

For Restricted Circulation only

 SHAKAMBHARI GROUP #SteelWithin		SHAKAMBHARI ISPAT & POWER LTD. (Formerly known as Ess Dee Aluminium Ltd.)	
STANDARD OPERATING PROCEDURE			
Title: Operation of Bond/Seal Strength Tester			Page No. 1 of 2
SOP No.	Version No.	Effective Date	Next review date
SIPL/QCI/005	00	06.07.2026	05.07.2028

1.0 PURPOSE

1.1 To define a procedure for operation of the Bond/Seal Strength Tester.

2.0 SCOPE

2.1 This SOP applies to the Quality Control Department.

3.0 REFERENCE(S) & ATTACHMENTS**3.1 References:**

3.1.1 In-house.

3.2 Attachments:

3.2.1 Nil.

4.0 RESPONSIBILITY**4.1 QC Department Head:**

4.1.1 To prepare the SOP.

4.1.2 To confirm the content, correctness, and detailing of the SOP.

4.2 QA Head:

4.2.1 To approve the new or revised SOP.

4.2.2 To ensure implementation of the defined system.

5.0 DISTRIBUTION

5.1 Quality Assurance.

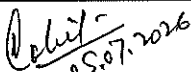
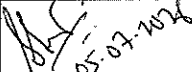
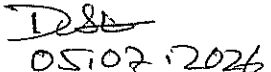
5.2 Quality Control.

6.0 DEFINITION(S) & ABBREVIATION(S)**6.1 Definitions:**

6.1.1 Nil.

6.2 Abbreviations:

6.2.1 Nil.

Prepared By:	Checked By:	Approved By:
		

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7.0 PROCEDURE

7.1 For Bond Strength Testing:

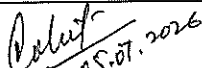
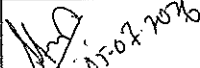
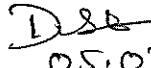
- 7.1.1 Cut the specimen to 15 mm of the sample to be tested. De-laminate the layers between which the bond is to be checked.
- 7.1.2 Power ON the system and attach one end of the de-laminated specimen to the upper jaw (movable jaw) with the help of self-adhesive tape.
- 7.1.3 Now attach the other end of the de-laminated specimen to the lower (fixed jaw) roller of the equipment.
- 7.1.4 Ensure that the sample is not stretched between the holding ends, so that the test starts from origin.
- 7.1.5 Press Zero, Reset, and Start, then press the load switch. NOTE: On startup, the system will always start in Peak HOLD mode.
- 7.1.6 The display will show the intended force (at breakage) and the same value shall be held until the Zero key is pressed again.

7.2 For Sealing Strength Testing:

- 7.2.1 Cut the specimen to 15 mm of the sample to be tested (Aluminium foil + PVC / Alu-Alu).
- 7.2.2 Fix both the samples in paper and seal at the Heat Seal Tester machine at the desired temperature.
- 7.2.3 The same procedure applies from step 7.1.2 onwards.

8.0 REVISION HISTORY

Revision No.	00	Effective Date	06.07.2026	CC No.	NA
Details of revision: New SOP					

Prepared By:	Checked By:	Approved By:
 05.07.2026	 05.07.2026	 05.07.2026