

For Restricted Circulation only

 SHAKAMBHARI GROUP # SteelWithin		SHAKAMBHARI ISPAT & POWER LTD. (Formerly known as Ess Dee Aluminium Ltd.)	
STANDARD TEST METHOD			
Title: Determination of Unwinding Direction of Printed Roll			Page No. 1 of 2
STM No.	Version No.	Effective Date	Next review date
SIPL/STM/009	00	06.07.2026	05.07.2028

1.0 PURPOSE

- 1.1 To define a test method for determination of the unwinding direction of printed rolls.

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

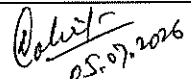
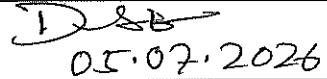
- 5.1 Quality Assurance

- 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 Remove the layer of the roll. Check the printing matter direction while unwinding.
7.2 Determine the unwinding direction as "Readable", "Un-Readable", "Back Panel Readable", "Eye mark LHS", etc., which is unique and can be identified easily.
7.3 Match the result with the standard.

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:
