



**Parmar Machines &
Technologies Pvt. Ltd.**



Manufacturers of :
**MACHINES &
DIES FOR TIN
CONIPAIL
DRUM
BARREL
CONICAL STEEL
DRUM**

**Horizontal Barrel Plant Machinery for 210L
with Capacity of 2500 - 3000 Drums in 8 hours.**
(Machinery capable to make open top barrels/close top
barrels/Gooseneck open top barrels)

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Horizontal Type Machinery





**Types of
steel drums
produced
on this
Machinery**



AUTOMATIC SEAM WELDING MACHINE



Fully automatic seam welding machine for Barrel welding complete with:

- a) Bush type weld wheel holder assy (Top and Bottom) with pneumatic cylinder operated cam type indexing system.
- b) Knurl wheel array (Top), with gear box and air cylinder.
- c) Bus bars and flexible shunts.
- d) Z bar assy with wear plates and nose piece. Including barrel guide segments for maintaining 3 mm overlap.
- e) Ram guide assy for bottom weld wheel with air cylinder.
- f) Drive shaft and transmission assy from motor and gear box up to knurl wheel for top & Bot.
- g) Hour glass rolls for Barrel guide at the welding point.
- h) Pusher assy with air cylinder, guide and pusher dog.
- i) Roll former assy with rolls and geared motor assy.
- j) Side roller support for barrel along the travel.
- k) Chain transportation assy with chain, sprockets, bearing hsg and full length chain support along with geared motor assy.
- l) Air line elements, Water line accessories and tubing.
- m) Epoxy molded 250 Kiva transformer.
- n) Table support at sheet entry.
- o) Weld controller, with PLC automation along with operator junction box.
- p) Exit conveyor up to 1 m from welding area.

SHEET SPECIFICATIONS	
CRCS, 0.8 MM -TO- 1.2 MM, 1800 X (915 -TO- 1050)	
DIAGONAL ACCURACY: WITHIN +/- 1 MM	LENGTH VARIATION: WITHIN +/- 1 MM

TECHNICAL SPECIFICATIONS	
RATING: @ 100% DUTY CYCLE 250 KVA	MAX ELECTRODE FORCE: @ 5.6 KG/CM ² 990 KGS
MAX ELECTRODE STROKE: 125 MM	PRODUCTION RATE: APPROX 300 TO 350 / HR

SERVICE REQUIREMENTS	
SUPPLY: 440 V, 50 HZ, OF 3 PHASE	SUPPLY CABLE SIZE: CU. 95 (SQ. MM)
SWITCH FUSE UNIT: 200 AMPS AIR SUPPLY @ 6 KG / SQ. CM PRESSURE	COOLING WATER SUPPLY: 100 LPM @ 3.1 KG / SQ PRESSURE AND 28 DEGREES INLET TEMPERATURE.



200 KVA LONGITUDINAL TYPE SEAM WELDING MACHINE

Model ARON-200/SML-110,

Pneumatically Operated, having 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 Micro Controller based Welder Controller.

Model: KBD-11

Key Board operator interface with display and easy to program weld schedules.



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. It is fitted with a pneumatic cradle system for ejection.

SPECIFICATIONS	SPECIFICATIONS
CYCLE TIME: 12 SECONDS, 5-6 BARRELS/MIN	HYDRAULIC OIL TANK: 300L
POWER: 10HP HINDUSTAN MOTOR	MAXIMUM LENGTH BARREL: 40'INCHES
CONTROL PANEL: SIEMENS	DIE MATERIAL: OHNS
MATERIAL USED: M.S / CASTING / WPS / EN-9	HYDRAULIC CYLINDER: 150MM BORE/STROKE 100MM
BEARINGS: SKF/ URB	POWER PACK: 40L (10H.P POWER PACK)
WEIGHT: 2.5TONS	MAN POWER: 1

HORIZONTAL DOUBLE ENDED 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. It is suitable for beading 0.8mm - 1.6mm sheets.



