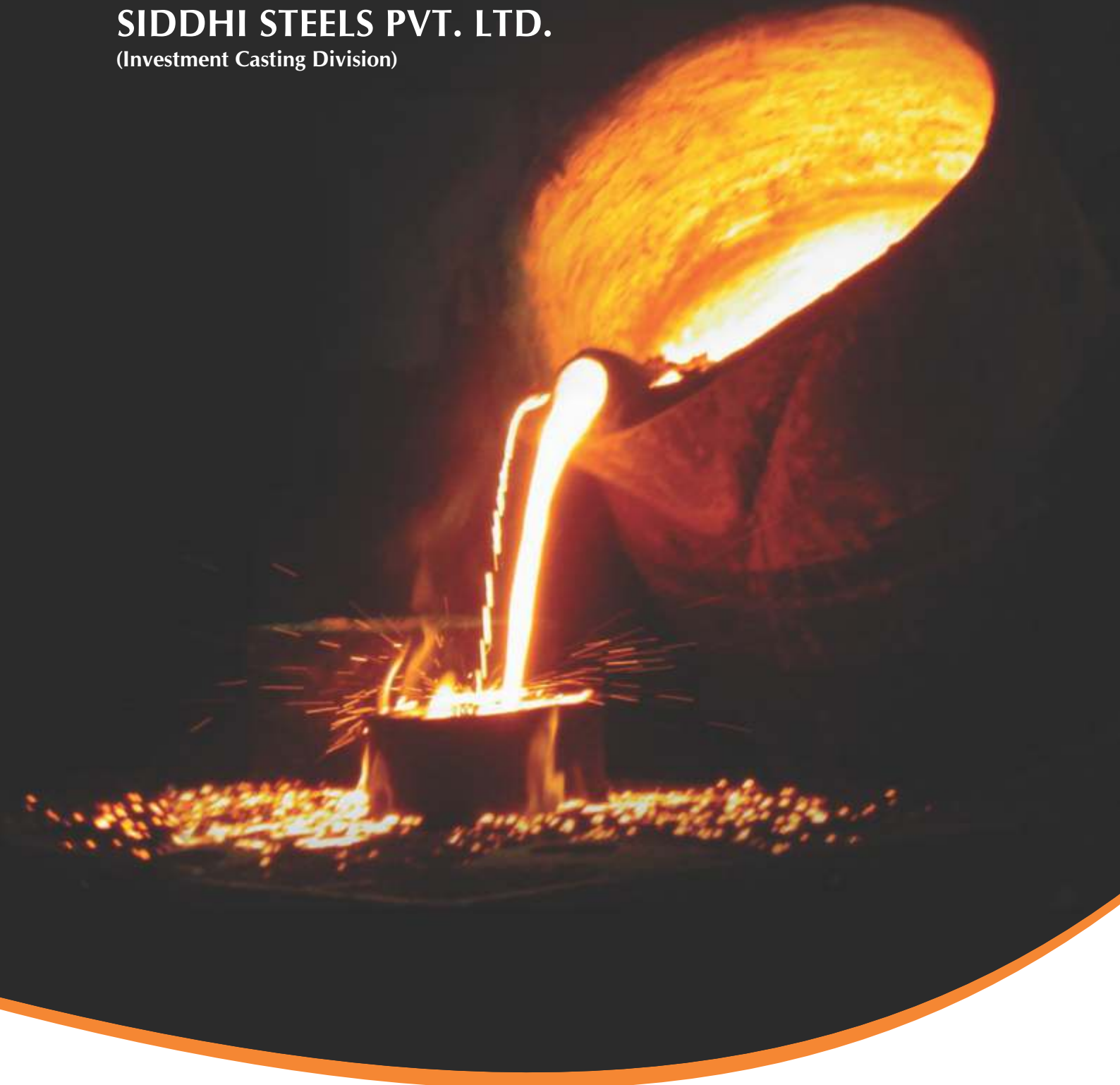


SIDDHI STEELS PVT. LTD.

