

# **H-TURN** Series

Horizontal Machining Centres



CHT 2000SY-Y | CHT 2500SY-Y | CHT 3000SY-Y | CHT 3500SY-Y | CHT 4000Y | CHT 5000Y



### **12-Station (24 Position) BMT Turret**

*BMT Turret is equipped with 2 separated motors for indexing and milling, ensuring high machining performance, reliability and reducing processing time of workpiece.*



### **Sub Spindle (SY Models)**

*Equipped with built-in motor and oil cooling unit as standard to minimise thermal displacement and ensure maximum machining accuracy even during a long period of machining.*



### **Main Spindle**

*Spindle Cartridge is designed to expose to air in all directions dissipating heat generated by axis movements, maintaining minimal thermal expansion.*



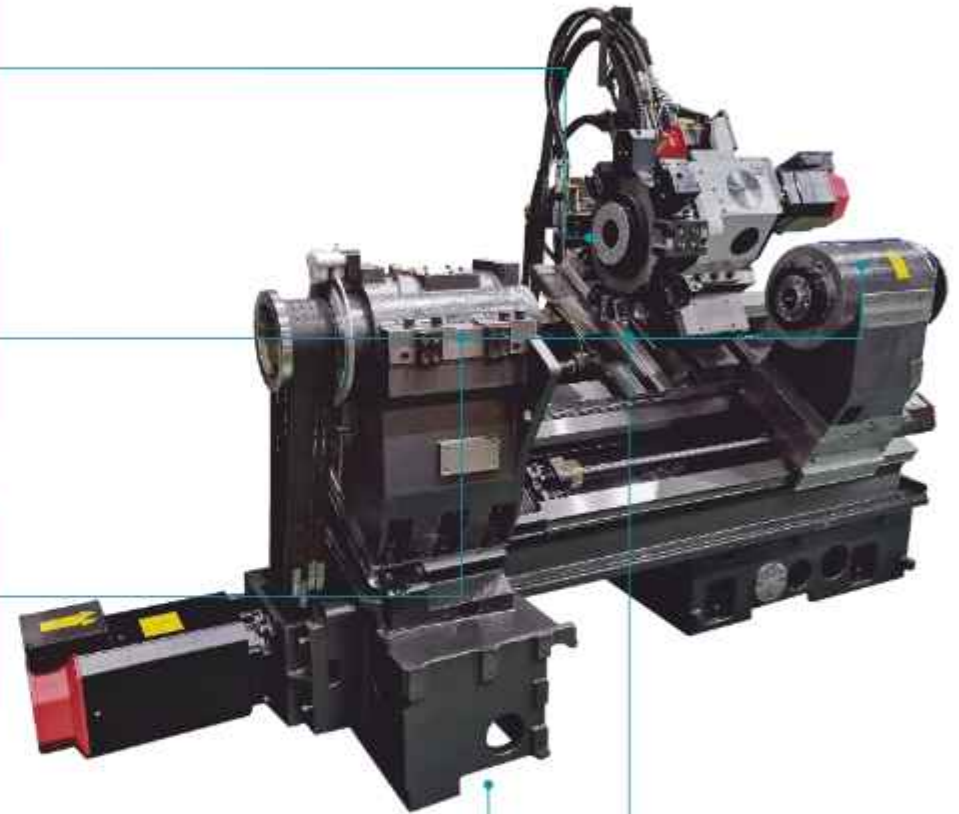
### **Servo Tailstock (Y Models)**

*Servo Tailstock, available as a standard feature for Y models, offers better machining efficiency and reduces set-up time.*



### **Rigid 30 Degree Slant Bed**

*One-piece casting 30 degree slant torque tube design bed which provides maximum vibration dampening and improves machining stability during heavy duty cutting.*



### **Main and Sub Spindle Synchronisation**

*Provides maximum machining flexibility for varieties of workpiece configuration. From simple machining to multi-axis simultaneous machining, all operations can be completed in one set-up.*



# Y-axis Machining Capability

Y-axis allows side milling, off-center drilling and grooving. This results in better machining accuracy and also enables more complex shape machining capability compared to conventional 2<sup>nd</sup> and 3<sup>rd</sup> axis turning centre.

The simultaneous operation of the X-axis and the

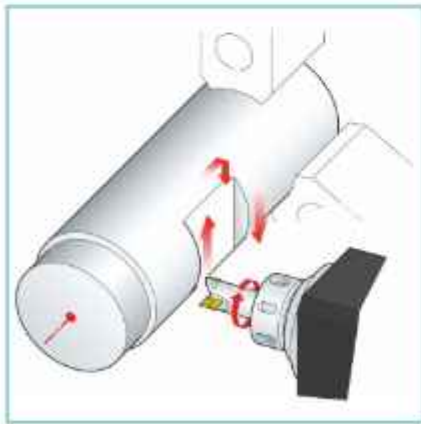
## Y-axis Travel

110 (±55) mm [4.33 (±2.17) inch]

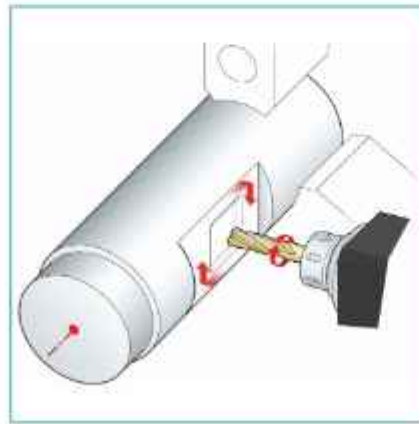
## Y-axis Rapid Traverse

10 m/min [394 ipm]