SPECIFICATIONS	SPECIFICATIONS
CYCLE TIME: 12 SEC. 5-6 BARRELS/MIN	DIMENSIONS: 10FT X 3FT X 7.5FT
MAXIMUM LENGTH BARREL : 40"	WEIGHT: 4 TON
MATERIAL USED: MS/CASTING/WPS/EN-9	BEARINGS: SKF/ URB
HYDRAULIC OIL TANK: 650L	HYDRAULIC CYLINDER: 550MM STROKE
CONTROL PANEL: SIEMENS	MOTOR: 20HP/1440 RPM/HINDUSTAN
POWER PACK: YUKEN 45L	MAN POWER: 1

HORIZONTAL DOUBLE ENDED MULTIPLE CORRUGATION MACHINE

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. 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.



SPECIFICATIONS	SPECIFICATIONS
CYCLE TIME: 12 SEC. 5-6 BARRELS/MIN	WEIGHT: 4 TON (APPROX.)
MAXIMUM LENGTH BARREL : 40"	BEARINGS: SKF/ URB
MATERIAL USED: MS/CASTING/WPS/EN-9	HYDRAULIC CYLINDER FOR HEADS: 15" STROKE
HYDRAULIC OIL TANK: 400L	MOTOR: 7.5HP GEARED / 80 RPM / HINDUSTAN MOTORS
CONTROL PANEL: SIEMENS	MAN POWER: 1
POWER PACK: YUKEN 45L	
DIMENSIONS: 10FT X 3FT X 7.5FT	

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 1.6mm thickness sheet.

SPECIFICATIONS	SPECIFICATIONS
CYCLE TIME: 10 SEC. 5-6 BARRELS/MIN	WEIGHT: 8 TON (APPROX.)
MAXIMUM LENGTH BARREL : 40"	BEARINGS: SKF/ URB
MATERIAL USED: MS/CASTING/WPS/EN-9	HYDRAULIC CYLINDER FOR HEADS:
HYDRAULIC OIL TANK: 400L	15" STROKE
CONTROL PANEL: SIEMENS	MOTOR: 30HP / 1440 RPM
POWER PACK: YUKEN 45L	MAN POWER: 1
DIMENSIONS: 10FT X 4FT X 7.5FT	

AUTOMATIC BARREL LEAKAGE TESTING MACHINE

Barrel leakage testing machine, MS fabricated Pneumatically operated with control panel, roto seal, pressure gauge and pneumatic accessories, having two heads rubberized (ONE SIDE) pneumatically operated and one operated via screw and nut system, with barrel centering roller system. The barrel rotates with reduction gear box of 3 HP system drive one of the rotating testing columns will be operated via chain and sprocket system and water tray for water collection. While the testing is done to check for any leakages with soap water or loss in pressure on pressure gauge, complete with standard accessories.



SPECIFICATIONS	SPECIFICATIONS
CYCLE TIME: 12 SEC. 5-6 BARRELS/MIN	DIMENSIONS: 5FT X 4FT X 5FT
MAXIMUM LENGTH BARREL : 40"	WEIGHT: 1 TON
MATERIAL USED: MS/CASTING/EN-9	PNEUMATIC CYLINDER:
MAN POWER : 1	12"X4" STROKE
CONTROL PANEL: SIEMENS	MOTOR: 3HP REDUCTION
RUBBERIZED HEADS	BEARINGS: SKF/URB



LID 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 Nos. 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 vide panel control system and accessories Lid to be manually inserted in machine after which the machine pre curls the lid and ejects it as the machine is sloped. Complete with one set roller duly hardened and standard fittings. Seaming compound ejection is monitored through control panel for application of seaming compound on lids to avoid leakage before seaming process.



SPECIFICATIONS	SPECIFICATIONS
OUTPUT: 12 LIDS/MIN	DIMENSIONS: 4FT X 4FT
CAPACITY: 1.6MM SHEETS	CONSTRUCTION: MS
POWER: 3HP STANDARD 1440RPM AND 3HP GEARED, HINDUSTAN	MAN POWER: 1
BEARING: SKF/URB	WEIGHT: 1 TON
MATERIAL USED: MS/CASTING/WPS/EN-9	PRECURL ROLLERS: WPS MATERIAL





2" & 3/4" BUNG OPENING

2" & 3/4" Bung Opening Die set in tandem pillar die set fittings the cutting material will be of WPSD2 hardened and ground for maximum life of the cutting and opening punches, complete. (Die to make Opening for bungs, this die will be fitted on the 75 Tons press).

