ALLPAX SATURATED STEAM

Horizontal Static/Agitating Retorts

PRODUCTION RETORTS & SOFTWARE

DESIGNED BY THERMAL PROCESSING SPECIALISTS

Allpax manufactures the most complete line of retorts and sterilization systems in the world. All of our equipment and control software is designed by engineers and specialists in the field of thermal processing of low-acid foods in cans, pouches, jars and bowls. Our products conform, meet or exceed the standards specified in 21 CFR in design and fabrication. The internal piping design of the Allpax ***SATURATED STEAM*** retort allows for even temperature distribution to deliver optimal come-up times.

ASME CODED AND RATED

The standard Allpax ***SATURATED STEAM*** retort is pressure rated to 58 psi. The retorts can be ordered with manual, or automatic quick-opening doors in either swing-open or orbiting design. Allpax retorts are ASME coded and registered with the National Board.

SEVERE-DUTY CONSTRUCTION AND COMPONENTS

We've used the same severe-duty construction / minimum-downtime concept for the Allpax ***SATURATED STEAM*** retort as we do for all of our retorts, robotics and material handling equipment. All components are premium quality. The valves, drive components and field devices are sourced for rapid availability for minimum spare parts inventory. The electrical / pneumatic panel attached to the retort is NEMA 4 rated complete with a 15" Allen Bradley color touch screen HMI.

DESIGNED, BUILT, AND SUPPORTED BY ALLPAX

All of our equipment is manufactured by Allpax technicians specializing in precision fabrication and control. Like all of our retorts and other processing equipment, Allpax ***SATURATED STEAM*** retorts are supported and serviced by the same people who designed and built them. Right here in Covington, Louisiana.

EQUIPMENT & SYSTEM FEATURES

- ☑ Available in standard diameters and lengths from 24" (600mm) to 72" (1800mm).
- ☑ Vent piping/valves designed to provide efficient scheduled vent times.
- ☑ Bleeders located above each basket location.
- ☑ Allen Bradley hardware & software products.
- ☑ 304 Stainless Steel or Carbon Steel Construction.
- ☑ 15" Allen Bradley touch screen HMI.
- ☑ Doors - Manual or Automatic / Swing-Open or Orbiting.
- ☑ Allpax ***PAXWARE*** PLC Retort Controller for automated process control.
- ☑ Allpax ***MONITOR*** Host Recipe Editor and report generator.
- ☑ Allpax ***ALLVIEW*** Operator Interface Graphics.
- ☑ Optional Flooded or Heat Exchanger Cooling.
- ☑ Severe duty drive components capable of 0-60 strokes per minute.
- ☑ 24/7 support available by Allpax Engineers.

RETORT CONTROLS

The Allpax ***MONITOR*** retort control system has been reviewed and accepted by both the FDA and USDA. It features automatic, on-line deviation correction, retort log reporting, electronic signatures, multi-level security, alarm reporting, and optional Ball Formula process calculation. The system is recipe-driven, allowing the company's process authority the greatest level of control over retort room operations. See the reverse side for the features and functions of this system.

The Allpax Line of Retort Room Equipment

RETORTS·LOADERS·AUTOMATION

HIGH TECHNOLOGY - HIGH QUALITY - STRONG SUPPORT

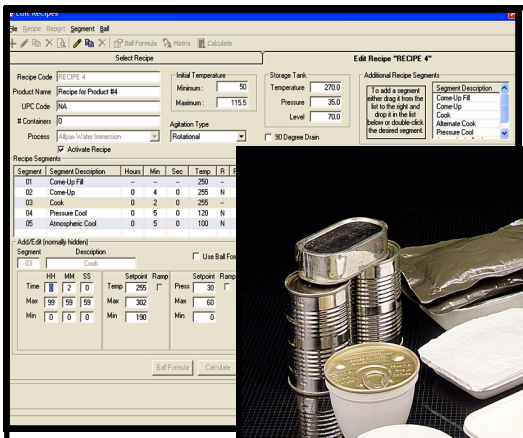
ALLPAX

ALLPAX PRODUCTS, INC
13510 SEYMOUR MYERS BLVD., COVINGTON, LA 70471
985 . 893 . 9277 FAX 985 . 893 . 9477 www.allpax.com

