



Gate Valve

Gate Valve

Model 1000

API 600 / BS 1414

Size - 2" to 48" (50mm to 1200mm)

Rating - Class 150 to Class 2500

Cast Steel Valves

Flange Design

Butt-Weld Design

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Gate Valve - Model 1000



Company Overview

“INVACO” (Industrial Valve Company) founded and promoted by the technocrats having experience of 18 years in National and International valve industry. INVACO PRIVATE LIMITED (Industrial Valve Company) is registered experience company in Design, Development, Fabrication & Manufacturing of Industrial Valves. Our mission is to produce high quality and reliable Valves to our national & international clients / customers. Our proactive approach to technical issues enables to understand and implement cost-effective solutions to our valuable customers.

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“INVACO” (Industrial Valve Company) committed to excellence by manufacturing top quality valves to exceed customer’s needs with low cost, on-time delivery & providing finest service in industry. “INVACO” manufacture Ball valves (Floating & Trunnion Mounted), Butterfly Valves (Damper, Sleeved, Double offset & Triple Offset), Gate Valves, Globe Valves , Check Valves, Strainers, Flap Valves, Dismantling Joints, Flange Adaptor, Flange Couplings & Sluice Gate / Penstock for Oil & Gas, Petrochemicals, Refineries, Power Plants, Water Treatment Plants, Chemical, Paper & Pulp, Sugar, Steel, Pharma, Pipeline Transmission and other process industries.

“INVACO” (Industrial Valve Company) is specialized in design, manufacturing & testing of CAST & FORGED Steel Gate Valves. All gate valves are designed as per ASME B16.34, API 600, API 602, BS 1414 and follows ISO 9001:2015 Quality Management Systems. INVACO, manufacture of Cast Steel Gate, Globe & Check valve size from 2” to 48” (50mm to 1200mm) with pressure range from Class 150 to Class 2500 and equivalent EN pressure ratings. Gate , Globe & Check valves produced from FORGED materials like WCB, WC6,WC9, CA15 , LCB, LCC, CF8, CF3 , CF3M, CF8, CF8M, Alloy20, 4A, 5A, 6A, Aluminum Bronze, Inconel, Monel, Hast Alloys, and other special materials.

INVACO (Industrial Valve Company) aims to produced a zero defect valves for long life and reliable services. Making continual improvements aims towards to minimize the Total Ownership Cost for valued customers. Also aims to established sales and services of valves & actuators worldwide.

This catalog provides basic information of Gate Valves. Every effort has been made to maintain technical accuracies however INVACO has reserve rights to make any change in design and materials without prior notice.



Quality Policy

At "INVACO", we established this comprehensive Quality Management System to implement a strategy of continual improvement and compliance with the requirements of the ISO 9001:2008 Quality Assurance standard and other industrial valves standards by:

Customer Focused:

- Make commitments we fully understand and believe we can meet and deliver.
- Meet all commitments to customers on time.
- Satisfy our customer's needs and exceed their expectations.

Performance Driven:

- Verify that our products and services meet customer requirements.
- Monitor benchmark and continuously improve our business, products, and services, organization and employee's performance.

Entire "INVACO" stick to the spirit and intent of this policy to ensure customer satisfaction is achieved at all respects and times.



Quality Standard for Gate Valves

American Petroleum Institute (API)

API 600 API 602
API 598 API Spec Q1

American Society of Mechanical Engineers

ASME B16.34 ASME B16.5
ASME B16.47 ASME B16.10
ASME B16.25

British / European Standards

BS 1414 BS 5352
BS 1868 BS EN 558
BS EN 1092 BS EN 12266
EN 10204 BS EN 6364

International Organization for Standardization (ISO)

ISO 9001:2015 ISO 5208
ISO 5211 ISO 14313
ISO 10434 ISO 15848

Manufacturers Standardization Society (MSS - SP)

MSS SP-6 MSS SP-25
MSS SP 44 MSS SP 45
MSS SP 55 MSS SP 61
MSS SP 72 MSS SP 82

National Association of Corrosion Engineers (NACE)

NACE MR 01-75 NACE TM 01-77
NACE TM 02-84 NACE MR 01-03

Materials and Equipment Standards and Code (MESC)

