200-220 LITRES DRUM BARREL PLANT MACHINES

INTRODUCTION

The complete range of semi-automatic machinery and equipments for producing drum barrel and buckets in various ranges for packing edible oil, paint, chemical, petrochemical and petroleum products. The importance of our machines lies in the modern and functional design based on many years of development, finest workmanship backed by a team of first class craftsmanship. Today the firm is a leader in steel metal machinery, which not only covers a range of drum barrel and buckets plants but also tin plate container manufacturing machinery plant. We export to the sophisticated world markets, a proof of our top quality and superior craftsmanship.
**COIL MOUNTER**

Mechanical manual with and without motor driven facility. Heavy duty steel fabricated coil mounter (stand) with horizontally fitted shaft, 2 coil holders. Simple convection uncoiling will be done by leveller pulling roller.

**LEVELLER**

Leveller with and without gear box for 2mm thickness material, 1.2mm with and without variable drive. Sheet Straightening Leveller machine with 11 rollers, approx. 4" body Mild Steel fabricated individual setting for each upper roller. Open gear drive heavy duty one piece complete body structure.
SHEARING UNIT: SHEARING MACHINE

This machine is required for cutting sized body blank & top bottom blanks from a sheet or a coil. The basic structure is steel fabricated that gives it an extra strength and rigidity. for smooth & trouble free operation, an appropriate lubricating system is provided everywhere. The shearing blades are made out of best quality material, hardened and ground to its best standard, both the blades are reversible type so that all the four edges can be utilized, giving the blades and extra lift. All the moving parts (Bushing) are made up of phosphorus bronze. the maximum speed is given to achieve more production.

Technical Specifications:

72” long SWG power operated shearing machine suitable for cutting sheets to length size machine equipped with 4 edge blades adjustment gauge sheets holders etc. with electric motor starter and "V" belts
**GRINDING BOTH ENDS: DOUBLE EDGE GRINDING MACHINE**

Edge grinding is very special operation in manufacturing of Drums & Barrels, because some amount of material is to be removed from the edges of the body which give advantages to

A) Welding operations (removes dirt, oiliness etc), extra strength to the weld and a leak proof joint.

B) Flanging operation.

C) End seaming operation (lesser thickness of side seam overlap).

Maximum parts of the machine ate steel fabricated. It can absorb all the jerks & vibration caused due to the grinding wheel. Proper dressing arrangement is for smooth grinding. the entire machine is divided in 3 parts as

A) Centre table on fixed guide rails by means of pneumatically operated long cylinder.

B) Right hand side grinding unit.

C) Left hand side grinding unit. All the tree units are properly assembled; micro setting arrangement is given for maintaining highly precise gap between the grinding wheels.

An Export Award Winning ISO 9001 Quality Certified Company
Technical Specifications:

Double ended sheets edge grinding machine with 2 nos. electric equipment and pneumatic cylinders for saddle drive and sheet holder with required pneumatic levers and filler pressure regulator with electrical motor starter and 'V' belts.
**FORMATION OF ROUND SHAPE: ROUND ROLLING MACHINE**

The machine serves to roll all sorts of drum bodies and it has a very high output. This machine can be operated easily and can be adjusted rapidly for drum bodies of various diameters. The rolls are of best quality steel and run on gun metal bearings. The gears are machine cut and encased. The adjustable curving plate enables bodies to be rolled practically as small as the top roller.

![Round Rolling Machine](image)

**Technical Specifications:**

- 40” width body bending rollers with sheets knock out system completely pedestal stand with electrical motor starter and ‘V’ belts.
The illustrated model is for side seaming to the full-length of the hollow drum and barrel body. Machine body is reinforced fabricated steel structure with a heavy duty transformer used as the main power source, for continuous welding operations. The machine is equipped with upper and lower weld wheel assembly, water cooling system and built in welding transformer.

Technical Specifications:

200 KVA longitudinal type welding machine with 42” deep throat with pneumatic drive motor and cunchronous welder control with electrical motor starter and ‘V’ belts Panel control.
The rocker arm spot welding machine is an important machine in manufacturing Drums & Barrels. It is better to give some spots to the body sides before side seam welding operation. The machine can also be used for spot welding the handles etc., this machine is specially designed with a longer arm, better rated transformer & electronic timer, also given are various tapping to transformer for welding current selection enabling universal use.

**Technical Specifications:**

30 KVA spot welding machine pneumatically operated with time rocket arm type.
This machine gives beading to the drum or the barrel. This bead gives an extra strength to the body cell. It also contains sets of segment made out of finest quality heat treated steel along with hydraulic power pack of all standard parts, high quality flexible tubing, and logic & control panel. Hydraulic cylinder etc. of this machine is very fast & the rejection rate is absolutely nil compared to rotary type bead machine. A separate power pack is provided. In case of lower production rate, single tooling bead expander can be used. Double beading machine gives both beads at one stroke. Normal, unskilled operator can also operate this machine.

