

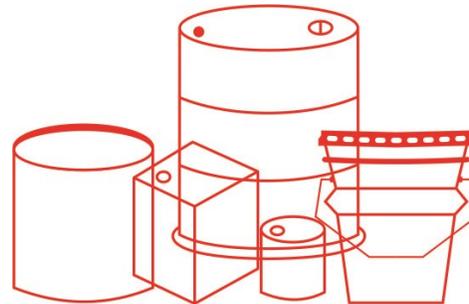


PARMAR MACHINES & TECHNOLOGIES

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

PRODUCT BROCHURE

210L Vertical Steel Drum Machinery with Capacity of 900-1000 Drums in 8 Hours



MACHINERY IN LINE AS PER PRODUCTION FLOW

**1. 200 KVA LONGITUDINAL TYPE SEAM
WELDING MACHINE**

**2. 20 KVA PRESS TYPE SPOT WELDING
MACHINE**

3. BODY BENDING MACHINE

4. PRESS TYPE FLANGING MACHINE

5. MULTIPLE CORRUGATION MACHINE

6. DOUBLE BEAD EXPANDER

7. BARREL SEAMING MACHINE

**8. PRE CURLING MACHINE WITH
COUMPOUND GUN**

**9. AUTOMATIC PAINTING EQUIPMENT
(VR COATING)**

10. AUTOMATIC BARREL TESTING MACHINE

11. DIES (TOP & BOTTOM LID FORMING)

12. 75 TON POWER PRESSES (SOHAL INT)

**13. MECHANICAL 200 TON POWER PRESS
(SOHAL INT)**

14. TRAVELLING HEAT OVEN

15. DE-COILING & STRAIGHTNER

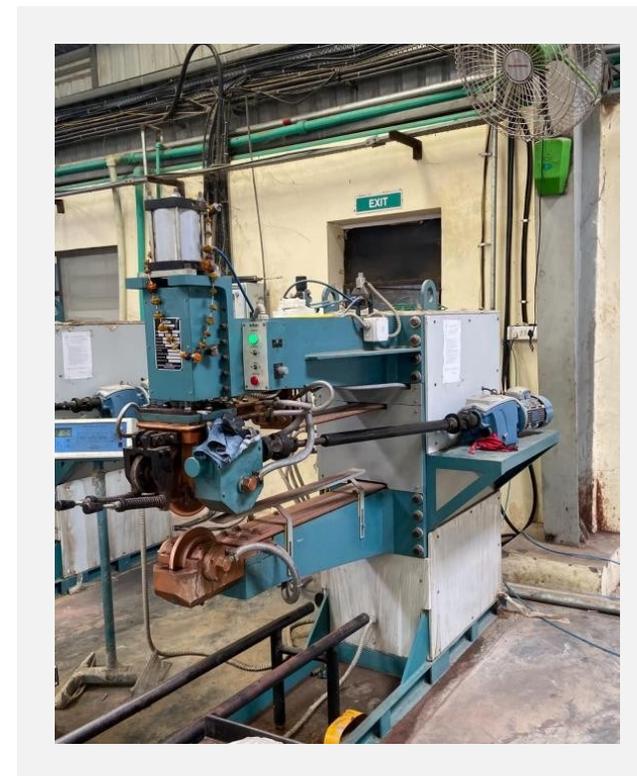


210L VERTICAL STEEL DRUM MACHINERY WITH
CAPACITY OF 900-1000 DRUMS IN 8 HOURS

1

200 KVA LONGITUDINAL TYPE SEAM WELDING MACHINE

200 KVA Longitudinal Type Seam Welding Machine, Model ARON-200/SML-110, Pneumatically Operated, having a throat depth of 1100mm, with 'F' class insulated water-cooled transformer, Operating on 415 Volts, Single Phase, 50 Hz. (2 lines of 3-phase supply), Incorporating A.C. Motor and Drive, Plate fabricated suitably stiffened arms on steel structure, with water-cooled Thyristor, with Microcontroller-based Welder Controller, Model: KBD-11, Keyboard operator interface with display and fifteen easy-to-program weld schedules.