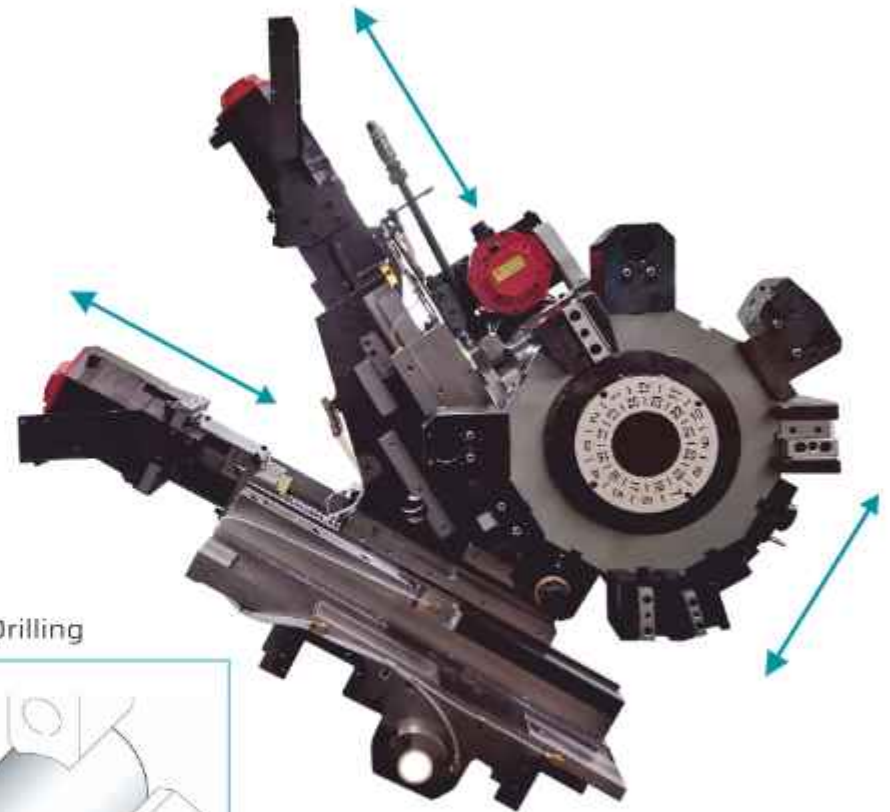
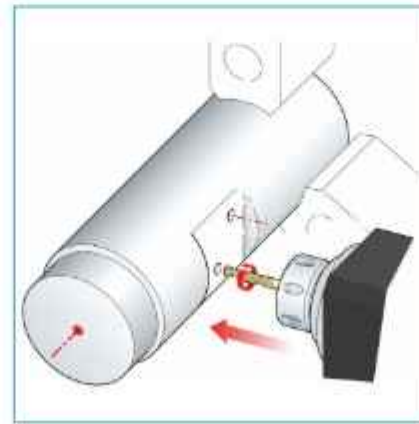
### • Side Milling



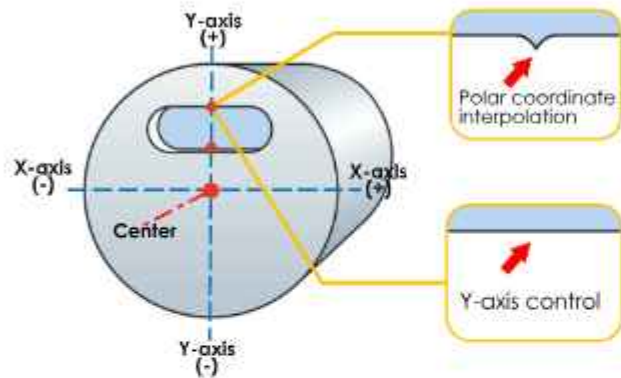
### • Off-center Grooving



### • Off-center Drilling

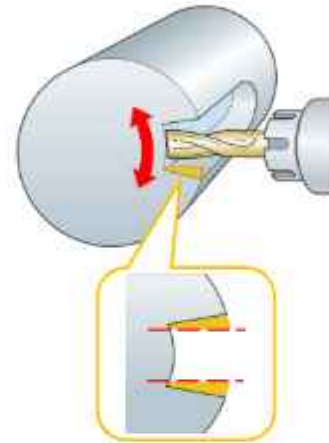


## ***Y-axis Control Compared to Polar Coordinate Interpolation***



*Polar coordinate interpolation control during grooving and contouring, the X-axis reverses at cross point between the centre line and the profile to be machined which cause change in cutting condition and affect profile accuracy. Machining with Y-axis control can avoid such issue and also provide better profile accuracy.*

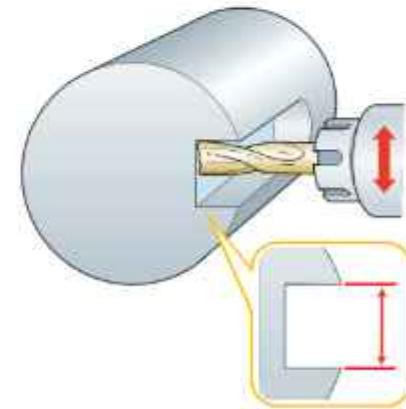
## ***Milling without Y-axis Control***



*Width of outer and inner grooves are not perfectly parallel.*

## ***Milling without Y-axis Control***

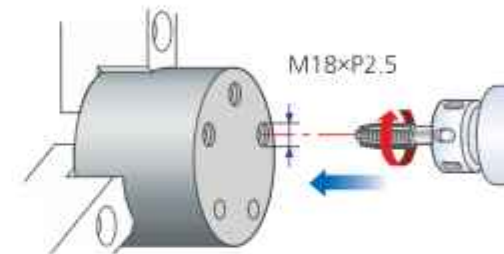
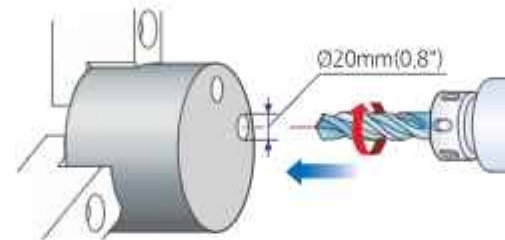
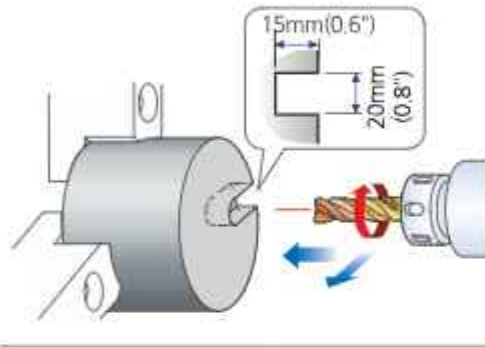
*Width of grooves are perfectly parallel.*



