



# Peoples Steel Mills Ltd.

**The Market Leader of Alloy & Special Steels in Pakistan**

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## COMPANY PROFILE

Peoples Steel Mills Ltd., a world class alloy and special steel manufacturing plant located in Manghopir Karachi. The plant is spread over an area of 239.11 acres & was set-up by the Government of Pakistan in 1975 with Japanese assistance.

In order to keep pace with emerging technologies, the plant was upgraded in 1996 through a comprehensive balancing & modernization programme with the technical assistance of VAIS, INTECO and Bohler of Austria. The plant is now equipped with modern melting, refining, degassing, electro slag re-melting, necessary casting, rolling and forging facilities with an annual capacity of 75,000/MT. Product quality is assured by highly qualified well trained staff with modern material testing facilities and enforcing quality management system.

The plant has the capability to produce steels according to all major international quality standards and to date more than 350 steel grades have been manufactured.

Peoples Steel enjoys the highest market share in the alloy and special steel market of Pakistan. A diversified base of more than 490 customers includes high profile illustrious end users in automotive, defense, agricultural machinery, transportation and engineering sectors in Pakistan. Besides direct export of alloy and tool steels, components manufactured from our steels are also supplied by our customers to renowned European automobile manufacturers.

In addition to manufacturing/ supply of quality materials, Peoples Steel also extends expertise in the following fields:

- Manufacturing of Seamless Tubes & Pipes
- Material Testing & Analyzing - Chemical, Mechanical, NDT, Metallography & Failure Analysis.
- Refractory manufacturing & testing.

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## QUALITY POLICY

Peoples Steel Mills Ltd. is committed to the achievement of customer requirements and expectations and to continuous improvement in productivity, quality, service, technology and costs.

The commitment to quality is demonstrated by:

- The achievement of quality assurance standard, such as ISO 9001:2015 and unwavering focus on customer.
- Providing commitment and leadership.
- The development of knowledgeable and motivated work force with a positive commitment to professional excellence.
- The setting of SMART objectives whereby continuous improvement in performance against agreed goals.
- The development of new and improved products designed to meet customer requirements and expectations.
- The emphasis on prevention rather than detection in the drive towards Total Quality Management.
- Identify risks and opportunities to the quality management system.





## STEEL TYPES

The steel types manufactured by us are broadly classified as:

- Cutting/ High Speed Tool Steels
- Free / Semi-Free Cutting Steels
- Case Hardening Steels
- Spring Steels
- Ball Bearing Steels
- Heat Resisting Steels
- Cold Work Tool & Die Steels
- Hot Work Tool & Die Steels
- Stainless/ Surgical Steels
- Armour Steels
- Plastic Mould Steels
- Steels for Special Applications

## ABILITY TO PRODUCE ACCORDING TO ALL MAJOR INTERNATIONAL QUALITY STANDARDS, GRADES & CUSTOMIZED SPECIFICATIONS

Always ensuring the right quality, Peoples Steel has the ability to produce steel according to all major international standards and grades. So far we have produced more than 350 steel grades according to:

• American	ASTM, AISI, SAE American
• British	BS
• Chinese	GB, YB
• European	EN
• French	AFNOR
• German	DIN
• Italian	UNI
• International	ISO
• Japanese	JIS
• Russian	GOST and several others

We can also manufacture steel according to customized specifications.





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## PROCESSES DESIGNED TO PRODUCE CLEAN STEELS

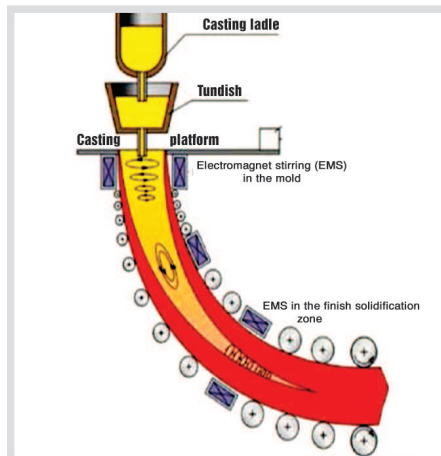
### “Clean” and Vacuum Degassed Steels

Non-metallic inclusions and gases entrapped in steel can lead to internal defects resulting in poor quality products. In addition to product consistency and performance, fatigue strength and tool / die life is strongly correlated with cleanliness and gas contents in steels.

Peoples Steel employs state-of-the-art melting and refining techniques to manufacture steels with low levels of non-metallic inclusions, residual elements and well controlled gas contents.



Vacuum Degassing (VD)/  
Vacuum Oxygen Decarburization (VOD)



Continuous Casting Plant with  
Electro-Magnetic stirrer



Electro-Slag Remelting

	(A) Sulfides	(B) Alumina	(C) Silicates	(D) Oxides
Inclusions Confirming to ASTM E-45 Method				
Inclusions Not-Confirming to ASTM E-45 Method				



## **A RELIABLE SOURCE OF STEEL FOR WORLD CLASS AUTOMOBILE MANUFACTURERS**

Peoples Steel's material meets the demanding and stringent quality requirements of world class automobile manufacturers. Components manufactured from our steels are used by leading OEMs in Pakistan for their prestigious brands.

