

## Production Range

Type	Size	Length	Type of Thread		Standards			Grade					
			Full	Half	I.S.	B.S.	ANSI	4.6	5.6 5.8	6.8	8.8	10.9	12.9
HEX BOLTS	M6	30 to 60	✓	✓	✓	✓	-	✓	✓	✓	✓	✓	
"	M8	30 to 60	✓	✓	✓	✓	-	✓	✓	✓	✓	✓	
"	M10	35 to 80	✓	✓	✓	✓	-	✓	✓	✓	✓	✓	
"	M12	30 to 60	✓	✓	✓	✓	-	✓	✓	✓	✓	✓	
"	M16	35 to 150	✓	✓	✓	✓	-	✓	✓	✓	✓	✓	✓
"	M20	35 to 100	✓	✓	✓	✓	-	✓	✓	✓	✓	✓	✓
"	M24	40 to 100	✓	✓	✓	✓	-	✓	✓	✓	✓	✓	✓
"	M27	40 to 100	✓	✓	✓	✓	-	✓	✓	✓	✓	✓	✓
"	M30	40 to 100	✓	✓	✓	✓	-	✓	✓	✓	✓	✓	✓
"	Step Bolt M16	150 to 250	✓	✓	✓	✓	-	✓	✓	✓	✓		
"	Step Bolt M20	150 to 250	✓	✓	✓	✓	-	✓	✓	✓	✓		
"	Step Bolt M24	150 to 250	✓	✓	✓	✓	-	✓	✓	✓	✓		
Foundation Bolts	M30	100 to 3200		✓	5624		-	✓	✓	✓	✓		
"	M33	100 to 3200		✓	5624		-	✓	✓	✓	✓		
"	M36	100 to 3200		✓	5624		-	✓	✓	✓	✓		
"	M39	100 to 3200		✓	5624		-	✓	✓	✓	✓		
U Bolts	M12	100 TO 500			730		-	✓	✓		✓	✓	✓
"	M16	100 TO 500			730		-	✓	✓		✓	✓	✓
"	M20	100 TO 500			730		-	✓	✓		✓	✓	✓
Studs	M12	100 TO 2000			1862		-	✓	✓		✓	✓	✓
"	M16	100 TO 2000			1862		-	✓	✓		✓	✓	✓
"	M20	100 TO 2000			1862		-	✓	✓		✓	✓	✓
Plain Washer	M 12 TO M 39				2016		-	-	-		-	-	-
Spring Washer	M 12 TO M 39				3063		-	-	-		-	-	-

We also develop and manufacture fasteners as per customer specifications.



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Kadevi reserves the right to change without notice the specifications of the production range.

IS: 12427



ISO 9001-2008 & BS OHSAS 18001-2007  
 CERTIFIED COMPANY



## Fasteners Division



# Fasteners Division

## About Kadevi

Kadevi was established in 1964 and started as a small scale industry manufacturing of Communication Antennas and Pneumatic Telescopic Masts. Subsequently the company further expanded its wings into various manufacturing & service fields.

Kadevi has rapidly grown to a large scale industry just in 3 years and have received several awards and became pioneer in all fields. Today the company is having 1000 plus strong manpower.

### Manufacturing Divisions

- Towers & Galvanising
- Telescopic & Guyed Masts
- Antenna Systems
- Steel Rolling Mill
- Fasteners
- AC Generators
- DC Generators

### Service Divisions

- Transmission & Distribution
- Tower Installations
- EPC & TSP



Kadevi is having a rare combination of full scaled Infrastructure under one roof with state of art in house facilities right from manufacturing of steel sections, fabrication of towers & structures, Hot dip galvanising, Fasteners & Generators at Ankireddypally Plant. These facilities are fully equipped to ensure the highest level of quality and delivery timelines of customer.

## Fasteners Division

Our Fasteners division is equipped with expertise manpower at the related areas and having state of art complete automatic in house manufacturing facilities right from Coil drawing stage to Hot Dip Galvanisation. Our Fasteners are BIS certified as per IS 12427 : 2001

Our range of fasteners include hexagonal Bolts, Nuts, Studs, U-Bolts, F-bolts, Washers any other configurations as per customer specifications.

