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Garris

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[54] **QUALITY CONTROL MONITOR FOR MEDICINAL CAPSULE PACKAGING APPARATUS**

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[52] **U.S. Cl.** **250/560;** 209/111.7; 250/223

[51] **Int. Cl.** **H01j 39/12**

[58] **Field of Search** 250/560, 561, 562, 206, 250/208, 222, 223; 209/111.7, 111.5; 53/266

[56] **References Cited**

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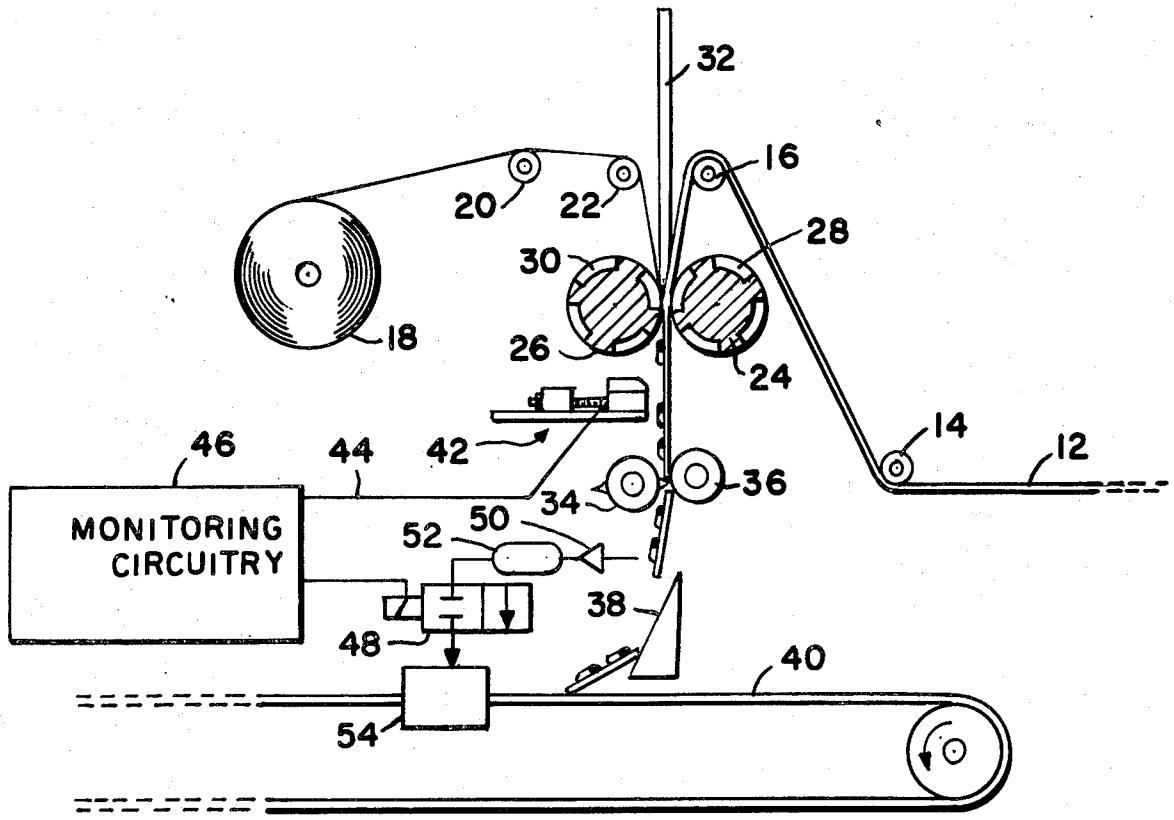
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Primary Examiner—James W. Lawrence
Assistant Examiner—D. C. Nelms
Attorney, Agent, or Firm—Smith, Harding, Earley & Follmer

[57] **ABSTRACT**

Medicinal capsules which are secured by machine to a backing strip are photoelectrically inspected by multiple pairs of light sources and detectors specially arranged so as to permit the simultaneous inspection of a number of closely spaced capsules arranged in a row. The extent to which a capsule is filled is determined by the time interval during which a light beam is blocked by the capsule contents. This interval is electrically compared with a standard time interval. After the backing strip is cut into separate cards, each carrying several capsules, the electrical comparison means effects rejection of any card containing an unsatisfactory capsule. Further means are provided for similarly rejecting cards having badly misaligned capsules. Should the apparatus sense an excessive number of unsatisfactory cards, the packaging machinery is automatically shut down. Electrical means are provided for adjusting the delay between the sensing of an unsatisfactory capsule or row of capsules and the mechanical rejection of a card in order to effect optimum operation.