# Cutting Performance

End Mill <Ø20mm (0.8") High-speed Steel> Drill <Ø20mm (0.8") High-speed Steel>

Tap <N18xP2.5>



| Machine Type              | CHT 2500              |
|---------------------------|-----------------------|
| Material <JIS>            | S45C                  |
| Rotary Tool Spindle Speed | 320 min <sup>-1</sup> |
| Depth of Cut              | 15 mm (0.6 inch)      |
| Cutting Speed             | 20 m/min (65.6 fpm)   |
| Feedrate                  | 65 mm/min (2.5 ipm)   |

| Machine Type              | CHT 2500              |
|---------------------------|-----------------------|
| Material <JIS>            | S45C                  |
| Rotary Tool Spindle Speed | 391 min <sup>-1</sup> |
| Cutting Speed             | 25 m/min (82.0 fpm)   |
| Feedrate                  | 105 mm/min (4.1 ipm)  |

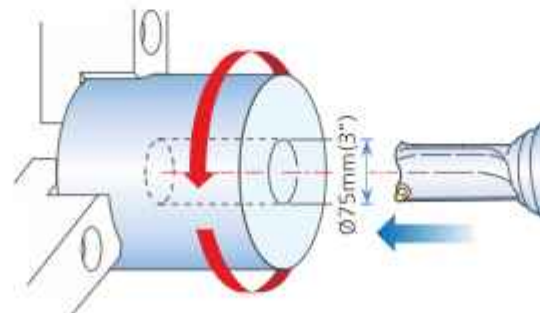
| Machine Type              | CHT 2500              |
|---------------------------|-----------------------|
| Material <JIS>            | S45C                  |
| Rotary Tool Spindle Speed | 367 min <sup>-1</sup> |
| Cutting Speed             | 10 m/min (32.8 fpm)   |
| Feedrate                  | 400 mm/min (15.7 ipm) |

Heavy-duty Cutting <Ø.D.>



| Machine Type   | CHT 2500               |
|----------------|------------------------|
| Material <JIS> | S45C                   |
| Spindle Speed  | 367 min <sup>-1</sup>  |
| Depth Of Cut   | 8 mm (0.312 inch)      |
| Cutting Speed  | 152 m/min (500 fpm)    |
| Feedrate       | 0.5 mm/rev (0.020 ipr) |

Insert Drill



| Machine type   | CHT 2500                |
|----------------|-------------------------|
| Material <JIS> | S45C                    |
| Spindle Speed  | 417 min <sup>-1</sup>   |
| Drill Diameter | 75 mm (3 inch)          |
| Feedrate       | 0.15 mm/rev (0.006 ipr) |

# CHT 2000SY-Y / 2500SY-Y / 3000SY-Y

| Specifications             |                                | Units        | CHT 2000ASY<br>[CHT 2000BSY]        | CHT 2000AY<br>[CHT 2000BY]                  | CHT 2500SY<br>[CHT 3000SY] | CHT 2500Y<br>[CHT 3000Y] |                        |
|----------------------------|--------------------------------|--------------|-------------------------------------|---|----------------------------|--------------------------|------------------------|
| <b>CAPACITY</b>            | Swing Over the Bed             | mm (inch)    | 810 (31.89)                         |   |                            |                          |                        |
|                            | Swing Over the Cross Slide     | mm (inch)    | 720 (28.35)                         |   |                            |                          |                        |
|                            | Max. Machining Diameter        | mm (inch)    | 411 (16.18)                         |   | 394 (15.51)                |                          |                        |
|                            | Max. Machining Length          | mm (inch)    | 750(29.53) [735(28.94)]             | 726.5(28.6) [711.5(28.01)]                  | 713(28.07) [700(27.56)]    | 690(27.17) [730(28.74)]  |                        |
| <b>MAIN SPINDLE</b>        | Chuck Size                     | inch         | 6 [8]                               |   | 10 [12]                    |                          |                        |
|                            | Bar Working Dia.               | mm (inch)    | 51(2) [65(2.56)]                    |   | 81(3.19) [102(4.02)]       |                          |                        |
|                            | Spindle Speed                  | rpm          | 6,000 [4,500]                       |   | 4,000 [2,800]              |                          |                        |
|                            | Spindle Motor (Cont./Max.)     | kW (Hp)      | 11/18.5 (15/25) [15/18.5(20/25)]    |   | 18.5/26(25/35)             |                          |                        |
|                            | Spindle Nose                   | ASA          | A2-5 [A2-6]                         |   | A2-8 [A2-11]               |                          |                        |
|                            | Spindle Torque (Max.)          | N.m (ft.lbs) | 157 (115.8) [376(277.3)]            |   | 647.4(477.5) [1,124(830)]  |                          |                        |
|                            | Spindle Through Hole Dia.      | mm (inch)    | 61 (2.4) [76(2.99)]                 |   | 91(3.58) [115(4.53)]       |                          |                        |
|                            | <b>SUB SPINDLE</b>             | Chuck Size   | inch                                | 6 [8]                                       | -                          | 8                        | -                      |
| Bar Working Dia.           |                                | mm (inch)    | 51(2)                               | -   | 51(2)                      | -                        |                        |
| Spindle Speed              |                                | rpm          | 6,000 [5,000]                       | -   | 5,000                      | -                        |                        |
| Spindle Motor (Cont./Max.) |                                | kW (Hp)      | 11/15 (15/20)                       | -   | 11/15 (15/20)              | -                        |                        |
| Spindle Nose               |                                | ASA          | A2-5 [A2-6]                         | -   | A2-6                       | -                        |                        |
| Spindle Torque (Max.)      |                                | N.m (ft.lbs) | 135 (99.6)                          | -   | 135 (99.6)                 | -                        |                        |
| Spindle Through Hole Dia.  |                                | mm (inch)    | 62 (2.44)                           | -   | 62 (2.44)                  | -                        |                        |
| <b>TRAVEL</b>              | Rapid Traverse (X/Z/Y/B)       | m/min (ipm)  | 30/30/10/30 (1,181/1,181/394/1,181) |   |                            |                          |                        |
|                            | Travel                         | X/Z          | mm (inch)                           | 239/830(9.41/32.68)                         | 239/830 (9.41/32.68)       | 248.5/830 (9.78/32.68)   | 248.5/830 (9.78/32.68) |
|                            |                                | Y/B          | mm (inch)                           | 110/790(4.33/31.1)<br>[110/760(4.33/29.92)] | 110/830 (4.33/32.68)<br>25 | 110/760 (4.33/29.92)     | 110/830 (4.33/32.68)   |
|                            | Feed Motor (X/Z/Y/B)           | kW (hp)      | 3/3/1.8/3 (4/4/2.4/4)               |   |                            |                          |                        |
| <b>TURRET</b>              | Number of Tool Stations        | st.          | 12 (24)                             |   |                            |                          |                        |
|                            | DD Tool Size                   | mm (inch)    |                                     |   |                            |                          |                        |
|                            | Max. Boring Bar Size           | mm (inch)    | Ø40 (1.5)                           |   | Ø50 (2)                    |                          |                        |
|                            | Indexing Time                  | sec          | 0.15/Step                           |   |                            |                          |                        |
|                            | Milling Tool Holder Type       | -            | BMT55                               |   | BMT65                      |                          |                        |
|                            | Max. Rotary Tool Spindle Speed | rpm          | 5,000                               |   |                            |                          |                        |
|                            | Rotary Tool Motor Power        | kW (hp)      | 3.7/5.5 (5/7.4)                     |   | 3.7/5.5/7.5 (5/7.4/10)     |                          |                        |

