



KOMET DIHART Reamax® TS
Modular reaming system

KOMET DIHART Reamax® TS

Modular reaming system

Application:

- All current materials
- Through holes and blind bores
- Small bore tolerances
- Up to $5 \times D$
- High speed – up to 500 m/min
- Feed – up to 2.4 mm/rev

Benefits for you:

- Faster, high precision tool change
- Absolute minimum setting time
- Maximum flexibility
- Simple and cost effective tool logistics
- High precision adjustment
- Application specified cutting edge geometry

Unlimited flexibility and cost-effectiveness

KOMET DIHART Reamax® TS is a uniform clamping system with a standardised separation point for all KOMET DIHART reaming heads, offering flexibility and cost-effectiveness thanks to fast and high-precision tool changing.

KOMET DIHART Reamax® TS guarantees a maximum of system modularity thanks to a versatile and clearly structured range of reaming heads which can handle all commonly encountered diameter ranges and machining requirements. Tool costs and logistical expenditure are thereby reduced to a minimum.



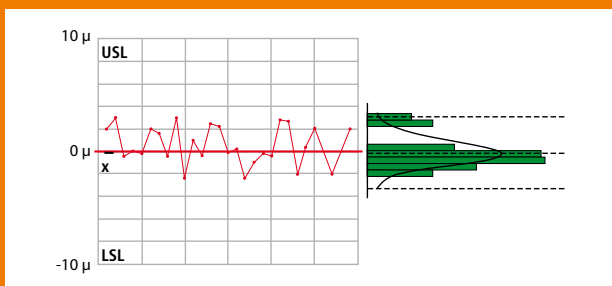
A connection for maximum production reliability

This high-precision connection guarantees safer transfer of the torque which occurs during reaming and the concentricity required for precision machining. KOMET DIHART Reamax® TS is designed for high speed machining.

Minimising setting time

The radial clamping system allows the reaming tools to be changed without removing the holder from the adaptor, reducing the setting time considerably.

KOMET DIHART Reamax® TS provides maximum production reliability for the smallest tolerances.



Multi-flute tools

Adjustable for small tolerances

To compensate for wear and to meet tolerances as small as IT4, all KOMET DIHART Reamax® TS multi-flute tools are adjustable. Maximum repeatable accuracy is achieved without pre-setting, i.e.

- Longer tool life
- Maximum performance
- Extremely tight bore tolerances
- Less machine down time

With internal coolant system

The coolant is supplied through the tool with radial or central outlet.



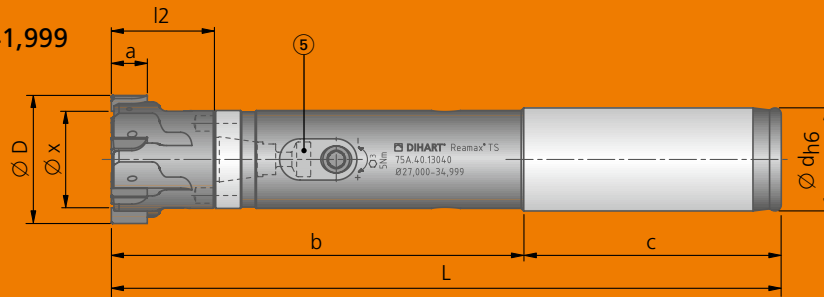
KOMET DIHART Reamax® TS

Reaming Heads Ø 18,000 – 64,999 mm and Holder

Reaming Heads – expandable

- Carbide and Cermet
- high precision changing
- variety of coatings

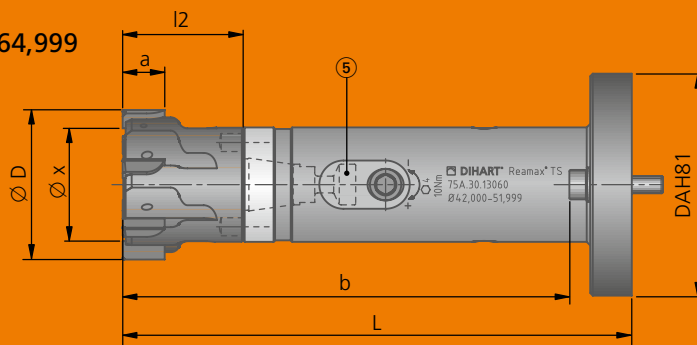
Ø 18,000 – 41,999



Holder

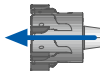
- with cylindrical shank similar to DIN1835
- with internal coolant supply

