

For Restricted Circulation only
SHAKAMBHARI ISPAT & POWER LTD.
 (Formerly known as Ess Dee Aluminium Ltd.)
STANDARD TEST METHOD

Title: Odour Test of Coated / Printed Foils and Laminates			Page No. 1 of 2
STM No.	Version No.	Effective Date	Next review date
SIPL/STM/012	00	06.07.2026	05.07.2028

1.0 PURPOSE

- 1.1 To define a test method to determine whether the Coated / Printed Foil is odour-free or not.

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

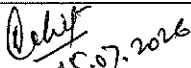
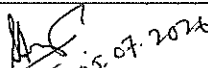
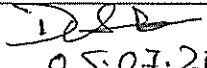
- 5.1 Quality Assurance

- 5.2 Quality Control

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

- 6.1.1 **ODOUR Test:** The odour test of foil / laminates is an organoleptic test to ensure that the product is odourless.

6.2 Abbreviations: Nil

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

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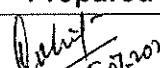
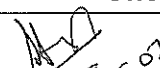
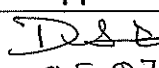
 SHAKAMBHARI GROUP # SteelWithin		SHAKAMBHARI ISPAT & POWER LTD. (Formerly known as Ess Dee Aluminium Ltd.)	
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7.0 PROCEDURE

- 7.1 Take an A-4 size sample of HSL Coated / Printed Aluminium foil or dry laminate and cut it into small pieces with scissors.
- 7.2 Place the foil pieces in the beaker / jar and close the mouth of the beaker / jar with plain aluminium foil, ensuring that there are no leakages.
- 7.3 Switch ON the electric oven.
- 7.4 Set the temperature of the electric oven at 75-100°C.
- 7.5 After the set temperature is achieved, keep the beakers containing the sample under test in the electric oven for 30 to 45 minutes.
- 7.6 After the stipulated time, remove the sample from the oven carefully.
- 7.7 Allow the beaker to stand until its temperature reduces to ambient.
- 7.8 Break the sealed mouth of the beaker with a sharp object and instantly smell the contents inside the beaker. Countercheck the odour with 3-4 people (preferably not from the process area) for obtaining a satisfactory result.
- 7.9 The sample must be odourless, thus ensuring the absence of any residual solvents.

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