electrode tip dresser for manual welding guns

electrode tip dresser for robot welding guns

electrode tip changer

combi units (combined electrode tip dresser/changer)

swivelling systems
electrode tip dresser
for manual welding guns

- pneumatically driven
  BF 2400.000.10
  BF 2401.000.00

- electrically driven
  BF 2450.000.00

- hand-operated
  BF 2470.000.00
The advantages of the Bräuer manual tip dresser are obvious. Our manual tip dresser are offered in several types, e.g. pneumatically and electrically driven or with manual leverage, and is an inexpensive solution for the manual electrode dressing for the single user.

The units are flexible, quick and milling head changes are possible and also the milling of different geometries is possible.

**delivery scope:**

The manual tip dresser **BF-2400.000.10** consists of the following parts:
- 1 milling gear unit
- 1 pneumatic drive (hand lever with turn-on-protection)
- 1 handle bar (mountable on left or right side)
- 1 ready-made connection tube (tube end with nozzle NW7,2; coupling NW 7,2 with nozzle for tube inner diameter of app. 9 mm)

**note:**
The necessary milling head needs to be ordered separately. Please supply us with a drawing of the used electrode caps and the desired shape of the electrode cap after the milling process.

**illustration:**

![Manual Tip Dresser BF-2400.000.10](image)

**ordering example:**
F-2400.000.10
manual tip dresser
The Bräuer electrode tip dresser BF 2400 is a pneumatically driven unit which can mill two electrodes or electrode caps at the same time. The welding gun needs to be closed for the milling operation due to the milling of both electrode caps.

**technical data:**

- **weight:** app. 2.5 kg
- **torque:** 90 Nm
- **revolutions at milling head:** 170 rpm
- **compressed air connection:** 5.5-6.3 bar
- **release measure:** min. 20 mm (between upper and lower electrode)
- **gun force:** min. 1.0 kN, max. 1.8 kN
The advantages of the Bräuer manual tip dresser are obvious. Our manual tip dresser are offered in several types, e.g. pneumatically and electrically driven or with manual leverage, and is an inexpensive solution for the manual electrode dressing for the single user. The units are flexible, quick and milling head changes are possible and also the milling of different geometries is possible.

**delivery scope:**

The manual tip dresser BF-2401.000.00 consists of the following parts:

- 1 milling gear unit
- 1 pneumatic drive (lever with start up fuse)
- 1 handle-bar (mountable on left or right side)
- 1 fork (positioning of electrode cap)
- 1 made-up connecting tube (tube end with plug-in nozzle NW7,2; clutch NW 7,2 with tube nozzle for inner tube diameter of app. 9 mm)

**note:**

The necessary milling head needs to be ordered separately. Please supply us with a drawing of the used electrode caps and the desired shape of the electrode cap after the milling process.

**illustration:**

![Image of the manual tip dresser BF-2401.000.00]

**ordering example:**

F-2401.000.00
manual tip dresser
manual tip dresser BF-2401.000.00

operating principle:

The manual tip dresser BF 2401 is a pneumatically driven unit that can mill each electrode separately due to its reversion of the lever. The closure of the welding gun is not necessary.

technical data:

- weight: app. 2,5 kg
- torque: 90 Nm
- revolutions at milling head: 170 U/min
- compressed air connection: 5,5-6,3 bar
- release measure: min. 20 mm (between upper and lower electrode)
- gun force: min. 1,0 kN, max. 1,8 kN
The advantages of the Bräuer manual tip dresser are obvious. Our manual tip dresser are offered in several types, e.g. pneumatically and electrically driven or with manual leverage, and is an inexpensive solution for the manual electrode dressing for the single user.

The units are flexible, quick and milling head changes are possible and also the milling of different geometries is possible.

**delivery scope:**

The manual tip dresser BF-2450.000.00 consists of the following parts:

- 1 milling gear unit
- 1 electrical drive
- 2 accumulators (Ni-Cd)
- 1 speed charger
- 1 hardcase for storage of unit

**note:**

The necessary milling head needs to be ordered separately. Please supply us with a drawing of the used electrode caps and the desired shape of the electrode cap after the milling process.