(Investment Casting Division)



www.siddhisteels.in





**SIDDHI
INDUSTRIES
LTD.**

**SIDDHI
MARGARINE
PEECIALITIES
LTD.**

**SIDDHI
DECOR
PVT. LTD.**

**SIDDHI
STEELS
PVT. LTD.**

**SIDDHI
BEVERAGES**

**SIDDHI
OILS LTD.**



SIDDHI
Group

Empowering Lives



Company Profile

The business founder of Siddhi Group Mr. Markandbhai V Parikh is a simple personality & a dedicated hard worker . We are Proud of his simple & great guidance to the Organisation.

It is on his guidance the strong foundation of the organisation is laid . Mr. Markand bhai V Parikh the entrepreneurship mind & the strong desire & dedication to move into the corporate world.

Mr Markand bhai V Parikh in his successful business journey of 35 years Siddhi sales corporation has been transformed into a diversified business and is now called “ SIDDHI GROUP OF COMPANIES”.

Till date, due to attractive “ PDQS “ philosophy (Price, Delivery, Quality, Service) the company has been able to generate & retain its loyal customers within India and also overseas. There has been a continuous increase in its customer base.

Siddhi Group of Companies

Siddhi Group involved in manufacturing activities of edible oils, investment casting and sand castings , innovative decorative laminates , packaged drinking water, table spread, textile and crossing the turnover of USA \$ 100 million.

All operations indexes stipulated by CMD Mr. Markandbhai V Parikh were attained with a continuous high speed growth. The new defined direction of advancement formulated long term development strategies and set up new goals.

CMD Mr. Markandbhai V Parikh is a visionary, an eminent industrialist, and an acute businessman. His vast experience saw the potential in his son Mr. Jay M Parikh who is a MBA from Australia and guided him to a career in the division of Table Spread and Textile Industries .

CMD Mr. Markand bhai V Parikh incorporated the company in the name of “SIDDHI INDUSTRIES LTD”. The company is to manufacture cotton yarn ranging between 24 count to 40 count with 25000 spindles and installed capacity of 54,25,000 kg per annum. The project is situated in Dholka (Ahmedabad) region which is a cotton belt Quality and there are lots of ginning factories which will be a source of raw material.

For the above expansion plan, the company has already procured and adjoining the present factory premises of 25000 spindles. The company is committed to have best Quality manpower, to work on specified targets with firm road map.



Company Profile.

SIDDHI STEELS PVT. LTD. were sown in 2006 by Mr. Markandbhai V Parikh, with production capacity of 40 Tons of lost wax investment Castings per month. Since then we have progressed exponentially and today the company produces 1000 Tons of lost wax Investment Castings PA.. Till now we have developed more than 1000 components applicable to a wide range of Industries and today we are one of the largest manufacturers and exporters of lost wax investment castings in Changodar-Ahmedabad.

Infrastructure:

Our manufacturing facility is housed in a modern and spacious building admeasuring 25,0000 square feet.

Design and Development

We are a reliable manufacturer engaged in design, development & mass production of Investment Castings. Using these castings, we are able to cater to the needs of varied industries like Industrial valves, Industrial Pump, Orthoadic implant, Railway Parts, Automotive parts, General Engineering, Textile, Pharmaceutical and others.

We manufacturing investment casting by lost wax method and able to supply components in various conditions like Raw, Finished, shell building, Dewax, Conventional Casting, knockout, cut off, Assembled or as per customer's Demand.

WHY CHOOSE US:

End-to-End Solution

We offer a complete in-house end-to-end service incorporating design, tooling, rapid prototyping, casting and machining. This enables us to time in logistics and also has complete control throughout the manufacturing processes. This assures that all the processes are done religiously and equally authentic.

Robust QMS Implementation

Our quality management system adheres to ISO 9001:2015 and hence provides adequate assurance for customer's quality requirements. Product Quality, On Time Delivery and Satisfied customers are the result of our QMS culture.

Quality Assurance

We maintain and strive for Quality in each and every sections of the company. Our Quality Department is headed by a qualified engineer and reports directly to our Technical Director. Our Quality Dept. is fully air-conditioned and having Microprocessor based and computerized testing machines/instruments like Spectrometer, Computerized Universal Testing Machine, Microscope with Digital Camera, etc. within our office building.

