a solid system for product quality assurance. How does the Allpax Challenger software work?

- A software module is added to the PLC controller with an operator interface screen selection for “Challenge Mode”

- The retort is then capable of performing an automated check of the critical factors, related instrumentation and deviation logic while processing a ballast load

- The “Challenge Mode” software code runs behind the scenes simulating critical factor deviations per each phase of the process

- Plant personnel will be able to view the measured critical parameters from the operator interface terminal screen as well as their defined limits for the active process step

- When a deviation occurs, the operator interface screen will display the measured deviation value along side a list of achieved deviations

- At the end of the “Challenge Mode” process test, a batch log will print the results of the simulated tests which closes the loop on the process records and host documentation
Performing preventative maintenance extends the life of your retort room equipment and will help eliminate down-time and loss of production. The Allpax Maintainer software assists in managing maintenance tasks. Maintainer aids plant personnel by managing maintenance items based on run time, providing support at the equipment HMI with drawings and helpful documentation, and much more. This software package is touch-screen friendly and can be used as an add-on to the ALLVIEW HMI application or as a stand alone Windows application.

**ALLPAX MAINTENANCE LISTS**

The Maintenance Manager List allows users to manage their preventative maintenance tasks by:

- Viewing total run times on maintenance items
- Viewing service and replacement schedules
- Viewing a history of service and replacement
- Viewing service and replacement required notifications
- Alarming past due maintenance items
- Recording when service and replacement have been performed
Maintainer also allows the operator to view, pan, and rotate drawings for your equipment and associated parts. Drawing types include:

- **3D Solidworks mechanical drawings**
- **2D AutoCad mechanical drawings**
- **2D AutoCad electrical drawings**

Another great feature of Allpax Maintainer is that personnel can view, zoom, print, page forward and page backward other general documentation for your equipment such as:

- **Tech notes**
- **Operator manuals**
- **Equipment Bill of Materials list**
- **Vendor spec sheets**
BASKET TRACKING AND PRODUCT STATUS: Eliminating The Retort Bypass

Basket Tracking is accomplished using the Allpax positional ALLTRACK logic, complete with 2D bar code laser etched tags that are read by a self contained vision sensor using pattern recognition software. Each Ethernet based vision sensor has a stand alone IP address for independent isolation. There are no electronic or moving parts that enter the retort in our system.

When an empty basket enters the first vision sensor zone, a number and personality are assigned in the ALLTRACK software. The basket personality includes the number of containers, production code, basket status (i.e. unprocessed, deviation, un-cleared deviation, etc.), the retort number, batch number, and other information.

When the basket reaches its final destination, the basket number is confirmed by the final vision sensor. If all permissives are met, the product is unloaded and sent to packaging.

ALARMS

Alarms occur if an ALLTRACK vision sensor scans a basket number that does not exist, or if identity is not detected. Additionally, if the basket number detected does not match the software data block transfer, the operator is alarmed. Proper personnel will be required to intervene via the HMI to clear these alarms.

SYSTEM REPORTS

The ALLTRACK system also produces information that is retrieved at the Allpax Host Computer. Whenever manual intervention takes place a transaction log is generated, identifying the action. Alarm reports can also be generated at the Host computer.
ALLPAX 24 PLUS 7
When it comes to support capability, Allpax is second to none. Our team of software engineers are equipped with the latest technology to supply immediate quality support through our ability to use a high speed Virtual Private Network (VPN) connection as a lifeline to your control system. We offer this service around the clock, 24 hours a day!

From this communication link, we can perform comprehensive tasks including:
- PLC Ladder logic troubleshooting and modifications
- Process monitoring to resolve deviations
- Remote HMI control
- Host Computer troubleshooting
- Online PID valve tuning
- Online operator task training
- Online HMI configuration
- Online Device configuration

When you purchase an Allpax system, our 24/7 Plus is an invaluable tool in minimizing troubleshooting and downtime. On other proprietary systems, the retort controller runs off a compiled executable file which does not allow for on-line access.

24/7 Plus, coupled with our standardized off the shelf Allen Bradley software and hardware virtually eliminates controls related downtime risks.

Who is behind the VPN connection? The same software engineers who wrote the code based on our standards. This way, you are ensured the highest technical expertise available. If you have an Allpax control system, you are covered!

Do you need an Allpax Retort to take advantage of our 24/7 Plus Support?

The answer is...Allpax Control Systems can be retro-fitted to any type of retort from basic manually controlled systems to automated retort rooms. We have experience with retrofits on retorts manufactured by:
- Malo
- Stock
- Lubecca
- Lagarde

With Allpax controls, we’ve got you covered!