PARMAR MACHINES & TECHNOLOGIES Shailesh Ind. Estate No. 3, Unit No. 11, Navghar Village, Vasai (East), Dist. Palghar - 401210, Maharashtra, India.

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210L VERTICAL STEEL DRUM MACHINERY WITH
CAPACITY OF 900-1000 DRUMS IN 8 HOURS

2

20 KVA PRESS TYPE SPOT WELDING MACHINE

20 KVA Press Type Spot Welding Machine, Model: ARON-20PR100, having a throat depth of 1000mm, Pneumatically operated, with an 'F' class insulated water-cooled transformer, Operating on 415 Volts, Single Phase, 50 Hz. (2 lines of 3-phase supply), with water-cooled Thyristor and Welder Controller Model: KSP-9.



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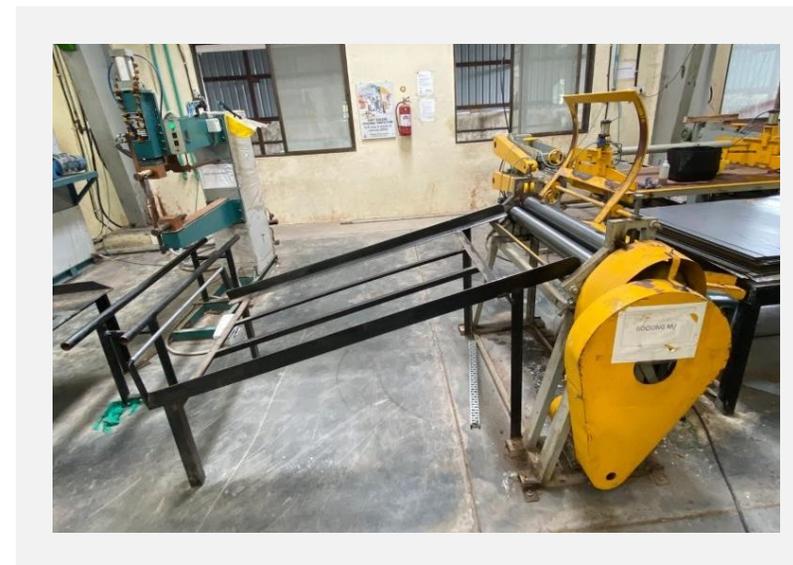
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BODY BENDING MACHINE

40" width, M.S. fabricated Body Bending machine, with a roller diameter of 75mm. Machine power-operated with 2 H.P electrical, with a geared drive and having a front feeding table Shell knock out system. All three rollers fitted in bronze bush bearings, and all rollers have a positive drive with V-belts guard and standard accessories complete.

SPECIFICATIONS

CYCLE TIME: 5 SECONDS 30 BARRELS/MIN	MATERIAL USED: M.S/CASTING/WPS/EN-9
POWER: 2HP HINDUSTAN MOTOR	BEARINGS: SKF/ URB
WEIGHT: 500KG	MAN POWER: 1

