

For Restricted Circulation only

 SHAKAMBHARI GROUP #SteelWithin	SHAKAMBHARI ISPAT & POWER LTD. (Formerly known as Ess Dee Aluminium Ltd.)
STANDARD TEST METHOD	
Title: Specific Gravity / Density of Roll Coolant Oil	
Page No. 1 of 2	
STM No.	Version No.
SIPL/STM/023	00
Effective Date	Next review date
06.07.2026	05.07.2028

1.0 PURPOSE

- 1.1 To determine the Specific Gravity / Density of roll coolant oil.

2.0 SCOPE

- 2.1 This STM applies to the Quality Control department.

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4.1.5 To retrieve the controlled copy of the STM when it is superseded / obsolete, and maintain its record.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

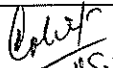
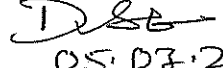
- 4.3.1 To approve the new or revised STM.
4.3.2 To ensure the implementation of the defined system.

5.0 DISTRIBUTION

- 5.1 Quality Control
5.2 Quality Assurance

6.0 DEFINITION(S) & ABBREVIATION(S)

- 6.1 Definitions: Nil
6.2 Abbreviations: Nil

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

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7.0 PROCEDURE**7.1 Material and Equipment**

- 7.1.1 Calibrated Hydrometer
- 7.1.2 Cylinder 500 ml
- 7.1.3 Thermometer for checking the temperature of the oil.

7.2 Method

- 7.2.1 Take the rolling oil sample in a long cylinder.
- 7.2.2 Check the temperature.
- 7.2.3 Slowly dip the appropriate hydrometer.
- 7.2.4 After 5 minutes, observe the hydrometer reading.
- 7.2.5 Calculate the temperature correction whenever needed.

7.3 Environmental Concern

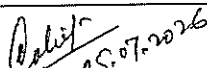
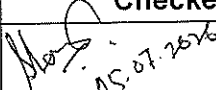
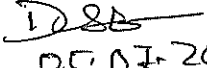
- 7.3.1 After completion of the test, clean the equipment.

7.4 Safety Concern

- 7.4.1 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