Technical Specifications:

Bead expander for forming beading on the body of drum by means of inner tool expanding made of steel duly tempered and hardened to form both corrugation, simultaneously hydraulically operated with power pack and special heavy duty cylinders complete with motors and electricals.
This machine is required for giving corrugation to the drum or the barrel. The illustrated model is a single stage corrugating machine where in one operation, we get a half body after turning in next operation we get another half body, this extremely silent, heavy duty & stable machine uses a specially designed gear box. Its strong drive is the main feature of this machine & the tooling is made up of best quality steel. Pneumatic cylinder is also given a heavy duty, so that the machine will minimize the jerks while overlapping of body drums & barrels. For various diameters a separate tool is not required.

Technical Specifications:

Single ended multi corrugation machine heavy duty with electric equipment pneumatic cylinders and foot lever pneumatic and single corrugation tooling with electric equipments.
These presses are specially designed for cutting, blanking, piercing and embossing on flat or circle sheets.

The press is of heavy construction in conjunction with rigid design to give it great stability even when presses are on Mass production.

**Technical Specifications:**
Heavy Duty Geared power press fixed type complete with standard accessories for pressing top bottom with motor starter and ‘V’ Belts

220 Litre. Top bottom cutting embossing die complete with top steel punch fitted with buffers and springs complete with base plate and attachment fitted with steel guided pillars duly tempered.
TOP BOTTOM FILLER HOLE & BUNK FIXING:

PRESS TOOLS (FILLER HOLES AND BUNKS)

These presses are specially designed for filler holes, bunks fixing after formation of top.

The press is of heavy construction in conjunction with rigid design to give it great stability even when presses are on Mass production.

Technical Specifications:

Heavy duty geared press for body inclinable adjustable stoke with standard accessories to piece bung holes and hugs fitted with motor starter and 'V' belts

Tandem Complete set of dies of filler hole ¾” & 2” hole cutting and embossing die made of steel duly hardened and grinded fixed between steel guided pillars both operation simultaneously.

Heavy duty geared press for body inclinable adjustable stoke with standard accessories to piece bung holes and hugs fitted with motor starter and 'V' belts

Tandem Complete set of dies of filler bunks fixing die ¾” & 2” die made of steel duly hardened and grinded fixed between steel guided pillars both operation simultaneously.
CURLING MACHINE: PRE CURLING MACHINE (TOP BOTTOM)

Semi Automatic type, where the component is placed on the table and the chuck, will come out with carry component and start rotating. Top spring loaded support will always be pressing the component so that the component formally sticks with chucks, after which one curling roller will come and automatically curl the component.

Technical Specifications:
Semi Automatic type, where the component to be placed on the table the chuck will come out with carry component and start rotating top spring loaded support will always be pressing the component so that the component formally sticks with chucks after that automatically one curling roller will come and curl the component the component on machine & removing of the same is manual.
CLOSING OF TOP BOTTOM:

SEMI AUTOMATIC DRUM SEAMING MACHINE

This machine will seam drums at approximately three seems per minute. A double cone clutch and break is fitted to enable accurate registration of the filling and vent holes in drum body, and top to be maintained, but the machine may be set so that the chuck runs continuously thereby increasing the output.
Technical Specifications:

Single ended vertical semi automatic barrel double seaming machine with one chuck and rollers, with accessories and pneumatic levers and motor starter and 'V' belts.
**DRYING OVEN**

Stationary oven having insulated walls roof with both sides opening for charges and discharges with internal exhaust fans revolving arrangement with rails for trolleys with control panel thermostats and temperature gauges with accessories complete.
Technical Specifications:

De Greasing and phosphating Drying oven Gravity type having insulated wall roof with both side opening for charges and discharges with internal exhaust fan for revolving arrangements with thermostat temperature gauge with accessories.

Conveyor oven for drying paint having insulated wall roof with both side opening for charges and discharges with internal exhaust fan for revolving arrangements conveyer system with control panel thermostat temperature gauge with accessories.
PAINTING BARRELS
Rotary spinners for spraying printing barrels with motor starter and complete with gear box and motors with attachments for back drop after painting paddle operated.

SCREEN PRINTING
Screen printing machine manual operated sliding type drum rotating complete.

DRUM TESTING MACHINE
Semi automatic drum testing machine for testing leakage with fittings and attachments complete.

DE GREASING
Cell rotting type with pressure water pump (3hp) with nozzle ejector for drum knock out complete with motor starter

PHOSPATHING
Cell rotting type with pressure water pump (2hp) with nozzle ejector for drum knock out complete with motor starter