2" & 3/4" BUNG FITTING

2" & 3/4" Bung Fitting Die set in tandem pillar die set fittings the curling punch material will be of WPSD2 hardened and ground for maximum life of the curling punch. (Die to Fit / Curl bungs on Top Lids, this die will be fitted on the 75 Tons press).



DIES (TOP & BOTTOM LID FORMING)



CLOSED TOP BARREL LIDS : 570mm Top & 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 pillar die set, Complete WPSD2 NON SEGMENTED. (Die to make Top & Bottom Lids from sheet upto 0.8mm-1.6mm, this die will be fitted on the 200 Tons press).



OPEN TOP BARREL LIDS : 570mm Top & 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 pillar die set, Complete WPSD2 NON SEGMENTED. (Die to make Top & Bottom Lids from sheet upto 0.8mm-1.6mm, this die will be fitted on the 200 Tons press).



OPEN TOP GOOSENECK BARREL LIDS : 550mm Top & 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 pillar die set, Complete WPSD2 NON SEGMENTED. (Die to make Top & Bottom Lids from sheet upto 0.8mm-1.6mm, this die will be fitted on the 200 Tons press).



75 TON POWER PRESSES

75 tons Power Press, inclinable, geared 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	SPECIFICATIONS
TYPE: AUTOMATIC	TABLE SIZE: 530X580MM
CAPACITY: 75 TONS /ON DIES (1.6MM SHEETS)	DISTANCE TO RAM: 38MM
OPERATION: CONTROL PANEL	STROKE LENGTH: 100MM
CONSTRUCTION: MS	RPM: 1440RPM.
POWER : 15 H.P	BORE IN TABLE: 175MM
MAN POWER: 1	SHUT HEIGHT: 250MM
OUTPUT: 35-40 STROKES/MIN	PULLEY SIZE: 150MM

MECHANICAL 200 TON POWER PRESS

200 tons 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's system. Fitted Mechanical rolling clutch system, suitable to fit top and bottom lid die set complete with vie belts, guards and standard accessories.

SPECIFICATIONS	SPECIFICATIONS
TYPE: AUTOMATIC	TABLE SIZE: 810X810MM
CAPACITY: 200 TONS /ON DIES (1.6MM SHEETS)	DISTANCE TO RAM: 450MM
OPERATION: CONTROL PANEL	STROKE LENGTH: 150MM
CONSTRUCTION: MS	RPM: 1440RPM.
POWER : 15 H.P	BORE IN TABLE: 250MM
MAN POWER: 1	SHUT HEIGHT: 300MM
OUTPUT: 35-40 STROKES/MIN	PULLEY SIZE: 150MM





AUTOMATIC PAINTING EQUIPMENT



Vertical Automatic Airless Spray Painting Equipment for 200 Letter. Barrel, Max. Complete with facility for three colors at a time. Only outside painting for three color- 250 nos, two color -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. Vertical automatic airless Lansing equipment for 200l. Open mouth barrel per hour 200. (For Open Mouth Barrel only). Water Curtain Pressurized Paint Booth for Four Stage system.

AUTOMATIC AIRLESS LANSING

Horizontal Automatic Airless Lansing Equipment for 200 Ltr. open mouth bottom closed barrel and Shell with inside Epoxy Painting system capacity Max. 150 Nos. per hour. Dry Back Type Paint Booth Single Suction (For Shell 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)

PAINTING BOOTH MACHINE WITH EXHAUSTER SYSTEM

M.S. Fabricated paint booth for MS 210ltr barrel with a horizontal rotary spinner adjustable type on which the barrel will be placed for painting process with a 1H.P. motor reduction gear box drive for adjustable rotary spinner. Machine has a 5H.P. exhaustor system for suction of excess paint in booth while spraying. Water tray giving below to collect excessive paint. Machine is also fitted with barrel auto ejection system for ejecting barrel after painting process is complete. Machine fitted with standard pneumatic and electric accessories.



