

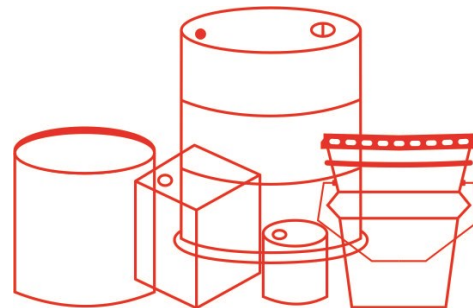


**PARMAR MACHINES & TECHNOLOGIES**

**MANUFACTURER OF PLANT & DIES FOR:  
TIN, CONIPAIL, DRUM, BARREL**

**PRODUCT BROCHURE**

# **210L Horizontal Steel Drum Machinery with Capacity of 2000-2500 Drums in 8 Hours**





## MACHINERY IN LINE AS PER PRODUCTION FLOW

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TYPE FLANGING MACHINE**

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# HORIZONTAL DOUBLE ENDED PRESS TYPE FLANGING MACHINE

Horizontal press type flanging for barrels with a 10 H.P power pack and hydraulic accessories. The machine is MS fabricated and hydraulically operated with two cylinders fitted on both sides of the head connected to the flanging die dishes through a guide bush assembly system, with both heads moving inside to flange the body. The machine has a panel control system and is capable of indexing conveyors. The machines are fitted with proximity sensors instead of limit switches for better accuracy. The system includes a hydraulic power pack (40L) and oil tank (300L), as well as electrical accessories, provided with two triple seam dies and complete standard accessories. The operation cycle is 14 seconds. The machine is suitable for flanging barrels with a maximum length of 40 inches and a maximum diameter of 575mm. It is fitted with a pneumatic cradle system for ejection.



## SPECIFICATIONS

<b>CYCLE TIME:</b> 14 SECONDS 4-5 BARRELS/MIN	<b>MATERIAL USED:</b> M.S/CASTING/WPS/EN-9	<b>HYDRAULIC OIL TANK:</b> 300L	<b>HYDRAULIC CYLINDER:</b> 150MM BORE/STROKE 100MM
<b>POWER:</b> 10HP HINDUSTAN MOTOR	<b>BEARINGS:</b> SKF/ URB	<b>MAXIMUM LENGTH BARREL:</b> 40'INCHES	<b>POWER PACK:</b> 40L (10H.P POWER PACK)
<b>CONTROL PANEL:</b> SIEMENS	<b>WEIGHT:</b> 2.5TONS	<b>DIE MATERIAL:</b> OHNS	<b>MAN POWER:</b> 1

# HORIZONTAL HYDRAULIC DOUBLE BEAD EXPANDER

Hydraulic horizontal double beading machine, the machine is MS fabricated and hydraulically operated via a 20 H.P power pack system. The machine is operated via a panel control system and includes electrical accessories. Bead dies are segmented and duly hardened on both moving heads, operated via hydraulic cylinders on both moving heads. Segments expand through the double hydraulic heads, which are connected to the hydraulic cylinders on both sides through a guide bush assembly system. The power pack is 20 HP, and the oil tank capacity is 650L. The operation cycle is 13-14 seconds with a maximum output of 5-6 shells/min. It is suitable for flanging and beading 0.8mm - 1.5mm sheets.



## SPECIFICATIONS

<b>CYCLE TIME:</b> 13-14 SECONDS 5-6 BARRELS/MIN	<b>DIMENSIONS:</b> 3X10FT	<b>HYDRAULIC OIL TANK:</b> 650L	<b>HYDRAULIC CYLINDER:</b> 550MM STROKE
<b>MAXIMUM LENGTH BARREL:</b> 40' INCHES	<b>WEIGHT:</b> 5 TONS	<b>CONTROL PANEL:</b> SIEMENS	<b>MOTOR:</b> 20H.P/1440 RPM/HINDUSTAN MOTORS
<b>MATERIAL USED:</b> M.S/CASTING/WPS/EN-9	<b>BEARINGS:</b> SKF/URB	<b>POWER PACK:</b> YUKEN 45L	<b>MAN POWER:</b> 1

# HORIZONTAL DOUBLE ENDED MULTIPILE CORRUGATION

Horizontal Multiple Corrugation double-ended machine, where two side corrugations on the barrel body are done in one operation. The machine is MS fabricated, hydraulically operated with a 10 H.P. electrical power pack and panel control system (Siemens). Two sets of corrugation dies, duly hardened and faced on both heads, are operated via hydraulic cylinders. Two moving heads for corrugating the body are operated in one operation, with both heads moving front and back for corrugating the body. The maximum length is 40 inches, and the maximum diameter is 575mm. The operating cycle of the machine is 14-15 seconds.



