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 SHAKAMBHARI GROUP #SteelWithin		SHAKAMBHARI ISPAT & POWER LTD. (Formerly known as Ess Dee Aluminium Ltd.)	
STANDARD TEST METHOD			
Title: Flash and Fire Point			Page No. 1 of 2
STM No.	Version No.	Effective Date	Next review date
SIPL/STM/020	00	06.07.2026	05.07.2028

1.0 PURPOSE

1.1 To determine the flash and fire point of roll coolant oil.

2.0 SCOPE

2.1 This STM is applicable to the determination of the flash and fire point of roll coolant oil.

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

3.1.1 ISO 15378:2017

3.2 Attachments

3.2.1 Nil

4.0 RESPONSIBILITY**4.1 Quality Assurance Person:**

4.1.1 To check the STM.

4.1.2 To maintain the original copy of the STM.

4.1.3 To issue the controlled copy of the STM.

4.1.4 To maintain the issuance record of the STM.

4.1.5 To retrieve the controlled copy of the STM when it is superseded / obsolete, and maintain its record.

4.2 QA Head:

4.2.1 To approve the new or revised STM.

4.2.2 To ensure the implementation of the defined system.

4.3 Plant Head:

4.3.1 To approve the new or revised STM.

4.3.2 To ensure the implementation of the defined system.

5.0 DISTRIBUTION

5.1 Quality Control

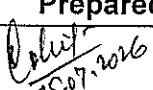
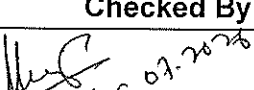
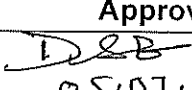
5.2 Quality Assurance

6.0 DEFINITION(S) & ABBREVIATION(S)

6.1 Definitions: Nil

6.2 Abbreviations

6.2.1 °C: Degree Celsius

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

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7.0 PROCEDURE**7.1 Materials & Equipment**

- 7.1.1 Cleveland open cup tester.
- 7.1.2 Thermometer, range 0 to 400°C (readability of 1°C).
- 7.1.3 250 ml Beaker.
- 7.1.4 Testing sample.
- 7.1.5 Flame (source: LPG cylinder).

7.2 Method

- 7.2.1 Thoroughly clean and dry all parts of the cup and its accessories before starting the test.
- 7.2.2 Fill the cup with the sample to be tested up to the level indicated by the filling mark.
- 7.2.3 Insert the thermometer in the cup with the material to be tested, keeping the bulb of the thermometer completely immersed in the oil under testing, and start heating.
- 7.2.4 Supply heat at such a rate that the temperature, as read by the thermometer, increases 5 to 6°C per minute.
- 7.2.5 Apply the test flame, which is lowered into the vapour space for one second and quickly raised to its original position.
- 7.2.6 Do not stir the sample while applying the test flame.

7.3 Result

- 7.3.1 Record the temperature when the test flame application causes a distinct flash in the interior of the cup, with accuracy up to 1°C.

7.4 Environmental Concern

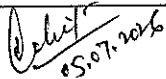
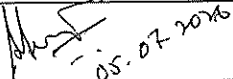
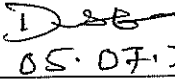
- 7.4.1 After completion of the test, clean the apparatus and beaker with tissue paper.
- 7.4.2 Dispose of the testing sample and tissue paper into the dustbin.

7.5 Safety Concern

- 7.5.1 Wear gloves while the testing is conducted.

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