TRAVELLING HEAT OVEN



- a) Automatic Temperature controller with indicators.
- b) Inter – Lock switch: This switch shall inter – lock with flame scanner in case the circulation fan is not switched to the `ON` the Gas supply shall automatically by to the Burner.
- c) Gas Burner: We shall supply Imported Gas Burner.
- d) Electrical: Includes all necessary motors as 7.50 HP for air circulation. Doll starter for lower HP motors and Star Delta Starters for 7.50 HP motors along with temperature controller will be fitted to the control panel.

SPECIFICATIONS	SPECIFICATIONS
TOTAL LENGTH OF OVEN : 60 FEET.	TYPE OF HEATING : DIRECT
OUTPUT : 6 TO 8 BARRELS / MIN	FUEL ENERGY: GAS
LOADING ZONE : 05 FEET.	HOT AIR SUPPLY: FROM BOTTOM DUCTING
OVENTUNNEL HEATING ZONE : 50 FEET.	OVEN CROSS SECTION : TO SUIT SINGLE ROW VERTICAL
UNLOADING ZONE : 05 FEET.	CONVEYING OF BARREL : 1000 MM X 600 MM.
MIN & MAX TEMPERATURE:100C TO 250C.	

GOOZNECK NECKING MACHINE (GOOSENECK OPEN TOP BARREL)



Gooseneck necking machine, M.S. Fabricated, gear-driven with a 5 H.P. motor. The machine is single-ended and capable of doing necking up to 25mm adjustable from 570mm to 550mm as per your size. Machine is pneumatically operated with via control panel system (full operation automatic) FRL unit 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	SPECIFICATIONS
CYCLE TIME: 30 SECONDS - 2 BARRELS/MIN	WEIGHT: 800 KG
MAXIMUM LENGTH BARREL: 40 INCHES	BEARINGS: SKF/ URB
MATERIAL USED: M.S/CASTING/WPS/EN-9	PNEUMATIC CYLINDER FOR TABLE: 6" X 3" STROKE AJDUSTABLE
MAN POWER: 1	MOTOR: 5H.P/1440 RPM
CONSTRUCTION: MS	
DIE: GOOSENECK NECKING DIE UPTO 25MM - 35MM NECKING (ADJUSTABLE)	

DE-COILING & STRAIGHTNER

STRAIGHTER MACHINE Roll: 9 Nos.

Materials: EN-31
 Hardness: 45 to 50
 Dimension: 125mm
 Length: 1850mm
 Gear Box: 8" Centre, 1:30 Ratio

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

DE-COILER WITH HYDRAULIC SYSTEM

Cap 10 Tons Width 1550mm working

HYDRAULIC SHEARING MACHINE

6Feet Length cutting capacity 0.3mm to 3mm Sheets.





Parmar Machines & Technologies Pvt. Ltd.

CONICAL DRUM MACHINERY



CONICAL BODY EXPANDER MACHINE



Conical body expander machine, hydraulically operated. Machine having 16 NOS segments in OHNS hardened and hard chromed material. Hard chroming and segments done for avoiding scratches. 16 NOS Segments expanded through adjustable taper cone system made of WPS material duly hardened at 55-57 hardness. Taper cone system connected to hydraulic cylinder through bush system and retracted through internal spring system. Segments duly hard chromed, segment assembly fitted on sturdy M.S. Fabricated stand. Machine is horizontal and shell to be fed manually Machine will be operated via panel control system in the machine. Complete with standard fittings and accessories.