MONITOR

ALLPAX

Retort Host System



ALLPAX Batch Summary Report — *Allpax Products*

Batch Date: 06/15/2009 10:41 AM
Unit #: 1
Batch #: 2

13510 Seymour Myers Blvd
Covington, LA 70433
Prepared By: Allpax Master

Production Code	Recipe Code	Initial Temp	# Items
1	RECIPE 4	100.0	4

Log Event	Time	Elapsed	Temp	Press	Level	RPM	Flow	Operator
Come-Up Fill								
Begin Comeup/Fill	16:42:53	00:00:00	93.0	1.0	0.0	0.0	0.0	Allpax Master
RPM Met	16:42:54	00:00:01	93.0	1.0	0.0	5.0	0.0	Allpax Master
Circulation Pump Started	16:43:14	00:00:21	93.0	10.0	25.0	5.0	0.0	Allpax Master
End Comeup/Fill	16:43:49	00:00:56	151.0	27.0	72.0	5.0	1500.0	Allpax Master
SCHEDULE	--------	00:00:00	250.0	-----	75.1	5.0	-----	
Come-Up								
Begin Come Up	16:43:50	00:00:00	151.0	27.0	72.0	5.0	1500.0	Allpax Master
RPM Met	16:43:52	00:00:02	155.0	27.0	72.0	15.0	1500.0	Allpax Master
Temperature Met	16:44:53	00:01:03	255.0	29.0	72.0	15.0	1500.0	Allpax Master
Pressure Met	16:44:56	00:01:06	255.0	30.0	72.0	15.0	1500.0	Allpax Master
End Come Up	16:47:50	00:04:00	256.0	30.0	72.0	15.0	1500.0	Allpax Master
SCHEDULE	--------	00:04:00	255.0	30.0	-----	15.0	-----	
Cook								
Begin Cook	16:47:50	00:00:00	256.0	30.0	72.0	15.0	1500.0	Allpax Master
End Cook	16:49:50	00:02:00	255.0	30.0	72.0	15.0	1500.0	Allpax Master
SCHEDULE	--------	00:02:00	256.0	30.0	-----	15.0	-----	
Pressure Cool								
Begin Pressure Cool	16:49:50	00:00:00	255.0	30.0	72.0	15.0	1500.0	Allpax Master
Temperature Met	16:53:33	00:03:43	120.0	11.0	100.0	15.0	1500.0	Allpax Master
Pressure Met	16:54:47	00:04:57	101.0	5.0	100.0	15.0	1500.0	Allpax Master
End Pressure Cool	16:54:50	00:05:00	101.0	5.0	100.0	15.0	1500.0	Allpax Master
SCHEDULE	--------	00:05:00	120.0	5.0	-----	15.0	-----	
Atmospheric Cool								
Begin Atmospheric Cool	16:54:50	00:00:00	101.0	5.0	100.0	15.0	1500.0	Allpax Master
Temperature Met	16:54:51	00:00:01	100.0	5.0	100.0	15.0	1500.0	Allpax Master
End Atmospheric Cool	16:59:50	00:05:00	80.0	5.0	100.0	15.0	1500.0	Allpax Master
SCHEDULE	--------	00:05:00	100.0	-----	-----	15.0	-----	
Drain								
Begin Drain	16:59:50	00:00:00	80.0	5.0	100.0	15.0	1500.0	Allpax Master
End Drain	17:01:17	00:01:27	79.0	1.0	0.0	0.0	1500.0	Allpax Master
Unload								
Begin Unload	17:01:17	00:00:00	79.0	1.0	0.0	0.0	1500.0	Allpax Master
Door Open	17:01:34	00:00:17	78.0	1.0	0.0	0.0	0.0	Allpax Master

DESIGNED BY FOOD SCIENTISTS

The Allpax **MONITOR** system was developed by the food scientists and food process professionals at Allpax for the purpose of insuring 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.

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.

Allpax Products 13510 Seymour Myers Blvd. Covington, LA 70433 985.893.9277 www.allpax.com

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