

# **A STUDY ON INNOFORGE PRIVATE LIMITED, HOSUR**

**Report on Internship Training submitted to Periyar University, Salem  
In partial fulfilment of the requirement for the award of the degree of**

## **BACHELOR OF COMMERCE**

Submitted By

**MEENA.S**

**Reg.No.C21UG152COM064**

Under the guidance of

**Dr. V. SENGAMALAM, M.Com., M.Phil., MBA., PhD.**

**Assistant Professor**



**DEPARTMENT OF COMMERCE**

**ST. JOSEPH'S COLLEGE OF ARTS AND SCIENCE FOR WOMEN, HOSUR**


**Mookandapalli, Hosur**


**(Affiliated to Periyar University, Salem)**

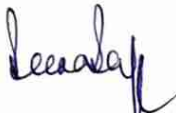
**JULY – 2023**

**PERIYAR UNIVERSITY**  
**INTERNSHIP TRAINING REPORT FORMAT**

1	Name of the candidate	MEENA.S
2	University examination registration number	C21UG152COM064
3	Name of the college	St Joseph's college of arts and science for women, Hosur
4	Name of the department /degree	Commerce/B.com
5	Name of industry/institute in which for internship training undergone	Innoforge private limited, Hosur
6	Guide/supervisor under whom the training undertaken	Dr. V. Sengamalam
7	Title of the training	A Study on innoforge private limited Hosur
8	Brief output of training (not more than 2 page)-attach annexure-1	(ENCLOSED)
9	Conclusion	The internship programme assisted in gaining both theoretical and practical knowledge.
10	Outcome of the training	The knowledge and skills acquired during the internship programme and the exposure to real world issues can now be applied in real-life business environment

  
Signature of the  
Student

  
Signature of the  
Guide

  
Head of the  
Department

  
Principal

  
Internal examiner

# **A STUDY ON INNOFORGE PRIVATE LIMITED**

## **INTRODUCTION**

Innoforge private limited is a Non-government company, incorporated on 02.August, 2007. It's a private unlisted company and is classified as company limited by shares. INNOFORGE PVT.LTD is one of the leading manufacturers and exporters of various open forging, closed die forging and ring rolled products to customers associated with various industry segments in proof machined and fully machined condition. The company is promoted by 3 technocrats with varied experience, led By M.Rajavelu, Managing director, who is Metallurgical Engineer with 25 years of experience in forging and heat treatment field. He guides a team of Engineers, skilled and equipped to handle forging process and other associated process company's ever improving system and practices, supported by tailor made ERP system, ensures delivery of ferrous forgings as per customer requirement on time and every time with quality, precision and metallurgical soundness.

## **HEAT TREATMENT DEPARTMENT**

Heat Treatment is the important mechanism which is used to change the properties of the metal. It changes the microstructure of the metal and modifies its properties. There are four types of process used in this company.

- 1) Normalizing
- 2) Tempering
- 3) Solution Annealing &
- 4) Isothermal Annealing

### **NORMALIZING**

It is the process of heating the steel to about 960 degrees Celsius, holding for a specific period of time and then cooling in still air or slightly agitated air at room temperature.

### **TEMPERING**

Tempering is a process whereby a metal is precisely heated to below the critical temperature, often in air, a vacuum, or inert atmosphere. It is used to enhance the toughness of the steel and to reduce the brittleness in the steel. It is done after hardening process

## **ISOTHERMAL ANNEALING**

It is the process of heating the steel or specimen to a temperature 850 degrees Celsius and soaking for a specific period of time of 2 hours and then decreasing the temperature to 590 degrees Celsius and finally it is soaked for a period of time and then cooled furnace.

## **SOLUTION ANNEALING**

Solution annealing is a relatively high temperature heat treating process typically run at temperatures between 915F and 990F. The material is held at the temperatures for a period of time necessary to bring the alloying elements into a solid solution. The soaking time is based on the product size. The material is quenched in water or polymer retaining the material in the solid solution state. The relatively high processing temperature coupled with the rapid cooling often results in some degree of distortion.