We have a well laid out Quality Manual and Process Manual, both of which adhere to strictly. At present we have implemented ISO 9001:2015 quality system. Some of the salient features of our Quality System are as follows:

All incoming Raw Materials are checked for their conformance to the requirements before allowed to be used. Stage wise Quality checks. Visual, Dimensional, Chemical & Physical Inspection of final product. Magnetic Particle Inspection, Dye Penetration Testing, Radiography, Ultrasonic Testing. Master Card, Quality Plans, and Process Plans for each item. Technical Data Cards for all departments for all items. Work Instructions on all workstations. All process parameters are recorded and monitored.

Stringent compliance with requirement of calibration of process instruments and measuring instruments with agencies having International trace ability. A separate list of "TESTING FACILITY" is enclosed herewith for your ready reference.

Testing Facility:

CHEMICAL Analysis

1. all type of raw material analysis by wet method

MICRO STRUCTURE ANALYSIS

1. Ferrite Testing as per ASTM E 562 etc..
2. Micro structure Examination as per ASTM A 923 etc

MECHANICAL TESTING

1. UTM Capacity of 200KN

HARDNESS Testing

1. Rockwell Hardness Testers.
2. Poldy Hardness Tester.
3. Brinell Hardness Tester.

N.D.T. Man Power: leave II in all NDT

ELECTRO POLISHING

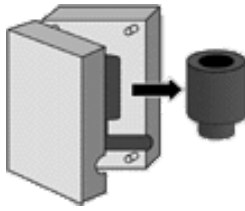
HYDRO TEST



Process

The Basics of the Investment Casting Process

1



Wax Injection

Wax design of the desired castings are produced by injection molding. These designs are called patterns.

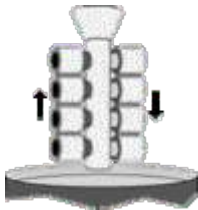
2



Assembly

The patterns are attached to a central wax stick, called a sprue, to form a casting cluster or assembly.

3



Shell Building

The shell is built by immersing the assembly in a liquid ceramic slurry and then Process Investment Cast Mfg & Exporter Of All Types Of Investment Casting into a bed of extremely fine sand. Up to eight layers may be applied in this manner.

4



Dewax

Once the ceramic is dry, the wax is melted out, creating a negative impression of the assembly within the shell.



5



Conventional Casting

In the conventional process, the shell is filled with molten metal by gravity pouring. As the metal cools, the parts and gates, sprue and pouring cup become one solid casting.

6



Knockout

When the metal has cooled and solidified, the ceramic shell is broken off by vibration or knock-out machine.

7



Cut Off

The parts are cut away from the central sprue using a high speed friction saw.

8



Finished Castings

After minor finishing operations, the metal castings becomes identical to the original wax patterns and are ready for shipment to the customer



TECHNICAL CAPABILITIES

Materials Cast Capabilities

	ASTM	DIN
Carbon Steel	A216 – WCB	1.0619
	A216 – WCC	
	A352 – LCC	1.1138
	A352 – LCB	
Low Alloys Steels	A217 – WC	11.5419
	A217 – Wc4	
	A217 – Wc5	
	A217 – WC6	1.7356
	A217 – WC9	1.7379
	A217 – Wc11	
	A217 – C5	1.7363
	A217 – C12	
Martensitic Steels	A743 – CA15	1.4008
	A743 – CA40	1.4028
	A743 CA-6NM	1.4313
Heat Resisting Steel	A297 – HF	1.4825
	A297 – HH	1.4837
	A297 – HI	1.4846
	A297 – HK	1.4848
		1.4749
	A297 – HD	1.4823
Austenitic Stainless Steel	A351 – CF8	1.4308
	A351 – CF8M	1.4408
	A351 – CF3	1.4306
	A351 – CF3M	1.4404 / 1.4409
	A351 – CF8C	1.4827
	A351 – CF10	1.4308
	A351 – CK20	1.4843
	A351 – Ch20	
	A351 – CN7M	1.4500
	A351 – CG8M	1.4431
	A351 – CG3M	

