

For Restricted Circulation only

 SHAKAMBHARI GROUP #SteelWithin		SHAKAMBHARI ISPAT & POWER LTD. (Formerly known as Ess Dee Aluminium Ltd.)	
STANDARD TEST METHOD			
Title: Shade Checking of Printed Sample / Drawdown			Page No. 1 of 2
STM No.	Version No.	Effective Date	Next review date
SIPL/STM/002	00	06.07.2026	05.07.2028

1.0 PURPOSE

1.1 To define a test method for checking the shade of a printed sample / drawdown.

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

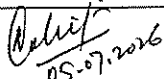
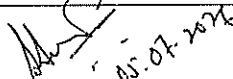
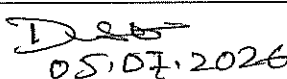
5.1 Quality Assurance

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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7.0 PROCEDURE**7.1 Checking Shade of Printed Sample**

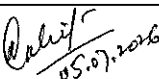
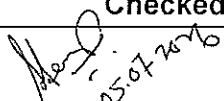
- 7.1.1 Take the sample of at least one repeat circumference of the cylinder.
- 7.1.2 Ensure the sample is flat and clean.
- 7.1.3 Check the sample shade against the standard. For new jobs, the standard may be a reference sample / Pantone book. For existing jobs, the standard is the 'approved shade card' only.
- 7.1.4 It is recommended that the sample be checked at a normal viewing distance, i.e. 14-16 inches preferably.

7.2 Checking Shade of Ink Drawdown

- 7.2.1 Take the drawdown of the ink sample.
- 7.2.2 The drawdown sample should be flat and clean.
- 7.2.3 Check the drawdown shade against the standard drawdown / Pantone for shade.

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