## SPECIFICATIONS

<b>CYCLE TIME:</b> 10 SECONDS, 5 BARRELS/MIN	<b>DIMENSIONS:</b> 3X10FT	<b>HYDRAULIC OIL TANK:</b> 200LX2	<b>HYDRAULIC CYLINDER FOR HEADS:</b> 15" STROKE
<b>MAXIMUM LENGTH BARREL:</b> 40' INCHES	<b>WEIGHT:</b> 4 TONS (APPROX)	<b>CONTROL PANEL:</b> SIEMENS	<b>MOTOR:</b> 7.5HP GEARED / 80 RPM / HINDUSTAN MOTORS
<b>MATERIAL USED:</b> M.S/CASTING/WPS/EN-9	<b>BEARINGS:</b> SKF/ URB	<b>POWER PACK:</b> YUKEN 45L	<b>MAN POWER:</b> 1

# HORIZONTAL DOUBLE ENDED BARREL SEAMING MACHINE

Horizontal double-ended barrel seaming machine power-operated with a 30HP motor. Machine MS fabricated, pneumatically operated with one pneumatic cylinder provided for moving both the right head. The head fits on the barrel for the seaming process to begin and is released after the seaming process is completed with the four hands (first & second operation hands) fitted with CAM system with a CAM shaft of DIA 75MM duly ground. The machine's two main shafts are 90mm DIA. The main shaft, which is driving the connecting CAM shaft, is gear-driven and then consecutively sprocket-driven. The machine is fitted with two seaming chucks duly hard-faced with two sets of WPS seaming rollers. The machine is fitted with a pneumatic clutch and brake assembly operated via panel control. The machine is suitable to seam both double and triple seam barrels in a maximum 1.3mm thickness sheet.



## SPECIFICATIONS

<b>CYCLE TIME:</b> 10 SECONDS, 4 BARRELS/MIN	<b>DIMENSIONS:</b> 4X12FT	<b>MATERIAL USED:</b> M.S/CASTING/WPS/EN-9	<b>HYDRAULIC CYLINDER FOR HEADS:</b> 15" STROKE
<b>MAXIMUM LENGTH BARREL:</b> 40' INCHES	<b>SEAMING CHUCK:</b> EN-9 MATERIAL HARDENED.	<b>MOTOR:</b> 30H.P/1440 RPM/HINDUSTAN MOTORS	<b>SEAMING ROLLERS:</b> TRIPLE SEAM/DOUBLE SEAM IN WPS
<b>MAN POWER:</b> 1	<b>BEARINGS:</b> SKF/ URB	<b>WEIGHT:</b> 6.5 TONS (APPROX)	<b>CONTROL PANEL:</b> SIEMENS

## GOOZNECK FLANGING MACHINE

Gooseneck flanging machine, M.S. Fabricated, gear-driven with a 5 H.P. motor and starter. The machine is single-ended and pneumatically operated with FRL unit, foot valve, and pneumatic accessories. Dies in the machine are fitted on the outer side with guide rollers on the gauge plate and an additional rotary supporting dish pneumatically operated to hold the barrel shell on the opposite side of the operation side. Complete with standard fittings and accessories.

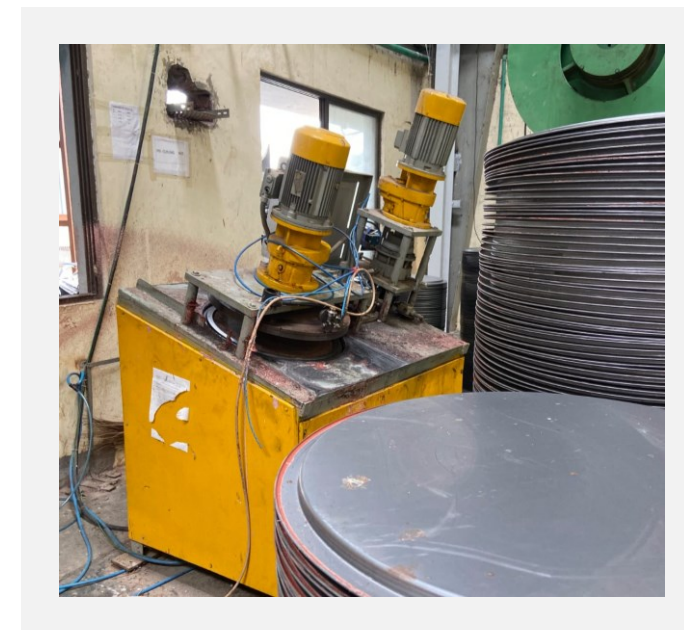
### SPECIFICATIONS

<b>CYCLE TIME:</b> 30 SECONDS - 2 BARRELS/MIN	<b>DIMENSIONS:</b> 6FT L X 3FT B X 5FT H
<b>MAXIMUM LENGTH BARREL:</b> 40' INCHES	<b>WEIGHT:</b> 1 TONS (APPROX)
<b>MATERIAL USED:</b> M.S/CASTING/WPS/EN-9	<b>BEARINGS:</b> SKF/ URB
<b>MAN POWER:</b> 1	<b>PNEUMATIC CYLINDER FOR TABLE:</b> 6" X 3" STROKE
<b>CONSTRUCTION:</b> MS	<b>MOTOR:</b> 30H.P/1440 RPM/HINDUSTAN MOTORS
<b>DIE:</b> GOOSENECK FLANGING DIE	