- Honda - Atlas
- Nissan
- MASSEY FERGUSON (Millat)
- Toyota
- Yamaha
- FIAT (Al-Ghazi)
- Suzuki
- Daewoo
- Hino

Components manufactured from Peoples Steel material are also supplied through vendors to renowned international automobile brands of USA & Europe.

## **EXCELLENT PRODUCTION PLANNING AND SUPPLY CHAIN MANAGEMENT GUARANTEES ON TIME DELIVERIES**

Peoples Steel is serving more than 250 customers across the Pakistan.

Being the 1st choice supplier of alloy and special steels, an intelligent production planning and supply chain management system is placed to ensure the deliveries to our customers irrespective of their order volumes, on time - every time.

Stocks of fast moving products are maintained to facilitate production schedules of prestigious brands through just in time supplies.





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## DIVISION-I: MELTING AND DOWNSTREAMING FACILITIES

### Melting & Refining

Melting is done in two 15MT capacity Electric Arc Furnaces (EAF) and refining is carried out in Ladle Furnaces (LF) with Vacuum Degassing (VD)/ Vacuum Oxygen Decarburization (VOD) to control gas contents.

### Continuous Casting

The (2+1) strand Continuous Caster specifically designed for alloy steels is equipped with soft secondary cooling, two stage magnetic stirrer and other special features for the production of 110 to 230 mm square/ round billets and blooms.

### Ingot Casting

Highly refined ingots in rectangular, round, octagonal and square sections are produced by bottom pouring technique. Ingot sizes vary from 500Kg to 14,000Kg depending on steel grade and initial stock size requirements. Ingots can be slow cooled, stress relieved or annealed.

### Bar Rolling

The mill is producing rounds from 18mm to 80mm and flats with width 50mm to 110mm & thickness from 6mm to 25mm. The shop is also equipped with auto-controlled pusher type reheating furnace and roll cutting/ grinding facilities.

### Blooming & Slabbing

Plates with width up to 1500 mm and thickness down to 8 mm are rolled from flat ingots. Round and square sections ranging from 75mm to 200mm are produced from cast and forged blooms. The Blooming Mill is also equipped with auto-controlled re-heating furnace and roll cutting/ grinding facilities.

### Press Forging

The 1700MT hydraulic press equipped with reheating furnace and auto-manipulator is used for the processing of heavy forging/ critical parts up to 12MT.



▲ ELECTRIC ARC FURNACE (EAF)



▲ LADLE FURNACE (LF)



▲ CONTINUOUS CASTING



▲ INGOT CASTING



▲ PRESS FORGING



▲ BAR ROLLING



▲ BLOOMING & SLABBING

### Hammer Forging

Forging facilities comprises of half to three tones hammers & mechanical presses, equipped with re-heating and heat treatment furnaces. Components up to 15Kg weight can be produced through die forging.

### Radial Forging

Radial forging is the state-of-the-art technique to manufacture profiles up to 200mm. The facility is equipped with reheating and annealing furnaces and auto manipulators.

### Cold Drawing, Peeling and Polishing

Round bars are drawn and peeled to exhibit a bright and/or polished surface, with increased mechanical properties, improved machining characteristics and precise and/or uniform dimensional tolerances up to h-9 quality standard. The mill range for cold drawing is 10mm to 65mm, for peeling is 20mm to 100mm and for ground and polished bars is in the range of 20mm to 78mm.

### Heat Treatment

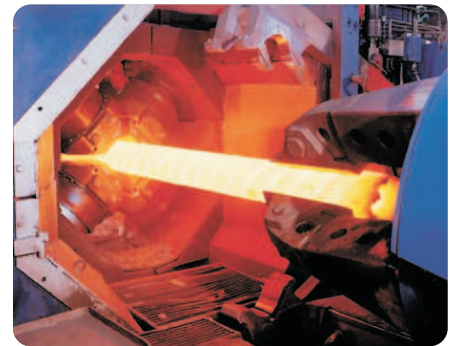
Heat treatment plays a vital role to induce certain desired properties by altering the internal structure of steel. We have expertise in all significant heat treatment processes like:

- Annealing
- Normalizing
- Stress Relieving
- Precipitation Hardening
- Aging
- Solution Treatment
- Spherodizing
- Hardening & Tempering
- Post-Weld Treatment

State-of-the-art automated heat treatment furnaces for lab scale samples to 30 tons charge are available.



▲ HAMMER FORGING



▲ RADIAL FORGING



▲ PEELING MACHINE



▲ HEAT TREATMENT



## A FEW REPRESENTATIVE STEEL GRADES PRODUCED BY PSM AND THEIR APPLICATIONS

PSM has so far produced more than 350 steel grades of International Standards and have capability to produce other grades with customized specification as well.