| Specifications               |                            | Units     | CHT 2000ASY<br>[CHT 2000BSY]     | CHT 2000AY<br>[CHT 2000BY]       | CHT 2500SY<br>[CHT 3000SY]       | CHT 2500Y<br>[CHT 3000Y]         |
|------------------------------|----------------------------|-----------|----------------------------------|----------------------------------|----------------------------------|----------------------------------|
| <b>TAILSTOCK</b>             | Tailstock Travel           | mm (inch) | -                                | 830 (32.68)                      | -                                | 830 (32.68)                      |
|                              | Taper of Tailstock Spindle | -         | -                                | MT#5 Live Centre                 | -                                | MT#5 Live Center                 |
| <b>BED TYPE</b>              |                            |           | 30° Slant                        |                                  |                                  |                                  |
| <b>ELECTRIC POWER SUPPLY</b> |                            | kVA       | 40                               |                                  | 45                               |                                  |
| <b>REQUIRED FLOOR SPACE</b>  |                            | mm (inch) | 3,570x1,818 (140.55x71.57)       |                                  | 3,790x1,818 (149.21x71.57)       |                                  |
| <b>MACHINE WEIGHT</b>        |                            | kg (lbs)  | 5,700(12,566)<br>[5,800(12,787)] | 5,600(12,345)<br>[5,700(12,566)] | 6,100(13,448)<br>[6,200(13,669)] | 6,000(13,228)<br>[6,100(13,448)] |
| <b>CONTROLLER</b>            |                            |           | Fanuc Oi-TF                      |                                  |                                  |                                  |

- Figures in inches are converted from metric measurements.
- Design and specifications are subject to change without notice.

#### Standard Accessories

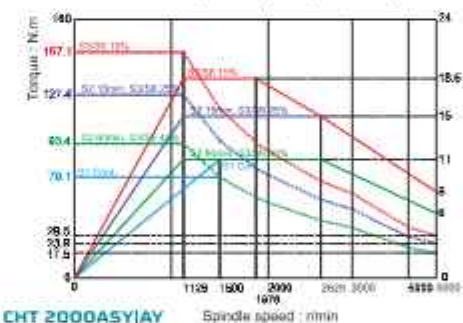
- Coolant Unit 20bar (290PSI)
- Work Light (LED lamp)
- Splash Guard with Side Coolant Tank
- Tool/Work Box
- Hyd. Hollow Chuck
- Levelling Blocks
- Chuck Clamp Foot Switch
- Chuck Clamp Confirmation
- Manual/Part List
- Door Interlock

#### Optional Accessories

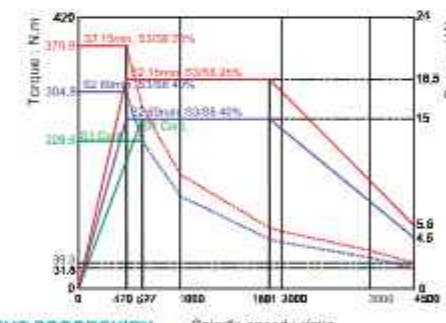
- Chip Conveyor
- Dual Pressure Chucking
- Auto Door
- Oil Skimmer
- Main Part Catcher
- Sub Part Catcher with Internal Part Conveyor (only SY Model)
- Work Ejector (only SY Model)
- Air Blower
- Coolant Gun
- Tool Presetter

Note: Specifications and features are subject to change without prior notice. Please refer to the offer document, as it has precedence.

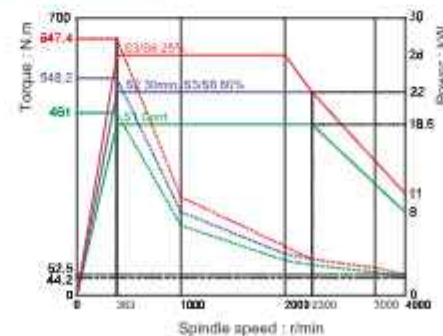
6" - 12" Chuck / A2-5, A2-6, A2-8, A2-11 Spindle Nose