## **HEAT TREATMENT CAPABILITY**

- 1 Ton induction based automatic Normalizing Furnace.
- 2.5 Ton of gas Fired water quenching & Tempering Furnace
- 1 Ton Electrically heated bogie hearth Furnace

Heat treatment is based on the customer requirement. The test piece is paralleled and prepared for the calculation of machine properties.

## **KNOWLEDGE GAINED DURING INTERNSHIP**

- I learned about the heat treatment process of steel and its various types.
- I learned how to use machines for cutting and temperature to heat the raw material.
- I discovered how to quality check the finished product.
- I acquired knowledge about Inspection and dispatch of finished products.
- I also learned how they attract their customers and deal with them.

## **CONCLUSION**

This internship training helps me to improve my knowledge about the heat treatment that taking place in the forging section. It provided the industrial experience and enhances the practical knowledge of the forging of the steels.





**Innoforge Pvt. Ltd**

Forging the future

Date: 14/07/2023


**TO WHOM SO EVER IT MAY CONCERN**

This is to certify that **Ms. MEENA.S**, Reg No. **C21UG152COM064**, Student of "B.Com - Final year from **St. JOSEPH'S COLLEGE OF ARTS & SCIENCE FOR WOMEN**" had undergone her internship Training in our organization from **26th Jun 2023 to 14th July 2023**.

During her internship, she has demonstrated her skills with self-motivation to learn new skills.

We wish her all the best for her upcoming future.

For Innoforge Pvt Ltd,

A.M.U. 

Authorized Signatory



# **A STUDY ON INNOFORGE PRIVATE LIMITED, HOSUR**

**Report on Internship Training submitted to Periyar University, Salem  
In partial fulfilment of the requirement for the award of the degree of**

## **BACHELOR OF COMMERCE**

Submitted By

**PALLAVI.B.V**

**Reg.No.C21UG152COM075**

Under the guidance of

**Dr. V. SENGAMALAM, M.Com., M.Phil., MBA., PhD.**

**Assistant Professor**



**DEPARTMENT OF COMMERCE**


**ST. JOSEPH'S COLLEGE OF ARTS AND SCIENCE FOR WOMEN, HOSUR**


**(Affiliated to Periyar University, Salem)**

**JULY – 2023**

**PERIYAR UNIVERSITY**  
**INTERNSHIP TRAINING REPORT FORMAT**

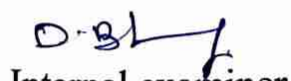
1	Name of the candidate	B.V.PALLAVI
2	University examination registration number	C21UG152COM075
3	Name of the college	St Joseph's college of arts and science for women, Hosur
4	Name of the department /degree	Commerce/B.com
5	Name of industry/institute in which for internship training undergone	Innoforge private limited, Hosur
6	Guide/supervisor under whom the training undertaken	Dr. V. Sengamalam
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Head of the  
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Principal

  
Internal examiner

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## **INTRODUCTION**

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## **PURCHASING DEPARTMENT**

### **RAW MATERIALS**

There are three types of raw materials used

- Carbon steel
- Alloy steel
- Stainless steal
  - Austenitic stainless steel
  - Martensitic stainless steel

The raw material are initially checked for the presence of defects using ultrasonic testing.

After checking the raw materials, if it is defect with "No defect", it is progressed to cutting section.



CLASSIFICATION	GRADES
Carbon steel	AISI-1018, 1020, 1030, 1040, 1045, 1050.
Alloy steel	BS-EN19, EN24, EN31, EN353, EN354.
Stainless steel (Austenite)	AISI-F304/304L, F316/F316L
Stainless steel (Martensite)	AISI-SS410, 416, 420, 431.

## CUTTING

The Raw materials are cut into required dimension for the forging production. The cutting ratio is followed with the standards.

The cutting ratio is defined as the ratio of initial cross section to the final cross section. Its constant ration is 4:1.

The Machine used to cut the material are classified into three types based on the diameter.

- Machine 1 - Maximum of diameter 450mm
- Machine 2 - Maximum of diameter 245 mm
- Machine 3 - Maximum of diameter 100 mm

After the process of cutting is done the part of specimen is taken to the quality lab for checking of the composition of the metal.

