

H R STEEL INDUSTRIES PVT. LTD.

Plant, Machinery & Laboratory · Capability Sheet

Manufacturer of HSFG bolting assemblies, lock bolts & collars, axle cap screws, hex bolts, nuts and washers across two units at Sankrail Industrial Park, Howrah. RDSO, PGCIL, ISO 9001:2015 & NABL approved.

Unit I — Cold & Hot Nut Forging

Cold nut forging · hot forging (above M30) · tapping · trimming · thread rolling · spring washer · assembly

Cold Nut Forging

- 2x Sanshing multi-station nut forging — San Shing, Taiwan — M16 & M12
- 1x 1" Nut Former — National, USA — up to M30
- 1x M20 Heavy Nut Former — National, USA — M24
- 1x Nut Former S2 — National, Germany — M16
- 1x M20 Light Nut Forging — National, Germany — M24

Tapping & Thread Rolling

- 3x M16 Nut Tapping (China); MAS-33, MAS-20 & M12 tapping — Nutap, Germany; vertical hot-forging tapping up to M80
- Hydraulic roll thread up to M80 (4 machines: M80, M50, M50, M39)

Rod Cutting, Heating, Presses & Spring Washer

- Shearing (50 mm), band saws (200 mm), induction heating (80 & 50 mm)
- Hot forging presses: 2x China press 100 MT, friction press 200 MT, power presses 200/150/150 MT
- Copying, boring & facing, centre drill; spring-washer cutting, coiling & reducing up to M39

Unit II — Wire Processing, Bolt Forging, Heat Treatment & Coating

Wire processing · wire drawing · cold bolt forging · trimming · roll thread · heat treatment · surface coating

- Wire processing (acid pickling/phosphating); wire drawing M16–M44, M16–M35, to 28 mm, to 22 mm, M16 & 5.5–12 mm; 4x pointing to M50
- Cold bolt forging — Sakamura (Japan) M30, GB Header (UK) M24, National (England), 4x M16 & M20 formers, double-blow formers
- Trimming — M30, M24 (UK), 4x M16, M20, M12, M10
- Roll thread — M30, 2x M24, M20, 4x M16, M22, M16, M10
- Heat treatment — 2x shaker hearth, mesh-belt continuous, rotary & 3x pit furnaces (up to M30 / any dia)
- Surface coating — Hot Dip Galvanizing 25 MT/day · Zinc Electroplating 10 MT/day · Zinc Phosphate 15 MT/day

Physical & Chemical Laboratory — NABL (ISO/IEC 17025:2017)

- Universal Testing Machine — 40 Tonne; Impact tester; Cantilever testing fixture; Proof-load extension fixture
- Digital & analog Rockwell hardness testers; Spectrometer (Germany)
- Microscope with image analyser; surface grinding & polishing machines

Key Capacities

HSFG bolting	2,500 MT / annum
Hot dip galvanizing	25 MT / day
Zinc electroplating	10 MT / day
Zinc phosphate coating	15 MT / day