**illustration:**

ordering example:
F-2450.000.00
manual tip dresser
manual tip dresser BF-2450.000.00

operating principle:

Bräuer's manual tip dresser BF 2450 is an electrically driven unit and especially designed for the milling process of electrode caps of manual welding guns. The welding gun needs to be closed during the milling procedure because both electrode caps are milled at the same time.

technical data:

- weight: app. 2.9 kg (with battery)
- torque: 94 Nm
- revolutions at milling head: 170 U/min
- rated voltage: 14.4 V
- release measure: min. 20 mm (between upper and lower electrode)
- gun force: min. 1.0 kN, max. 1.8 kN
The advantages of the Bräuer manual tip dresser are obvious. Our manual tip dresser are offered in several types, e.g. pneumatically and electrically driven or with manual leverage, and is an inexpensive solution for the manual electrode dressing for the single user. The units are flexible, quick and milling head changes are possible and also the milling of different geometries is possible.

**delivery scope:**

The manual tip dresser BF-2470.000.00 consists of the following parts:
- 1 milling gear unit
- 1 ratching tool

**note:**
The necessary milling head needs to be ordered separately. Please supply us with a drawing of the used electrode caps and the desired shape of the electrode cap after the milling process.

**ordering example:**
F-2470.000.00
manual tip dresser
manual tip dresser BF-2470.000.00

operating principle:

The manual electrode tip dresser BF 2470 is a low-priced unit. This manual tip dresser has been especially designed for the milling process of electrodes and electrode caps of manual welding guns, the BF 2470 can also be operated on spot welding machines or similar assembled systems. The manual tip dresser is even suitable for manual welding guns without a proportional valve, a gun pressure up to app. 4 kN is not a problem. The welding gun needs to be closed during the milling procedure because both electrode caps are milled at the same time.

technical data:

weight:            app. 1,6 kg
release measure:   min. 20 mm (between upper and lower electrode)
gun force:         app. 1,5 kN
Technical Information

electrode tip dresser for robot welding guns

single head
BFS 3600.037.00A

double head
BFS 3610.037.00A

Bräuer Systemtechnik GmbH
Gewerbestraße 4
09488 Thermalbad Wiesenbad OT Schönfeld
Germany

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Stationary electrode tip dresser support the welding process within a robot cell by reshaping the electrode cap after a certain amount of welding points. These units can be ordered in setup H, V1 and V2. For setup type V2 an additional vertical angle needs to be added to your order. The necessary milling head needs to be ordered separately. We will be glad to assist you in choosing one.

**delivery scope:**

The standard stationary electrode tip dresser BFS-3600.037.00A consists:

- 1 milling base unit with vertical height equalization
- 1 proximity switch "rotation" with connecting cable
- 1 motor (power: 0.75 kW) including terminal box and connecting cable
- 1 electrical switch box (standard) with double bit lock in RAL-colour 7035
- 1 swarf lead system and swarf bag
- 1 solenoid valve (standard) for swarf blow-out and connecting cable
- 1 height-adjustable stand without dowel

*Please specify RAL-colour when ordering, otherwise stand will be painted RAL-colour 9002.*

**illustrations:**

![setup type H](image1)

![setup type V1 (standard)](image2)

![setup type V2](image3)

**ordering example:**

F-3600.037.00A electrode tip dresser, setup type H

*stand in RAL-colour 9010*
<table>
<thead>
<tr>
<th>Zeit</th>
<th>Datum</th>
<th>Name</th>
<th>Bearb.</th>
<th>Norm</th>
<th>Grenz</th>
<th>Gepr.</th>
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<td>1</td>
<td>25.07.05</td>
<td>Rico Sander</td>
<td>02.08.06</td>
<td>NSB-3000-038.3</td>
<td>0</td>
<td>1</td>
</tr>
</tbody>
</table>