## KNOWLEDGE GAINED DURING INTENSHIP

- I learned how the management deals with the raw materials as well as with the customer satisfaction
- I learned the ERP system that the organization follows inside the management
- I discovered that the steels and metals are treated in different ways for the cutting process.

## CONCLUSION

For me this internship training provided a knowledge about the process that taking place in the forging section. It provided the industrial experience and enhances the practical knowledge of the forging of the steels.



**Innoforge Pvt. Ltd**  
Forging the future

Date: 14/07/2023

**TO WHOM SO EVER IT MAY CONCERN**

This is to certify that **Ms. PALLAVI.B.V**, Reg No. **C21UG152COM075**, Student of "B.Com - Final year from **St. JOSEPH'S COLLEGE OF ARTS & SCIENCE FOR WOMEN**" had undergone her internship Training in our organization from **26th Jun 2023 to 14th July 2023**.

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For Innoforge Pvt Ltd,

  
Authorized Signatory



# **A STUDY ON INNOFORGE PRIVATE LIMITED, HOSUR**

**Report on Internship Training submitted to Periyar University, Salem**

**In partial fulfilment of the requirement for the award of the degree of**

## **BACHELOR OF COMMERCE**

Submitted By

**RAKSHITHA.S**

**Reg.No.C21UG152COM086**

Under the guidance of

**Mrs. G. BANUPRIYA, M.Com., M.Phil., (PhD.)**

**Assistant Professor**



**DEPARTMENT OF COMMERCE**

**ST. JOSEPH'S COLLEGE OF ARTS AND SCIENCE FOR WOMEN, HOSUR**

**Mookandapalli, Hosur**

**(Affiliated to Periyar University, Salem)**

**JULY – 2023**

**PERIYAR UNIVERSITY**  
**INTERNSHIP TRAINING REPORT FORMAT**

1	Name of the candidate	RAKSHITHA.S
2	University examination registration number	C21UG152COM086
3	Name of the college	St Joseph's college of arts and science for women, Hosur
4	Name of the department /degree	Commerce/B.com
5	Name of industry/institute in which for internship training undergone	Innoforge private limited, Hosur
6	Guide/supervisor under whom the training undertaken	Mrs. G. Banupriya
7	Title of the training	A Study on innoforge private limited Hosur
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*Rakshitha.S*  
Signature of the  
Student

*G. R. S.*  
Signature of the  
Guide

*Secretary*  
Head of the  
Department

*Doc*  
Principal

*D. B. f.*  
Internal examiner



# **A STUDY ON INNOFORGE PRIVATE LIMITED**

## **INTRODUCTION**

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## **PRODUCTION DEPARTMENT**

### **FORGING**

Forging is the process in which metals are formed and shaped using compressive force.

### **OPEN DIE FORGING**

Open die forging is the process of deforming a piece of metal between multiple dies that do not completely enclose the material. The metal is altered as the dies "stamp" the material through a series of movements until the desired shape is achieved products formed through open forging often need secondary machining and refining specifications. Open die forging is widely used for the products in small quantity that are simple, rather than complex, such as dies, rings, sleeves ,cylinders and shafts.

Simply, open die forging that leaves the metal open and very huge products like cylinder, shafts.

- No predetermined shape
- Volume constancy
- Near net shape not possible
- Shape is given by the direction of force heavy forging and large size components can be forged
- Products: Shaft, Step shaft, Hub, Valves, Piston, and Ring.

## **CLOSED DIE FORGING**

Closed die forging [also known as impression die forging] is a metal forming process that compresses a piece of metal into a shape that fills an enclosed die impression. For some special shapes, a second forging operation is required to reach final shapes and dimensions. The type of material, tightness of tolerances, and need for that heat treatment can determine the cost of a closed die forged part. The weight ranges from 0.5 kg till 15 kg of product are produced.

- No Machining is required
- Volume constancy
- Near net shape can be achieved
- Pre-determined shape
- Products: Bonnets, Knuckles, Ball joints, valves.

