

For Restricted Circulation only

 SHAKAMBHARI GROUP #SteelWithin		SHAKAMBHARI ISPAT & POWER LTD. (Formerly known as Ess Dee Aluminium Ltd.)	
STANDARD OPERATING PROCEDURE			
Title: Operation for Foil Separator Machine			Page No. 1 of 3
SOP No.	Version No.	Effective Date	Next review date
SIPL/PDI/003	00	06.07.2026	05.07.2028

1.0 PURPOSE

- 1.1 To establish a standard procedure for the safe and effective operation of the Foil Separator Machine, to ensure correct separation of aluminium foil rolls while maintaining product quality and minimizing damage.

2.0 SCOPE

- 2.1 This SOP applies to all production Department.

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

- 3.1.1 In-house

3.2 Attachments

- 3.2.1 Attachments: Production Logbook: SIPL/PDI/003/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To retrieve the controlled copy of the SOP when it is superseded/obsolete and maintain its record.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 Nil

6.2 Abbreviations

- 6.2.1 Nil

Prepared By:	Checked By:	Approved By:
 04.07.2026	 04.07.2026	 04.07.2026

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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 Check the width of the input coil against the instruction of the programme book.
- 7.3 Check the thickness on the top portion of the part coil and discard the off-gauge portion, if any.
- 7.4 Set the blade / cutter as per the instruction of the programme / planning book.
- 7.5 Clean all path rolls with a microfiber cloth to remove dust and foreign particles.
- 7.6 Load the coil on the input and thread it to ensure proper centering on the output rewinder.
- 7.7 Set the tension value and start the machine in run mode.
- 7.8 Monitor the output foil surface and report to the Shift In-charge for any abnormality.
- 7.9 Join each break by ultrasonic welding and insert a marker.
- 7.10 Check the thickness of the foil near the joint portion and discard the off-gauge portion before joining.
- 7.11 Check the reel density as per planning.
- 7.12 Remove finished reels from the machine, weigh them and stack them on the appropriate rack / tray.
- 7.13 Record the reel number, specification and net weight of each reel.
- 7.14 Enter the relevant details in the production log book.

7.15 Tension Setting Chart:

Foil Thickness (mm)	Pack Density	Width (mm)	Abs. Tension (N/mm ²)
0.040	92-94 %	1001-1500	40-43
		901-1000	35-37
		801-900	33-35
		701-800	31-35
		500-700	29-33
0.030	90-92 %	1001-1500	39 - 41
		901-1000	29 - 33
		801-900	
		701-800	25 - 28
0.020-0.025	87-90 %	1001-1500	26 - 30
		901-1000	
		801-900	
		701-800	

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Foil Thickness (mm)	Pack Density	Width (mm)	Abs. Tension (N/mm ²)
0.012-0.018	86-89 %	701-1000	36 - 40
		501-700	
		401-500	
		301-400	
		200-300	
0.008-0.010	86-89 %	1001-1500	28 - 30
		701-1000	
		500-700	
0.006-0.0075	85-87 %	1001-1500	28 - 32

8.0 REVISION HISTORY:

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

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 04.07.2026	 04.07.2026	 04.07.2026