**EINSPEISUNG**

- Power supply

**ZUM NÄCHSTEN FRÄSER**

- To the next tip dresser

**FRÄSERMOTOR**

- Drive

**START FRÄSEN**

- Start cutting

**AUSBLASVORRICHTUNG**

- Blow out

**DREHIMPULSE**

- Rotary sensor detection

---

**Diagram Notes**

- 400V AC 3/PE 50Hz
- 24V DC
- Start cuting: 0V DC 4 kW
- Drive: 3/4 = 5/6
- Blow out: 1/2 = 3/4 = 5/6
- Tip dresser turning: 13/14
- Detection: 1/2 = 3/4 = 2
- Sensor: 2
- 0.75 kW
- 4 kW
- 4x2.5mm
- 5x1.0mm
- L1
- L2
- L3
- PE

---

**Schweiftechnik Bräuer GmbH**

Gewerbestraße 4
09488 Thermalbad Wiesenbad / Schöna
Tel: 03733/560110
Fax: 03733/560111
Stationary electrode tip dresser support the welding process within a robot cell by reshaping the electrode cap after a certain amount of welding points. These units can be ordered in setup H, V1 and V2. For setup type V2 an additional vertical angle needs to be added to your order. The necessary milling heads need to be ordered separately. We will be glad to assist you in choosing one.

**delivery scope:**

The standard stationary electrode tip dresser BFS-3610.037.00A consists:
- 1 milling base unit with vertical height equalization
- 1 proximity switch "rotation“ with connecting cable
- 1 motor (power: 0.75 kW) including terminal box and connecting cable
- 1 electrical switch box (standard) with double bit lock in RAL-colour 7035
- 1 swarf lead system and swarf bag
- 1 solenoid valve (standard) for swarf blow-out and connecting cable
- 1 height-adjustable stand without dowel

*Please specify RAL-colour when ordering, otherwise stand will be painted RAL-colour 9002.*

**illustrations:**

* setup type H
* setup type V1 (standard)
* setup type V2

**ordering example:**

F-3610.037.00A

electrode tip dresser, setup type H / V1 / V2

*stand in RAL-colour 9010*
EINSPEISUNG: power supply
ZUM NÄCHSTEN FRÄSER to the next tip dresser
FRÄSMOTOR: drive

400/480V AC 3/PE 50/60Hz

24V DC

START FRÄSEN start cutting
AUSBLASVORRICHTUNG blow out
DREHIMPULSE rotary sensor detection

Schweizitätchnik Bräuer GmbH
Kranenstraße 4
D-09488 Wiesenbad / Schönafeld
Tel: 03733/560110
Fax: 03733/560111

NSB-3000.038.3
electrode tip changer for robot welding guns

single head
BWS 5700.037.00A

double head
BWS 5710.037.00A
Stationary electrode tip changer support the welding process within a robot cell by changing the electrode cap automated after a certain amount of welding points. These units can be ordered in setup types H and V2. For setup type V2 an additional vertical angle needs to be added to your order. The necessary changing heads are already included in the delivery scope. The cap magazine will have to be adapted to your used electrode caps. Please provide us with a technical data sheet on the used electrode caps.

**delivery scope:**

The standard stationary electrode tip changer BWS-5700.037.00A consists of:
- 1 base unit with electrical drive
- 1 electrical switch box (standard) with double bit lock in RAL-colour 7035
- 1 changing head
- 1 proximity switch for cap control monitoring
- 1 basic magazine body with refillable changing magazine
- 1 cap push-on plate if required
- 1 cap catching box
- 1 height-adjustable stand without dowel

*Please specify RAL-colour when ordering, otherwise stand will be painted RAL-colour 9002.*

**illustrations:**

*illustration not available*

**ordering example:**

BWS-5700.037.00A
electrode tip changer, setup type H / V2
*stand in RAL-colour 9010*
**EINSPEISUNG**

power supply

**ZUM NÄCHSTEN KAPPENWECHSLER**

to the next tip device

**MOTOR**

electric motor

---

**Datum**

14.03.11

**Bearb.**

SANDER

**Grafik**

21.11.11

---

**KAPPENWECHSLER**

BKS 5700/5710...