CHT 2000ASY|AY



CHT 2000BSY|BY



CHT 2500SY|Y

# CHT 3500SY-Y 12" - 15" Chuck / A2-11 Spindle

| Specifications      |                                |     | Units        | CHT 3500Y<br>[CHT 3500XLY]                          | CHT 3500BY<br>[CHT 3500BXY]  | CHT 3500SY                         | CHT 3500BSY      |
|---------------------|--------------------------------|-----|--------------|---|------------------------------|------------------------------------|------------------|
| <b>CAPACITY</b>     | Swing Over the Bed             |     | mm (inch)    | 987(38.86)  |                              |                                    |                  |
|                     | Swing Over the Cross Slide     |     | mm (inch)    | 852(33.54)  |                              |                                    |                  |
|                     | Max. Machining Diameter        |     | mm (inch)    | 430(16.93)  |                              |                                    |                  |
|                     | Max. Machining Length          |     | mm (inch)    | 1,500(59.06) [3,000(118.11)]                        | 1,470(57.87) [2,970(116.93)] | 1,500(59.06)                       | 1,470(57.87)     |
| <b>MAIN SPINDLE</b> | Chuck Size                     |     | inch         | 12  | 15                           | 12                                 | 15               |
|                     | Bar Working Dia.               |     | mm (inch)    | 102(4.02)   | 116.5(4.59)                  | 102(4.02)                          | 116.5(4.59)      |
|                     | Spindle Speed                  |     | rpm          | 2,800   | 2,000                        | 2,800                              | 2,000            |
|                     | Spindle Motor (Cont./Max.)     |     | kW (Hp)      | 18.5/26(25/35)                                      | 22/30(30/40)                 | 18.5/26(25/35)                     | 22/30(30/40)     |
|                     | Spindle Nose                   |     | ASA          | A2-11   |                              |                                    |                  |
|                     | Spindle Torque (Max.)          |     | N.m (ft.lbs) | 1,124.4(829)  | 1,612.1(1,188.6)             | 1,124.4(829)                       | 1,612.1(1,188.6) |
|                     | Spindle through Hole Dia.      |     | mm (inch)    | 115(4.53)   | 132(5.2)                     | 115(4.53)                          | 132(5.2)         |
| <b>SUB SPINDLE</b>  | Chuck Size                     |     | inch         | -   | -                            | 10                                 | -                |
|                     | Bar Working Dia.               |     | mm (inch)    | -   | -                            | 81(3.19)                           | -                |
|                     | Spindle Speed                  |     | rpm          | -   | -                            | 4,000                              | -                |
|                     | Spindle Motor (Cont./Max.)     |     | kW (Hp)      | -   | -                            | 15/22(20/30)                       | -                |
|                     | Spindle Nose                   |     | ASA          | -   | -                            | A2-8                               | -                |
|                     | Spindle Torque (Max.)          |     | N.m (ft.lbs) | -   | -                            | 599.1(441.7)                       | -                |
|                     | Spindle through Hole Dia.      |     | mm (inch)    | -   | -                            | 91(3.58)                           | -                |
| <b>TRAVEL</b>       | Rapid Traverse (X/Z/Y/B)       |     | m/min (ipm)  | 30/30/10(1,181/1,181/394)                           |                              | 30/30/10/30(1,181/1,181/394/1,181) |                  |
|                     | Travel                         | X/Z | mm (inch)    | 295/1,570(11.61/61.81)<br>[295/3,065(11.61/120.67)] |                              | 295/1,570(11.61/61.81)             |                  |
|                     |                                | Y/B | mm (inch)    | 130/-(-5.12/-)                                      |                              | 130/1,570(5.12/61.81)              |                  |
|                     | Feed Motor (X/Z/Y/B)           |     | kW (hp)      | 4/7/4/-(5.4/9.4/5.4/-)                              |                              | 4/7/4/3(5.4/9.4/5.4/4)             |                  |
| <b>TURRET</b>       | Number of Tool Stations        |     | st.          | 12(24)  |                              |                                    |                  |
|                     | OD Tool Size                   |     | mm (inch)    | Ø50(2)  |                              |                                    |                  |
|                     | Max. Boring Bar Size           |     | mm (inch)    | Ø50(2)  |                              |                                    |                  |
|                     | Indexing Time                  |     | sec          | 0.25/Step   |                              |                                    |                  |
|                     | Milling Tool Holder Type       |     | -            | BMT65   |                              |                                    |                  |
|                     | Max. Rotary Tool Spindle Speed |     | rpm          | 5,000   |                              |                                    |                  |
|                     | Rotary Tool Motor Power        |     | kW (hp)      | 7.5/11(10/14.8)                                     |                              |                                    |                  |



| Specifications               |                            | Units     | CHT 3500Y<br>[CHT 3500XLY]                             | CHT 3500BY<br>[CHT 3500BXY]        | CHT 3500SY               | CHT 3500BSY    |
|------------------------------|----------------------------|-----------|--|------------------------------------|--------------------------|----------------|
| <b>TAILSTOCK</b>             | Tailstock Travel           | mm (inch) | 1,450(57.1) [2,950(116.14)]                            |                                    |                          | -              |
|                              | Quill Diameter             | mm (inch) | 140(5.51)  |                                    |                          | -              |
|                              | Quill Travel               | mm (inch) | 120(4.72)  |                                    |                          | -              |
|                              | Taper of Tailstock Spindle |           | MT#5 (Built-in)  |                                    |                          | -              |
| <b>BED TYPE</b>              |                            |           | 30° Slant  |                                    |                          |                |
| <b>ELECTRIC POWER SUPPLY</b> |                            | kVA       | 45   | 55                                 | 65                       | 65             |
| <b>REQUIRED FLOOR SPACE</b>  |                            | mm (inch) | 5,000x2,300 (196.9x90.6)<br>[6,522x2,300 (256.7x90.6)] |                                    | 5,000x2,300 (196.9x90.6) |                |
| <b>MACHINE WEIGHT</b>        |                            | kg (lbs)  | 9,000 (19,842)<br>[11,100(24,471)]                     | 9,300 (20,503)<br>[11,400(25,133)] | 9,400 (19,842)           | 9,700 (21,385) |
| <b>CONTROLLER</b>            |                            |           | Fanuc Oi-TF  |                                    |                          |                |

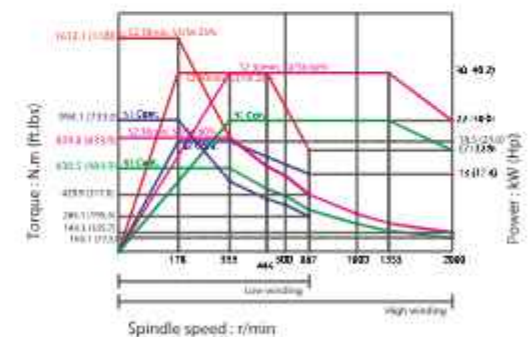
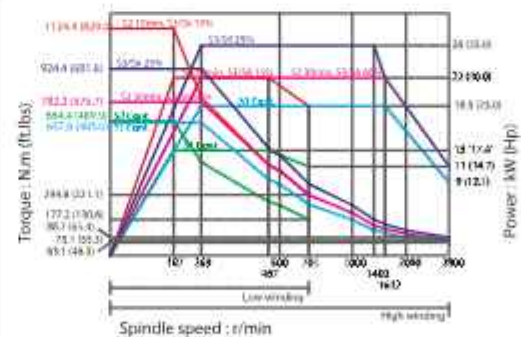
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#### Standard Accessories