Ø 42,000 – 64,999



Holder

- for DAH® adapters, patent DIHART®
- with internal coolant supply

Reamax® TS						Basic recommendation									
Ø D	Ø x* ~	a ~	l2 ~	 No. of flutes	 kg	Cutting material / Coating	Reaming head		for material						
							 Order No.	 Order No.	P	M	K	N	S	H	
18,000 – 19,999	Ø D – 4,0	6,0	20	6	0,03										
20,000 – 21,999	Ø D – 4,0	6,0	20	6	0,03								GGG		
22,000 – 26,999	Ø D – 4,2	6,0	20	6	0,04										
27,000 – 31,799	Ø D – 5,4	6,0	25	6	0,04										
31,800 – 34,999	Ø D – 6,0	6,0	25	8	0,05										
35,000 – 41,999	Ø D – 6,9	6,0	25	8	0,13-0,15										
42,000 – 51,999	Ø D – 7,5	6,0	30	8	0,20-0,25										
52,000 – 64,999	Ø D – 8,8	8,0	35	10	0,35-0,45										

Supply includes: Reamax® TS reaming head complete.

* minimal diameter for face machining!

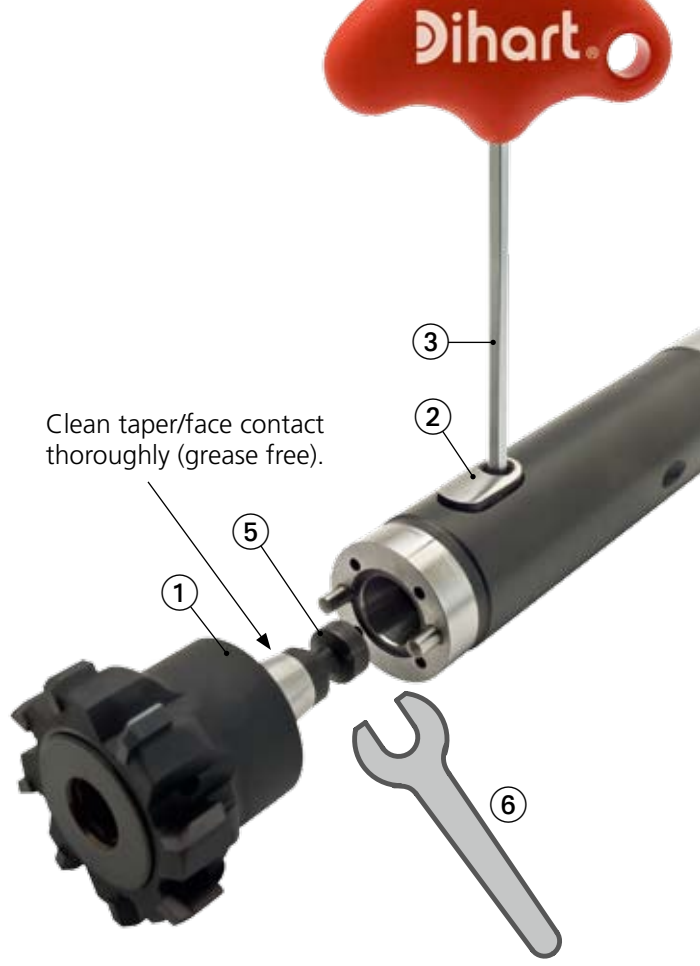
Ø D	Short version						Long version						Assembly parts
	Order No.	L	b	c	Ø d	kg	Order No.	L	b	c	Ø d	kg	Pull studs (5) Order No.
18,000 – 19,999	75A.40.13010	130	80	50	20	0,2	75A.40.15010	190	140	50	20	0,3	15E.30.10010
20,000 – 21,999	75A.40.13020	130	80	50	20	0,2	75A.40.15020	190	140	50	20	0,3	15E.30.10020
22,000 – 26,999	75A.40.13030	130	80	50	20	0,3	75A.40.15030	210	160	50	20	0,4	15E.30.10030
27,000 – 31,799	75A.40.13040	176	120	56	25	0,5	75A.40.15040	236	180	56	25	0,7	15E.30.10040
31,800 – 34,999													
35,000 – 41,999	75A.40.13050	176	120	56	25	0,6	75A.40.15050	256	200	56	25	1,0	15E.30.10050
42,000 – 51,999	75A.30.13060	138	120	DAH 81	0,9	0,9	75A.30.15060	238	220	DAH 81	1,5	1,5	15E.30.10050
52,000 – 64,999	75A.30.13070	138	120	DAH 81	1,0	1,0	75A.30.15070	238	220	DAH 81	2,0	2,0	15E.30.10070