## **KNOWLEDGE GAINED DURING INTERNSHIP**

I learned about the closed die and opened die forging. How to use machines for cutting and temperature to heat the raw material. I discovered how to make quality check and finished product and acquired knowledge about Inspection and dispatch of finished products and also learned how they attract their customers and deal with them.

## **CONCLUSION**

For me this internship training provided a knowledge about the process that taking place in the forging section. It provided the industrial experience and enhances the practical knowledge of the forging of the steels. The work done in the company brought me a real time experience I created this report as to best of my knowledge.



**Innoforge Pvt. Ltd**

Forging the future

Date: 14/07/2023

**TO WHOM SO EVER IT MAY CONCERN**

This is to certify that **Ms. RAKSHITHA.S**, Reg No. **C21UG152COM086**, Student of "**B.Com - Final year from St. JOSEPH'S COLLEGE OF ARTS & SCIENCE FOR WOMEN**" had undergone her internship Training in our organization from **26th Jun 2023 to 14th July 2023**.

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For Innoforge Pvt Ltd,

*A.M.U.*  
Authorized Signatory



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**In partial fulfilment of the requirement for the award of the degree of**

## **BACHELOR OF COMMERCE**

**Submitted By**

**SANDHIYA.P**

**Reg.No.C21UG152COM089**

**Under the guidance of**

**Mrs. G. BANUPRIYA, M.Com., M.Phil.,(PhD.,)**

**Assistant Professor**



## **DEPARTMENT OF COMMERCE**

**ST. JOSEPH'S COLLEGE OF ARTS AND SCIENCE FOR WOMEN, HOSUR**

**Mookandapalli, Hosur**

**(Affiliated to Periyar University, Salem)**

**JULY – 2023**



## PERIYAR UNIVERSITY

### INTERNSHIP TRAINING REPORT FORMAT

1	Name of the candidate	SANDHIYA.P
2	University examination registration number	C21UG152COM089
3	Name of the college	St Joseph's college of arts and science for women, Hosur
4	Name of the department /degree	Commerce/B.com
5	Name of industry/institute in which for internship training undergone	Innoforge private limited, Hosur
6	Guide/supervisor under whom the training undertaken	Mrs. G. Banupriya
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Signature of the  
Student



Signature of the  
Guide



Head of the  
Department



Principal



Internal examiner

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### **Operation management**

- Forge shop
- Heat treatment shop
- Machine shop

### **Forge Shop**

This company is equipped with 5 ton & 10 ton pneumatic hammers powered adequately by air compressors. This helps to manoeuvre the stroke to ensure dimensional control, thus enabling us to produce forgings of 1 kg/piece to 1500 kg/piece. The machine used here is having a capacity of 5 tons which uses a pneumatic hammer to give the force on the material.

### **Pneumatic hammer**

Pneumatic hammers consists of a frame, an anvil and a reciprocating ram holding a hammer head or die. The billet is placed on the lower anvil or die, and the head or upper die strikes the workspace until the desired shape is achieved. Tools are used to create shaped pieces

like hubs or rings. A typical pneumatic hammer works by storing potential energy in an arrangement of a billet. The stored potential energy provides a more forceful stroke than merely allowing the weight to fall. Upon using the hammer to reduce the size, the height and diameter of the product is checked properly.

## **Heat Treatment Shop**

Heat treatment facility presently equipped to handle annealing, normalizing consists of furnace which is provided with controlled internal atmosphere to ensure the desired microstructure. The furnace is uniquely designed, by virtue of which, special alloy steels can undergo consistently slow heating to ensure proper grain orientation and uniformity of properties, especially in reference to larger components. The heat Treatment Furnace are calibrated to ensure uniformity of temperature at various zones, thus under heating or over heating to grain coarsening is avoided.

## **Machine Shop**

Array of lathe – both conventional and NC controlled augment our machining capacity in catering forgings in proof machined and fully machined condition.