7 Claims, 10 Drawing Figures



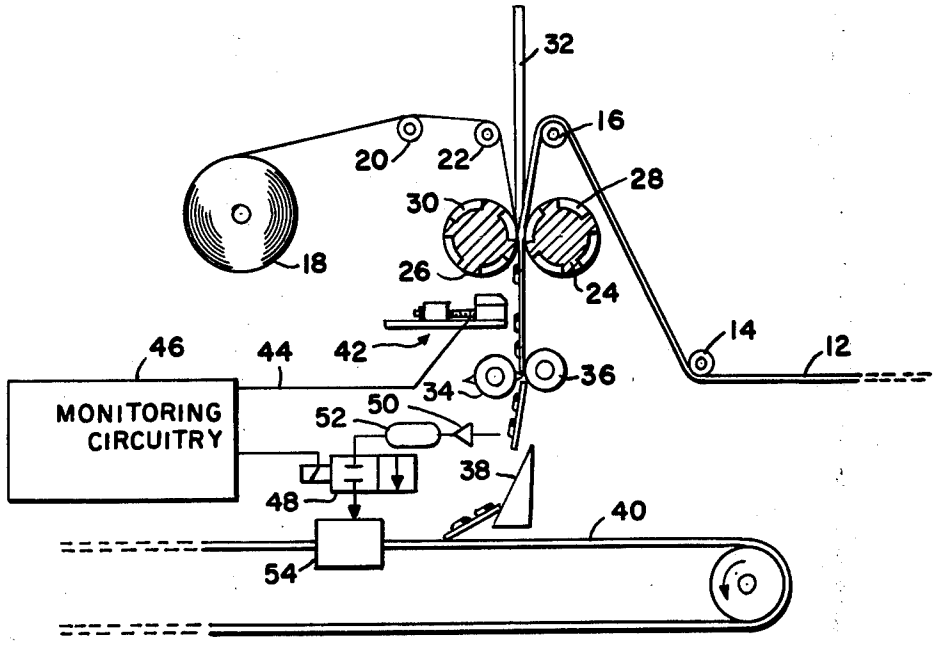

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MONITORING CIRCUITRY
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FIG. 1.

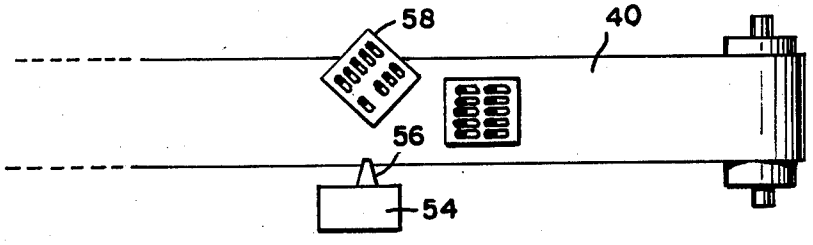

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FIG. 2.

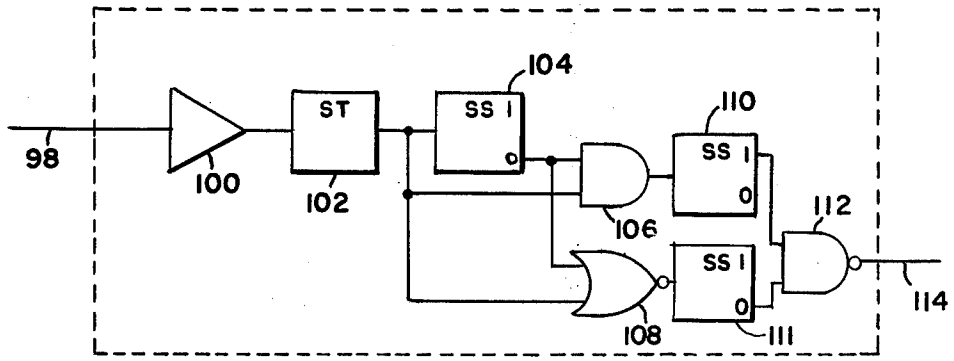


FIG. 10.

FIG. 3.

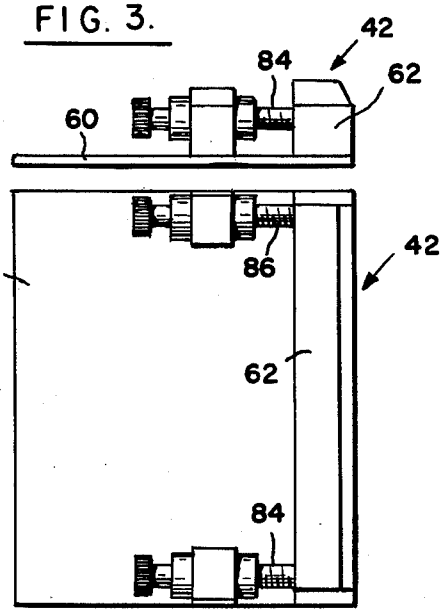


FIG. 4.

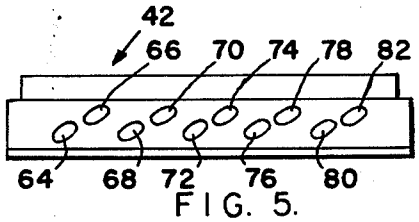


FIG. 5.