- Coolant Unit 10bar (140PSI)
- Work Light (LED lamp)
- Splash Guard with Side Coolant Tank
- Tool/Work Box
- Hyd. Hollow Chuck
- Levelling Blocks
- Chuck Clamp Foot Switch
- Chuck Clamp Confirmation
- Manual/Part List
- Door Interlock
- Tailstock in-out Foot Switch

#### Optional Accessories

- Chip Conveyor
- Dual Pressure Chucking
- Auto Door
- Oil Skimmer
- Steady Rest Prep (only Y Model)
- Air Blower
- Coolant Gun
- Tool Presetter



Note: Specifications and features are subject to change without prior notice. Please refer to the offer document, as it has precedence.

# CHT 4000Y / 5000Y 18", 21" Chuck / A2-11, A2-15 Spindle Nose

| Specifications   |                                | Units        | CHT 4000LY                      | CHT 5000LY    |
|------------------|--------------------------------|--------------|---------------------------------|---------------|
| <b>CAPACITY</b>  | Swing Over the Bed             | mm (inch)    | 900 (35.43)                     |               |
|                  | Swing Over the Cross Slide     | mm (inch)    | 850 (33.46)                     |               |
|                  | Max. Machining Diameter        | mm (inch)    | 550 (21.65)                     |               |
|                  | Max. Machining Length          | mm (inch)    | 2,017 (79.41)                   | 1,992 (78.43) |
|                  | Chuck Size                     | inch         | 18                              | 21            |
|                  | Bar Working Dia.               | mm (inch)    | 116.5 (4.59)                    | 165.5(6.52)   |
| <b>SPINDLE</b>   | Spindle Speed                  | rpm          | 2,000                           | 1,500         |
|                  | Spindle Motor (Cont./Max.)     | kW (Hp)      | 30/45(40/60)                    |               |
|                  | Spindle Nose                   | ASA          | A2-11                           | A2-15         |
|                  | Spindle Torque (Max.)          | N.m (ft.lbs) | 2,687 (1,981)                   | 3,105 (2,289) |
|                  | Spindle through Hole Dia.      | mm (inch)    | 132 (5.2)                       | 181 (7.13)    |
| <b>TRAVEL</b>    | Rapid Traverse (X/Z/Y)         | m/min (ipm)  | 16/20/10(630/787/394)           |               |
|                  | Travel (X/Z/Y)                 | mm (inch)    | 300/2,155/150(11.81/84.84/5.91) |               |
|                  | Feed Motor (X/Z/Y)             | kW (hp)      | 7/6/7(9.4/8/9.4)                |               |
| <b>TURRET</b>    | Number of Tool Stations        | st.          | 12                              |               |
|                  | OD Tool Size                   | mm (inch)    | 32(1.25)                        |               |
|                  | Max. Boring Bar Size           | mm (inch)    | Ø60(2.5)                        |               |
|                  | Indexing Time                  | sec          | 0.25/step                       |               |
|                  | Milling Tool Holder Type       | -            | BMT75                           |               |
|                  | Max. Rotary Tool Spindle Speed | rpm          | 4,000                           |               |
|                  | Rotary Tool Motor Power        | kW (hp)      | 7.5/11/15<br>(10/14.8/20.1)     |               |
| <b>TAILSTOCK</b> | Tailstock Travel               | mm (inch)    | 2,077(81.77)                    |               |
|                  | Quill Diameter                 | mm (inch)    | 140(5.51)                       |               |
|                  | Quill Travel                   | mm (inch)    | 120(4.72)                       |               |
|                  | Taper of Tailstock Spindle     |              | MT#5 (Built-in)                 |               |

| Specifications               | Units     | CHT 4000LY              | CHT 5000LY     |
|------------------------------|-----------|-------------------------|----------------|
| <b>BED TYPE</b>              |           | 45° Slant               |                |
| <b>ELECTRIC POWER SUPPLY</b> | kVA       | 60                      |                |
| <b>REQUIRED FLOOR SPACE</b>  | mm (inch) | 5,720x2,340(225.2x92.1) |                |
| <b>MACHINE WEIGHT</b>        | kg (lbs)  | 14,800(32,628)          | 15,000(33,069) |
| <b>CONTROLLER</b>            |           | Fanuc Oi-TF             |                |

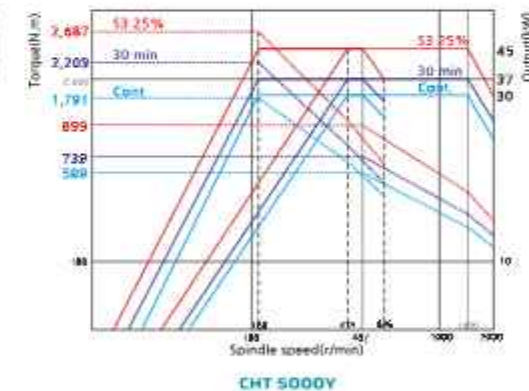
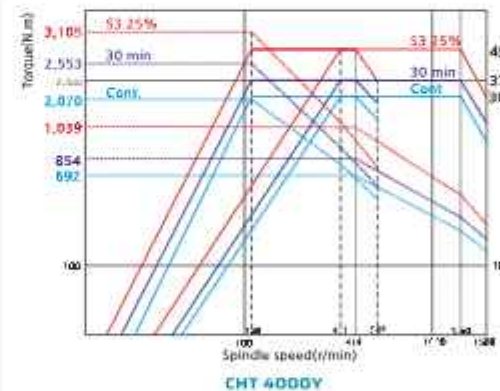
- Figures in inches are converted from metric measurements.
- Design and specifications are subject to change without notice.