	ASTM	DIN
Austenitic Ferrite	A351 – CF3MN	1.4435
	A351 – CD4MCu	
	A351 – CG6MMN	1.3964
	A351 – CK3MCuN	
Super Duplex Stainless Steel	A890 – GR1A	
	A890 – GR2A	
	A890 – GR3A	
	A890 – GR4A	
	A890 – GR5A	
	A890 – GR6A	
Nickle Based Super Alloys	A494 – M-35-1	2.4365
	A494 – M-35-2	
	A494 – M 30 C	
	A494 – N-12MV	
	A494 – N-7M	
	A494 – CY40	2.4816
	A494 – CW12MW	2.4686
	A494 – CW6M	
	A494 – CW2M	2.4610
	A494 – CW6MC	2.4856
	A494 – CX2MW	2.4602
	A494 – Cu5MCuC	2.4858
	A560 – 50Cr50Ni	
	A560 – 50Cr50Ni-Nb	2.4813
	A560 – 60Cr40Ni	
Cobalt Based Alloys	STELLITE 3	
	STELLITE 6	
	STELLITE 21	
	STELLITE 23	
	TRIBALLOY T 400	
Non Ferrous Material Grades	ALUMINIUM BRONZE	
	BRASS	
	GUN METALS	

IS 11166 (1993), CLASS 2 (Reference International Standard: VDG P690)
Permissible Deviations on Dimentions, Class 2

Nominal Dimensions of Rough casting		Over all Dimensions							
Over	Up to	Up to 6	Over 6 Up to 10	Over 10 Up to 18	Over 18 Up to 30	Over 30 Up to 80	Over 80 Up to 180	Over 180 Up to 300	Over 300 Up to 500
0	6	± 0.10	± 0.12	± 0.15	± 0.20	± 0.25	± 0.25	± 0.30	± 0.35
6	10	-	± 0.12	± 0.15	± 0.25	± 0.25	± 0.30	± 0.35	± 0.45
10	18	-	-	± 0.20	± 0.30	± 0.35	± 0.35	± 0.40	± 0.55
18	30	-	-	-	± 0.30	± 0.40	± 0.45	± 0.50	± 0.65
30	80	-	-	-	-	± 0.45	± 0.55	± 0.60	± 0.75
80	180	-	-	-	-	-	± 0.60	± 0.70	± 0.90
180	300	-	-	-	-	-	-	± 1.00	± 1.15
300	500	-	-	-	-	-	-	-	± 2.00

Permissible Deviation On Centre to Centre, Distance Between Holes, Bosses etc.

Nominal Dimension		Permissible Deviation
Over	Up to	Class 2
0	6	±0.125
6	10	±0.125
10	18	±0.15
18	30	±0.25
30	80	±0.35
80	180	±0.45
180	300	±0.70
300	500	±0.90

Permissible Machining Allowance

Nominal		Overall Dimensions (mm/face)							
Over	Up to	6	6-10	10-18	18-30	30-80	80-180	100-300	-
0	6	0.3	0.35	0.4	0.5	0.7	1	1	-
6	10	-	0.35	0.4	0.5	0.7	1.25	1.5	-
10	18	-	-	0.5	0.6	0.7	1.25	1.5	-
18	30	-	-	-	0.6	0.8	1.4	1.75	-
30	80	-	-	-	-	1	1.6	2	-
80	180	-	-	-	-	-	2	2.25	-
180	300	-	-	-	-	-	-	3	-

Permissible Deviations On Angles

Permissible Deviations On Specified Angles For Class 2 is ± 1°

Permissible Deviation On Surface Roughness

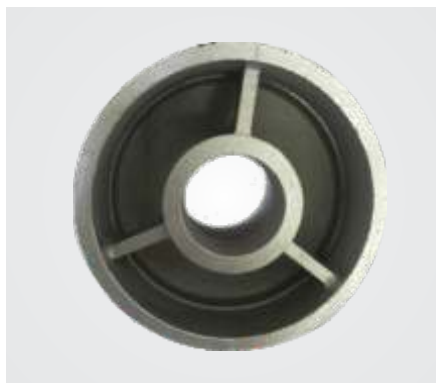
Surface Roughness Would Be Between 3.0 Ra to 6.0 Ra.