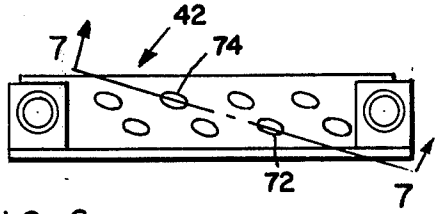


FIG. 6.

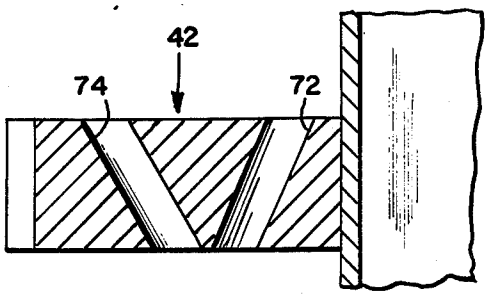


FIG. 7.

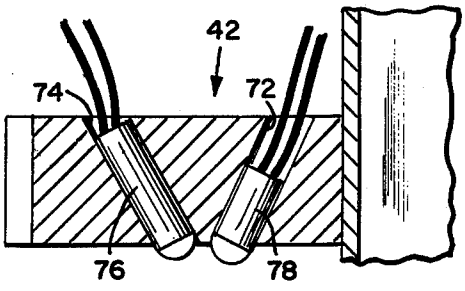


FIG. 8.

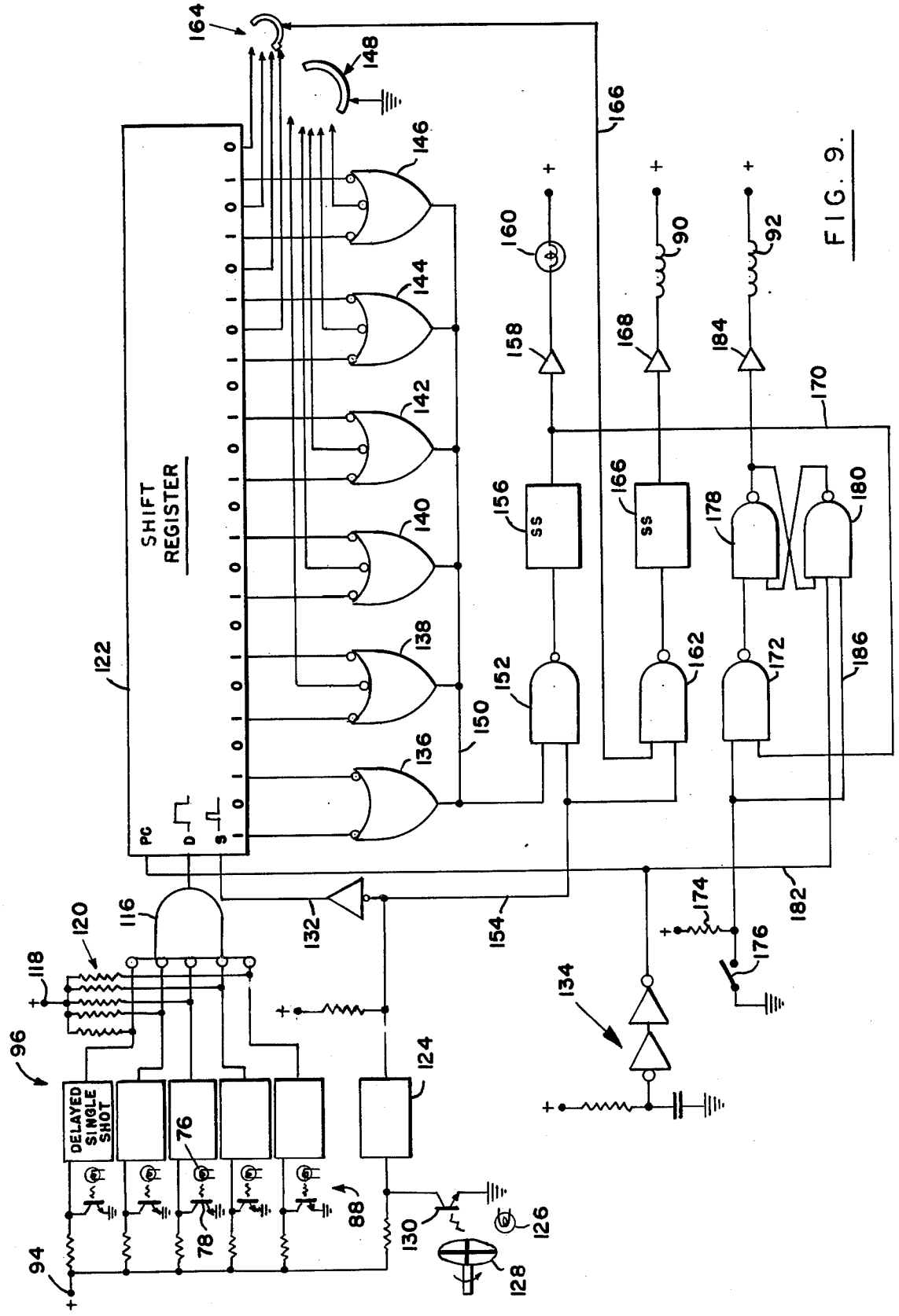


FIG. 9.