## PRE CURLING MACHINE WITH COMPOUND GUN

Pre Curling machine, to pre-curl top and bottom lids of Barrel for triple seam. Machine M.S. Fabricated and having two geared motors, one to drive the chuck spindle and one to drive the cam assembly. One geared motor is 5 H.P. and the other 2 H.P., respectively. The machine has a pneumatic clutch and brake assembly and is operated via a panel control system and accessories. Lids are to be manually inserted into the machine, after which the machine pre-curls the lid and ejects it as the machine is sloped. Complete with one set of rollers duly hardened and standard fittings. Seaming compound ejection is monitored through the control panel for application of seaming compound on lids to avoid leakage before the seaming process.



### SPECIFICATIONS

<b>OUTPUT:</b> 20 LIDS/MIN	<b>DIMENSIONS:</b> 4X4FT	<b>MATERIAL USED:</b> M.S/CASTING/WPS/EN-9
<b>CAPACITY:</b> 1.5MM SHEETS	<b>CONSTRUCTION:</b> MS	<b>PRE CURL ROLLERS:</b> WPS MATERIAL
<b>POWER:</b> 3HP STANDARD 1440RPM AND 3HP GEARED, HINDUSTAN	<b>MAN POWER:</b> 1	
<b>BEARINGS:</b> SKF/ URB	<b>WEIGHT:</b> 1 TONS	



## DIES (TOP & BOTTOM LID FORMING)

1 2” and ¾” bung opening & fitting die set in tandem pillar die set, fitting the cutting material will be of WPS hardened and ground for maximum life of the cutting and opening punches, complete.

### SPECIFICATIONS

<b>HARDNESS:</b> OHNS 55-58RC WPS 58-60RC	<b>DIMENSIONS:</b> 33LX10”X50MM
<b>CAPACITY:</b> 75 TON PRESS	<b>CONSTRUCTION:</b> MS
<b>MATERIAL USED:</b> MS/MAIN DIE PLATES OHNS/PILLAR & SLEEVES WPS D2/ CUTTING PUNCHES.	<b>WEIGHT:</b> 200KILOS



2 Gooseneck 550mm top cutting and embossing die set, consisting of top cutting punch and ejector buffer, pressure ring, forming block, and spring assembly, and cutting ring fitted in a pillar die set with ball sleeve gauge on pillars. Complete. WPS D-2 one-piece cutting rings top and bottom rings.

**SPECIFICATIONS**

<b>HARDNESS:</b> OHNS 55-58RC WPS 58-60RC	<b>DIMENSIONS:</b> 33LX33BX50MM
<b>CAPACITY:</b> 75 TON PRESS	<b>CONSTRUCTION:</b> MS
<b>MATERIAL USED:</b> MS/MAIN DIE PLATES OHNS/PILLAR & SLEEVES WPS D2/ CUTTING PUNCHES.	<b>WEIGHT:</b> 800KILOS



3

570mm top lid and bottom lid cutting and embossing die set, consisting of top cutting punch and ejector buffer, pressure ring, forming block, and spring assembly, and cutting ring fitted in a pillar die set. Complete with WPS ONE PIECE. Buffer, pressure ring, forming block, and spring assembly, and cutting ring fitted in a pillar die.

**SPECIFICATIONS**

<b>HARDNESS:</b> OHNS 55-58RC WPS 58-60RC	<b>DIMENSIONS:</b> 33LX33BX50MM
<b>CAPACITY:</b> 200 TON PRESS	<b>CONSTRUCTION:</b> MS
<b>MATERIAL USED:</b> MS/MAIN DIE PLATES OHNS/PILLAR & SLEEVES WPS D2/ CUTTING PUNCHES.	<b>WEIGHT:</b> 800KILOS