Supply includes: Reamax® TS holder with pull stud. Please order reaming head separately.

KOMET DIHART Reamax® TS

Assembly instructions

- Screw pull stud ⑤ into reaming head and tighten with open-end wrench ⑥.
- Open clamping jaws ② with key ③.
Insert reaming head ①.
- Close clamping jaws ② with key ③, noting recommended torque.
- When inserting the reaming head ① this is drawn into its final position by closing the clamping jaws ②.
- When removing the reaming head ① this is pressed out of its position by the clamping jaws ② which allows it to be easily removed from the holder: open the clamping jaws ② with the key ③, remove the reaming head ①.



Nominal size	Ø D	③			④	⑤	⑥	
		Operating key			Hexagonal key*	Pull studs	Open-end wrench for pull studs	
		Size	Order No.	Torque	Size	Order No.	Size	Order No.
TS1	18,000 – 19,999	8IP	L05 01240	1,5 Nm	SW 4	15E.30.10010	SW 5	18589 10005
TS2	20,000 – 21,999	SW 2,5	340.35.002	2,5 Nm	SW 5	15E.30.10020	SW 5	18589 10005
TS3	22,000 – 26,999	SW 3	340.35.003	4 Nm	SW 5	15E.30.10030	SW 6	18589 10006
TS4	27,000 – 34,999	SW 3	340.35.003	5 Nm	SW 8	15E.30.10040	SW 8	18589 10008
TS5	35,000 – 41,999	SW 3	340.35.003	6 Nm	SW 6	15E.30.10050	SW 10	18589 10010
TS6	42,000 – 51,999	SW 4	640.43.001	10 Nm	SW 8	15E.30.10050	SW 10	18589 10010
TS7	52,000 – 64,999	SW 5	640.43.002	13 Nm	SW 10	15E.30.10070	SW 13	18589 10013

* sold separately

Adjusting to compensate for wear

The smallest bore tolerances of up to IT4 can be achieved by readjusting with the hexagonal key.