MESC SPE 77/101 MESC SPE 77/102 MESC SPE 77/105 MESC SPE 77/160 MESC SPE 77/300
MESC SPE 77/302 MESC SPE 77/312 MESC SPE 77/200

Testing & Inspection for Gate Valves

Test	Applicable Standards	Extent of Test
Visual Inspection	MSS SP - 55	100%
Marking Inspection	MSS SP - 25	100%
Chemical, Physical & Heat Treatment	Relevant ASTM Standards	100%
Alloy Verification / Positive Material Identification(PMI)	INVACO Procedure	Upon Customer Request
Hardness Requirement	NACE MR 01 - 75	Upon Customer Request
Radiographic Testing (RT) (X-Ray & Gamma Ray)	ASME B16.34 (Annex B) , ASTM E94 , E142 , E446 , E186 , E280, BPVC Sec V-Art 7 & 22, ASME Sec VIII - Div-1	Upon Customer Request
Ultrasonic Testing (UT)	ASME B16.34 , ASTM A388 , A609 , A578 , BPVC Sec V – Art 4 & 23, ASME VIII Div-1	Upon Customer Request
Magnetic Particle Inspection(MPI)- (Dry & Wet)	ASME B16.34 Annex C , ASTM E709 , ASTM A275 , E1444, ASME Sec VIII Div-2, BPVC Sec V – Art 7 & 23	Upon Customer Request
Liquid / Dye Penetrant Inspection (LP / DP)	ASME B16.34 Annex D ,ASTM E 165 , E1417 , ASME Sec VIII Div 1,BPVC Sec V – Art 6 & 24.	Upon Customer Request
Impact Test	ASTM A 370	Upon Customer Request
Microstructural & Ferrite Content measurement	ASTM E 562	Upon Customer Request
Microscopic / inclusion Count Test	ASTM E 45	Upon Customer Request
Pitting Corrosion	ASTM G 48	Upon Customer Request



Crevice Corrosion	ASTM G 48	Upon Customer Request
Hydrogen Induced Cracking Test (HIC)	NACE TM 02 - 84	Upon Customer Request
Ferric Chloride Corrosion Test	ASTM A 923	Upon Customer Request
Hardness Test	ASTM E 18 , ASTM E 92, NACE MR 01 - 75	Upon Customer Request
Intergranular Corrosion Cracking (IGC)	ASTM A 262	Upon Customer Request
Chloride Stress Corrosion Cracking Test (CSCC)	NACE TM 01 - 75	Upon Customer Request
Size / Dimension Check	INVACO Approved Drawings	100%
Functional Check	INVACO Approved Drawings	100%
Shell Test (Hydro Test)	API 598, Approved GA Drawings	100%
Seat Test (Hydro Test)	API 598, Approved GA Drawings	100%
Backseat Test (Hydro Test)	API 598, Approved GA Drawings	100%
Seat Test (Air/Pneumatic Test)	API 598, Approved GA Drawings	100%
Helium Leak / Fugitive Emission Test	ISO 15848, MESC 77 / 312	Upon Customer Request
Torque Test	INVACO Procedure	10% or Upon Customer Request
Blasting Report	INVACO Procedure	10% or Upon Customer Request
Surface Finish Report	INVACO Procedure	10% or Upon Customer Request
Painting / Dry Film Thickness Report	INVACO Procedure	10% or Upon Customer Request
Tag No, Serial No, Name Plate	INVACO Procedure	100%
Note: - 1) Backseat test is applicable to Gate & Globe Valve. 2) Above Test available upon customer request with extra cost. 3) For more information kindly contact "INVACO".		

Manufacturing Range for GGC (Gate, Globe & Check Valve)

Valve	ASME CLASS / Size - in (mm)						
	150	300	600	800	900	1500	2500
Gate Valve	2" - 48" (50 - 1200)	2" - 48" (50 - 1200)	2" - 48" (50 - 1200)	----	2" - 24" (50 - 600)	2" - 12" (50 - 300)	2" - 12" (50 - 300)
Globe Valve	2" - 24" (50 - 600)	2" - 24" (50 - 600)	2" - 24" (50 - 600)	----	2" - 18" (50 - 450)	2" - 16" (50 - 400)	2" - 12" (50 - 300)
Check Valve	2" - 48" (50 - 1200)	2" - 48" (50 - 1200)	2" - 48" (50 - 1200)	----	2" - 16" (50 - 400)	2" - 14" (50 - 350)	2" - 10" (50 - 250)
Forge Valve (GGC)	----	----	----	1/2" - 2" (15 - 50)	1/2" - 2" (15 - 50)	1/2" - 2" (15 - 50)	----



