



# GLS Aluminium Industries Pvt. Ltd.

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TITLE: PROCEDURE FOR SUSPENDED OPERATIONS	DOC. NO.	GLS/FOIL/MR/SOP/07
	REV. NO.	00
	EFFECTIVE DATE	01/08/2025
	REVIEW DATE	31/07/2026
	SUPERSEDES	NIL

## GLS ALUMINUM INDUSTRIES PVT. LTD.

### PROCEDURE FOR SUSPENDED OPERATIONS

*(Aligned with ASI Performance Standard V3 )*

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#### 1. PURPOSE

To establish protocols for the safe, compliant, and environmentally responsible management of **temporarily suspended aluminium rolling, annealing, and packing operations**, ensuring asset preservation, stakeholder protection, and readiness for operational restart.

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#### 2. SCOPE

Applies to all temporary suspensions (>30 days) of:

- Rolling mills
  - Annealing lines
  - Packing/slitting operations
  - Associated utilities (e.g., coolant systems, gas supplies)
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### 3. DEFINITIONS

Term	Definition
<b>Warm Shutdown</b>	Suspension with equipment maintained at minimal operational readiness.
<b>Process Fluids Preservation</b>	Treatment of oils/coolants to prevent degradation during idling.
<b>Stakeholder Hibernation</b>	Formal notification protocol for communities/regulators during suspension.

### 4. RESPONSIBILITIES

Role	Key Responsibilities
<b>Operations Head</b>	Authorize suspension; approve restart protocols.
<b>Preservation Engineer</b>	Implement equipment mothballing; corrosion control.
<b>EHS Custodian</b>	Environmental compliance; residual risk monitoring.
<b>Community Liaison</b>	Manage stakeholder communications; employment transition support.



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## 5. PROCEDURE

### 5.1 Suspension Planning

#### Facility-Specific Preservation Plans

Operation	Critical Actions
Rolling Mills	<ul style="list-style-type: none"><li>- Purge hydraulic lines with preservative oil</li><li>- Coat rolls with VCI film</li></ul>
Annealing Lines	<ul style="list-style-type: none"><li>- Drain H<sub>2</sub>/N<sub>2</sub> systems; inert gas blanketing</li><li>- Seal furnace atmospheres</li></ul>
Packing Areas	<ul style="list-style-type: none"><li>- Deep-clean dust collectors</li><li>- Seal aluminium coil stocks with desiccant packs</li></ul>

#### Risk Assessment Matrix

Risk	Mitigation	ASI Ref.
Corrosion in idle mills	Vapor corrosion inhibitors (VCIs)	3.3
Residual oil leaks	Secondary containment + weekly inspections	4.5
Uncontrolled dust ignition	Nitrogen purging of silos	4.8

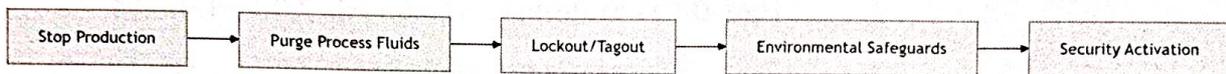
### 5.2 Implementation Protocol



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## Step 1: Safe Shutdown Sequence



## Step 2: Equipment Preservation

- **Rolling Stands:**
  - Apply NSF H1 food-grade preservative oil
  - Rotate rolls 90° weekly to prevent bearing brinelling
- **Annealing Furnaces:**
  - Maintain 40°C internal temperature with trace heating
  - Oxygen sensors (<0.5% O<sub>2</sub>) with auto-nitrogen backup

## 5.3 Monitoring & Maintenance

### Dormancy Monitoring Schedule

System	Parameter	Frequency	Tool
Hydraulic reservoirs	Water content (<0.1%)	Biweekly	Karl Fischer titrator
Annealing atmospheres	O <sub>2</sub> concentration (<1%)	Weekly	Portable gas analyzer
Packing dust collectors	Temperature differential	Daily	IR thermography

### Critical Compliance Checks



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- **Weekly:** Spill containment integrity, security perimeter
- **Monthly:** EPA air emission controls (40 CFR §63)
- **Quarterly:** ASI-conformity gap assessment

## 5.4 Stakeholder Management

### Communication Framework

Stakeholder	Protocol	Medium
Employees	Transition packages; skills bank enrolment	Town halls + SMS
Local Community	Noise/air quality monitoring reports	Bilingual newsletters
Regulators	Formal suspension notice (30-day advance)	Certified mail + email

## 6. RESTART PREPARATION

### Pre-Startup Safety Review (PSSR)

#### 1. Phase 1 (14 days prior):

- Fluid system reconditioning (oil filtration, coolant testing)
- Dust collector explosion integrity checks (NFPA 652)

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## 2. Phase 2 (72 hours prior):

- Annealing furnace atmosphere verification
- Rolling mill backup power test

## 7. RISK ASSESSMENT MATRIX

### *Suspension-Specific Threats*

Risk Category	Identified Risk	Potential Impact	Likelihood	Mitigation Strategy
<b>Technical</b>	Bearing corrosion in idle mills	\$500K+ replacement costs	High	Automated rotation systems
<b>Environmental</b>	Coolant biodegradation in sumps	Groundwater contamination	Medium	Biocides + aeration systems
<b>Security</b>	Copper theft from de-energized sites	Production delays at restart	High	Tamper-proof RFID tagging + armed patrols
<b>Reputational</b>	Perceived abandonment by community	Social license loss	Medium	Community employment retainers

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## 8. DOCUMENTATION & DISCLOSURE

- **Public Dashboard:** Real-time suspension status at:
- **Records Retention:**
  - Preservation logs: 7 years
  - Stakeholder notices: 5 years

## 9. TRAINING REQUIREMENTS

Role	Training Focus	Certification
Preservation Technicians	Mothballing techniques; corrosion science	NACE CIP Level 1
Security Personnel	Hazardous material security (CFATS)	DHS 18-hour course

## REVISION HISTORY

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

