

SHAKAMBHARI ISPAT & POWER LTD.
(Formerly known as Ess Dee Aluminium Ltd.)

STANDARD OPERATING PROCEDURE

Title: Operation of Pneumatic Heat Sealer			Page No. 1 of 2
SOP No.	Version No.	Effective Date	Next review date
SIPL/QCI/002	00	06.07.2026	05.07.2028

1.0 PURPOSE

1.1 To define a procedure for operation of the Pneumatic Heat Sealer.

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.

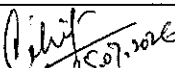
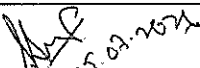
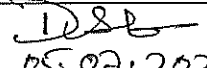
6.0 DEFINITION(S) & ABBREVIATION(S)

6.1 Definitions:

6.1.1 Dwell Time: the time, in seconds, for which the sample is kept in contact with the hot sealing jaws.

6.2 Abbreviations:

6.2.1 Nil.

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

For Restricted Circulation only

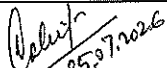
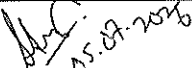
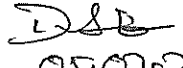
 SHAKAMBHARI GROUP # SteelWithin		SHAKAMBHARI ISPAT & POWER LTD. (Formerly known as Ess Dee Aluminium Ltd.)	
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7.0 PROCEDURE

- 7.1 Check that the in-let air pressure is above 4 bars. If required, adjust the pressure as per the test requirement.
- 7.2 Put on the switch (with built-in LED) located on the front lower side.
- 7.3 Set the temperature and dwell time as per the test requirement.
- 7.4 Cut a sample of the desired width.
- 7.5 Fold the sealing ply or heat-sealing surface inside.
- 7.6 Once the set temperature is achieved, insert the folded portion (test specimen) in between the jaws of the instrument.
- 7.7 Press the Start switch (green switch).
- 7.8 When the preset dwell time is over by reverse counting, the timer display will show '0.0' and the jaws will automatically separate. After separation of the jaws, the display will show the 'set' value.
- 7.9 Take out the sample from the jaws.
- 7.10 Allow the sample to cool down to normal temperature, then take it for further analysis.

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