Features of Gate Valve (Model - 1000)



Quality Standards:-

Design Standards	- API 600 / ASME B16.34 / BS 1414 / MESC SPE 77-101,102,105,160,302,300,312.
Testing Standards	- API 598 / EN 12266 / ISO 5208 / BS 6755
End to End Standards	- ASME B 16.10 / EN 558
Flange Drilling Standards	- ASME B16.5 / ASME B 16.47 / BS EN 1092.
Butt-Weld	- ASME B 16.25
Actuator Mounting	- ISO 5211
Fugitive Emission Test	- MESC SPE 77 - 312 / ISO 15848
Cryogenic Services	- BS 6364, MSS SP 134
Valve Marking	- MSS SP 25 / ASME B 16.34
Visual Inspection	- MSS SP 55
Material Testing	- NDE / NACE MR 01- 75 / NACE MR 01- 03 Compliance available.

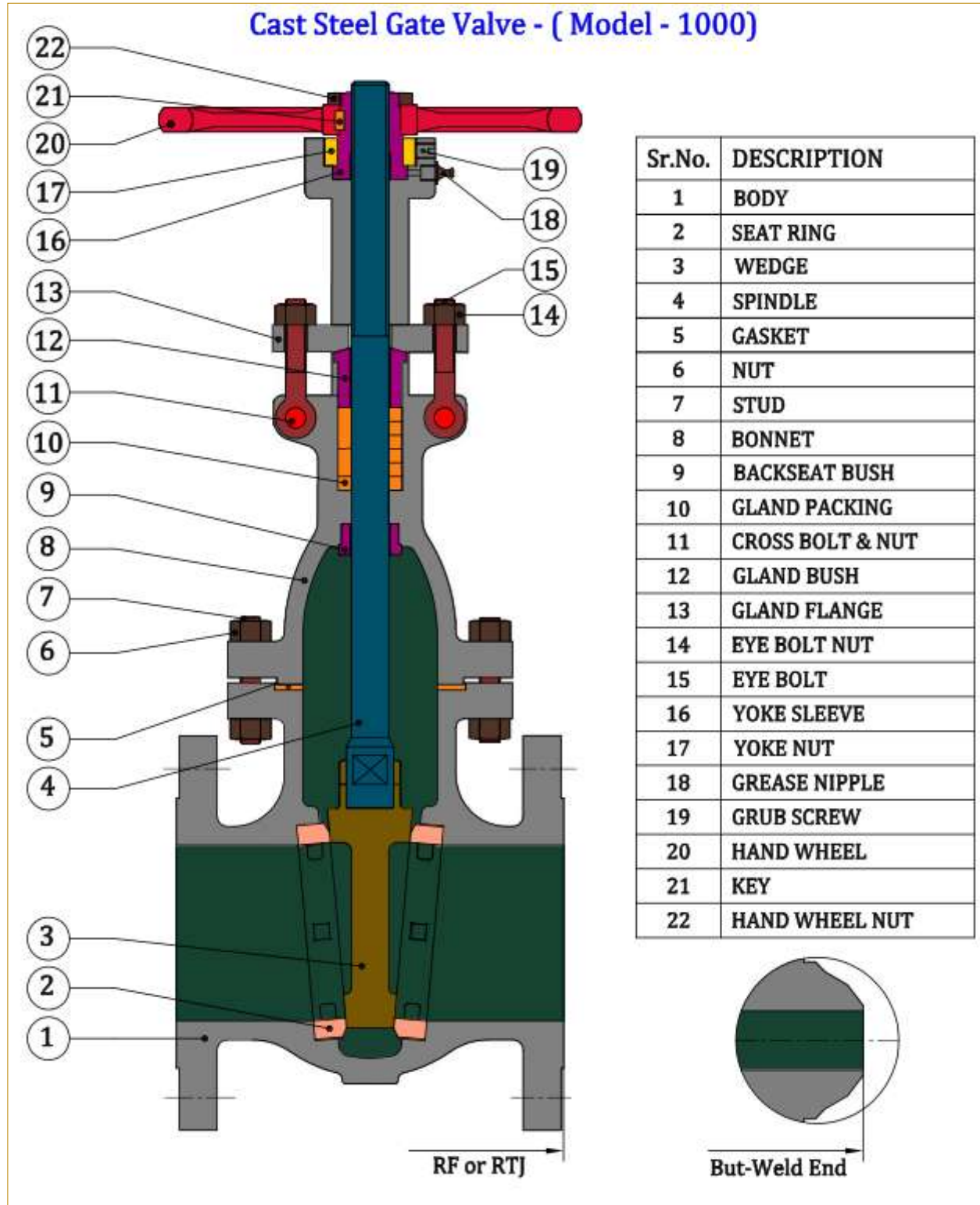
Key Features:-

- Size :- 2" to 48" (50mm to 1200mm)
- All API Trim, Hard Face, Stallite
- Extended Bonnet & Extended Stem