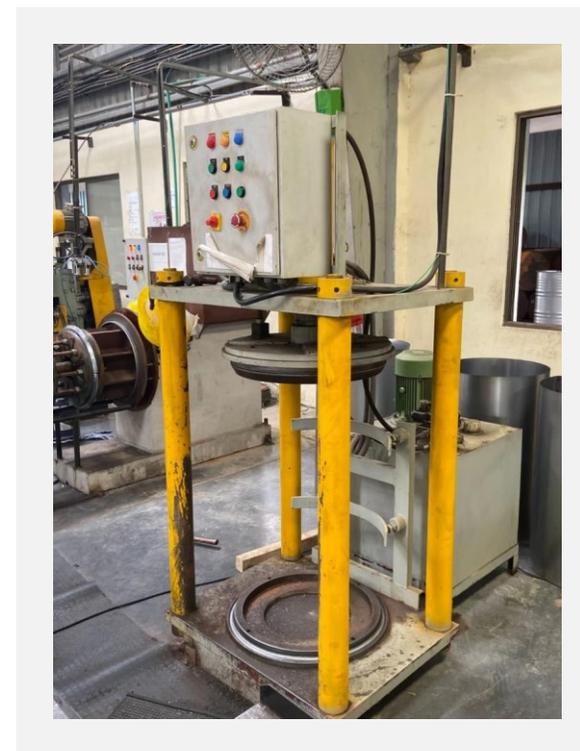


PRESS TYPE FLANGING MACHINE

Vertical Press Type Flanging machine for Barrels with a 5 H.P. Hydraulic power pack and hydraulic accessories. Machine made of sturdy M.S. plate construction with a hydraulic cylinder fitted on top of the machine and connected to flanging die dishes through a guide bush assembly and four sturdy M.S. shafts or pillars between the two plates to make the machine very heavy and rigid in construction. Machine operated via panel control system and electrical accessories. Machine provided with two triple seam dies and one open top die dish, complete with standard accessories.

SPECIFICATIONS

CYCLE TIME: 13-14 SECONDS 5 BARRELS/MIN	DIMENSIONS: 4FTX4FTX8FT H	CONTROL PANEL: SIEMENS
MAXIMUM LENGTH BARREL: 40' INCHES	WEIGHT: 1.5 TONS	MOTOR: 5H.P/1440 RPM/HINDUSTAN MOTORS
MATERIAL USED: M.S/CASTING/WPS/EN-9	BUSHINGS: GUNMETAL	POWER PACK: YUKEN 5HP
HYDRAULIC OIL TANK: 200L	HYDRAULIC CYLINDER: 6" X 12" STROKE	MAN POWER: 1

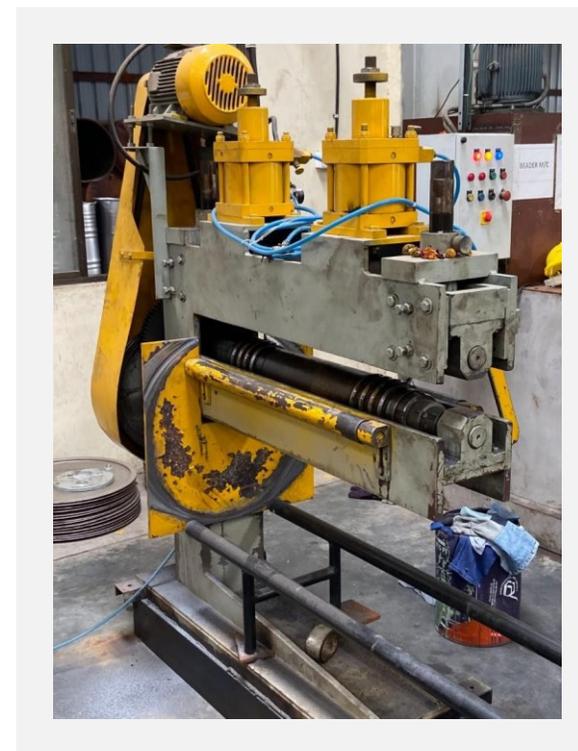


MULTIPLE CORRUGATION MACHINE

Multiple corrugation machine, where two side corrugations on Barrel body are done in one operation. Machine M.S. fabricated, power-operated with 5 H.P. electrical. The machine is pneumatically operated with one adjustable gauge plate and one set of multiple corrugation dies duly hardened. Ram System in the machine is operated via pneumatic cylinder, guide shaft assembly, and shaft assembly. The machine is driven through gear assembly. Ram moves up and down and is parallel to the lower shaft, complete with F.R.L. unit, foot valve for engaging barrel and ejection, along with standard accessories. The machine will be fitted with a timer and solenoid system to avoid overlaps on the barrel.

SPECIFICATIONS

CYCLE TIME: 6 BARRELS/MIN	DIMENSIONS: 4FT L X 3FT B X 5FT H	MAN POWER: 1
MAXIMUM LENGTH BARREL: 40'INCHES	WEIGHT: 1TONS	MOTOR: 5H.P/1440 RPM/HINDUSTAN MOTORS
MATERIAL USED: M.S/CASTING/WPS/EN-9	BUSHINGS: GUNMETAL	HYDRAULIC CYLINDER: 6" X 12" STROKE



DOUBLE BEAD EXPANDER

Double Bead Expander machine, M.S. fabricated and hydraulically operated via a 5 H.P. hydraulic power pack system and accessories. Machine operated via a panel control system and electrical accessories. Bead dies are segmented and duly hardened. Segments expanded through cones connected to the cylinder through a guide bush assembly and retracted through a spring system. Machine making double bead (corrugation) on Barrel body in one operation. Complete with standard accessories.