---

**Bräuer Systemtechnik GmbH**

Gewerbestraße 4

09488 Thermalbad Wiesenbad / Schönfeld

Tel: 03733/560110

Fax: 03733/560111

---

**NSB-5700-037.00**

Bl. 1

---

400V AC 3/PE 50Hz

---

W1 4x2.5mm²

---

W1.1 4x2.5mm²

---

PE 1/2 3/4 5/6

---

-XL1

---

-K1 3,3

---

-K2 3,5

---

-ZUM NÄCHSTEN KAPPENWECHSLER

to the next tip device

---

M 5~

---

-M1 0,80kW

---

-KAPPENWECHSLER

BKS 5700/5710...

---

Bräuer Systemtechnik GmbH

Gewerbestraße 4

09488 Thermalbad Wiesenbad / Schönfeld

Tel: 03733/560110

Fax: 03733/560111

---

**Bl. 1**

---

**Datum**

14.03.11

**Bearb.**

SANDER

**Grafik**

21.11.11

---

400V AC 3/PE 50Hz

---

W1 4x2.5mm²

---

W1.1 4x2.5mm²

---

PE 1/2 3/4 5/6

---

-XL1

---

-K1 3,3

---

-K2 3,5

---

-ZUM NÄCHSTEN KAPPENWECHSLER

to the next tip device

---

M 5~

---

-M1 0,80kW

---

-KAPPENWECHSLER

BKS 5700/5710...

---

Bräuer Systemtechnik GmbH

Gewerbestraße 4

09488 Thermalbad Wiesenbad / Schönfeld

Tel: 03733/560110

Fax: 03733/560111

---

**Bl. 1**
1.8/PE
-XL1

power supply control 24VDC

+24VDC

sensor 1 for caps level

INITIATOR 1

FÜLLSTAND MAGAZIN

sensor 1 for caps level

INITIATOR 2

FÜLLSTAND MAGAZIN

sensor 2 for caps level

sensor caps control/monitoring

INITIATOR 1

KAPPENKONTROLLE

sensor caps control/monitoring

INITIATOR 2

KAPPENKONTROLLE

signal cap relaxedly

SIGNAL KAPE GELT

Y-KABEL

-B2

-B3

-B4

+3.1 +24VDC

RESET/3.1

KAPPE/3.1

PE/3.1

-24VDC

Brüder Systemtechnik GmbH
Gewerbestraße 4
09488 Thermalbad Wiesenbad / Schönfeld
Tel: 03733/560110
Fax: 03733/560111

KAPPENWECHSLER
BKS 5700/5710...
Stationary electrode tip changer support the welding process within a robot cell by changing the electrode cap automated after a certain amount of welding points. These units can be ordered in setup types H and V2. For setup type V2 an additional vertical angle needs to be added to your order. The necessary changing heads are already included in the delivery scope. The cap magazine will have to be adapted to your used electrode caps. Please provide us with a technical data sheet on the used electrode caps.

**delivery scope:**

The standard stationary electrode tip changer BWS-5710.037.00A consists of:

- 1 base unit with electrical drive
- 1 electrical switch box (standard) with double bit lock in RAL-colour 7035
- 2 changing heads
- 1 proximity switch for cap control monitoring
- 1 basic magazine body with refillable changing magazine
- 1 cap push-on plate if required
- 1 cap catching box
- 1 height-adjustable stand without dowel

*Please specify RAL-colour when ordering, otherwise stand will be painted RAL-colour 9002.*

**illustrations:**

*Illustration not available*

**ordering example:**

BWS-5710.037.00A electrode tip changer, setup type H / V2 stand in RAL-colour 9010
EINSPEISUNG
power supply

ZUM NÄCHSTEN KAPPENWECHSLER
to the next tip device

MOTOR
electric motor

400V AC 3/PE 50Hz

Bräuer Systemtechnik GmbH
Gaußparkstraße 4
09488 Dreschfeld / Schönbüel
Tel.: 03733/560110
Fax: 03733/560111

NSB-5700-037.00

Datum: 14.03.11
Bearb.: SANDER

Datum: 21.11.11
Bearb.: SANDER

KAPPENWECHSLER
BKS 5700/5710...

M1
0,80 kW
Technical Information

combi units
(combined electrode tip dresser/changer)

do double head
BKS 5810.037.00A

do triple head
BKS 5820.037.00A
Stationary combi units support the welding process within a robot cell by milling the shape of the electrode cap after a certain amount of welding spots and changing this electrode cap after worn. These unit can be ordered in setup type H and V2. For setup type V2 an additional vertical angle needs to be added to your order.