There are 6 types of machines used in this company. They are listed below

- CNC (Computer networking control)-3
- VMC (Vertical machining cell)-1
- Lathe machine
- Drilling machine

## **Knowledge gained during Internship**

- I learnt how ERP system (Enterprise resource planning) is carried on Inside the management.
- I discovered how to apply theoretical knowledge in practical world.
- I also discovered how the products are well designed into a perfect finished product through closed die forging and opened die forging

## **Conclusion**

For us this internship training provided a knowledge about the process that taking place in the forging section. It provided the industrial experience and enhances the practical knowledge of the forging of the steels.





Innoforge Pvt. Ltd

Forging the future

Date: 14/07/2023

**TO WHOM SO EVER IT MAY CONCERN**

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For Innoforge Pvt Ltd,

  
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## **BACHELOR OF COMMERCE**

Submitted By

**SRUTHI M**

**Reg.No.C21UG152COM100**

Under the guidance of

**Dr. D. BHUVANA M.Com., M.Phil., B.Ed., B.Litt (Tamil)., Ph.D.**

Assistant Professor



## **DEPARTMENT OF COMMERCE**

**ST. JOSEPH'S COLLEGE OF ARTS AND SCIENCE FOR WOMEN, HOSUR**


**Mookandapalli, Hosur**


**(Affiliated to Periyar University, Salem)**

**JULY – 2023**

**PERIYAR UNIVERSITY**  
**INTERNSHIP TRAINING REPORT FORMAT**


1	Name of the candidate	<b>SRUTHI M</b>
2	University examination registration number	<b>C21UG152COM100</b>
3	Name of the college	St Joseph's college of arts and science for women, Hosur
4	Name of the department /degree	Commerce/B.com
5	Name of industry/institute in which for internship training undergone	Innoforge private limited, Hosur
6	Guide/supervisor under whom the training undertaken	<b>Dr. D. BHUVANA</b>
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## **STEP 1: RAW MATERIALS**

There are three types of raw materials used

- Carbon steel
- Alloy steel
- Stainless steal

Austenitic stainless steel

Martensitic stainless steel

## **STEP 2: CUTTING**

The Raw materials are cut into required dimension for the forging production.

The Machine used to cut the material are classified into three types based on the diameter.

- Machine 1 - Maximum of diameter 450mm
- Machine 2 – Maximum of diameter 245 mm
- Machine 3- Maximum of diameter 100 mm

### **STEP 3: OPEN DIE FORGING**

Open die forging is the process of deforming a piece of metal between multiple dies that do not completely enclose the material. The metal is altered as the dies “stamp” the material through a series of movements until the desired shape is achieved. Products formed through open forging often need secondary machining and refining specifications.

### **STEP 4: CLOSED DIE FORGING**

Closed die forging [also known as impression die forging] is a metal forming process that compresses a piece of metal into a die. The process involves compressing a piece of metal under high pressure to fill an enclosed die impression. For some special shapes, a second forging operation is required to reach final shapes and dimensions. The type of material, tightness of tolerances, and need for that heat treatment can determine the cost of a closed die forged part.

### **STEP 5: HEAT TREATMENT**

It is the process of heating and cooling a metal product thereby to enable the intended properties for the fitment of the product.

## **HARDNESS TESTING METHOD**

### **BRINELL HARDNESS TESTING METHOD**

Hardness testing of a product is to check the resistance of the product and to determine the depth of penetration of the indenter under a known load.

$$\text{FORMULA} = \frac{\text{HARDNESS NUMBER}}{\text{LOAD APPLIED}}$$



## **STEP 6: MACHINING**

After the process of heat treatment, the product is taken to the machining section. Here the extra dimensions are removed. There is a separate machining department which is "INNO MAKING SOLUTIONS" also branch of "INNOFORGE".

## **STEP 7: INSPECTION AND DISPATCH**

As according to TDC the products are checked thoroughly by inspecting all the products and after inspection the products all are dispatched to the customer with full satisfaction the product are well designed and forged.

## **CONCLUSION**

For us this internship training provided a knowledge about the process that taking place in the forging section. It provided the industrial experience and enhances the practical knowledge of the forging of the steels.



**Innoforge Pvt. Ltd**

Forging the future

Date: 14/07/2023

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