#### Standard Accessories

- Coolant Unit 10bar (140PSI)
- Work Light (LED lamp)
- Splash Guard with Side Coolant Tank
- Tool/Work Box
- Hyd. Hollow Chuck
- Levelling Blocks
- Chuck Clamp Foot Switch
- Chuck Clamp Confirmation
- Manual/Part List
- Door Interlock
- Tailstock in-out Foot Switch

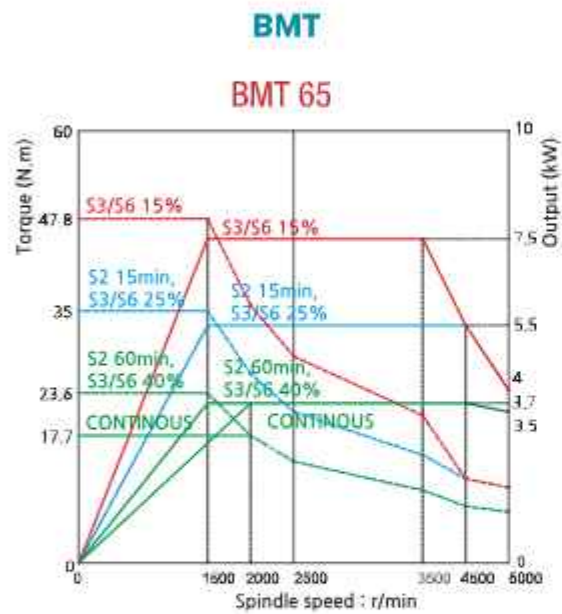
#### Optional Accessories

- Chip Conveyor
- Dual Pressure Chucking
- Auto Door
- Coolant Gun
- Tool Presetter
- Oil Skimmer
- Steady Rest Prep

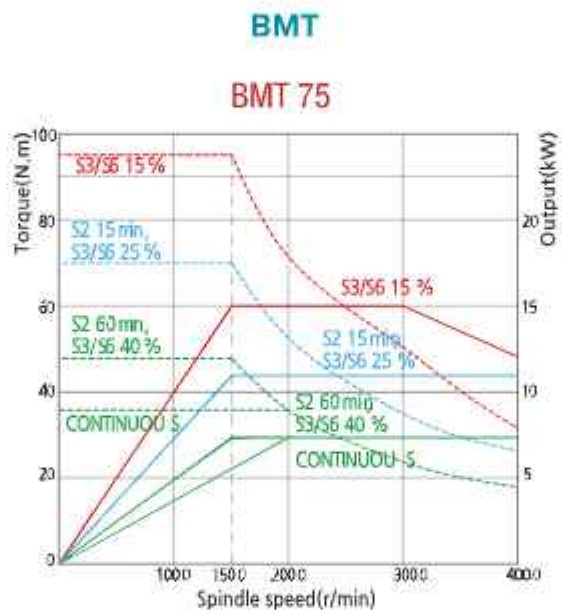


Note: Specifications and features are subject to change without prior notice. Please refer to the offer document, as it has precedence.

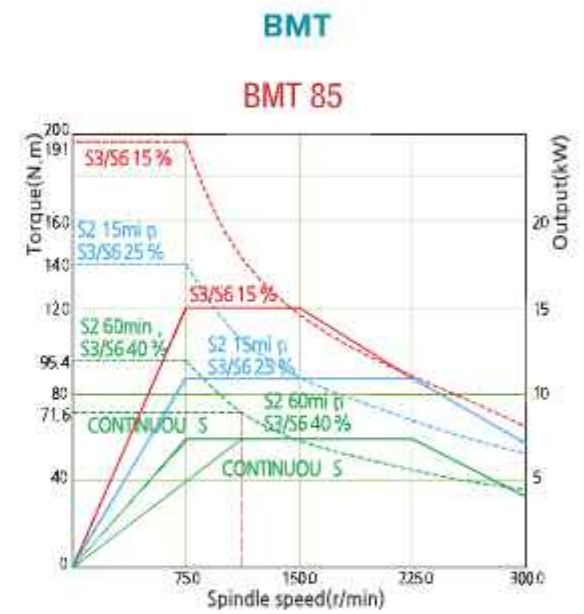
# Rotary Tool Spindle Output Diagram



Spindle Speed (r/min)  
CHT 2500 | CHT 3000



Spindle Speed (r/min)  
CHT 4000 | CHT 5000



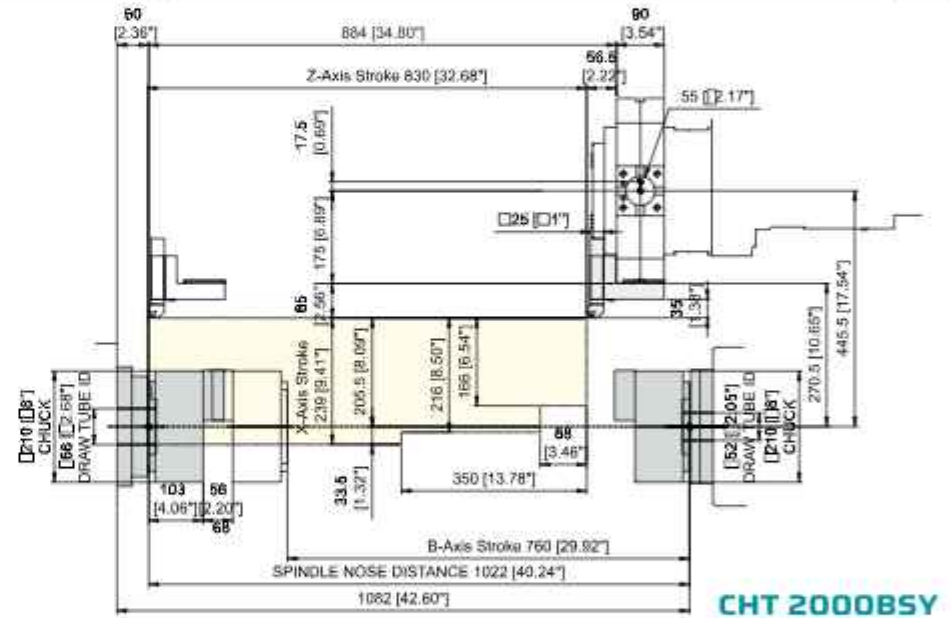
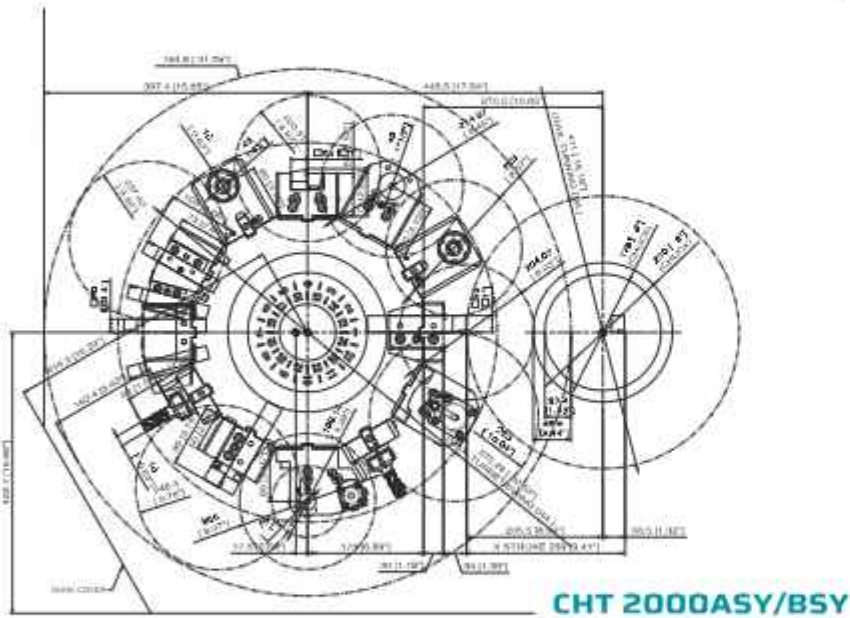
Spindle Speed (r/min)  
CHT 6000