SR. NO.	STEEL TYPES	STEEL GRADES	CHEMICAL COMPOSITION (Wt %)										NEAREST GERMAN (BöHLER) GRADES	TYPICAL APPLICATIONS
			C	Si	Mn	P	S	Cr	Mo	Ni	Cu	Others		
1	Carbon Steels	AISI 1045	0.43	0.15	0.60	max.	max.	---	---	---	max.	---	1.1191	Parts of general engineering automobiles, vehicles, axles, coupling parts & shafts spindle etc.
			0.50	0.35	0.90	0.030	0.050	---	---	---	0.35	---		
2		AISI 1141	0.37	0.15	1.35	max.	0.08	---	---	---	---	---	1.0726	Generator Shafts, worm gears, wheel puller bolts where parts must resist wear and also be tough with good machinability.
			0.45	0.30	1.65	0.040	0.13	---	---	---	---	---		
3		ASTM A706	max.	max.	max.	max.	max.	---	---	---	---	---	1.057	Deformed and plain bars for concrete reinforcement, specially for construction of high rise earthquake resistance structures.
			0.30	0.50	1.50	0.035	0.045	---	---	---	---	---		
4	Case Hardening Steels	SCM-415	0.13	0.15	0.60	max.	max.	0.90	0.15	max.	max.	---	1.7262	Parts requiring toughness & core strength e.g. gears, shafts for automotive & general mechanical engineering.
			0.18	0.35	0.85	0.030	0.030	1.20	0.30	0.25	0.30	---		
5		20MnCr5	0.17	0.15	1.10	max.	max.	1.00	---	---	---	---	1.7147	Average size cog wheels, arbors & gears for vehicles etc.
			0.22	0.40	1.40	0.035	0.035	1.30	---	---	---	---		
6		AISI 8620	0.18	0.15	0.70	max.	max.	0.40	0.15	0.40	max.	---	1.6523	Parts of large cross section requiring toughness and core strength e.g. gears, crank shafts, shafts for aircraft, truck and for general mechanical engineering.
			0.23	0.35	0.90	0.035	0.040	0.60	0.25	0.70	0.35	---	(E 116)	
7	Heat Treatable Steels	AISI 5135	0.33	0.15	0.60	max.	max.	0.80	---	---	max.	---	1.7034	Highly stressed components of automobiles, vehicles and general mechanical engineering.
			0.38	0.35	0.80	0.035	0.040	1.05	---	---	0.35	---	(V 500)	
8		AISI 4140	0.38	0.15	0.75	max.	max.	0.80	0.15	max.	max.	---	1.7225	Automotive connecting rods, crankshafts, knuckles, rear axle and trailer axle shafts, oil industry, bits, core drills, reamer bodies, drill collars, tool joints, piston rods, aircraft, shapes, tubing and pump parts.
			0.43	0.35	1.00	0.030	0.040	1.10	0.25	0.25	0.35	---		
9		AISI 4340	0.38	0.15	0.80	max.	max.	0.70	0.20	1.65	max.	---	1.6565	Highly stressed components of large cross section e.g. aircraft, automotive & machines propeller/ gear/crank shafts, connecting rods & landing gear components etc.
			0.43	0.35	0.80	0.030	0.040	0.90	0.30	2.00	0.35	---	(V 121)	
10	Armour Steel	PSM 3	0.27	0.20	0.30	max.	max.	0.70	0.30	2.80	---	---	1.6659	Armour plates for tanks, military vehicles and bullet proof applications.
			0.33	0.40	0.60	0.020	0.015	1.10	0.50	3.50	---	---	(V 121)	
11	Spring Steels	SUP-9 (JIS-G 4801)	0.52	0.15	0.65	max.	max.	0.65	---	---	max.	---	1.7176	Leaf springs for automobiles/ heavy duty vehicles/ railways. Torsion bars & Coil springs.
			0.60	0.35	0.95	0.035	0.035	0.95	---	---	0.30	---		
12	Bearing Steel	AISI E 52100	0.98	0.15	0.25	max.	max.	1.30	max.	max.	max.	---	1.3505	Ball and roller bearing parts e.g. balls, rollers, needles, cones, rings and discs upto 30mm finishing thickness for service temperature upto 200°C.
			1.10	0.35	0.45	0.025	0.025	1.60	0.06	0.25	0.35	---	(R 100)	
13	Austenitic Stainless Steels	AISI 304L	max.	max.	max.	max.	max.	18.00	---	8.00	max.	N: 0.05-0.080	1.4306	Chemical industry, pharmaceutical industry and nuclear engineering.
			0.030	0.75	2.00	0.045	0.030	20.00	---	12.00	0.35	---	(A 604)	
14		AISI 316L	max.	max.	max.	max.	max.	16.00	2.00	10.00	---	N: ≤ 0.10	1.4404	Dyeing, sulphite, pulp, wood, dairy equipment, chemical & rayon industries.
			0.030	0.75	2.00	0.045	0.030	18.00	3.00	14.00	---	---	(A 100)	
15	Heat Resistant Stainless Steels	AISI 321	max.	max.	max.	max.	max.	17.00	---	9.00	---	Ti≥5x(C+N)≤ 0.70 N ≤ 0.10	1.4541	Aircraft exhaust stacks and manifolds, pressure vessels, large mufflers for stationary diesel engines, expansion bellows, stack liners & fire walls etc.
			0.08	1.00	2.00	0.045	0.030	19.00	---	12.00	---	---		
16		AISI 310S	max.	max.	max.	max.	max.	24.00	---	19.00	---	---	1.4845	Heat treatment furnace parts, grate, fitting, door, fan, super heated suspension, valves, spindles, bolts, nuts, rivets and tubes and tubular components in petroleum industry.
			0.08	1.50	2.00	0.045	0.030	26.00	---	22.00	---	---	(H 532)	
17	Martensitic Stainless Steels	SUS 420J2	0.26	max.	max.	max.	max.	12.00	---	max.	---	---	1.4028	Cutlery, knives, sword and valve parts, etc.
			0.40	1.00	1.00	0.040	0.030	14.00	---	0.60	---	---	(N 540)	
18		AISI 440C	0.95	max.	max.	max.	max.	16.00	max.	---	---	---	1.4125	Cutting tools requiring superior corrosion resistance, detergent resistant cutlery and for wear resistant components.
			1.20	1.00	1.00	0.040	0.030	18.00	0.75	---	---	---	(N 695)	
19	Tool Steels	AISI D2	1.40	0.30	0.30	max.	max.	11.00	0.70	---	---	V ≤ 0.80 Co ≤ 0.60	1.2379	Excellent toughness and suitable for bath nitriding, High-performance cutting dies and punches, shear blades for cutting, thread rolling dies, deep drawing, measuring tools, plastic molding, extrusion and pressing tools etc.
			1.60	0.50	0.50	0.030	0.025	13.00	1.20	---	---	---	(K 110)	
20		AISI P20	0.28	0.20	0.60	max.	max.	1.40	0.30	---	---	---	1.2330	Plastic moulds, backers, bolsters & die holders, Also suitable for applications like rails, shafts and wear strips.
			0.40	0.80	1.00	0.030	0.030	2.00	0.55	---	---	---		
21		AISI H13	0.30	0.80	0.20	max.	max.	4.75	1.25	---	---	V: 0.80 - 1.20 Al ≤ 0.10	1.2344	Heavy duty hot work dies, mandrels and tubes for hot extrusion. Die casting equipment, hot shear blades and plastic molding dies.
			0.40	1.20	0.40	0.025	0.025	5.50	1.75	---	---	---	(W 302)	
22		AISI T4	0.70	0.20	0.20	max.	max.	3.75	0.70	---	---	V: 0.80 - 1.20 W: 17.25 - 18.75 Co: 4.25 - 5.75	1.3255	Lathe and planing tools with eminent cutting strength and toughness.
			0.80	0.40	0.40	0.030	0.030	4.50	1.00	---	---	---		