The necessary changing heads are already included in the delivery scope. The cap magazine will have to be adapted to your used electrode caps. Please provide us with a technical data sheet on the used electrode caps.

**delivery scope:**

The stationary combi unit BKS-5810.037.00A consists of:

- 1 basic unit with electric drive
- 1 electrical switch box (standard) with double bit lock in RAL-colour 7035
- 1 changing head
- 1 proximity switch for cap control monitoring
- 1 magazine basic body with refillable changing magazine
- 1 cap push-on plate if required
- 1 cap collection box
- 1 height-adjustable stand without dowels

*Please specify your RAL-colour when ordering, otherwise stand will be painted in RAL 9002.*

**illustrations:**

![setup type H](image1)

![setup type V2](image2)

**ordering example:**

**BKS-5810.037.00A**

combi unit (electroden tip dresser & changer), setup type H / V2

*stand in RAL-colour 9010*
Stationary combi units support the welding process within a robot cell by milling the shape of the electrode cap after a certain amount of welding spots and changing this electrode cap after worn. These unit can be ordered in setup type H and V2. For setup type V2 an additional vertical angle needs to be added to your order. The necessary changing heads are already included in the delivery scope. The cap magazine will have to be adapted to your used electrode caps. Please provide us with a technical data sheet on the used electrode caps.

**delivery scope:**

The stationary combi unit BKS-5820.037.00A consists of:
- 1 basic unit with electric drive
- 1 electrical switch box (standard) with double bit lock in RAL-colour 7035
- 2 changing heads
- 1 proximity switch for cap control monitoring
- 1 magazine basic body with refillable changing magazine
- 1 cap push-on plate if required
- 1 cap collection box
- 1 height-adjustable stand without dowels

Please specify your RAL-colour when ordering, otherwise stand will be painted in RAL 9002.

**illustrations:**

[Images of the combi unit in setup types H and V2]

**ordering example:**

**BKS-5820.037.00A**
combi unit (electroden tip dresser & changer), setup type H / V2
*stand in RAL-colour 9010*
Schweißtechnik Brüer GmbH
Gewerbestraße 4
09488 Thermalbad Wiesenbad / Schönfeld
Tel: 03733/560110
Fax: 03733/560111

EINSPEISUNG
power supply

ZUM NÄCHSTEN KAPPENWECHSLER
to the next tip device

MOTOR
electric motor

400V AC 3/PE 50Hz

KAPPENWECHSLER
BKS 5820...
Technical Information

swivelling systems

pneumatically driven
FS 1000.37000

electrically driven
FS 1600.37000
Swivelling systems are used for pedestal welding guns where stationary tip dressers cannot be applied. These swivelling systems can be ordered as electrically or pneumatically driven units. The swivelling electrode tip dresser is supplied on a basic mounted swing-in unit. According to our longtime experience the basic mounted swing-in unit consists of basic component groups. Depending on the project further components can be added accordingly.

**delivery scope:**

The basic mounting of the swivelling system **FS-1000.37000** includes:

- **swing-in unit F-1000.037.00** with standard cylinder (size:100x250mm), split swivelling arm as well as 2 proximity switches "end position monitoring" and 2 shock absorbers for end position
- **1 cross-clamp for the radial arm**
- **1 radial arm** (length: 400mm)
- **electrode tip dresser (type: BF-3600.037.500)** which also includes a swarf blow-out system, standard solenoid valve for swarf blow-out and a proximity switch "rotation monitoring"  
  *Please note that the milling head needs to be ordered separately!*
- **1 standard 5/3-distributing valve, 2 throttle valves and 2 throttle check valves** for the triggering of the cylinder of the swivelling system including hosing  
  *Please see the pneumatic plan 1000-037.00 for further information!*
- **standard electrical switch box containing of all connecting cables to the swing-in unit respectively the electrode tip dresser**  
  *Please see wiring diagramm NSB-1000-037.00 for further technical details! Note that the cable package is approximately 2m long, electrical switch box needs to be mounted at a proper place by customer.*

**illustrations:**

*Schwenksystem in Fräsposition*
Product Information Sheet

complete swivelling system

swivelling system FS-1000.37000

illustrations:

Schwenksystem in Ruheposition

ordering example:
FS-1600.37000
swivelling system 1600.37000
(basic plate RAL 9002 / swivelling arm RAL 2000)

note:
Please state the RAL-colours of the moving and fixed parts when ordering!