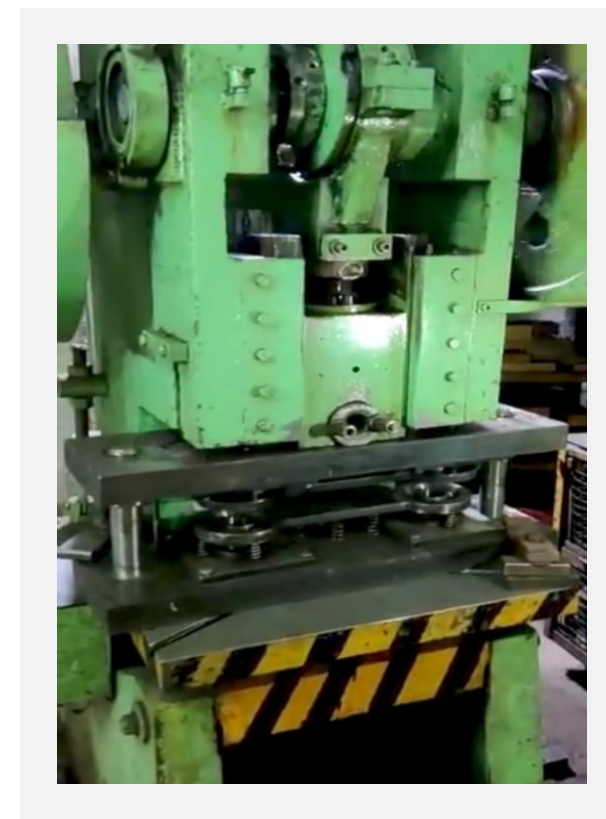


4

Composite die for plastic linear in (opening on lids) in tandem pillar die set consisting of pillars & bushes made of OHNS hardened material. Cutting punches for the die are made from WPS hardened material. The die consists of a spring ejection system for ejecting lids after the opening process.

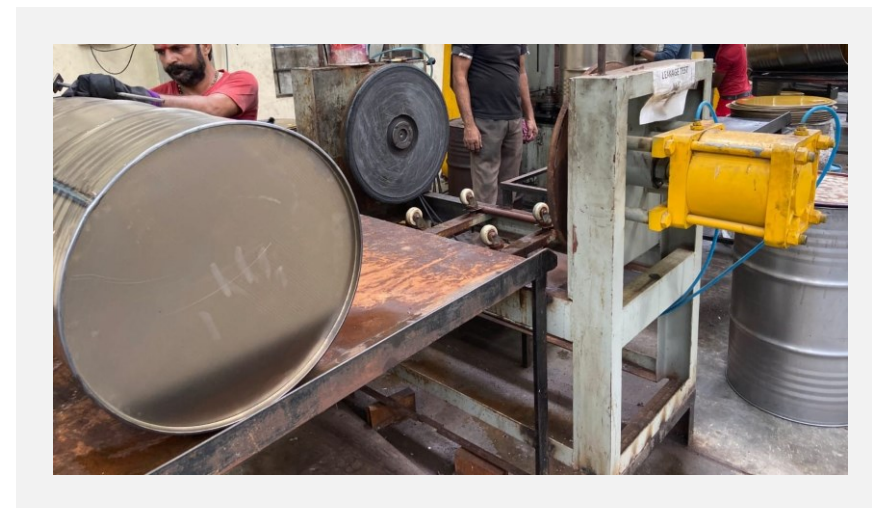
**SPECIFICATIONS**

<b>HARDNESS:</b> OHNS 55-58RC WPS 58-60RC	<b>DIMENSIONS:</b> 33LX10”X50MM
<b>CAPACITY:</b> 75 TON PRESS	<b>CONSTRUCTION:</b> MS
<b>MATERIAL USED:</b> MS/MAIN DIE PLATES OHNS/PILLAR & SLEEVES WPS D2/ CUTTING PUNCHES.	<b>WEIGHT:</b> 300KILOS



# AUTO-MATIC BARREL LEAKAGE TESTING MACHINE

Barrel testing equipment, MS fabricated, pneumatically operated with hand lever valve, roto seal, pressure gauge, and pneumatic accessories, having two rubberized heads (ONE SIDE) pneumatically operated and one operated via screw and nut system, with barrel centering roller system. The barrel rotates while the testing is done to check for any leakages with soap water or loss in pressure on pressure gauge, complete with standard accessories. The operating cycle is 14 seconds, with a maximum diameter of 575mm and a maximum length of 40 inches.



## SPECIFICATIONS

<b>CYCLE TIME:</b> 15 SECONDS - 4 BARRELS/MIN	<b>DIMENSIONS:</b> 5LX3FTBX4½FT	<b>HYDRAULIC CYCLINDER FOR HEADS:</b> 15" STROKE	<b>MOTOR:</b> 3H.P/200RPM/HINDUSTAN MOTORS
<b>MAXIMUM LENGTH BARREL:</b> 40' INCHES	<b>WEIGHT:</b> 1TONS (APPROX)	<b>MATERIAL USED:</b> M.S/CASTING/WPS/EN-9	<b>MAN POWER:</b> 1
<b>CONTROL PANEL:</b> SIEMENS	<b>BEARINGS:</b> SKF/ URB	<b>HEAD PLATES:</b> RUBBERZING	