# Turret Interference & Work Range

Turret Head Interference

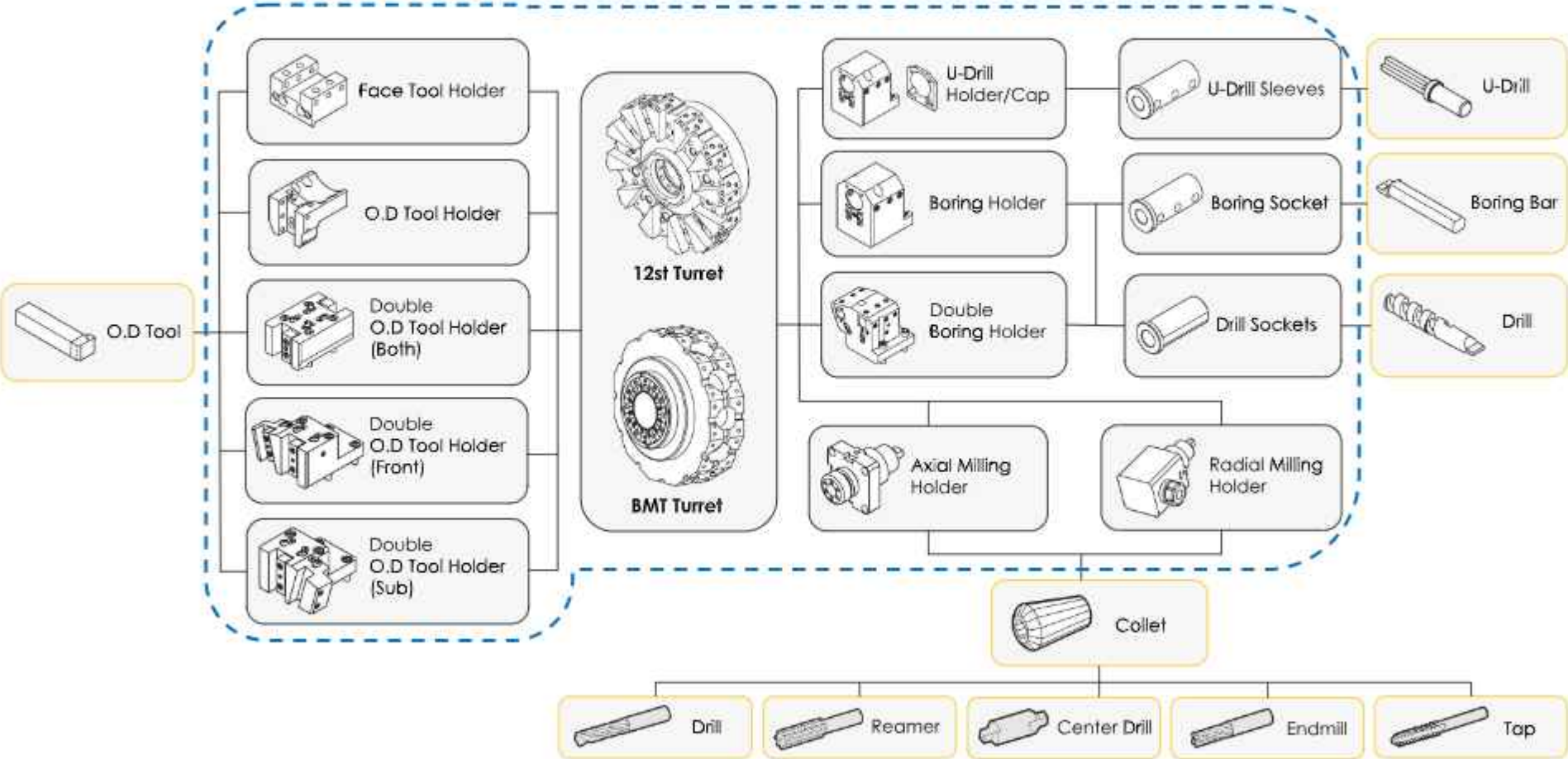
Unit: mm (inch) Work Range

Unit: mm (inch)





# Tooling System





**Corporate Office**

Cosmos House, Plot No. 85/2, Padra Road, Atladara, Vadodara, Gujarat - 390 012

**Manufacturing Facilities**

**Plant - I**

Cosmos Impex India Pvt. Ltd., Plot No. 847, 848 Village Ranu, Ta. Padra, Vadodara, Gujarat - 391 445

**Plant - II**

Plot No. 68-B, Sigil Compound, Padra Road, Atladara, Vadodara, Gujarat - 390 012

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