- Solid Wedge , Flexible Wedge options
- Flange RF, FF, RTJ, Butt-Weld End
- Rating:- 150# to 2500# & Equiv. DIN Rating
- Vacuum seal arrangement
- OS & Y, BB, Rising / Non Rising Stem.
- Low Emission Design
- Hand-wheel , Gear Operated & Actuated

Materials - Carbon Steel, Low Temperature Carbon Steel, Stainless Steel, Duplex, Super Duplex, Incoloy, Inconel, Monel, Aluminum Bronze, Hastalloy, Titanium and other materials.

Applications - Offshore / Onshore Oil & Gas, Chemical, Petrochemical & Allied Process, Power Plant, Water Treatment Plant, Liquefied Natural Gas, Sugar, Paper & Pulp, Steel, Piping & Process Industries.

GA Drawing for Gate Valve (Model - 1000)



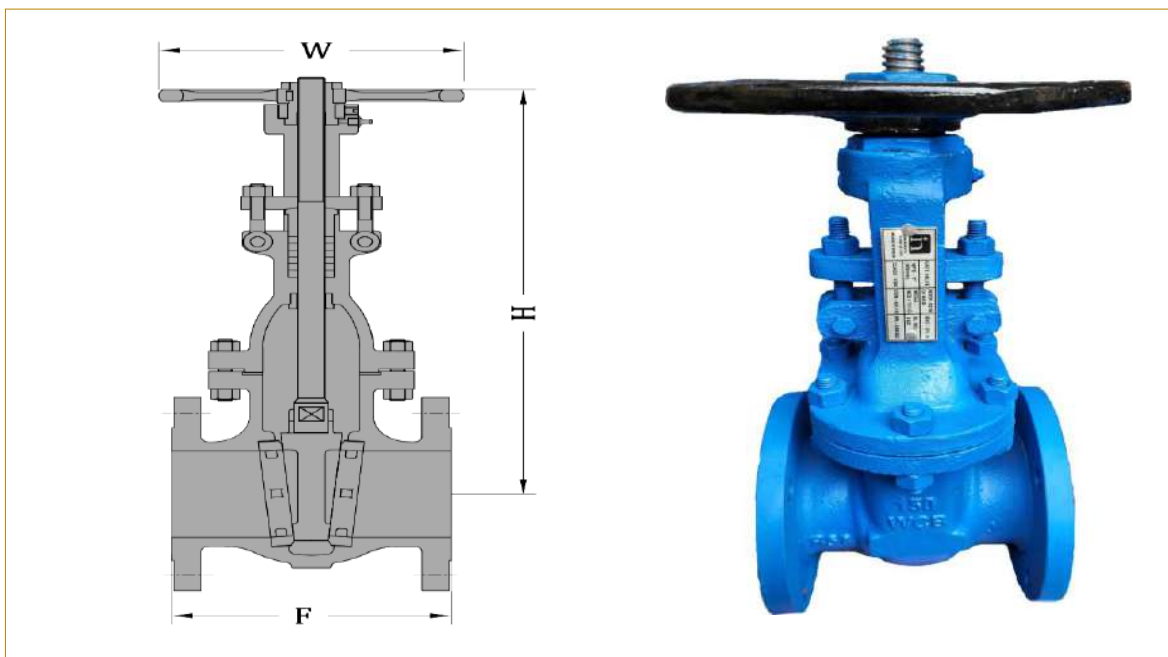
Material of Construction for Gate Valve (Model - 1000)