KOMET DIHART Reamax® TS

Guideline values for reaming

Reamax® TS													 								
Material group	Strength Rm (N/mm²)	Hardness HB	Material	Material example material code/ DIN	Recommendation				Alternative				Recommendation				Alternative				
					Cutting material/ coating	Order No. ASG	v_c m/min	f_z mm/tooth	Cutting material/ coating	Order No. ASG	v_c m/min	f_z mm/tooth	Cutting material/ coating	Order No. ASG	v_c m/min	f_z mm/tooth	Cutting material/ coating	Order No. ASG	v_c m/min	f_z mm/tooth	
1.0	P	≤ 500	non-alloy steels	St37-2/1.0037; 9SMn28/1.0715; St44-2/1.0044																	
2.0		500-900	non-alloy / low alloy steels	St52-2 / 1.0050, C55 / 1.0525, 16MnCr5 / 1.7131		75J.93 ASG09	120 200	0,10 0,25		75J.71 ASG09	60 160	0,10 0,20		75J.71 ASG09	60 120	0,08 0,15		75J.71 ASG01	60 120	0,08 0,15	
2.1		< 500	lead alloys	9SMnPb28 / 1.0718																	
3.0		> 900	non alloy / low alloy steels: heat resostant structural, heat treated, nitride and tools steels	42CrMo4 / 1.7225, CK60 / 1.1221		75J.93 ASG09	70 180	0,08 0,20		75J.71 ASG01	50 120	0,05 0,20		75J.71 ASG01	50 120	0,05 0,12		–			
4.0		> 900	high alloy steels	X6CrMo4 / 1.2341, X165CrMoV12/ 1.2601		75J.71 ASG01	15 45	0,06 0,16		–				75J.71 ASG01	15 45	0,05 0,12		–			
4.1			HSS																		
5.0	S	250	special alloys: Inconel, Hastelloy, Nimonic, stc.	Inconel 718/2.4668, Nimonic 80A/2.4631																	
5.1		400	titanium, titanium alloys	TiAl5Sn2 / 3.7114																	
6.0	M	≤ 600	stainless steels	X2CrNi189 / 1.4306, X5CrNiMo1810/ 1.4401		75J.71 ASG01	15 40	0,07 0,12		75J.71 ASG09	15 40	0,07 0,20		75J.71 ASG01	15 40	0,05 0,10		75J.71 ASG09	15 40	0,07 0,15	
6.1		< 900	stainless steels	X8CrNb17/1.4511, X10CrNiMoTi1810/ 1.4571		75J.71 ASG01	10 35	0,07 0,12		–				75J.71 ASG01	10 35	0,05 0,10		–			
7.0		> 900	stainless / fireproof steels	X10CrAl7 / 1.4713, X8CrS-38-18/1.4862		75J.71 ASG01	10 35	0,07 0,12						75J.71 ASG01	10 35	0,05 0,10					