QUALITY CONTROL MONITOR FOR MEDICINAL CAPSULE PACKAGING APPARATUS

SUMMARY OF THE INVENTION

This invention relates to quality control monitoring, and particularly to a quality control monitor especially adapted for use in conjunction with an apparatus for packaging medicinal capsules and the like.

Medicinal capsules, for example the well known CONTAC decongestant capsules, are frequently packaged in a manner such that the capsules are secured to a backing strip by means of a sheet of transparent thermoplastic material which is heated-sealed to the card so as to form individual pockets for the capsules. In a typical packaging machine, capsules are delivered through a group of parallel tubes to the point at which the thermoplastic sheet is secured to a backing strip to provide the aforementioned pockets. The capsules are fastened to the moving backing strip in rows which are transverse to the direction of movement of the backing strip. After the backing strip moves past the point at which the rows of capsules are secured to it, it is automatically cut into cards, each card carrying one or more rows of capsules.

Heretofore, the cards, after cutting, were carried by a conveyor to a delivery location at which they were collected. A visual inspection was made by one or more operators located along the path of the conveyor. A card which an operator deemed unsatisfactory, because of a partially filled capsule, a missing capsule, or a badly misaligned row of capsules would be manually removed from the conveyor. Visual inspection is obviously costly and tedious. It is also unreliable because it is difficult to judge whether or not a capsule is adequately filled by a quick visual inspection. Visual inspection is made still less reliable by tinted capsule material, which often renders the capsule contents almost invisible.

Automatic inspection means are provided in accordance with this invention, having among its objects the following.

A first object of the invention is to provide automatic optical inspection means which is capable of inspecting capsules which are closely spaced in rows arranged on and transverse to the direction of movement of an opaque, reflective backing strip. This object is accomplished by arranging light beam producing means and photosensitive detectors in pairs for the simultaneous inspection of the capsules in a row, so that each beam approaches the backing strip at an oblique angle and is reflected to a different one of the detectors and so that each plane defined by the approaching and reflecting part of a beam intersects the plane defined by the movement of a row of capsules to define a line which is oblique with respect to the direction of motion of the row of capsules. With the light beam producing means and the photosensitive detectors so arranged, the beam is able to pass through the capsule in a direction transverse to the capsule's long dimension, and is therefore capable of making a more accurate determination of the amount of medication in a capsule than would be possible if the beam passed through the capsule in the longitudinal direction. However, with the arrangement described, the light beam producing means and photosensitive detectors do not physically interfere with each other even though they are capable of simultaneously inspecting capsules which are closely spaced with respect to each other in rows.

A second important object of the invention is the accurate and consistent determination of whether or not a capsule meets the criteria for acceptability. In accordance with the invention, this is accomplished by automatically comparing an electronically established time interval with the interval during which an inspection beam is blocked by the capsule contents. If any capsule on a card fails to meet the criteria for acceptance, a reject mechanism is activated to effect delivery of the card to a reject location.

Another object of the invention is to insure that the capsules in a row are satisfactorily aligned with each other. As the contents of each capsule clears the inspection beam, assuming the capsule is filled satisfactorily, a pulse is produced. The corresponding pulses for all of the capsules in the row must overlap in order for the apparatus to determine that satisfactory alignment exists. This is accomplished by the use of a coincidence gate. The criteria for proper alignment may be adjusted by adjusting the pulse lengths. In addition, the apparatus insures that each row of capsules is positioned within certain limits measured in the direction of backing strip movement by means of a clock pulse, synchronized with the packaging mechanism, and with which the aforementioned predetermined pulses must all coincide.

The packaging machinery, equipped with the quality control monitor may be operated unattended for extended periods of time. Nevertheless, it is possible for the packaging machinery to break down so that it produces unacceptable cards with great frequency. Another object of the invention is to effect shutdown of the packaging apparatus when the occurrence of unacceptable cards becomes so frequent as to indicate that continued operation of the machine would result in a large amount of waste. This determination is preferably accomplished by the use of a shift register in conjunction with gating circuitry to determine if a predetermined number of successively produced cards are unacceptable. The predetermined number may be adjusted by the operator.

A still further object of the invention is to optimize the operation of the rejection means. This is accomplished by the production of a rejection pulse at an appropriate time determined by the shift register. This also may be adjusted by the operator to insure rejection of all unacceptable cards.

Various other objects will be apparent from the following description.