Bill Of Material For Gate Valve						
Sr. No.	Part	Carbon Steel	Low Temp. Carbon Steel	Stainless Steel	DUPLEX	Nickel Alloys
1	Body	A216 Gr WCB	A325 Gr. LCB , LCC	A351 Gr. CF8M, CF8	A890 Gr. 4A, 5A, 6A	A 494 Gr. CW6MC, CW12M, M 35-1
2	Seat Ring	CA15, CF8, CF8M	A351 Gr. CF8M	A351 Gr. CF8M, CF8	A890 Gr. 4A, 5A, 6A	CW6MC, 12MW , M35 -1
3	Wedge					
4	Spindle	F6a, AISI410, F304 , F316	F316L	F316L, F304L	F51, F53, F55	Inconel 625, 750, 825, Monel
5	Gasket	SPWG + (SS304/SS316)	SPWG + SS316	SPWG + (SS304/SS316)	SPWG + Duplex	SPWG + Monel / Inconel
6	Nut	A194 Gr. 2H / 2HM	A194 Gr. 4L / 7M / 4	A194 Gr. 8MA / 8M		
7	Stud	A193 Gr. B7 / B7M	A320 Gr. L7 / L7M	A193 Gr. B8M / 8M		
8	Bonnet	WCB	LCB , LCC	CF8M, CF8	4A, 5A, 6A	CW6MC, 12MW , M35 -1
9	Backseat Bush	F6a, AISI410, F304 , F316	F316L	F316L, F304L	F51, F53, F55	Inconel / Monel
10	Gland Packing	Graphite				
11	Cross Bolt & Nut	B7, B7M & 2H, 2HM / CS	L7,L7M & 4,4L,7M / Carbon Steel	B8, B8M & 8M,8MA / Stainless Steel		
12	Gland Bush	WCB(ENP), A105(ENP), F6a, AISI410, F304 , F316	LCC, LCB, LF2 , SS316	CF8M, CF8, F316L, F304L	Duplex	Inconel / Monel
13	Gland Flange					
14	Eye Bolt Nut	2H, 2HM / CS	4L, 7M, 4 / CS	8M, 8MA / Stainless Steel		
15	Eye Bolt	B7, B7M / CS	L7, L7M / CS	B8, B8M / Stainless Steel		
16	Yoke Sleeve	S. G. Iron/ D2 / Brass				
17	Yoke Nut	2H, 2HM / CS	4L, 7M, 4 / CS	8M, 8MA / Stainless Steel		
18	Grease Nipple	Carbon Steel		Stainless Steel		
19	Grub Screw					
20	Hand Wheel	Malleable, Ductile Iron / Carbon Steel (Fabricated)		Malleable, Ductile Iron / Stainless Steel (Fabricated)		
21	Key	EN 8				
22	Hand Wheel Nut	2H, 2HM / Carbon Steel	4L, 7M, 4 / Carbon Steel	8M, 8MA / Stainless Steel		

NOTE:
 ** All API 600 Trims are available as per customer requirement.
 ** Stellite or Hardface are optional and as per customer requirement.
 ** "INVACO" reserve rights to change MATERIALS & DESIGN anytime without prior notice.



