

For Restricted Circulation only

 SHAKAMBHARI GROUP #SteelWithin		SHAKAMBHARI ISPAT & POWER LTD. (Formerly known as Ess Dee Aluminium Ltd.)	
STANDARD OPERATING PROCEDURE			
Title: Operation for Rewinder Machine			Page No. 1 of 2
SOP No.	Version No.	Effective Date	Next review date
SIPL/PDI/001	00	06.07.2026	05.07.2028

1.0 PURPOSE

- 1.1 To check the surface quality of incoming raw material and to change the core material on the rewinder.

2.0 SCOPE

- 2.1 This SOP applies to Production Department.

3.0 REFERENCE(S) & ATTACHMENTS

3.1 References

- 3.1.1 In-house

3.2 Attachments

- 3.2.1 Attachment I: Rewinder / Inspection Logbook - SIPL/PDI/001/F01/00

4.0 RESPONSIBILITY

4.1 Production Department Person

- 4.1.1 To prepare the SOP.

4.2 Production Head

- 4.2.1 To ensure the training of the SOP to all concerned personnel involved in implementation of the SOP.

- 4.2.2 To ensure the implementation of the SOP after training.

4.3 Quality Assurance Person

- 4.3.1 To check the SOP and to maintain the original copy of the SOP.

- 4.3.2 To issue the controlled copy of the SOP and maintain its issuance record.
To retrieve the controlled copy of the SOP when it is superseded/obsolete and maintain its record.

4.4 QA Head / Plant Head

- 4.4.1 To approve new or revised SOP.

- 4.4.2 To ensure the implementation of the defined system.

5.0 DISTRIBUTION

- 5.1 Quality Control

- 5.2 Production

6.0 DEFINITION(S) & ABBREVIATION(S)

6.1 Definitions

- 6.1.1 **Rewinder:** Inspect the incoming roll and change the core.

- 6.1.2 **Inspection:** Checking for any kind of defects, such as wrinkles, spot, dent, roll loose winding, etc.

6.2 Abbreviations

- 6.2.1 QC: Quality Control

- 6.2.2 M/C: Machine

- 6.2.3 MPM: Meters Per Minute

- 6.2.4 HMI: Human Machine Interface

- 6.2.5 PSI: Pound per square inch (1 lb/in²; one pound-force applied to an area of one square inch).

Prepared By:	Checked By:	Approved By:
		

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7.0 PROCEDURE

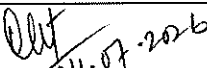
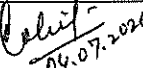
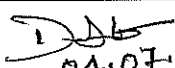
- 7.1 JOB cards are given to the operators, which give the permission and identification of the planned job to start.
- 7.2 Find and check the supplier sticker and unpack the coil as per the JOB card.
- 7.3 Check build-up, gauge, width, OD and any damages.
- 7.4 During rewinding, ensure the build-up is straight.
- 7.5 During rewinding, observe the defects of the foil stock. Any deviance in the foil stock quality should be brought to the notice of the supplier, or in case of rejection it has to be sent back to the supplier.
- 7.6 Lift the fresh coil from the foil stock and load it into the decoiler.
- 7.7 Clean every roll with dry cotton waste, load onto the empty spool on the recoiler, clamp the decoiler and perform centering.
- 7.8 Set all parameters (torque / coil specification / speed) in the system and run the machine to avoid any kind of damage.

Speed (MPM)	20 - 50
Torque (KG)	50-70

- 7.9 Check that the recoiler build-up is straight and inform QC when any surface defects are found, for confirmation.
- 7.10 After complete rewinding, put the identification sticker on the coil body, keep a sample for quality check and maintain the record.

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:
 04.07.2026	 04.07.2026	 04.07.2026