Caution!
These swivelling systems can only be used for setup types in which the electrode tip dresser will not leave its position due to its own weight when remaining in the electrode tip dressers's resting position.

Please see the pneumatic plan and wiring diagram on the following pages.
Pneumatikzylinder 100x250

Ausblaseinheit

Druckluftanschluß
6 bar

Schwenkeinheit- ohne Abstecker
swing in unit without peggin unit
Standard
Swivelling systems are used for pedestal welding guns where stationary tip dressers cannot be applied. These swivelling systems can be ordered as electrically or pneumatically driven units. The swivelling electrode tip dresser is supplied on a basic mounted swing-in unit. According to our longtime experience the basic mounted swing-in unit consists of basic component groups. Depending on the project further components can be added accordingly.

**delivery scope:**

The basic mounting of the swivelling system FS-1600.37000 includes:
- swing-in unit F-1600.037.00 consisting of 2 proximity switches for end position check, 2 cams and a range position switch for end position switch-off
- 1 cross-clamp for the radial arm
- 1 radial arm (length: 400mm)
- electrode tip dresser (type: BF-3600.037.400) which also includes a swarf blow-out system, standard solenoid valve for swarf blow-out and a proximity switch “rotation monitoring”

Please note that the milling head needs to be ordered separately!

- standard electrical switch box containing of all connecting cables to the swing-in unit respectively the electrode tip dresser

Please see wiring diagramm NSB-1600-037.00 for further technical details! Note that the cable package is approximately 2m long, electrical switch box needs to be mounted at a proper place by customer.

**illustrations:**

"left-handed" type with above stated equipment (electrical switch box not shown in illustrations)
The swing-in system can supplied as a "left-handed" (ill. 1) or "right-handed" (ill. 2) version for 4 different swinging areas each. In addition to that, two motor types are possible. Due to the different versions 16 delivery packages for the standard swing-in system are possible:

### swing-in system - "left-motorized" type:

<table>
<thead>
<tr>
<th>type</th>
<th>swivel angle</th>
<th>Bräuer article number</th>
<th>motor by SIEMENS</th>
<th>motor by SEW</th>
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<td>&quot;left&quot;</td>
<td>90°</td>
<td>FS-1600.37000</td>
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<td>FS-1600.37005</td>
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<td>&quot;left&quot;</td>
<td>80°</td>
<td>FS-1600.37001</td>
<td></td>
<td>FS-1600.37006</td>
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<td>70°</td>
<td>FS-1600.37002</td>
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<td>FS-1600.37007</td>
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<td>FS-1600.37003</td>
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</table>

### swing-in system - "right-motorized" type:

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<th>swivel angle</th>
<th>Bräuer article number</th>
<th>motor by SIEMENS</th>
<th>motor by SEW</th>
</tr>
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<tbody>
<tr>
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<td>90°</td>
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<td>FS-1600.37015</td>
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</tr>
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<td>60°</td>
<td>FS-1600.37013</td>
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</tr>
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</table>

**note:**

Please state the RAL-colours of the moving and fixed parts when ordering!

**ordering example:**

FS-1600.37000
swing-in system 1600.37000
(basic plate RAL 9002 / swinging arm RAL 2000)
INDIA
NATASHA ENTERPRISES
362, Aggarwal Modern Bazar
C-33, Lawrence Road Industrial Area
Delhi-110035
INDIA
phone: +91 11 32 91-8574
fax: +91 11 27 15-2799
e-mail: enquiry@natashaenterprises.co.in
URL: www.natashaenterprises.co.in
contact person: Mr. Kumar Ashok
phone: +91 11 47 35-4897
e-mail: ashok@natashaenterprises.co.in

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contact person: Mr. Paolo Gai

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