Manufacturing Facility

- Foundry Shop
- CNC Machining
- Centerless Grinding
- Verticle Machining
- Work Shop
- Plateau Honing Machine

Centrifugal Casting
1. Company Name: Anand Enterprise Inc.
2. Establishment: 1980
3. Activity: Centrifugally Cast Cylinder Liners, Sleeves, Air Cooled Blocks, Valve Guides & Seats.
4. Employees: 260 (Group)
6. Facility: All in house facilities
   - Foundry shop
   - Machine shop
   - Inspection &
   - Packing div.
7. Group of Companies: Anand Enterprise
   - J.J. Metal Craft Pvt. Ltd.
   - J.J. Auto Components (I) Pvt. Ltd.
   - Akbari International.

**In House Facilities**

**Foundry Shop**
- Induction Furnaces
- Centrifugal Casting Machines
- Core Shutter & Shell Moulding

**Machine Shop**
- Vertical Machining Centre
- Vertical Boring Machine
- CNC Turning Centres
- SPM Turning Machines
- Centreless & Cylindrical Grinding Machine

**Quality Assurance Facilities**
- Spectrometer
- Material Analysis Lab installed with Spectrometer
- Compound Optical Microscope
  - C M M
  - Profile Projector
- Surface Roughness Tester
- Air Gaug
- Measuring Instruments

**Our Capabilities**

We offer more than 1500 types of the entire Range of Cylinder Liners, Sleeves, Air Cooled Blocks, Valve Guides & Seats for ranging varieties of:

- **CARS**: COMPACT, MID SIZE, LUXURY, SALOON & MPV
- **TRUCKS**: LIGHT, MEDIUM & HEAVY COMMERCIAL TRUCKS
- **TRACTORS**: HEAVY LOAD, LIGHT LOAD
- **ENGINES**: COMPRESSOR, MARINE & DIESEL

**PRODUCTION CAPACITY**
- **FOURUERY**: CENTRIFUGAL CASTING : 500 TON / MONTH
- **MACHINING**: LINERS & SLEEVES : 1,00,000 Pcs / MONTH

**PARAMETER**
- **INTERNAL DIAMETER**: 40 mm - 350 mm
- **OUTER DIAMETER**: 45 mm - 375 mm
- **LENGTH**: 65 mm - 600 mm

**CHEMICAL COMPOSITION**

<table>
<thead>
<tr>
<th>Element</th>
<th>Minimum</th>
<th>Maximum</th>
</tr>
</thead>
<tbody>
<tr>
<td>Carbon</td>
<td>3.00</td>
<td>3.60</td>
</tr>
<tr>
<td>Silicon</td>
<td>1.90</td>
<td>2.50</td>
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<tr>
<td>Phosphorus</td>
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<td>0.35</td>
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<tr>
<td>Sulphur</td>
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<td>0.15</td>
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<tr>
<td>Manganese</td>
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<td>1.00</td>
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<tr>
<td>Chromium</td>
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<td>0.60</td>
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<tr>
<td>Moly</td>
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<td>0.50</td>
</tr>
<tr>
<td>Copper</td>
<td></td>
<td>0.60</td>
</tr>
<tr>
<td>Nickel</td>
<td></td>
<td>0.50</td>
</tr>
</tbody>
</table>

**HARDNESS (BH) TENSILE STRENGTH MICRO STRUCTURE**
- **MINIMUM 210**
- **GRAPHITE TYPE**: "A" & "B" ("C" & "E" RACDON)
- **FLAKE SIZE**: 4-6
- **FREIE FERRITE**: LESS THAN 3%
- **MATRIX**: FINE LAMELLAR & SORBICITE PEARLITE

**SURFACE ROUGHNESS (R. PROFILE For Honing)**
- **Rz**: 0.4 To 0.8 micron
- **Rz**: 4 To 7 micron (DIN)
- **Vc**: A2 = 0.16 To 0.45
- **Ra**: 0.4 micron max
- **Rk**: 2 To 4 micron
- **Rk**: 1 To 2 micron
- **Rk**: 6 To 12 micron
- **Mr 1**: Less Than 10 %
- **Mr 2**: 70 To 85 %