

For Restricted Circulation only

 SHAKAMBHARI GROUP #SteelWithin		SHAKAMBHARI ISPAT & POWER LTD. (Formerly known as Ess Dee Aluminium Ltd.)	
STANDARD OPERATING PROCEDURE			
Title: Operation of Ford B4/B-6 Viscosity Cup			Page No. 1 of 2
SOP No.	Version No.	Effective Date	Next review date
SIPL/QCI/004	00	06.07.2026	05.07.2028

1.0 PURPOSE

1.1 To define a procedure for operation of the Ford B4/B-6 Viscosity Cup.

2.0 SCOPE

2.1 This SOP 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 Head:**

4.1.1 To prepare the SOP.

4.1.2 To confirm the content, correctness, and detailing of the SOP.

4.2 QA Head:

4.2.1 To approve the new or revised SOP.

4.2.2 To ensure implementation of the defined system.

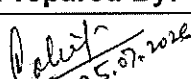
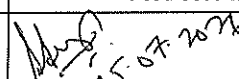
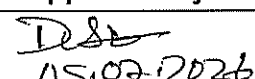
5.0 DISTRIBUTION

5.1 Quality Assurance.

5.2 Quality Control.

6.0 DEFINITION(S) & ABBREVIATION(S)**6.1 Definitions:**6.1.1 **Viscosity:** the property of a fluid that resists the force tending to cause the fluid to flow. It is the measure of the extent to which a fluid possesses this property.6.1.2 **Ford Viscosity Cup:** a simple gravity device that permits the timed flow of a known volume of liquid passing through an orifice located at the bottom.**6.2 Abbreviations:**

6.2.1 Nil.

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

For Restricted Circulation only

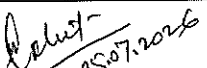
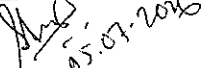
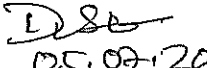
 SHAKAMBHARI GROUP # SteelWithin		SHAKAMBHARI ISPAT & POWER LTD. (Formerly known as Ess Dee Aluminium Ltd.)	
STANDARD OPERATING PROCEDURE			
Title: Operation of Ford B4/B-6 Viscosity Cup			Page No. 2 of 2
SOP No.	Version No.	Effective Date	Next review date
SIPL/QCI/004	00	06.07, 2026	05.07, 2028

7.0 PROCEDURE

- 7.1 Mount the B-4/B-6 Ford Cup on the retort stand.
- 7.2 Place a glass beaker underneath the B-4/B-6 Ford Cup.
- 7.3 Hold a finger at the bottom of the B-4/B-6 Ford Cup to prevent flow out.
- 7.4 Pour the solvent/liquid/solution into the B-4/B-6 Ford Cup till it overflows into the outer cavity of the cup.
- 7.5 Keep a stopwatch ready in the 00.00 position before starting the flow.
- 7.6 Remove the finger to allow the solvent/liquid/solution to flow out, and simultaneously start the stopwatch.
- 7.7 Record the time taken, in seconds, for the first break in the flow.
- 7.8 The reading represents viscosity in "seconds".

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