SPECIFICATIONS

CYCLE TIME: 13-14 SECONDS 5 BARRELS/MIN	DIMENSIONS: 6FT L X 3FT B X 5FT H	MAN POWER: 1
MAXIMUM LENGTH BARREL: 40' INCHES	WEIGHT: 1.5 TONS	CONTROL PANEL: SIEMENS
MATERIAL USED: M.S/CASTING/WPS/EN-9	HYDRAULIC CYLINDER: 6" X 4" STROKE	MOTOR: 5H.P/1440 RPM/HINDUSTAN MOTORS
HYDRAULIC OIL TANK: 200L	BUSHINGS: GUNMETAL	POWER PACK: YUKEN 5HP





BARREL SEAMING MACHINE

Vertical single-ended Barrel seaming machine, power-operated with 15 H.P. Electrical. Machine M.S. fabricated and pneumatically operated with F.R.L. unit, hand valve, and pneumatic accessories. Fitted with one seaming chuck duly hard-faced and one set of seaming rollers duly hard-faced. Machine having a M.S. fabricated table working on dove tail and screw system for height adjustments, fitted with a pneumatic clutch and brake assembly. Operated via panel control system. Machine suitable to seam both double seam and triple Seam Barrels in max 1.6 mm thickness sheet. Complete with standard fittings.



SPECIFICATIONS

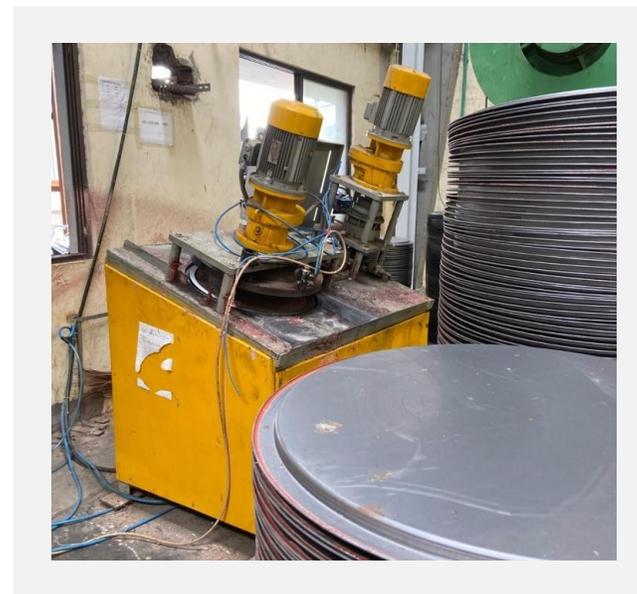
CYCLE TIME: 15 SECONDS 4 BARRELS/MIN	DIMENSIONS: 5FT L X 4FT B X 8FT H	MAN POWER: 1	WEIGHT: 3TONS
MAXIMUM LENGTH BARREL: 40'INCHES	MATERIAL USED: M.S/CASTING/WPS/EN-9	CONTROL PANEL: SIEMENS	BEARINGS: SKF/URB
MOTOR: 15H.P/1440 RPM/HINDUSTAN MOTORS	HYDRAULIC CYLINDER FOR TABLE: 6" X 3" STROKE	SEAMING ROLLERS: TRIPLE SEAM/DOUBLE SEAM IN WPS	SEAMING CHUCK: EN-9 MATERIAL HARDENED

PRE CURLING MACHINE WITH COUMPOUND 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. Machine having a pneumatic clutch and brake assembly and operated via panel control system and accessories. Lid to be manually inserted in 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

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



AUTOMATIC PAINTING EQUIPMENT (VR COATING)

1 Vertical Automatic Airless Spray Painting Equipment for 200-liter Barrel, Max. Complete with facility for three colors at a time. Only outside painting for three colors - 250 nos, two colors - 300, and one color – 350.