Note: Elements given in ( ) are optional.

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## DIVISION-II: RE-MELTING DIVISION

### VIM Plant (Vacuum Induction Melting)

A Vacuum Induction Melting (VIM) plant with bottom and top ingot pouring techniques is producing electrodes up to 8 Mton. Re-melting and casting under vacuum makes possible the effective degassing of the melt and precise adjustment of alloy composition thereby producing an end product that is clean and homogeneous. The process has some distinct advantages like:

- High yield of expensive elements (Ni, Cr, etc.)
- Vacuum allows controlled addition of highly reactive elements
- Close tolerances achievable for various alloying elements-especially for reactive elements such as Al, Ti, Nb, Ta, B and Zr
- Very low Hydrogen, Oxygen and Nitrogen gas contents possible
- Removal of undesired trace elements (Pb, Cu, Se, Te, Bi)



▲ VIM PLANT

### VAR Plant (Vacuum Arc Re-melting)

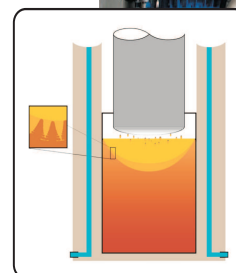
A secondary refining, VAR unit having 5 Mton capacity is used to improve the cleanliness and refine the structure of standard air-melted or vacuum induction melted ingots/ electrodes through continuous re-melting by means of an arc under vacuum.

The process produces special steels & super alloys required in high integrity applications where cleanliness, homogeneity, improved fatigue and fracture toughness of the final product are indispensable like nuclear and aerospace applications. The advantages of VAR process may be summarized as follows:

- No slag
- Inert heat source (electric arc)
- Inert atmosphere and mould controlled solidification
- Low gas content (H, N, O)



▲ VAR PLANT



- Good macro cleanliness
- Superior micro cleanliness
- Less segregation



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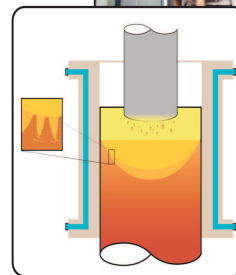
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## Electro-Slag Re-Melting (ESR)

A new Electro-Slag Re-Melting (ESR) plant with 35MT facility has been added in to the system. The technique involves re-melting of consumable electrodes in which liquid metal droplets are refined with contact of a molten slag providing a cleaner, more uniform alloy with minimum segregation. The resulting final metal product is used in the most demanding aerospace as well as a vast array of other applications.

