



GLS Aluminium Industries Pvt. Ltd.

EHS DEPARTMENT

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TITLE: Aluminium Emergency response procedure

DOC. NO.

GLS/Foil/EHS/SOP/03

REV. NO.

00

EFFECTIVE
DATE

01/08/2025

REVIEW DATE

31/07/2026

SUPERSEDES

NIL

GLS Aluminium Industries Pvt Ltd Emergency response procedure

1. PURPOSE

To establish site-specific ERPs addressing hazards in **aluminium rolling, separation, annealing, and packing operations**, ensuring personnel safety, asset protection, and environmental compliance during emergencies.

2. SCOPE

Applies to:

- Rolling mills (Foil rolling)
- Slitting/separation lines
- Batch annealing furnaces
- Packing/storage facilities
- Contractors and visitors

3. DEFINITIONS

Term	Definition
Roll Stack Incident	Uncontrolled release of coiled aluminium during handling.



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Term	Definition
Annealing Gas Hazard	Leak of protective atmospheres
Oil Mist Fire	Ignition of lubricant aerosols in rolling mills.
Dust Explosion	Combustion of aluminium fines during rolling, cutting/packing.
CMT	Crisis Management Team (C.O.O. + EHS + Security).

4. RESPONSIBILITIES

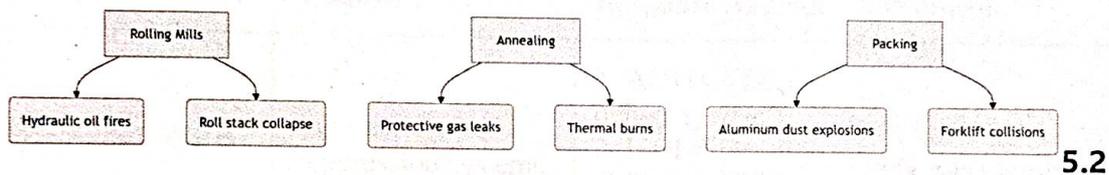
Role	Key Responsibilities
Operations Head	Activate CMT; coordinate plant-wide response.
EHS Manager	Gas monitoring; spill containment; compliance with ASI 4.5.
Maintenance Head	Emergency equipment (e-stop systems, ventilation shutdown).
Packing Supervisor	Safe evacuation of packing areas; flammable material control.

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5. ERP DEVELOPMENT PROCEDURE

5.1 Hazard-Specific Planning

Focus Areas for Rolling/Packing Operations:



Critical ERP Components

- Site maps with:
 - **Rolling mills:** Oil collection trenches, e-stop locations
 - **Annealing zones:** Gas shutoff valves, O₂ sensors
 - **Packing areas:** Dust collection points, forklift-free escape routes
 - Emergency equipment inventory:
 - Class B fire extinguishers (oil fires)
 - Portable gas detectors (H₂/N₂)
 - Thermal imaging cameras (overheated bearings)
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6. EMERGENCY SCENARIOS & RESPONSE

Operational-Specific Protocols:

Emergency Type	Preventive Measures	Immediate Response Actions	Communication Protocol
OIL MIST FIRE	Automatic mist suppression systems	<ol style="list-style-type: none"> 1. ACTIVATE deluge system 2. ISOLATE rolls 3. EVACUATE upwind 	"CODE RED – MILL 2" via PA + strobes
ROLL STACK RELEASE	Coil restraints; load sensors	<ol style="list-style-type: none"> 1. CLEAR 20m radius 2. LOCKOUT machinery 3. BARRICADE area 	Radio alert: "COIL DROP – LINE B"
ANNEALING GAS LEAK	Gas detectors with auto-shutoff	<ol style="list-style-type: none"> 1. SHUT gas supply 2. VENTILATE horizontally 3. TEST O₂ levels 	"GAS ALERT – ZONE 5" via intercom
DUST	Explosion vents; daily housekeeping	<ol style="list-style-type: none"> 1. CUT power 2. ACTIVATE spark suppression 3. EVACUATE vertically 	Mobile app alert: ""

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7. TESTING & MAINTENANCE

7.1 Drill Schedule

Drill Type	Frequency	Focus Area
Roll Stack Simulation	Annual	Coil restraint failure
Gas Leak Response	Annual	Annealing furnace zones
Dust Fire Containment	Annual	Packing/slitting areas

7.2 Equipment Checks

- Daily: Gas detectors, e-stop functionality
- Monthly: Deluge system valves, spill kits
- Annually: Dust collector explosion vents

8. TRAINING REQUIREMENTS

Role	Training Focus	Certification
Rolling Operators	Oil fire response; roll restraint protocols	NFPA 70E (Arc Flash)
Annealing Technicians	H ₂ /N ₂ leak procedures; burn first aid	Confined Space Entry
Packing Staff	Dust explosion prevention; forklift safety	OSHA 1910.178

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9. DOCUMENTATION & DISCLOSURE

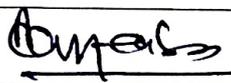
- **Public Summary:** Disclose on GLS website:

*"ERP covers rolling mill oil fires, annealing gas risks, and packing dust hazards.
Full redacted plan available at [Link]."*

- **Records Retention:**

- Drill logs: 7 years
- Equipment inspections: 5 years

REVISION HISTORY

Rev.	Date	Changes	Approved By
00	01/08/2025	Initial Issue	 Rajesh Singh (C.O.O.)