8.0	K	180	gray cast iron	GG-25/0.6025, GG-35/0.6035		75J.37 ASG07	80 220	0,10 0,20		75J.71 ASG01	40 100	0,10 0,20		75J.71 ASG01	40 100	0,10 0,20		–			
8.1		250	alloy gray cast iron	GG-NiCr202 / 0.6660		75J.37 ASG07	35 130	0,10 0,20		75J.71 ASG01	20 90	0,10 0,20		75J.71 ASG01	20 90	0,10 0,20		–			
9.0		≤ 600	spheroidal graphite cast iron, ferritic	GGG-40 / 0.7040		75J.93 ASG07	160 280	0,10 0,20		75J.37 ASG07	160 280	0,10 0,20		75J.37 ASG07	160 240	0,08 0,15		–			
9.1		230	spheroidal graphite cast iron, ferritic/ perlitic	GGG-50 / 0.7050 GGG-55 / 0.7055 GTW-55 / 0.8055		75J.93 ASG07	120 220	0,08 0,20		75J.37 ASG07	120 220	0,08 0,20		75J.37 ASG07	120 220	0,08 0,15		–			
10.0		> 600	spheroidal graph. cast iron, perlitic malleable iron	GGG-60 / 0.7060 GTS-65 / 0.8165		75J.93 ASG07	120 220	0,08 0,20		75J.37 ASG07	120 220	0,08 0,20		75J.37 ASG07	120 220	0,08 0,15					
10.1		200	alloyed spheroidal graphite cast iron	GGG-NiCr20-2 / 0.7661		75J.37 ASG07	50 100	0,10 0,20		75J.71 ASG01	35 65	0,10 0,20		75J.37 ASG07	50 100	0,08 0,15		75J.71 ASG01	35 65	0,08 0,15	
10.2		300	vermicular cast iron	GGV Ti < 0,2 GGV Ti > 0,2		75J.37 ASG07	35 130	0,10 0,20		75J.71 ASG01	20 90	0,10 0,20		75J.37 ASG07	35 130	0,08 0,15		75J.71 ASG01	20 90	0,08 0,15	
12.0	N	90	copper alloy, brass, lead-alloy bronze, lead bronze: good cut	CuZn36Pb3 / 2.1182, G-CuPb15Sn / 2.1182		75J.71 ASG01	50 250	0,10 0,20		75J.93 ASG07	120 250	0,10 0,20		75J.71 ASG01	50 200	0,10 0,20		–			
12.1		100	copper alloy, brass, bronze: average cut	CuZn40Al1 / 2.0550, E-Cu57 / 2.0060		75J.71 ASG01	50 165	0,10 0,20		75J.93 ASG07	100 200	0,10 0,20		75J.71 ASG01	50 165	0,10 0,20		–			
13.0		60	wrought aluminium alloys	AlMg1 / 3.3315, AlMnCu / 3.0517																	
13.1		75	cast alum. alloy: Si-content <10% magnesium alloy	G-AlMg5 / 3.3561, G-AlSi9Mg / 3.2373																	
14.0		100	cast alum.alloy: Si-content >10%	G-AlSi10Mg / 3.2381																	
15.0	H	1400	hardened steels < 45 HRC																		
16.0		1800	hardened steels > 45 HRC																		