The new advancements in Peoples Steel's manufacturing facilities enabled us to offer products like:

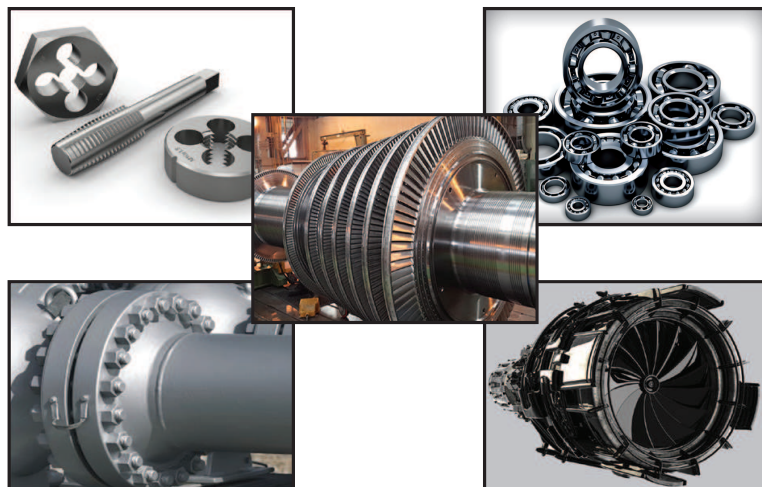
- Nickel based super alloys for high temperature applications
- Cobalt based alloys for medical applications
- Super alloys for aviation & aerospace industry
- Stainless steels for aggressive environments
- Tool Steels
- Ball Bearing Steels
- High purity and very clean Copper alloys
- Magnetic alloys for high permeability etc.



▲ ELECTRO-SLAG REMELTING (ESR)

