

For Restricted Circulation only

 SHAKAMBHARI GROUP #SteelWithin		SHAKAMBHARI ISPAT & POWER LTD. (Formerly known as Ess Dee Aluminium Ltd.)	
STANDARD TEST METHOD			
Title: Determination of Inner Diameter (ID) of Material			Page No. 1 of 2
STM No.	Version No.	Effective Date	Next review date
SIPL/STM/011	00	06.07.2026	05.07.2028

1.0 PURPOSE

- 1.1 To define a test method to determine the Inner Diameter (ID) of a material such as a core.

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:

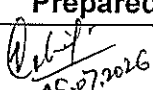
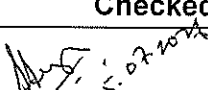
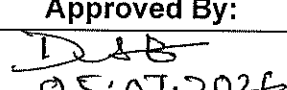
- 4.3.1 To approve the new or revised STM, and to ensure the implementation of the defined system.

5.0 DISTRIBUTION

- 5.1 Quality Assurance
5.2 Quality Control

6.0 DEFINITION(S) & ABBREVIATION(S)**6.1 Definitions:** Nil**6.2 Abbreviations**

- 6.2.1 Nil

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

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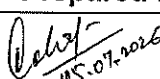
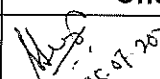
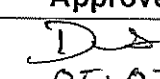
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7.0 PROCEDURE

- 7.1 Take the sample whose ID is to be checked.
- 7.2 Take the calibrated Steel Scale.
- 7.3 Touch the scale starting from zero to the inner wall of the core or tube.
- 7.4 Check the reading and note this as ID.

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