

T-TAP

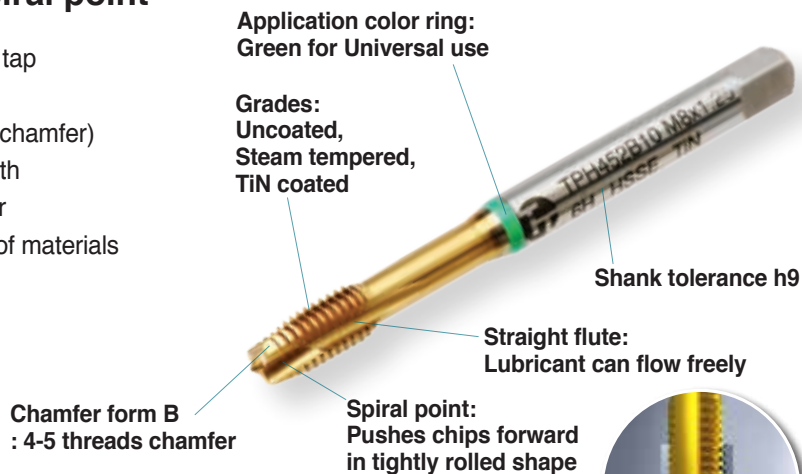
TaeguTec Multi Purpose Taps



Features

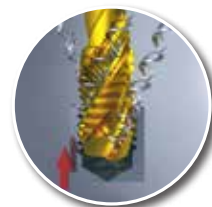
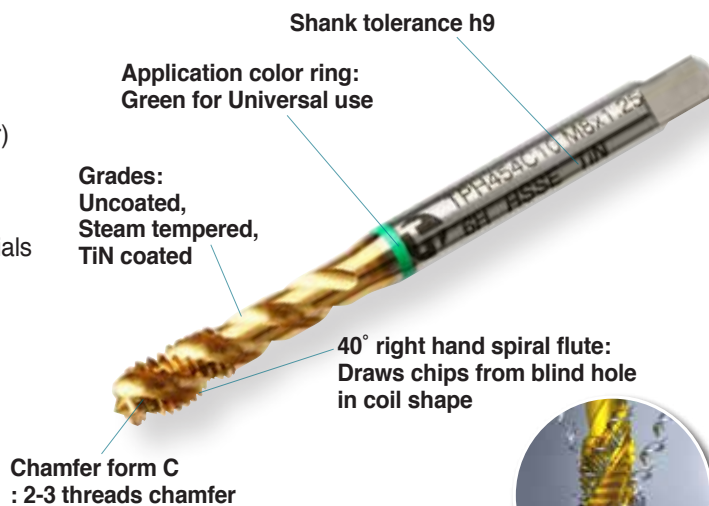
Straight flute with spiral point

- Premium HSS-E through hole tap
- Straight flute with spiral point
- Chamfer Form B (4-5 threads chamfer)
- Capable up to 3xD thread depth
- Optimized cutting geometry for universal use in a wide range of materials
- ISO 2-6H tolerance
- Industrial Standard
M2-M10: DIN371
M12-M20: DIN376
MF8-MF16: DIN374






Right hand spiral flute, 40°

- Premium HSS-E blind hole tap
- Right hand 40° spiral flute
- Chamfer Form C (2-3 threads chamfer)
- Capable up to 3xD thread depth
- Optimized cutting geometry for universal use in a wide range of materials
- ISO 2-6H tolerance
- Industrial Standard
M2-M10: DIN371
M12-M20: DIN376
MF8-MF16: DIN374



T-TAP Grade

| Grades | Code | Color | Characteristics & Applications |
|----------------|---|--------------|--|
| Uncoated | No | Bright metal | <ul style="list-style-type: none"> Economical choice Recommended for steel up to max. 800N/mm² and non ferrous materials |
| |  | | |
| Steam tempered | 05 | Dark black | <ul style="list-style-type: none"> Ferric oxide layer at the cutting edges protect the surface and prevent built-up edge Recommended for mild steels, low carbon steels and stainless steels |
| |  | | |
| TiN coated | 10 | Gold yellow | <ul style="list-style-type: none"> PVD titanium nitride layer High hardness, chemical stability and heat resistance Longer tool life credit to balanced characteristics Universal application on a wide range of materials |
| |  | | |