BRIEF DESCRIPTION OF THE DRAWINGS

FIG. 1 is a diagrammatic view of a capsule packaging machine equipped with a quality control monitor in accordance with the invention;

FIG. 2 is a plan view of the conveyor and card rejection mechanism in accordance with the invention;

FIG. 3 is a side elevation of a capsule inspection head;

FIG. 4 is a top plan view of the capsule inspection head;

FIG. 5 is an elevation of the inspection head viewed from the capsule side;

FIG. 6 is an elevation of the capsule inspection head viewed from the side opposite the capsule side;

FIG. 7 is a section of the inspection head taken on the plane indicated at 7—7 in FIG. 6;

FIG. 8 is a sectional view similar to FIG. 7, showing a light beam producing means and a photosensitive detector mounted in the inspection head;

FIG. 9 is a schematic diagram of the electrical circuitry associated with the quality control monitor; and

FIG. 10 is a schematic diagram of a delayed single shot multivibrator, several of which are used in the circuit of FIG. 9.

DETAILED DESCRIPTION

FIG. 1 shows the basic elements of a capsule packaging machine and the relationship to it of the quality control monitor in accordance with the invention.

A continuous backing strip **12**, preferably of cardboard having a reflective white surface, is fed around a series of guide rollers including rollers **14** and **16** preferably at a substantially constant speed. A heat-sealable thermoplastic material such as polyvinyl chloride is fed from a supply roll **18** over rollers **20** and **22**. The backing strip and the thermoplastic sheet are brought together between a pair of heated die rollers **24** and **26**, which, by heating, seal the thermoplastic sheet to the backing strip. The die rolls are provided with pockets, typical pockets being indicated at **28** and **30**. These pockets provide clearance which allows capsules to be inserted between the backing strip and the thermoplastic sheet through a bank of tubes, the tube on the near end of the bank being indicated at **32**. The die rolls effect heat sealing so as to form pockets which secure the capsules in place in rows on the backing strip, the rows being transverse to the direction of movement of the backing strip. Each pocket is heat-sealed around its entire periphery.

A bladed roller **34** and a backing roller **36** effect cutting of cards from the backing strip which slide down incline **38** onto conveyor **40** which normally delivers the cards to a delivery location.

The quality control monitor comprises an optical inspection head **42** which is connected through cable **44** to monitoring circuitry **46**. The monitoring circuitry effects control of a solenoid valve **48** which controls the flow of air from compressor **50** and reservoir **52** to a reject mechanism **54**. Reject mechanism **54** is positioned alongside the conveyor and is provided with a nozzle **56** (FIG. 2) which is located just above the conveyor surface whereby a blast of air delivered through the nozzle is able to effect movement of an unacceptable card such as **58** to a reject location. The principal function of the monitoring circuitry **46**, as will be explained more fully, is to establish and apply predetermined criteria for acceptance or rejection of a card and to effect rejection of unacceptable cards at the proper time as they pass nozzle **56** of reject mechanism **54**.

FIGS. 3–8 show the optical inspection head **42** in detail. As shown in FIGS. 3 and 4, the inspection head comprises a mounting plate **60** on which is secured a block **42** in which there is provided an array of cylindrical passages for mounting light beam producing means and photosensitive detectors.

The cylindrical passages are specially arranged so as to permit the simultaneous inspection of a number of closely spaced capsules arranged in a row. In particular, the cylindrical passages are arranged in pairs so that, as shown in FIG. 5, passages **64** and **66** constitute a first pair, **68** and **70** constitute a second pair, **72** and **74** constitute a third pair, **76** and **78** constitute a fourth pair, and **80** and **82** constitute a fifth pair.

One passage in each pair is used to mount a light beam producing means such as incandescent lamp **76** shown mounted in cylindrical passage **74** in FIG. 8. The other passage in a pair is used to mount a photosensitive detecting means such as phototransistor **78** shown mounted in cylindrical passage **72** in FIG. 8. The axis of each cylindrical passage in a pair intersects the axis of the other cylindrical passage in the pair so that the planes defined by the intersecting axes intersect a plane defined by the movement of a row of capsules past the inspection head to define lines which are oblique with respect to the direction of motion of the row of capsules. The beam produced by the light beam producing means is aligned with the axis of the cylindrical passage in which the beam producing means is mounted. Therefore, it is apparent that each beam approaches the backing strip at an oblique angle and is reflected to a different one of the detectors in the array so that each plane defined by the part of the beam approaching the backing strip and the part of the beam reflected by the backing strip intersects the plane defined by the movement of a row of capsules to define a line which is oblique with respect to the direction of motion of the row of capsules.

The aforementioned oblique relationship allows the light beam producing means and photosensitive detectors to be accommodated in a relatively small row-wise space without interfering with each other, and thus allows the simultaneous inspection of a large number of capsules which are closely spaced in a row.

Returning to FIGS. 3 and 4, screws **84** and **86** permit adjustment of the distance between block **62** and the backing strip to obtain optimum reflection of the inspection beams back to their corresponding photosensitive detectors.