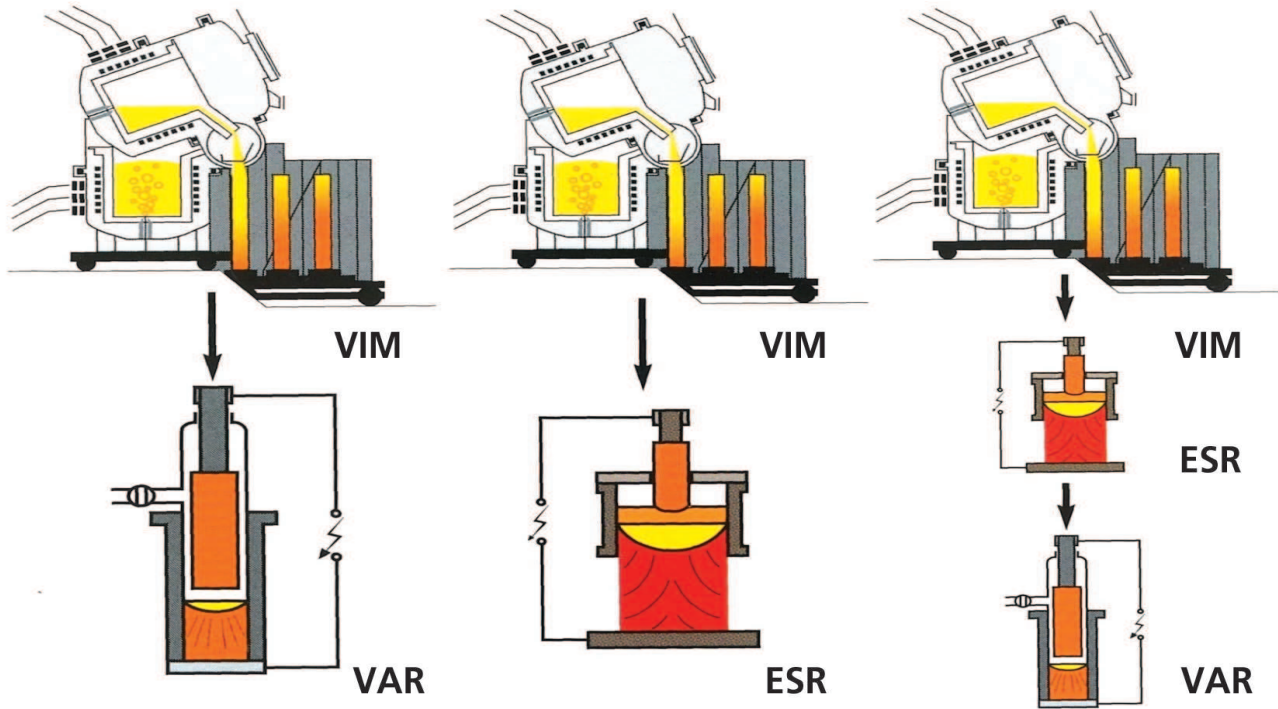


▲ 35 MT ESR INGOT

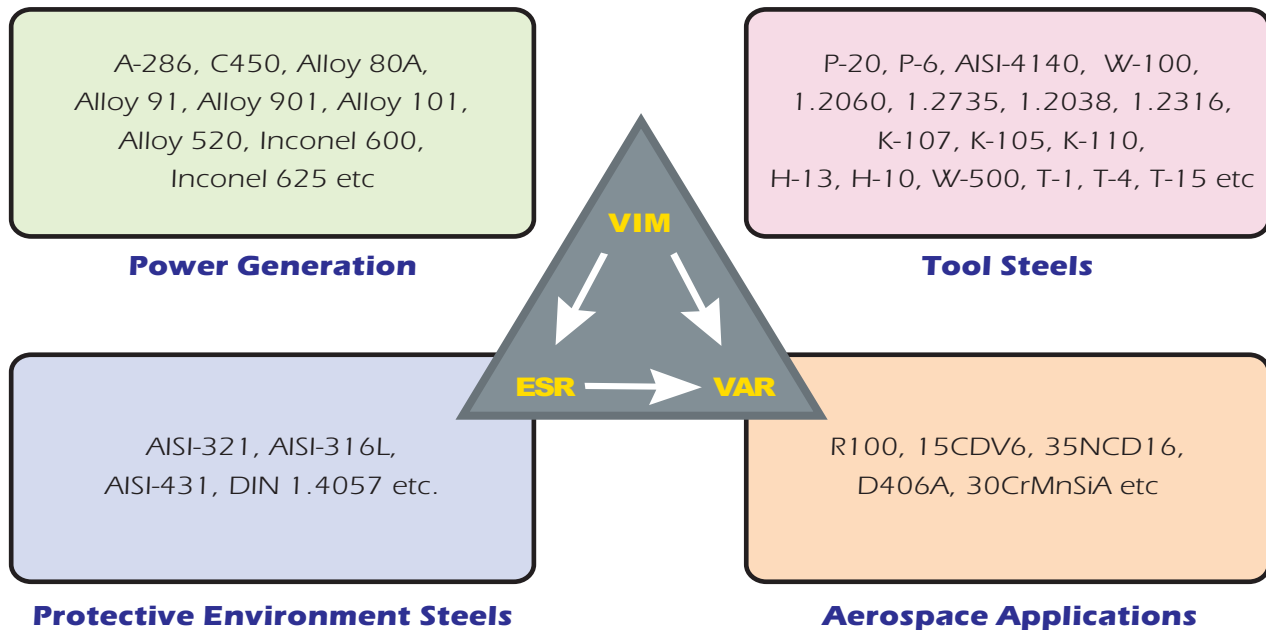


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## SOME REPRESENTATIVE APPLICATIONS/ GRADES





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## QUALITY ASSURANCE: MATERIAL TESTING, INSPECTION & FAILURE ANALYSIS

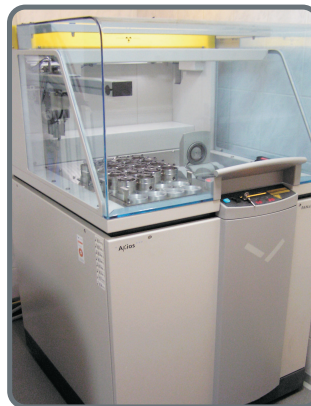
To meet the stringent quality requirements and adherence to the international quality standards Peoples Steel has strong quality assurance system and employs state-of-the-art material testing and analyzing facilities which includes:

- Chemical Analysis
- Material Identification
- Mechanical Testing
- Non-Destructive Testing (NDT)
- Metallography
- Failure Analysis
- Corrosion Testing
- Scanning Electron Microscopy (SEM)

In addition to in-house use, Peoples Steel also extends the Material Testing, Inspection, Failure Analysis and third party inspection facilities to industries such as petro-chemicals, fertilizer, engineering & railway etc.



▲ TENSILE TESTING MACHINE



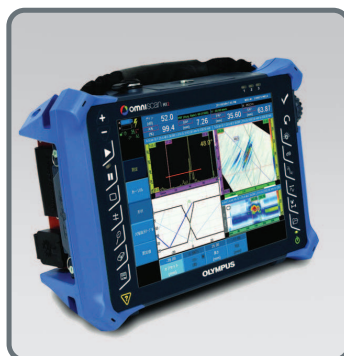
▲ XRF



▲ SPECTROMETER



▲ OPTICAL MICROSCOPE



▲ TOFD



▲ SCANNING ELECTRON MICROSCOPE

## REFRACTORY MANUFACTURING AND SERVICES

Peoples Steel is also producing high temperature refractory products. Our refractory division is engaged in production of High Alumina Bricks, Castables, Mortar, Calcined Bauxites etc. The refractory Mill is equipped with rotary kiln, screw friction press, ball mill, crushers of various types, mixture and gas fired furnaces along with following testing facilities;

- Cold Crushing Strength (CCS)
- Refractoriness under load (RUL)
- Quantitative XRF
- Bulk Density
- Apparent Porosity
- Wet Chemistry