Reaming allowance in Dia.:

Dia.-range (mm):

16 – 30

> 30

Reaming allowance in dia. (mm):

0,1 – 0,3

0,2 – 0,5

																								
	Recommendation				Alternative				Recommendation				Alternative				Carbide				Carbide			
	Cutting material/coating	Order No. ASG	v_c m/min	f_z mm/tooth	Cutting material/coating	Order No. ASG	v_c m/min	f_z mm/tooth	Cutting material/coating	Order No. ASG	v_c m/min	f_z mm/tooth	Cutting material/coating	Order No. ASG	v_c m/min	f_z mm/tooth	Cutting material/coating	Order No. ASG	v_c m/min	f_z mm/tooth	Cutting material/coating	Order No. ASG	v_c m/min	f_z mm/tooth
																	HM	75J.21 ASG01	6 $\frac{10}{200}$	0,07 $\frac{0,12}{0,20}$	HM	75H.21 ASG01	6 $\frac{10}{200}$	0,07 $\frac{0,12}{0,20}$
	DST	75H.93 ASG07	120 $\frac{10}{200}$	0,10 $\frac{0,20}{0,20}$	TIN	75H.71 ASG01	60 $\frac{160}{160}$	0,08 $\frac{0,15}{0,15}$	TIN	75H.71 ASG01	60 $\frac{120}{120}$	0,08 $\frac{0,15}{0,15}$	-				HM	75J.21 ASG02	6 $\frac{10}{200}$	0,10 $\frac{0,20}{0,20}$	HM	75H.21 ASG02	6 $\frac{10}{200}$	0,10 $\frac{0,20}{0,20}$
																	HM	75J.21 ASG01	10 $\frac{30}{30}$	0,07 $\frac{0,12}{0,12}$	HM	75H.21 ASG01	10 $\frac{30}{30}$	0,07 $\frac{0,12}{0,12}$
	DST	75H.93 ASG07	70 $\frac{180}{180}$	0,08 $\frac{0,15}{0,15}$	TIN	75H.71 ASG01	50 $\frac{120}{120}$	0,07 $\frac{0,12}{0,12}$	TIN	75H.71 ASG01	50 $\frac{120}{120}$	0,07 $\frac{0,12}{0,12}$	-				HM	75J.21 ASG01	6 $\frac{10}{10}$	0,05 $\frac{0,10}{0,10}$	HM	75H.21 ASG01	6 $\frac{10}{10}$	0,05 $\frac{0,10}{0,10}$
	TIN	75H.71 ASG01	15 $\frac{45}{45}$	0,06 $\frac{0,16}{0,16}$	-				TIN	75H.71 ASG01	15 $\frac{45}{45}$	0,05 $\frac{0,12}{0,12}$	-				HM	75J.21 ASG01	5 $\frac{8}{8}$	0,05 $\frac{0,10}{0,10}$	HM	75H.21 ASG01	5 $\frac{8}{8}$	0,05 $\frac{0,10}{0,10}$
																	HM	75J.21 ASG03	8 $\frac{12}{12}$	0,05 $\frac{0,16}{0,16}$	HM	75H.21 ASG03	8 $\frac{12}{12}$	0,05 $\frac{0,16}{0,16}$
	TIN	75H.71 ASG01	15 $\frac{40}{40}$	0,07 $\frac{0,12}{0,12}$	-				TIN	75H.71 ASG01	15 $\frac{40}{40}$	0,05 $\frac{0,10}{0,10}$	-				HM	75J.21 ASG01	4 $\frac{7}{7}$	0,05 $\frac{0,10}{0,10}$	HM	75H.21 ASG01	4 $\frac{7}{7}$	0,05 $\frac{0,10}{0,10}$
	TIN	75H.71 ASG01	10 $\frac{35}{35}$	0,07 $\frac{0,12}{0,12}$	-				TIN	75H.71 ASG01	10 $\frac{35}{35}$	0,05 $\frac{0,10}{0,10}$	-				HM	75J.21 ASG01	4 $\frac{7}{7}$	0,05 $\frac{0,10}{0,10}$	HM	75H.21 ASG01	4 $\frac{7}{7}$	0,05 $\frac{0,10}{0,10}$
	DBG-N	75H.37 ASG07	80 $\frac{220}{220}$	0,10 $\frac{0,20}{0,20}$	TIN	75H.71 ASG01	40 $\frac{100}{100}$	0,10 $\frac{0,20}{0,20}$	TIN	75H.71 ASG01	40 $\frac{100}{100}$	0,10 $\frac{0,20}{0,20}$	-				HM	75J.21 ASG01	8 $\frac{20}{20}$	0,10 $\frac{0,16}{0,16}$	HM	75H.21 ASG01	8 $\frac{20}{20}$	0,10 $\frac{0,16}{0,16}$