Vertical Four-Stage Walking Beam for Tight Head & open-mouth barrel with chain conveyor. Electro-pneumatic panel complete for conveyor, variable speed, sensors & operator pendants.

2 Vertical automatic airless painting equipment for 200L open-mouth barrels, capable of painting 200 per hour (for open-mouth barrels only).

Water Curtain Pressurized Paint Booth for Four-Stage system.



AUTOMATIC AIRLESS LANSING

- Horizontal Automatic Airless Painting Equipment for 200 Ltr. open-mouth bottom-closed barrels and shells with inside Epoxy Painting system capacity Max. 150 Nos. per hour.
- Dry Back Type Paint Booth Single Suction (For Shells and open mouth).
- Dummy Water Wall.
- Barrel cover Airless painting system for Top.
- Barrel Cover Coating System for Bottom.
- Pneumatic Cover Rotating Arrangement.
- Dry Back Type Paint Booth (For Top/Bottom cover painting).

AUTOMATIC BARREL TESTING MACHINE

Barrel testing equipment, MS fabricated. Pneumatically operated with a hand lever valve, root seal, pressure gauge, and pneumatic accessories, having two heads rubberized (ONE SIDE) pneumatically operated and one operated via a screw and nut system, with a 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 the pressure gauge, complete with standard accessories. Operating cycle is 14 seconds, maximum diameter 575mm, maximum length 40 inches.

SPECIFICATIONS

MODEL: PMT/MCM	TYPE: AUTOMATIC
CAPACITY: 1.5MM THICKNESS SHEET	OPERATION: AUTOMATIC/CONTROL PANEL
CONSTRUCTION: MS	POWER: 5 H.P
OUTPUT: 5-7 SHELLS TESTING/MIN	MAN POWER: 1



DIES (TOP & BOTTOM LID FORMING)

1

570mm top and bottom 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 NON SEGMENTED. (Die to make Top & Bottom Lids from sheet, this die will be fitted on the 200 Tons press).



2

2" and 3/4" bung piercing and bung fitting die set in tandem pillar die set fittings. The cutting material will be of WPS, hardened and ground for maximum life of the cutting and opening punches, complete. (Die to make Opening & curling for bungs, this die will be fitted on the 75 Tons press).



**2" & 3/4"
BUNG FITTING
DIE**



**2" & 3/4"
OPENING TANDEM
DIE**

3 570mm OPEN MOUTH 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 pillar die set. Complete NON SEGMENTED. WPS (Die to make Top open mouth Lids from sheet for open-mouth barrels, this die will be fitted on the 200Tons press when you want to make open-mouth barrels replace the 570mm top & bottom lid die with this one).



75 TON POWER PRESSES (SOHAL INT)

75-ton Power Press, inclinable, gear-driven. Power-operated with 5 H.P electrical. Machine M.S. Fabricated and having an adjustable ram system and fitted with a mechanical rolling key clutch system. Machine suitable to fit tandem bung die set, complete with standard fittings.

SPECIFICATIONS

TYPE: AUTOMATIC	CAPACITY: 75 TONS/ON DIES (1.5MM SHEETS)	OPERATION: MANUAL
CONSTRUCTION: MS	POWER: 15 H.P	MAN POWER: 1
OUTPUT: 35-40 STROKES/MIN	TABLE SIZE: 530 X 580MM	DISTANCE TO RAM: 38MM
STROKE LENGTH: 100MM	RPM: 1440 RPM	BORE IN TABLE: 175MM
SHUT HEIGHT: 250MM	PULLEY SIZE: 150MM	



MECHANICAL 200 TON POWER PRESS (SOHAL INT)

200-ton Power Press “H” Frame. Pillar type of sturdy M.S. fabrication, power-operated with 15 H.P. Electrical. Machine geared driven and having an adjustable stroke ram system. Fitted with a Mechanical rolling clutch system, suitable to fit top and bottom lid die set complete with vee belts, guards, and standard accessories.