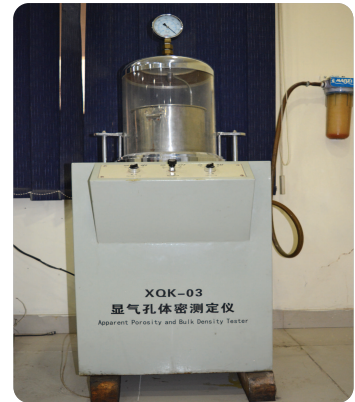
▲ ROTARY KILN



▲ FRICTION PRESS



▲ REFRACTORINESS UNDER LOAD



▲ APPARENT POROSITY MACHINE



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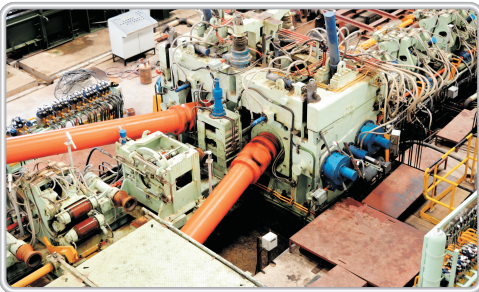
## SEAMLESS PIPE MANUFACTURING

To meet the diversified requirements of Oil and Gas, Process Industry, General Engineering, Automotive, Defence etc., Seamless Pipe Mill has been setup for the production of carbon/ alloy/ special steel seamless pipes and tubes as per international standards.

The Plant is equipped with state of the art facilities to produce hot rolled, cold drawn and cold rolled pipes / tubes, in the size range OD: 16mm - 220mm, wall thickness 1mm - 30mm and length upto 40ft.



▲ Rotary Hearth Furnace



▲ PIERCER



▲ HOT EXTRUSION



▲ READY TO SHIP

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## PRODUCTS

### ESR Ingot

Diameter : 400, 600, 800, 1000, 1250 mm  
Length : 3.6 meters (max.)  
Weight : 35 mt (max.)

### Concast Billet

Square : 110, 125, 150, 230 mm  
Round : 110 mm  
Length : 4 - 6 meters

### Round Bars

Diameter : 18, 20, 23, 25, 26, 28, 30, 32, 34, 36, 38, 40, 43, 45, 48, 50, 53, 55, 57, 60, 63, 65, 68, 70, 75, 80, 90, 110, 120, 130mm  
Length : 4 - 6 meters

### Flat Bars

Thickness : 6 - 25 mm  
Width : 50 - 110 mm  
Length : 4 - 6 meters

### Cold Drawn Bars

Diameter : 10 - 65 mm  
Length : 4 - 6 meters

### Sheets

Thickness : 3 - 8mm  
Width : Up to 950mm  
Length : Up to 3000 mm

### Press Forging

Shafts : Dia 500 mm (max.)  
Disc : Dia 1500 mm (max.)  
Length : 8 meters (max.)  
Weight : 12 mt (max.)

### Forged Rings

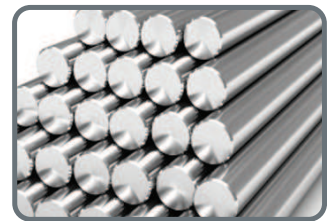
Outer Diameter : 500 - 2200 mm  
Inner Diameter : 300 - 1950 mm  
Thickness : 125 - 950 mm  
Height : 100 - 350 mm  
Weight : 2.2 mt (max.)

### VIM/ VAR Ingot

VAR Diameter : 650mm (max)  
VAR weight : 5 mt (max.)  
VIM weight : 8 mt (max.)

### Rolled Billet

Square : 75, 90, 100, 120, 160 mm  
Length : 4 - 6 meters



### Peeled, Ground and Polished Bars

Diameter : 20 - 80 mm  
Length : 3 - 6 meters

### Plates

Thickness : 8 - 50mm  
Width : Up to 1500 mm  
Length : 6 - 12 meters (Depending upon thickness & width)