	DBG-N	75H.37 ASG07	35 $\frac{130}{130}$	0,10 $\frac{0,20}{0,20}$	TIN	75H.71 ASG01	20 $\frac{90}{90}$	0,10 $\frac{0,20}{0,20}$	TIN	75H.71 ASG01	20 $\frac{90}{90}$	0,10 $\frac{0,20}{0,20}$	-				HM	75J.21 ASG01	8 $\frac{12}{12}$	0,10 $\frac{0,16}{0,16}$	HM	75H.21 ASG01	8 $\frac{12}{12}$	0,10 $\frac{0,16}{0,16}$
	DST	75H.93 ASG07	160 $\frac{280}{280}$	0,10 $\frac{0,20}{0,20}$	DBG-N	75H.37 ASG07	160 $\frac{280}{280}$	0,10 $\frac{0,20}{0,20}$	DBG-N	75H.37 ASG07	160 $\frac{240}{240}$	0,08 $\frac{0,15}{0,15}$	-				HM	75J.21 ASG02	9 $\frac{18}{18}$	0,08 $\frac{0,20}{0,20}$	HM	75H.21 ASG02	9 $\frac{18}{18}$	0,08 $\frac{0,20}{0,20}$
	DST	75H.93 ASG07	120 $\frac{220}{220}$	0,08 $\frac{0,20}{0,20}$	DBG-N	75H.37 ASG07	120 $\frac{220}{220}$	0,08 $\frac{0,20}{0,20}$	DBG-N	75H.37 ASG07	120 $\frac{220}{220}$	0,08 $\frac{0,15}{0,15}$	-				HM	75J.21 ASG01	9 $\frac{18}{18}$	0,08 $\frac{0,15}{0,15}$	HM	75H.21 ASG01	9 $\frac{18}{18}$	0,08 $\frac{0,15}{0,15}$
	DBG-N	75H.37 ASG07	50 $\frac{100}{100}$	0,10 $\frac{0,20}{0,20}$	TIN	75H.71 ASG01	35 $\frac{65}{65}$	0,10 $\frac{0,20}{0,20}$	DBG-N	75H.37 ASG07	50 $\frac{100}{100}$	0,08 $\frac{0,15}{0,15}$	TIN	75H.71 ASG01	35 $\frac{65}{65}$	0,08 $\frac{0,15}{0,15}$								
	DBG-N	75H.37 ASG07	35 $\frac{130}{130}$	0,10 $\frac{0,20}{0,20}$	TIN	75H.71 ASG01	20 $\frac{90}{90}$	0,10 $\frac{0,20}{0,20}$	DBG-N	75H.37 ASG07	35 $\frac{130}{130}$	0,08 $\frac{0,15}{0,15}$	TIN	75H.71 ASG01	20 $\frac{90}{90}$	0,08 $\frac{0,15}{0,15}$								
	TIN	75H.71 ASG01	50 $\frac{200}{200}$	0,10 $\frac{0,20}{0,20}$	DST	75H.93 ASG07	120 $\frac{250}{250}$	0,10 $\frac{0,20}{0,20}$	TIN	75H.71 ASG01	50 $\frac{200}{200}$	0,10 $\frac{0,20}{0,20}$	-				HM	75J.21 ASG01	10 $\frac{20}{20}$	0,08 $\frac{0,16}{0,16}$	HM	75H.21 ASG01	10 $\frac{20}{20}$	0,08 $\frac{0,16}{0,16}$
	TIN	75H.71 ASG01	50 $\frac{165}{165}$	0,10 $\frac{0,20}{0,20}$	DST	75H.93 ASG07	100 $\frac{200}{200}$	0,10 $\frac{0,20}{0,20}$	TIN	75H.71 ASG01	50 $\frac{165}{165}$	0,10 $\frac{0,20}{0,20}$	-											
																	HM	75J.21 ASG02	10 $\frac{20}{20}$	0,10 $\frac{0,20}{0,20}$	HM	75H.21 ASG02	10 $\frac{20}{20}$	0,10 $\frac{0,20}{0,20}$
																	HM	75J.21 ASG01	8 $\frac{20}{20}$	0,10 $\frac{0,20}{0,20}$	HM	75H.21 ASG01	8 $\frac{20}{20}$	0,10 $\frac{0,20}{0,20}$
																	HM	75J.21 ASG01	8 $\frac{20}{20}$	0,10 $\frac{0,20}{0,20}$	HM	75H.21 ASG01	8 $\frac{20}{20}$	0,10 $\frac{0,20}{0,20}$

