

For Restricted Circulation only

 SHAKAMBHARI GROUP #SteelWithin		SHAKAMBHARI ISPAT & POWER LTD. (Formerly known as Ess Dee Aluminium Ltd.)	
STANDARD OPERATING PROCEDURE			
Title: Procedure for Product Start-up			Page No. 1 of 2
SOP No.	Version No.	Effective Date	Next review date
SIPL/PDS/004	00	06.07.2026	05.07.2028

1.0 PURPOSE

- 1.1 To define a procedure to ensure that the quality of the output remains as per specification each time the machine starts.

2.0 SCOPE

- 2.1 This SOP applies to all production processes in the plant.

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 Department Head**

- 4.1.1 To prepare the SOP.

4.2 QA Head and Plant Head

- 4.2.1 To approve and 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.

- 4.2.3 To approve new or revised SOP.

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 Rewinding/Rolling

/Separation/Furnace/Coating/Lamination/Slitting/Doctoring Process

- 7.1.1 When any job starts on the machine, line clearance shall be filled by the machine technician.
- 7.1.2 Check the sample thoroughly for all quality aspects and take the signature of QC in the column in the log sheet.
- 7.1.3 Whenever there is a change of job, repeat the above two steps again.
- 7.1.4 If there is a job which is being carried forward to the next day, first sample checking is to be done once again.
- 7.1.5 Upon job completion, remove all the related material of the previous job and fill the line clearance form.

7.2 Printing Process

- 7.2.1 When any job starts on the machine, line clearance shall be filled by the machine technician.
- 7.2.2 Check the sample thoroughly for all quality aspects and sign off the first sample with QC as per the defined format.
- 7.2.3 Whenever there is a change of job, repeat the above two steps again.
- 7.2.4 If there is a job which is being carried forward to the next day, first sample checking is to be done once again.
- 7.2.5 Upon job completion, remove all the related material of the previous job and fill the line clearance form.

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