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 SHAKAMBHARI GROUP # SteelWithin		SHAKAMBHARI ISPAT & POWER LTD. (Formerly known as Ess Dee Aluminium Ltd.)	
STANDARD TEST METHOD			
Title: Determination of Viscosity			Page No. 1 of 2
STM No.	Version No.	Effective Date	Next review date
SIPL/STM/015	00	06.07.2026	05.07.2028

1.0 PURPOSE

- 1.1 To define a test method for determination of the viscosity of all 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

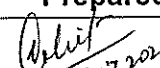
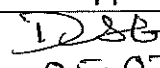
- 5.2 Quality Control

6.0 DEFINITION(S) & ABBREVIATION(S)**6.1 Definitions**

- 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:** It is 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: Nil

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

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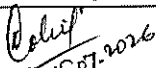
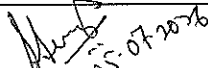
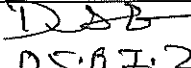
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7.0 PROCEDURE

- 7.1 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 the finger at the bottom of the B-4/B-6 Ford Cup to prevent flow out.
- 7.4 Pour solvent / liquid / solution into the B-4/B-6 Ford Cup until 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					

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 05.07.2026	 05.07.2026	 05.07.2026