FIG. 9 shows the monitor circuitry which receives outputs from the array of light beam producing means and photosensitive means indicated generally at **88**, and automatically effects operation of solenoid **90** of solenoid valve **48** (FIG. 1) to effect card rejection, and which also automatically operates a solenoid **92** to cause the capsule packaging machinery to halt when the occurrence of unacceptable cards becomes too frequent.

Each phototransistor in array **88** acts as a gate allowing delivery, when the light beam approaching it is blocked, of a positive signal from positive supply terminal **94** to the input of a delayed single shot multivibrator in group **96**, which consists of five such multivibrators, there being one for each phototransistor in the array.

The function of the delayed single shot multivibrator is to establish a standard time interval, to compare the standard time interval with the duration of the positive signal provided when the contents of a capsule block the light beam which normally impinges on the associated phototransistor, and to provide an output pulse when the duration of the applied pulse exceeds the standard time interval, the output pulse commencing at the end of the standard time interval. In other words, the delayed single shot multivibrator provides its output pulse when the duration of the input pulse exceeds a predetermined limit.

The internal details of a single delayed single shot multivibrator are illustrated in FIG. 10. The positive

pulse produced by the blocking of the light beam to a phototransistor is applied at line **98** to the input of amplifier **100,** the output of which is delivered to a Schmitt trigger **102.** The output of the Schmitt trigger is delivered to the input of an ordinary single shot (or monostable) multivibrator **104,** to one of the inputs of AND gate **106,** and to an input of OR gate **108.** The "0" output of single shot multivibrator **104** (which output is normally high) is connected to the other input of AND gate **106** and to the other input of OR gate **108.** The output of AND gate **106** is connected to the input of a second single shot multivibrator **110,** and its "1" output (which is normally low) is delivered to one of the inputs of AND gate **112.** The output of OR gate **108** is negated and delivered to the other input of a third single shot multivibrator **111.** The "0" output of multivibrator **111** is delivered to the other input of AND gate **112.** The output of AND gate **112** is negated and delivered at output line **114.**

In operation, multivibrator **104** determines the predetermined time interval with which the duration of the applied pulse is compared. Multivibrator **110** determines the duration of the output pulse if an output pulse is produced for a given input pulse. Multivibrator **111** primes gate **112** for coincidence with the output of multivibrator **110,** and inhibits the output at line **114,** if the input pulse is interrupted. The time constants of multivibrators **104, 110** and **111** are preferably adjustable so that their output pulse lengths may be varied.

Suppose for example, that a pulse is applied at line **98** which has a duration shorter than the delay of multivibrator **104.** At the beginning of the applied pulse, assuming a rectangular waveform, multivibrator **104** is immediately triggered so that its "0" output goes low. Line **114** is high at this time by reason of the high condition of the output of multivibrator **111.** Assuming that the applied pulse terminates before the end of the time interval established by multivibrator **104,** the output of OR gate **108** goes high, and triggers multivibrator **111** so that its output goes low. The output of multivibrator **110** remains low. Therefore, the condition of line **114** remains high, which is its normal condition.

A second possibility may occur as a result of a capsule which is partially filled at both ends but which has a gap at some point intermediate its ends. Two short pulses are produced at line **98** having a gap between them. At the end of the first short pulse, the output of gate **108** goes high and triggers multivibrator **111.** The low condition of the output of multivibrator **111** holds gate **112** in a disabled condition so that line **114** remains high even though multivibrator **110** is triggered as a result of the return of multivibrator **104** to its stable condition during the second of the short pulses.

Under normal circumstances, the duration of the applied pulse exceeds the time interval established by multivibrator **104.** The output of multivibrator **104** will be high at the same time that the output of Schmitt trigger **102** is high. This will produce a high at the output of AND gate **106** which will trigger multivibrator **110** so that its output goes high. This high and the high from multivibrator **111** will satisfy AND gate **112,** and, two highs being present at the inputs of AND gate **112,** a low is produced at output line **114,** indicating a satisfactory capsule.

Returning now to FIG. **9,** the outputs of the five delayed single shot multivibrators in group **96** are fed through negated inputs to a five input AND gate **116.** The input lines are normally held positive by the connection of positive supply terminal **118** through resistors **120** to the lines. However, the output AND gate of each delayed single shot multivibrator includes a transistor which grounds the output line, thereby producing a low potential at the output line. When all of the five input lines to AND gate **116** are low, a high appears at its output which is connected to the data input "D" of a 12 bit shift register **122.** An additional delayed single shot multivibrator **124** receives positive pulses which are produced as a result of the reflection of light from source **126** off a rotating marked disk **128** to phototransistor **130,** the phototransistor being connected as a gate in a manner similar to the manner of connection of the phototransistors in array **88.** The multivibrators in delayed single shot **124** are adjusted so as to produce a relatively short negative-going output pulse which normally occurs about half way between the beginning and end of the coincidence pulse produced at the output of AND gate **116.** The output of multivibrator **124** is inverted, then delivered through line **132** to set input "S" of the shift register.