### Hammer Forging

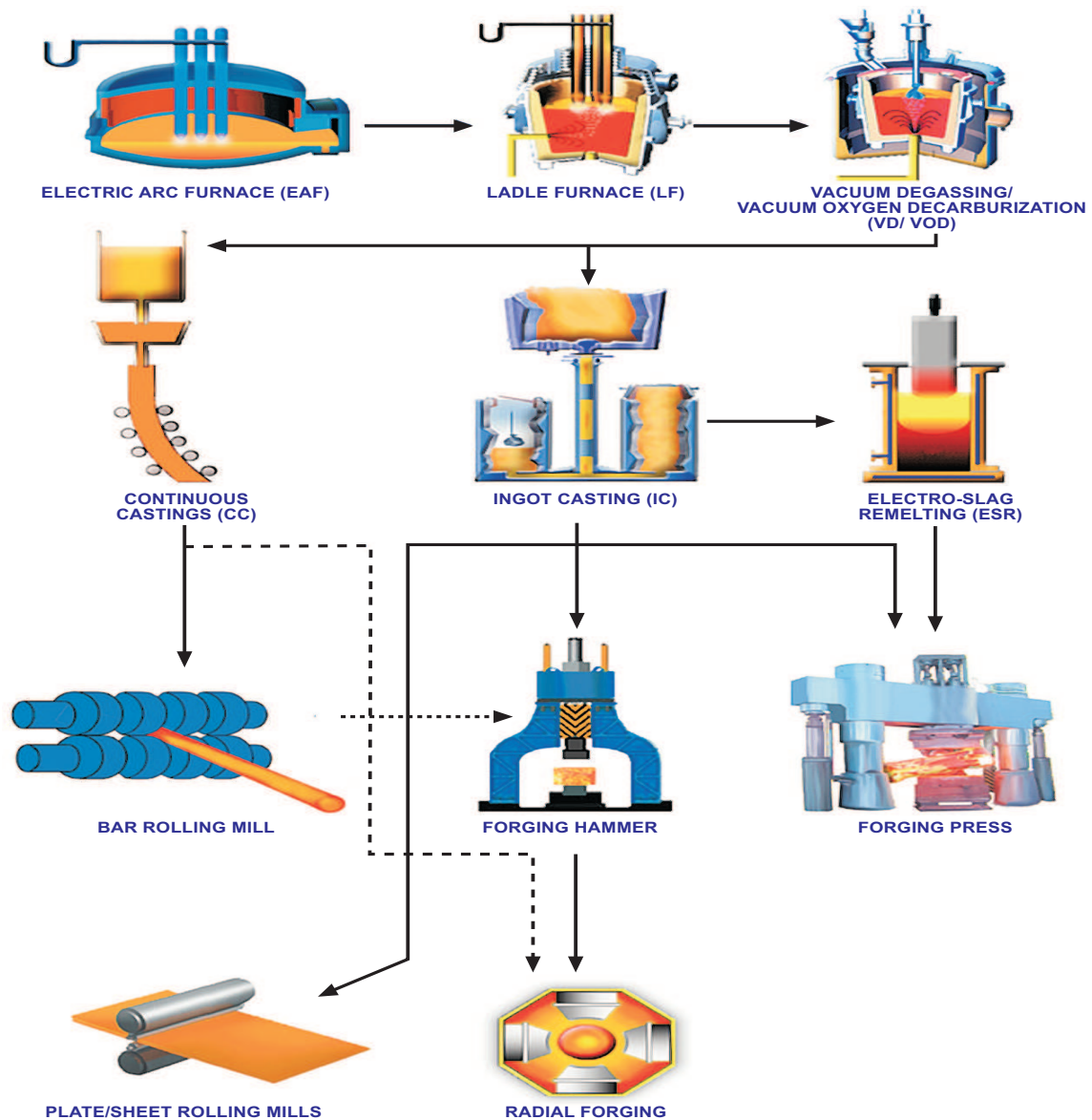
Close Die : Up to 15 kg  
Free Forging : Up to 1500 kg

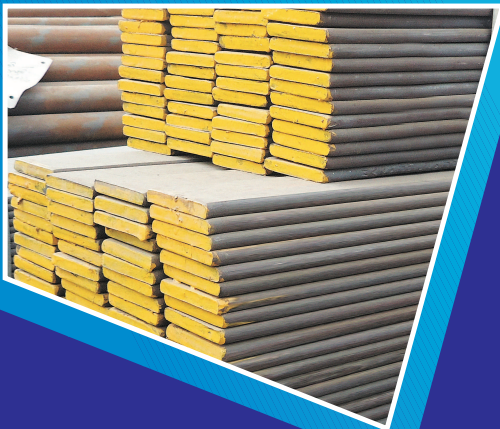
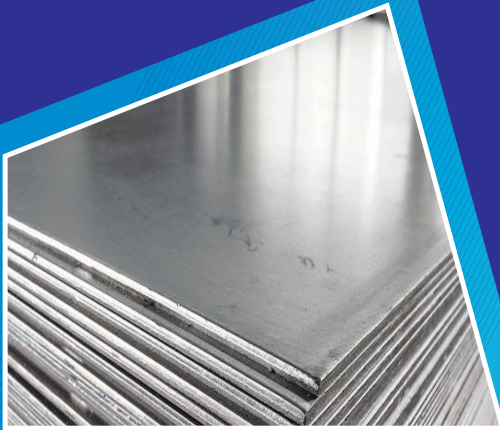
### Radial Forging

Size : Square, Round & Varying Section  
Profile/ Axle of cross section  
60-200 mm and Flat of thickness  
30 - 150 mm & width 60 - 180 mm  
Length : 4 - 6 meters



# PROCESS FLOW DIAGRAM





## Peoples Steel Mills Ltd.

Javedan Nagar, Manghopir, Karachi-75890, Pakistan.

PABX: (92-21) 36770126-28, Fax: (92-21) 36770112,

Marketing: (92-21) 36770116-18, 36770130-32

E-mail : [marketing@psmltd.com](mailto:marketing@psmltd.com), Website : [www.psmltd.com](http://www.psmltd.com)