

MASTER COPY

For Restricted Circulation only

 SHAKAMBHARI GROUP #SteelWithin	SHAKAMBHARI ISPAT & POWER LTD. (Formerly known as Ess Dee Aluminium Ltd.)		
STANDARD TEST METHOD			
Title: Determination of Solid Contents			Page No. 1 of 2
STM No.	Version No.	Effective Date	Next review date
SIPL/STM/014	00	06.07.2026	05.07.2028

1.0 PURPOSE

- 1.1 To define a test method for determination of the solid contents in liquids (Ink / Toner / Adhesive / Hardener / VMCH / Foil Wash / OPV, etc.).

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:

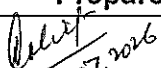
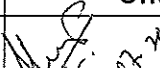
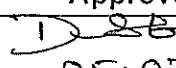
- 4.3.1 To approve the new or revised STM, and to ensure the implementation of the defined system.

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

For Restricted Circulation only

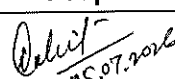
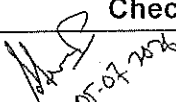
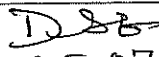
 SHAKAMBHARI GROUP #SteelWithin	SHAKAMBHARI ISPAT & POWER LTD. (Formerly known as Ess Dee Aluminium Ltd.)		
STANDARD TEST METHOD			
Title: Determination of Solid Contents			Page No. 2 of 2
STM No.	Version No.	Effective Date	Next review date
SIPL/STM/014	00	06.07.2026	05.07.2028

7.0 PROCEDURE

- 7.1 Collect samples of liquids (Ink / Toner / Adhesive / Hardener / VMCH / Foil Wash / OPV, etc.) as per the sampling plan.
- 7.2 Make sure that the sample is taken in a closed container / vessel so that the solvent inside cannot evaporate.
- 7.3 Make a small bowl shape using bare foil and weigh it. Note the weight.
- 7.4 Place a small quantity of ink into it.
- 7.5 Weigh this bowl and record this weight as W1. Also calculate $W = W1 - \text{bare foil weight}$.
- 7.6 Place this bowl into the oven at a temperature of 80-100°C for sixty minutes, then weigh again.
- 7.7 Note this weight and repeat the process until a constant value is obtained. Note this weight as W2.
- 7.8 Calculate $W3 = W1 - W2$.
- 7.9 Calculate the ink's solid contents using the formula below:
- 7.10 $\text{Solid Contents} = (W3 \times 100) / W$
- 7.11 The result is in percentage (%). Record the results in the specified format.

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