The shift takes place in shift register **122** whenever a positive-going pulse appears in line **132.** Normally, the shift occurs when a high is present at the date input "D." Consequently, the "1" outputs of the shift register normally remain in the high condition at all times. The "1" outputs are set to the high condition when positive supply voltages applied to the various supply terminals of the circuit by the application of a positive signal produced at that time by the circuit indicated at **134** to the preset control terminal "PC" of the shift register.

The first two "1" outputs of the shift register are connected to the negated inputs of a two input OR gate **136.** The second two "1" outputs of the shift register are connected to two of three negated inputs of a three input OR gate **138.** The remaining "1" outputs of the shift register are similarly connected in pairs to three input OR gates **140, 142, 144** and **146.** The third input of each of the three input OR gates is negated and connectable to ground through a rotary switch **148** which is so designed as to short successively closed contacts together. The outputs of all five OR gates are connected together through line **150** which is connected to an input of two input AND gate **152.** The output of delayed single shot **124** is connected through line **154** to the other input of AND gate **152.** The output of AND gate **152** is negated and connected to the input of a single shot multivibrator **156,** the output of which is amplified by amplifier **158** to control indicator lamp **160.**

Line **154** is also connected to an input of two input AND gate **162.** The other input to AND gate **162** is derived from any one of four "0" outputs of shift register **122,** the selection being made by switch **164,** the wiper of which is connected through line **166** to AND gate **162.** The negated output of AND gate **162** is delivered to single shot multivibrator **166,** the output of which is amplified by amplifier **168** and used to operate valve solenoid **90.**

The output of single shot multivibrator **156** not only controls indicator lamp **160,** but is also connected through line **170** to an input of AND gate **172.** The other input is connected through resistor **174** to the positive supply, a reset switch **176** being provided to produce a low momentarily to this input. The negated output of AND gate **172** is connected to an input of two input AND gate **178,** the other input of which is de-

rived from the negated output of three input AND gate **180.** AND gates **178** and **180** are interconnected in a latch configuration. One of the other inputs of AND gate **180** is derived from the negated output of AND gate **178.** The third input of AND gate **180** is derived through line **182** from circuitry **134** so that a positive pulse is delivered to a third input when power is applied to the monitoring circuitry. The output of the latch at the output of AND gate **178** is amplified by amplifier **184** and used to operate halt solenoid **92.**

The operation of the solenoid valve **90** of the reject mechanism is effected after a delay whenever a condition occurs such that the clock pulse appears at shift register set terminal "S" when the data terminal is in a low condition. A high travels along the "0" output of the shift register until it reaches the "0" output to which line **166** is connected through switch **164.** With line **166** temporarily in a high condition, the reappearance of a high in line **154** following the clock pulse results in the production of a low at the output of AND gate **162.** This low triggers multivibrator **166,** and effects opening of the solenoid valve which delivers a blast of air to reject nozzle **56** (FIG. **2**), thereby removing a defective card from the conveyor. The shift register produces the necessary delay to allow the card to travel from the point at which it is inspected by inspection head **42** to the point where it is rejected by reject mechanism **56.** Switch **164** (FIG. **9**) allows the operator to make an electrical adjustment of the delay to insure that the blast of air occurs when the unacceptable card is in the optimum position with respect to the nozzle for reliable rejection.

OR gates **136–146** are arranged so that a high is produced in line **150** whenever at least one input of each of the gates is low. By the adjustment of switch **148,** an artificially produced low can be effected at inputs of up to five of the six OR gates. For example, with switch **148** in the position shown, a high in line **150** will be produced only when six consecutive unacceptable cards (having two rows each) are sensed by the inspection head. In the event of six unacceptable cards, there will be at least one low at the inputs of each of the six OR gates.

If the switch **148** is moved one position clockwise, at least five consecutive unacceptable cards are necessary to produce a high in line **150.** Switch **148** can be adjusted so as to produce a high in line **150** for any number of consecutive unacceptable cards between one and six.

When line **154** goes high at the end of a clock pulse, if line **150** is high, a low at the output of AND gate **152** triggers single shot multivibrator **156.** The output of multivibrator **156** causes illumination of indicator lamp **160** and also produces a high in line **170** which results in a low at the output of AND gate **172.** This low latches the interconnected AND gates **178** and **180** to a condition such that the output of AND gate **178** goes high and effects operation of halt solenoid **92.** Halt solenoid **92** halts operation of the capsule packaging machinery by effecting disconnection of electric motive power. Resetting of the latch is effected by momentary closure of switch **176** which delivers a low through line **186** to an input of AND gate **180.** The output of AND gate **180** goes high, and since both inputs of AND gate **180** are high at this time, its outputs go low and halt solenoid **92** is deenergized. Thus, the operator can cause operation of the packaging machine to resume by momentary operation of switch **176.**

The operation of the electrical circuitry in FIG. **9** may be briefly summarized as follows.