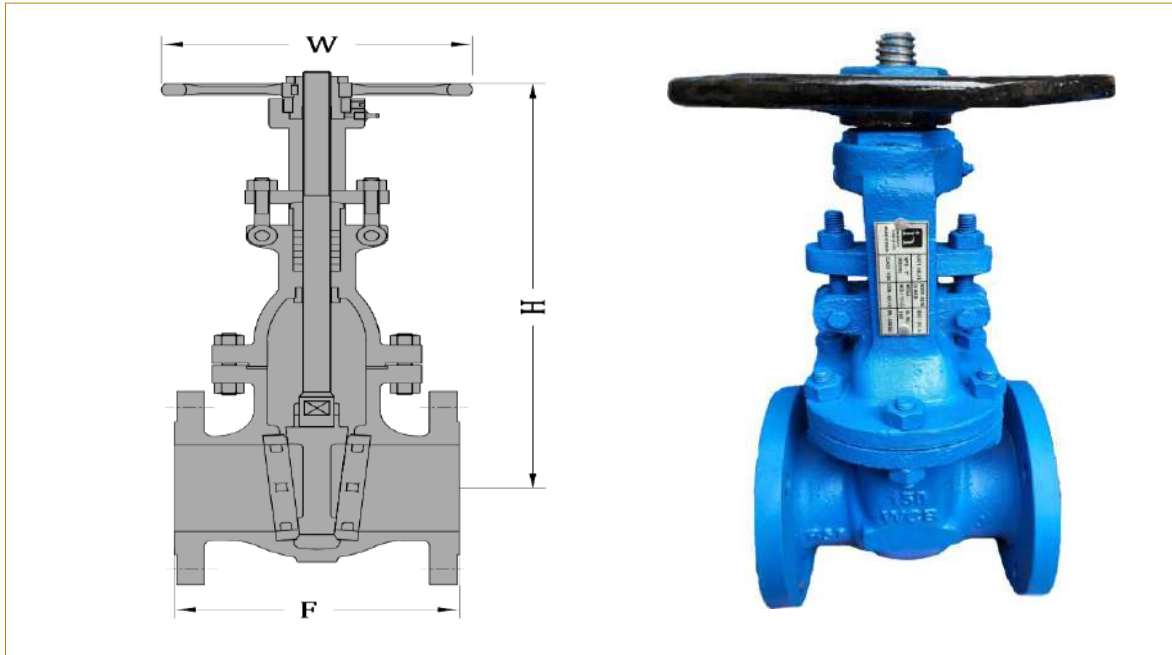
Dimensions for Gate Valve (Model - 1000)



Size		150#					300#				600#			
		Face to Face (mm)			H	W	Face to Face (mm)		H	W	Face to Face (mm)		H	W
in	mm	RF	WE	RTJ	mm	mm	RF & WE	RTJ	mm	mm	RF & WE	RTJ	mm	mm
2	50	178	216	191	370	200	216	232	390	200	292	295	425	250
2½	65	191	241	203	385	200	241	257	430	200	330	333	490	250
3	80	203	283	216	465	250	283	298	490	250	356	359	653	300
4	100	229	305	241	565	250	305	321	580	250	432	435	750	300
6	150	267	403	279	770	300	403	419	840	350	559	562	910	450
8	200	292	419	305	990	300	419	435	1030	350	660	664	1120	500
10	250	330	457	343	1170	400	457	473	1235	450	787	791	1345	550
12	300	356	502	363	1370	450	502	518	1420	500	838	841	1545	550
14	350	381	572	394	1520	450	762	778	1600	600	889	892	1730	600
16	400	406	610	419	1730	500	838	854	1840	600	991	994	1845	600
18	450	432	660	445	1900	500	914	930	1940	GO	1092	1095	2100	GO
20	500	457	711	470	2090	GO	991	1010	2120	GO	1194	1200	2270	GO
24	600	508	813	521	2420	GO	1143	1165	2575	GO	1397	1407	2980	GO
26	650	559	864	---	2808	GO	1245	1270	2910	GO	1448	1461	3125	GO
28	700	610	914	---	3050	GO	1346	1372	3000	GO	1549	1562	3353	GO
30	750	610	914	---	3100	GO	1397	1422	3150	GO	1651	1664	3539	GO
32	800	660	965	---	3290	GO	1524	1553	3291	GO	1778	1794	3625	GO
36	900	711	1016	---	3720	GO	1727	1756	3762	GO	2083	2099	3786	GO
40	1000	762	1067	---	4020	GO	1930	---	4245	GO	2286	---	4395	GO
48	1200	914	---	---	4815	GO	---	---	---	---	---	---	---	---

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Dimensions for Gate Valve (Model - 1000)