"Kadevi" Fasteners Divisions is equipped with:

- Four Stations of Bolt Making Machinery Consisting of Header Machine/Trimming/Thread Machine.
- Four Station of Nut forming Machine and Ten Nut Tapping Machines to manufacture M 8 to M 24 Nuts BSW 5/16" to 7/8" respectively.
- Two Galvanising Plants
- Two Sets of Automatic Bolts, Nuts assembly machines.
- In house workshop for tools making

## Production Process



### Wire Drawing Machine:-

The raw material received in the form of coils/rods are subjected for cleaning in HCL and Phosphating process. Subsequently the coils are fed into drawing machine and will be drawn to exact size required to ensure roundness of the coil rod.



### Nut Forming Machine :-

The required size of coil will be fed into the machine which are fully automatic and finished product of nuts (blank) are formed in 5 stage operation. The present production range is from M-8 to M-24 with four of stations machinery installed.



### Nut Tapping Machine :-

The nuts are tapped by automatic hopper nut tapping machines with double spindle for the most accurate and utmost quality threading. We have 10 Nut Tapping Stations.



**Bolt Header Machine :-**The required coil is fed into the fully automatic bolt head forming machine. The output is in the form of round head with required length of bolt. We are equipped with four stations of bolt making machines manufacturing different sizes from M8 to M24 & BSW 1/2" to 1".



### Bolt Trimming Machine >

The semi finished bolts received from the header are fed into this machine which converts the round head into hexagonal head and the length of the bolt is trimmed to required size. The bolts are automatically fed by a conveyor system.



### Bolt Thread Machine :-

The semi finished bolts received from the trimming are fed into this machine which forms threading (half/full). The bolts are automatically fed by a conveyor system.



### Galvanising Plant :-

The machined bolts & nuts are cleansed by a chemical process vide pickling, cleaning, fluxing and finally sent for pre-heat treatment. After chemical process bolts & nuts are dipped into the galvanising kettle at well maintained temperature of 450 c. Our Hot Dip Galvanising Plant is a state of art plant conforming to IS Specification.



**Assembly Machine:-**The galvanized bolts & nuts are fed into the assembly machine separately through conveyor system which automatically assembles the nuts to the bolts to a prescribe length to ensure that proper mating of the bolts & nuts.



**Packing:-**We pack our bolts & nuts in a standard pack of 50 kgs in double lined gunny bags with poly propylene exclusively developed. These bags are very robust in construction and every bag is filled 50 kgs of fasteners duly assembled with a electronic weighing machine.

### High Tensile Bolts & Nuts :-

Kadevi High Tensile Bolts & Nuts 8.8 or other grades are manufactured out of High Tensile Steel (EN-8, EN-8D, EN-15, 18, 19) as per customer's specifications. Bolts & Nuts manufactured out of above material will undergo Heat treatment which is a very critical process for quality products. The basic process of hardening by heat treatment consists of heating the fasteners to a temperature of 900° C and then quenching in oil. Such hardening or Blackened as per customer's specification.

## Quality Assurance

Our strong focus on manufacturing process and quality assurance enables us to supply high quality material and deliver cost effective solution. Our manufacturing practice has been technology driven and to stay at the fore front of innovation, we continuously invest in Research and Development. Our quality management system ensures high level of quality by inspection of incoming material and mandatory quality checks at every stage throughout the manufacturing process. Our highly equipped quality and testing facility enables us to deliver superior quality products conforming to Indian/International standards and achieve total customer satisfaction.

### In process Inspection:

Online testing will be carried out at every stage with suitable jigs & gauges to ensure the required specifications as defined in the standards.

### Final Inspection:

Final inspection check is carried out to ensure that Product Quality is in conformance with specified requirements.

Inspection and Test Reports / Records are maintained to establish that the product has passed inspection and testing in accordance criteria defined in the Inspection and Testing Procedures. Records are maintained for calibration and verification of monitoring and measuring equipments. We are ISO 9001-2008 certified for well maintained Quality Management Systems by NQA-UKAS.

Kadevi test equipment include;

1. Emission Spectrometer for material analysis
2. Universal Testing Machine for Tensile / Compression / Shear Tests
3. Hardness Testing machine for Checking Hardness (Brinell & Rockwell)
4. Profile Projector - for measuring the thread profiles / contours etc.,
5. Other measuring Instrument, Gauges etc. to confirm to Specification & Drawings