The occurrence of an inadequately filled capsule is sensed by the comparison of the time through which its contents block the inspection beam with a time interval which is electrically predetermined by the parameters of the components of a multivibrator corresponding to monostable multivibrator **104** (FIG. **10**). These parameters may be adjusted to set the criteria for acceptability, and also to accommodate the operating speed of the packaging machinery, which, of course, determines the interval through which the inspection beam is blocked for a given quantity of capsule contents.

All of the capsules in a row are inspected simultaneously, and the circuitry effects a rejection of the card if any capsule in any row on the card is unacceptable because of inadequate contents.

When all of the capsules in a row are aligned, the pulses produced by the delayed single shot multivibrators in group **96** coincide. However, if a capsule is badly misaligned with the remaining capsules in its row, the pulse corresponding to it will not coincide with the other pulses, and no coincidence pulse will be produced at the output of AND gate **116.** The card carrying the misaligned capsule will be rejected. The extent of misalignment which will be tolerated is determined by the lengths of the pulses produced at the outputs of the delayed single shot multivibrator, and these lengths may be adjusted.

The row itself must be located within certain limits measured in the direction of travel of the backing strip since otherwise rows of capsules might be positioned too close together or too far apart on a card. The pulse produced by delayed single shot **124** is synchronized with the packaging machinery, and insures the rejection of any card in which a row is so far out of proper position that the coincidence pulse at the output of AND gate **116** does not overlap the pulse at the output of delayed single shot **124.** The length of the pulse produced by delayed single shot **124** may be adjusted electrically, and its position may be adjusted either electrically or mechanically.

Switch **164** provides for especially simple and convenient adjustment of the delay between inspection and rejection.

Switch **148** establishes the criteria for causing the packaging machinery to stop automatically. Generally speaking, the apparatus senses the frequency of unacceptable cards and causes the packaging maachinery to halt when the frequency of unacceptable cards becomes too high. More specifically, the apparatus makes use of the shift register to effect a halt when a predetermined number of unacceptable cards in a row is produced. Various other means for effecting a halt of the packaging machinery when the frequency of unacceptable cards becomes too high will occur to those skilled in the art.

Similarly, other modifications may be made to what is specifically disclosed without departing from the scope of the invention as defined in the following claims.

I claim:

1. A quality control monitor for medicinal capsule packaging apparatus comprising:

means for photoelectrically sensing the presence of medication in a capsule and providing an electrical signal the time duration between the onset and the cessation of said signal being a function of the quantity of medication in the capsule, and

means, establishing a predetermined time interval and providing an indication whether said duration of the electrical signal is greater or less than the predetermined time interval, including a first monostable multivibrator connected to be triggered to its unstable state at the onset of said electrical signal, a second monostable multivibrator, and gating means responsive to said electrical signal and to the output of the first multivibrator for triggering the second multivibrator to its unstable state if and only if the first monostable multivibrator returns to its stable state during said duration of said electrical signal.

2. A quality control monitor according to claim **1** including means synchronizable with the packaging apparatus for producing a series of pulses at the same rate at which said electrical signals are produced when the packaging apparatus is producing packaged capsules without interruption, and means for preventing an indication, that the duration of the electrical signal is greater than the predetermined interval, from being produced if the unstable condition of the second multivibrator does not coincide with one of said pulses.

3. A quality control monitor for medicinal capsule packaging apparatus in which transparent capsules are filled with medication and fastened to a backing strip in rows, comprising:

means for photoelectrically sensing the presence of medication in all of the capsules in a row substantially simultaneously and providing a plurality of electrical signals the time duration between the onset and cessation of each of said signals being a function of the quantity of medication in a particular capsule in the row, and

means establishing, for each of said electrical signals, a predetermined time interval and providing an indication if the duration of any of said electrical signals is less than the predetermined time interval corresponding thereto, the last mentioned means comprising a plurality of units, one for each of said electrical signals, each unit comprising a first monostable multivibrator connected to receive an electrical signal and to be triggered to its unstable state at the onset of said electrical signal, a second monostable multivibrator, and gating means responsive to the electrical signal and to the output of the first multivibrator for triggering the second multivibrator to its unstable state if and only if the first monostable multivibrator returns to its stable state during the duration of the electrical signal.

4. A quality control monitor according to claim **3** including a coincidence gate connected to receive the outputs of the second monstable multivibrators in said units, said indication being derived from the output of said coincidence gate.

5. A quality control monitor according to claim **4** in which the second monostable multivibrators in said units have unstable states of adjustable duration.

6. A quality control monitor according to claim **4** including means synchronizable with the packaging apparatus for producing a series of pulses at a rate at which the packaging apparatus produces rows of capsules when operating without interruption, and means for providing an indication if the output of said coincidence gate does not coincide with one of said pulses.

7. A quality control monitor according to claim **6** in which the second monostable multivibrators in said units have unstable states of adjustable duration.

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