Note: The application details shown depend on the environmental and application conditions (e.g. machine, ambient temperature, use of lubricant/coolant and the machining result required). These are subject to correct operating conditions, correct application and compliance with the spindle speed limits given for the tools.

GERMANY

KOMET GROUP GmbH
Zeppelinstraße 3
74354 Besigheim
Tel. +49(0)7143.373-0
Fax +49(0)7143.373-233
info@kometgroup.com

GERMANY

KOMET GROUP GmbH
Werk Stuttgart-Vaihingen
Ruppmannstraße 32
70565 Stuttgart / Vaihingen
Tel. +49(0)711.78891-0
Fax +49(0)711.78891-11
info@kometgroup.com

BRAZIL

Komet do Brasil Ltda.
Rua Brasileira, 439
07043-010 Guarulhos - São Paulo
Tel. +55(0)11.6423-5502
Fax +55(0)11.6422-0069
info.br@kometgroup.com

CHINA

KOMET GROUP
Precision Tools (Taicang) Co., Ltd.
(Headquarter Asia Pacific)
No. 5 Schaeffler Road
Taicang, Jiangsu Province, 215400
Tel. +86(0)512.535757-58
Fax +86(0)512.535757-59
info.cn@kometgroup.com

FRANCE

KOMET S.à.r.l.
46-48 Chemin de la Bruyère
B.P. 47
69574 Dardilly CEDEX
Tel. +33(0) 4 37 46 09 00
Fax +33(0) 4 78 35 36 57
info.fr@kometgroup.com

GREAT BRITAIN

KOMET (UK) Ltd.
Unit 4 Triton Park
Brownsover Road
Swift Valley
Rugby, CV21 1SG
Tel. +44(0)1788.5797-89
Fax +44(0)1788.5797-90
info.uk@kometgroup.com

INDIA

KOMET Precision Tools India Pvt. Ltd.
121/B, Bommasandra Industrial Area
BANGALORE - 560 099
Tel. +91-80-27834821
Fax +91-80-27834495
info.in@kometgroup.com

ITALY

KOMET Utensili S.R.L.
Via Massimo Gorki n. 11
20098 S. Giuliano Mil.
Tel. +39-02-98 40 28 1
Fax +39-02-98 44 96 2
info.it@kometgroup.com

JAPAN

KOMET GROUP KK
180-0006
1-22-2 Naka-cho Musashino-shi
Tokyo Japan
Grand Preo Musashino 203
Tel. +81(0)422 50 0682
Fax +81(0)422 50 0683
info.jp@kometgroup.com

KOREA

KOMET GROUP Precision Tools
Korea Co.,Ltd.
#201, Lotte IT Castle-2, 550-1,
Gasam-dong, Geumcheon-gu,
Seoul, 153-768
Tel. +82(0)2.2082-6300
Fax +82(0)2.2082-6309
info.kr@kometkorea.com

MEXICO

KOMET de Mexico
S. de R. L. de C.V
Acceso „A“, No. 110
Parque Industrial Jurica,
76120, Queretaro, Qro. Mexico
Tel. +52-442 2-18-25-44
Fax +52-442 2-18-20-77
info.mx@kometgroup.com

AUSTRIA

KOMET GROUP GmbH
Wagramer Straße 173
1220 Wien
Tel. +43-1-2 59 22-04
+43-1-2 59 22-12
Fax +43-1-2 59 22 12-76
info.at@kometgroup.com

POLAND

KOMET-URPOL Sp.z.o.o.
ul. Stoczniewców 2
47-200 Kędzierzyn-Koźle
Tel. +48-77-482 90 60
Fax +48-77-406 10 70
info.pl@kometgroup.com

RUSSIA

KOMET GROUP GmbH
ul. Spartakovskaya, 2V
420107, Kazan
Tel. +7 843 5704345
Fax +7 843 2917543
info.ru@kometgroup.com

SWEDEN

Square Tools AB
Box 9177
20039 Malmö
Tel. +46-40-49 28 40
Fax +46-40-49 19 95
info.se@kometgroup.com

SWITZERLAND

KOMET DIHART AG Precision Tools
Industriestrasse 2
4657 Dulliken
Tel. +41(0)62.2854-200
Fax +41(0)62.2854-202
info.ch@kometgroup.com

SPAIN

KOMET IBERICA TOOLS S.L.
Planta baja, Local 6B
Av. Corts Catalanes 9-11
08173 Sant Cugat del Valles

CZECH REPUBLIC

KOMET GROUP CZ s.r.o.
Na Hůrce 1041/2,
160 00 Praha 6
Tel. +42(0)2 35 01 00 10
Fax +42(0)2 35 31 18 90
info.cz@kometgroup.com

USA

KOMET of America, Inc.
2050 Mitchell Blvd.
Schaumburg
IL 60193-4544
Tel. +1-8 47-9 23 / 84 00
+1-8 47-9 23 / 84 80
Fax +1-8 00-8 65 / 66 38
customerservice@komet.com

www.kometgroup.com

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