Size		900#				1500#				2500#			
		Face to Face (mm)		H	W	Face to Face (mm)		H	W	Face to Face (mm)		H	W
in	mm	RF & WE	RTJ	mm	mm	RF & WE	RTJ	mm	mm	RF & WE	RTJ	mm	mm
2	50	368	371	655	250	368	371	660	350	451	454	750	400
2½	65	419	422	700	250	419	422	705	350	508	514	840	500
3	80	381	384	795	300	470	473	855	400	578	584	875	500
4	100	457	460	895	350	546	549	935	400	673	683	1065	600
6	150	610	613	1130	500	705	711	1225	600	914	927	1445	600
8	200	737	740	1435	600	832	841	1415	600	1022	1038	1605	GO
10	250	838	841	1550	600	991	1000	1680	GO	1270	1292	2090	GO
12	300	965	968	1710	GO	1130	1146	1990	GO	1422	1445	2285	GO
14	350	1029	1038	1895	GO	1257	1276	2155	GO	---	---	---	---
16	400	1130	1140	2045	GO	1384	1407	2480	GO	---	---	---	---
18	450	1219	1232	2250	GO	1537	1559	2760	GO	---	---	---	---
20	500	1321	1334	2795	GO	1664	1686	3100	GO	---	---	---	---
24	600	1549	1568	3145	GO	1943	1972	3715	GO	---	---	---	---

NOTE:-

- ** RF – Raised Face, RTJ – Ring Type Joint, BW – But Weld End, GO – Gear Operated
- ** All API Trims are available.
- ** All dimensions are in “mm” unless & otherwise specified.
- ** INVACO reserves the right to change materials, design & dimensions anytime without prior notice.

Torque & Thrust for Gate Valve (Model - 1000)

Torque & Thrust for Gate Valve											
Size		150#		300#		600#		900#		1500#	
in	mm	Thrust	Torque	Thrust	Torque	Thrust	Torque	Thrust	Torque	Thrust	Torque
		KN	N-m	KN	N-m	KN	N-m	KN	N-m	KN	N-m
2	50	8	17	12	28	20	46	25	68	34	123
2½	65	9	19	15	33	27	51	33	87	42	178
3	80	11	25	19	44	34	90	41	96	73	236
4	100	14	38	26	73	52	149	69	184	96	367
6	150	23	71	45	164	98	212	131	553	219	953
8	200	34	116	75	270	145	684	207	952	341	1804
10	250	46	170	113	426	212	1175	306	1687	459	2331
12	300	64	254	149	621	298	1554	423	2452	653	3349
14	350	73	315	185	785	350	1978	513	2891	---	---
16	400	101	423	238	589	449	2479	549	3236	---	---
18	450	127	547	295	1364	522	2987	729	5231	---	---
20	500	158	720	364	1816	678	4014	869	6708	---	---
24	600	209	1181	446	2589	870	6163	1194	10017	---	---

Note: -

- For higher size information kindly contact INVACO.
- For actuator selection or sizing, factor of safety 1.3 – 1.5 is recommended
- This is general information; values can vary with change in materials, trim, bonnet type, hand-wheel size, packing and other factor.
- INVACO reserve the right to change Design, Material or specification or any other information without prior notice.



Body & Trim Material for Gate Valve (Model - 1000)

Body & Trim Material:-		
Material Group / Type	Casting	Forging
Carbon Steel	A216 Gr WCB , WCA	A105 / A 106
	A216 Gr WCC	A105N
Low Temperature Carbon Steel	A352 Gr LCB	A350 Gr LF2 CL.1
	A352 Gr LCC	
	A352 Gr LC1 / LC2	
	A352 Gr LC3	A350 Gr LF3 CL.1
Alloy Steel	A217 Gr WC1	A182 Gr F1
	A217 Gr WC5	
	A217 Gr WC6	A182 Gr F11 CL.2
	A217 Gr WC9	A182 Gr F22 CL.3
	A217 Gr C5	A182 Gr F5a
	A217 Gr C12	A182 Gr F9
	A217 Gr C12A	A182 Gr F91
Stainless Steel	A217 Gr CA15	A182 Gr F6A / ANSI 410
	A351 Gr CF10M	A182 Gr F304H
	A351 Gr CF8A	A182 Gr F347H
	A351 Gr CF8	A182 Gr F304
	A351 Gr CF3	A182 Gr F304L
	A351 Gr CF8M	A182 Gr F316
	A351 Gr CF3M	A182 Gr F316L
	A351 Gr CF8C	A182 Gr F347
Duplex / Super Duplex	A890 Gr CD4MCuN (1B)	
	A890 Gr CD3MCuN (1C)	
	A890 Gr CE8MN (2A)	
	A890 Gr CD3MN (4A)	A182 Gr F51
	A890 Gr CE3MN (5A)	A182 Gr F53
	A890 Gr CD3MWCuN (6A)	A182 Gr F55
Nickel / Super Nickel Alloys	A494 Gr CY40	Inconel 600
	A494 Gr CZ100	
	A494 Gr CW6MC	Inconel 625
	A494 Gr M 35 -1	Monel 400
		Monel K-500
	A494 Gr CW6M / CW12MW	Hastalloy C / C-276
Aluminum Bronze	B148 Gr C95200	
	B148 Gr C95400	
	B148 Gr C95500	
	B148 Gr C95800	
Titanium	B367 Gr C2	B381 Gr F2
	B367 Gr C3	B381 Gr F3
Special Materials	A351 Gr CN7M	Alloy 20
	A351 Gr CN2MCuN	904L
	A351 Gr CK3MCuN	SMO 254 / A182 Gr F44
	CB7CU -1	17 - 4 PH