SINGLE PIECE CAST CAPABILITIES

Weight : Few grams to 65 Kgs.

Maximum Size : 350MM (Length) x 350MM (Width) Width x 400MM (Height).

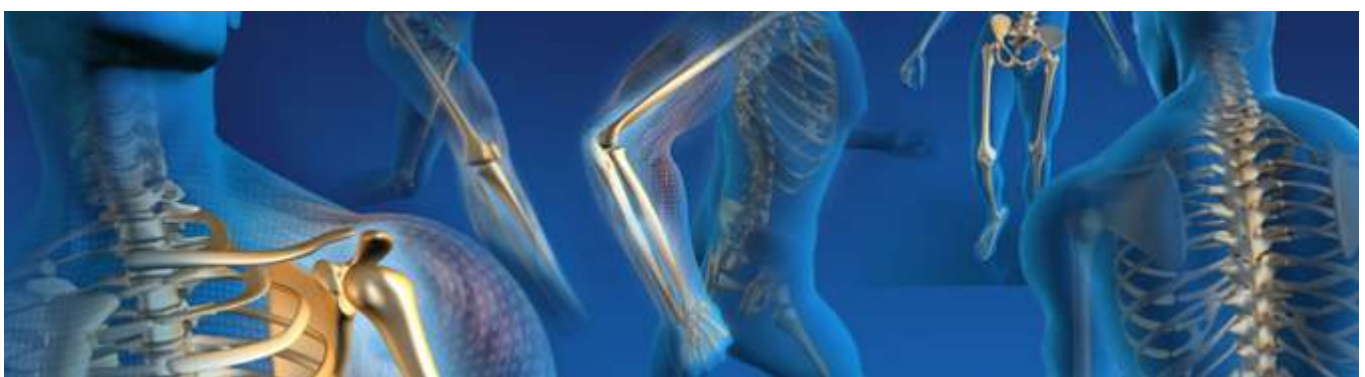
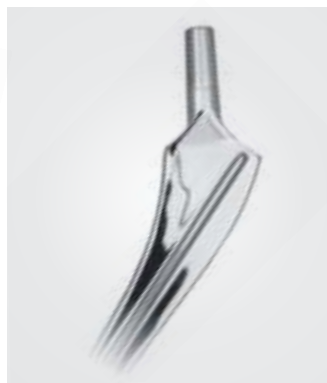
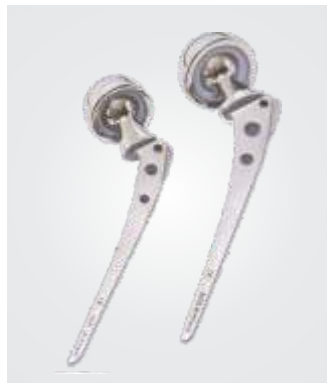
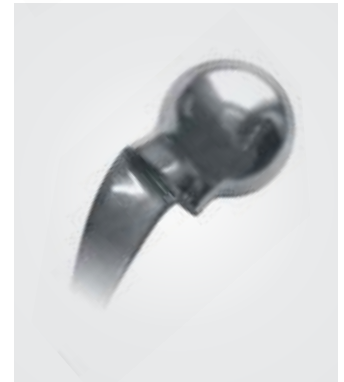
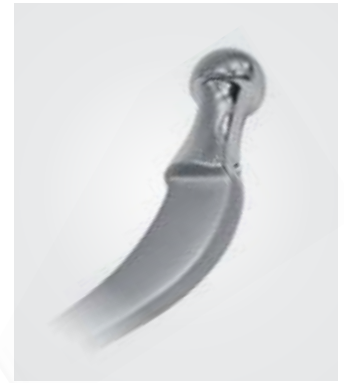
Pumps



Valves



Orthopadic



General Egg.





SIDDHI STEELS PVT. LTD.

(Investment Casting Division)

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