SPECIFICATIONS	SPECIFICATIONS
CYCLE TIME: 5 SEC., 10-12 BARRELS/MIN	WEIGHT: 3TONS
MAXIMUM LENGTH BARREL: 40 INCHES	DIMENSIONS: 7FT L X 3FT B X 5FT H
MATERIAL USED: M.S/CASTING/WPS/EN-9	BUSHINGS: GUNMETAL
HYDRAULIC OIL TANK: 300L	HYDRAULIC CYLINDER : 12" X 5"STROKE
CONTROL PANEL: SIEMENS	POWER PACK: YUKEN
MOTOR : 15H.P/1440 RPM/HINDUSTAN	15HP/ 45L Hydraulic Pump.
MOTORS	MAN POWER: 1

SINGLE CONICAL BEAD EXPANDER

Horizontal Conical Bead Expander machine, M.S. fabricated and hydraulically operated vide 7.5 H.P. hydraulic Power pack system and accessories. Machine operated vide panel control system and electrical Accessories. Bead dies are segmented and duly hardened. Segments expanded through cones Connected to cylinder through guide bush assembly and retracted through hydraulic cylinder system. Machine making one bead (corrugation) on Barrel body in one operation. Complete with standard accessories with trolley system for feeding body shell working through a pneumatic cylinder.



SPECIFICATIONS	SPECIFICATIONS
CYCLE TIME: 12 SEC., 5-6 BARRELS/MIN	WEIGHT: 1.5TONS
MAXIMUM LENGTH BARREL: 40 INCHES	DIMENSIONS: 6FT L X 3FT B X 5FT H
MATERIAL USED: M.S/CASTING/WPS/EN-9	BUSHINGS: GUNMETAL
HYDRAULIC OIL TANK: 200L	HYDRAULIC CYLINDER :
CONTROL PANEL: SIEMENS	6" X 4"STROKE
MOTOR : 7.5H.P/1440 RPM/HINDUSTAN	MAN POWER: 1
MOTORS	



HORIZONTAL DOUBLE ENDED PRESS TYPE FLANGING/OPEN-TOP MACHINE



Horizontal press type flanging/open-top for Conical 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 and make open-top ball formation on the shell. 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 flanging tool for bottom flange and open-top ball forming tool for ball forming top side. It is fitted with a pneumatic cradle system for ejection.

SPECIFICATIONS

CYCLE TIME: 12 SECONDS, 5-6 BARRELS/MIN
POWER: 10HP HINDUSTAN MOTOR
CONTROL PANEL: SIEMENS
MATERIAL USED: M.S/CASTING/WPS/EN-9
BEARINGS: SKF/ URB
WEIGHT: 2.5TONS

HYDRAULIC OIL TANK: 300L
MAXIMUM LENGTH BARREL: 40'INCHES
DIE MATERIAL: OHNS
HYDRAULIC CYLINDER: 150MM BORE/STROKE 100MM
POWER PACK: 40L (10H.P POWER PACK)
MAN POWER: 1

DIES (TOP & BOTTOM LID FORMING)



CONICAL BOTTOM LID DIA

516mm 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 pillar die set, Complete WPS D-2 NON SEGMENTED CUTTING RINGS. (Die to make Bottom Lids from sheet, this die will be fitted on the 200 Tons press). (TEMPER/ HARDENESS WITH MATERIAL CERTIFICATE WILL BE PROVIDED WITH DIE)



CONICAL OPEN-TOP LID DIA

557mm 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 CUTTING RINGS. D-2 WPS (Die to make open-top lids from sheet for conical 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). (TEMPER/ HARDENESS WITH MATERIAL CERTIFICATE WILL BE PROVIDED WITH DIE)



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**“ Empowering
Industries with
Precision-Engineered
Solutions for
STEEL DRUMS AND BARREL
Machinery Needs. ”**



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Manufacturers of: PLANTS & DIES FOR CONIPAIL | DRUM | BARREL | CONICAL STEEL DRUM

UNIT 1: Shailesh Ind. Estate No. 3, Unit No. 11, Navghar, Vasai (East), Dist. Palghar - 401210.

UNIT 2: Shailesh Ind. Estate No. 2, Unit No. 2, Navghar, Vasai (East), Dist. Palghar - 401210.

Ph.: +91 9920190820 | +91 9819629655 | +91 9619817973

Email: sales@parmarmachinestech.com | Website: parmarmachinestech.com