Note: - Wrought names are given as a reference for commonly accepted equivalent material. "INVACO" cannot hold any liability for any damages incurred due to this table. For more information kindly contact "INVACO".

Material Specification for Fastener's:-

Bolting Material	Nut Materials	Temperature Range	Body Material
ASTM A193 Gr. B7	ASTM A194 Gr. 2H	-40°C to +538°C	Carbon Steel
ASTM A193 Gr B7M	ASTM A194 Gr. 2HM	-50°C to +538°C	Low Alloy Steel
ASTM A320 Gr. L7	ASTM A194 Gr. 7/4	-100°C to +371°C	Low Temp. Carbon Steel
ASTM A320 Gr. L7M	ASTM A194 Gr. 7M	-75°C to +538°C	Low Temp. Carbon Steel
ASTM A193 Gr. B8	ASTM A194 Gr. 8	-200°C to +538°C	Stainless Steel
ASTM A193 Gr. B8M	ASTM A194 Gr. 8M / 8MA	-200°C to +538°C	Stainless Steel/Nickel Alloys / AL-Br / Duplex
A453 Gr 660 CL A	A453 Gr 660 CL A	-30°C to +538°C	Duplex

NOTE:- <ul style="list-style-type: none"> ➤ Above temperature range is for BOLTING, not body materials. ➤ Welding repair on Bolting is strictly not allowed. ➤ Temperature range & use may vary with requirement like NACE, Impact Test. ➤ For more information refer ASME B31.3, B16.34, A193, A194, A320 & A453. ➤ Other Bolt & Nut material available on request. ➤ INVACO cannot hold any liability for any damages incurred to this table. 	Coating for Fastener's <ul style="list-style-type: none"> ➤ ENP ➤ Hot Deep Galvanized ➤ Hot Zinc ➤ Red Xylem ➤ PTFE Coating ➤ Cadmium ➤ Cadmium with PTFE
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Static and Dynamic Seals (Gaskets & Packing):-

- Graphite Packing / Gasket.
- PTFE, R-PTFE Packing / Rings.
- Spiral Wound Gasket (Soft + Metal filled)
- Metal Gasket (RTJ, BX, T type seal ring).
- Lip Seal (U/O type, radial or face seal).

Testing Pressure:-

ASME CLASS	Working Pressure			Body Test (Hydro)			Seat Test (Hydro)			Seat Test (Air)		
	psi	bar	Kg/cm ²	psi	bar	Kg/cm ²	psi	bar	Kg/cm ²	psi	bar	Kg/cm ²
150	285	19.6	20	464	32	33	333	23	23.5	100	6	7
300	741	51.1	52	1145	79	81	842	58	59	100	6	7
400	988	68.1	69	1523	105	107	1189	82	84	100	6	7
600	1480	102.1	104	2262	156	159	1653	114	116	100	6	7
800	2001	138	141	3046	210	214	2248	155	158	100	6	7
900	2222	153.2	156	3423	236	240	2494	172	175	100	6	7
1500	3703	255.3	260	5685	392	400	4177	288	293	100	6	7
2500	6171	425.5	434	945	652	665	6932	478	487	100	6	7

Note: - Rating Pressure may be change for different materials.





Model 1000

Gate Valve

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Ambernath (E) - 421 506
Thane, India

Your Local INVACO Representative -

We are 70 Km away from Mumbai International Airport.