

For Restricted Circulation only**SHAKAMBHARI ISPAT & POWER LTD.**
(Formerly known as Ess Dee Aluminium Ltd.)**STANDARD TEST METHOD****Title:** Determination of Bond Strength**Page No.** 1 of 2**STM No.****Version No.****Effective Date****Next review date**

SIPL/STM/008

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06.07.2026

05.07.2028

1.0 PURPOSE

- 1.1 To define a test method for determination of the bonding strength between two layers of a composite laminate.

2.0 SCOPE

- 2.1 This STM 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 Person**

- 4.1.1 To carry out the testing as per the STM.

4.2 QC Department Head:

- 4.2.1 To prepare and ensure the implementation of the STM.

4.3 QA Head:

- 4.3.1 To approve the new or revised STM, and to ensure the implementation of the defined system.

5.0 DISTRIBUTION

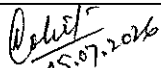
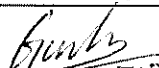
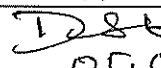
- 5.1 Quality Assurance

- 5.2 Quality Control

6.0 DEFINITION(S) & ABBREVIATION(S)

- 6.1 Definitions: Nil

- 6.2 Abbreviations: Nil

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

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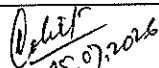
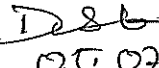
 SHAKAMBHARI GROUP #SteelWithin	SHAKAMBHARI ISPAT & POWER LTD. (Formerly known as Ess Dee Aluminium Ltd.)		
STANDARD TEST METHOD			
Title: Determination of Bond Strength			Page No. 2 of 2
STM No.	Version No.	Effective Date	Next review date
SIPL/STM/008	00	06.07.2026	05.07.2028

7.0 PROCEDURE

- 7.1 Take ethyl acetate in a beaker.
- 7.2 Cut a 15 mm or 25 mm strip of the laminated sample.
- 7.3 Test Method**
- 7.3.1 Dip approximately 2 cm of the strip in ethyl acetate for around 4 minutes.
- 7.3.2 Separate both layers of the laminate by hand marginally. Once both layers are separated, fix one layer in the upper clamp and the other layer in the lower clamp of the machine using self-adhesive tape.
- 7.3.3 The bond strength is determined on the Digital Bond / Peel Strength Tester at a separation angle of 180°.
- 7.3.4 The bond strength of the laminate is shown on the digital display of the Digital Bond / Peel Strength Tester in grams force.
- 7.3.5 Record the result in the specified format as gms/15 mm or gms/25 mm.

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