SPECIFICATIONS

TYPE: MANUAL	CAPACITY: 200 TONS/ON DIES (1.5MM SHEETS)	OPERATION: AUTOMATIC
CONSTRUCTION: MS	POWER: 15 H.P	MAN POWER: 1
OUTPUT: 35-40 STROKES/MIN	TABLE SIZE: 810 X 810MM	DISTANCE TO RAM: 450MM
STROKE LENGTH: 150MM	RPM: 1440 RPM	BORE IN TABLE: 250MM
SHUT HEIGHT: 300MM	PULLEY SIZE: 150MM	



TRAVELLING HEAT OVEN

TOTAL LENGTH OF OVEN: 60 FEET	OVEN TUNNEL HEATING ZONE: 50 FEET	OVEN CROSS SECTION: TO SUIT SINGLE ROW	VERTICAL CONVEYING OF BARREL: 100MM X 600MM
LOADING ZONE: 5 FEET	INLOADING ZONE: 5 FEET	MIN & MAX TEMPERTURE: 100°c to 250°c	TYPE OF HEATING: DIRECT
HOT AIR SUPPLY: FROM BOTTOM DUCTING	FUEL ENERGY: GAS		

STRUCTURE:

The oven structure shall mainly be fabricated from 75 x 40mm channels and 50 x 50mm angles. Cross frame components shall be fabricated and reinforced with 6mm thick gusset plates. These frames shall be bolted to each other at 5ft (five feet) intervals using 50mm x 50mm angles. The structure shall span 50 ft and be formed with 11 units.





PANELS:

The two side panels and the top panel shall be fabricated from 18 SWG CRCA MS sheets. A 4" gap between these plates shall be filled with mineral wool to serve as insulation. Specially perforated sheet metal channels shall be used. These sheets are intended to reduce heat connection at the edges. Forming the bottom part of the oven, it shall be closed by an 18 SWG CRCA panel with 4" insulation, serving as protection for the return chain and reducing heat loss to the atmosphere.

CONVEYOR:

A chain conveyor (600 cc Type) with variable speed drive arrangement will be used for feeding at one end and unloading at the other end.

HEATING CHAMBER:

The heating chamber shall be mounted at the top of the oven. The entire chamber shall be lined with super fine mineral wool from the outside. The gas burner and complete control system shall be mounted on the chamber. There shall be one stainless steel component.

DUCTS:

The air circulation ducts shall be fabricated from 18 SWG CRCA sheet and shall have perforated holes on one side. Adjustable dampers shall be placed at appropriate intervals to enable uniform air circulation.



FANS:

All fans shall be fabricated from 10 SWG CRCA MS sheets with suitable reinforcements. Fan impellers shall be dynamically balanced to ensure vibration and noise-free operation at high speeds. The blades of the impellers are designed based on highly efficient centrifugal principles. There shall be 2 Re-Circulation fans, 1 Extract Fan, 1 Conveyor Motor, 1 Gas Burner, and 1 Gear Motor, etc.

CONTROL INSTRUMENTS:

The following control system instruments shall be supplied:

- Automatic temperature controller with indicators.
- Interlock switch. This switch shall interlock with the flame scanner; in case the circulation fan is not switched to the 'ON' position, the gas supply shall automatically be cut off to the burner.
- Gas burner: We shall supply an imported one.
- Electrical: Our offer includes all necessary motors, such as a 7.50 HP motor for air circulation, a DOL starter for lower HP motors, and Star Delta starters for 7.50 HP motors. These, along with the temperature controller, will be fitted to the control panel. The incoming supply to the control panel and wiring from starters to individual motors are not included in this quotation.

DE-COILING & STRAIGHTNER

1

SPECIFICATIONS

STRAIGHTER MACHINE ROLL: 9 NOS.	MATERIALS: EN-31
HARDNESS: 45 to 50	DIMENSION: 125MM
LENGTH: 1850MM	GEAR BOX: 8" CENTRE, 1:30 RATIO



2

- 10 H.P. 1440 RPM motor with an A.C. Drive Cut-to-Auto System Panel.
- Conveyor System with Stand & Gear Motor

3

- De-Coiler with Hydraulic System Cap 10 Tons
- Width 1550mm working

4

- Hydraulic Shearing Machine
- 6 feet length cutting capacity 0.3mm to 3mm Sheets.