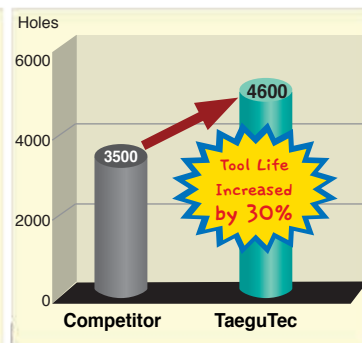
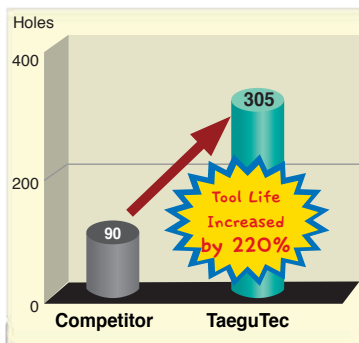
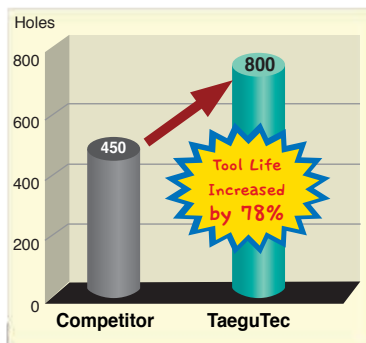
| Application(ISO) | P | M | K | N | S |
|------------------|---|---|---|---|---|
| Uncoated | ○ | | ○ | ● | |
| Steam tempered | ● | ● | ○ | ○ | |
| TiN coated | ● | ● | ○ | ○ | ○ |

● : Recommended
○ : Suitable

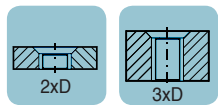
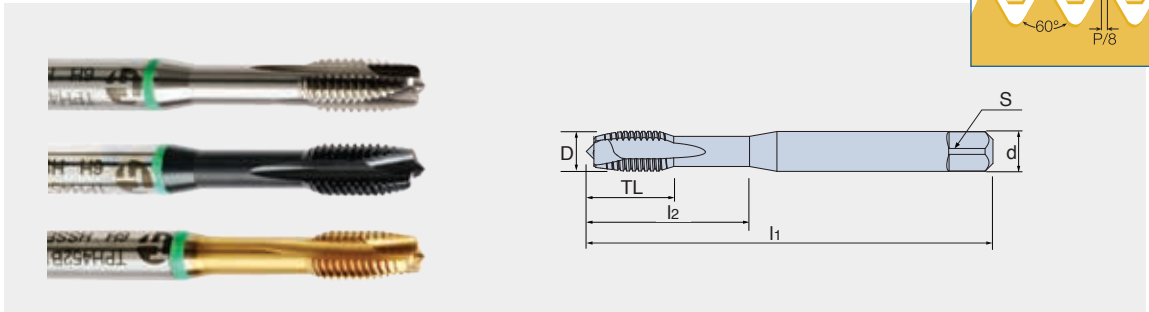
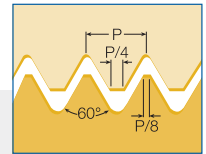
Case study

| Tool | TPH452B10 M5x0.8 | Tool | TPH554C10 MF16x1.5 | Tool | TPH454C10 M8x1.25 |
|--------------------|------------------------------------|--------------------|---------------------------|--------------------|--|
| Workpiece material | Safe Cabinet: High manganese steel | Workpiece material | Gear Bar: SAE 1045 (S45C) | Workpiece material | Cylinder Base: Carbon structural steel (St.42) |
| Hole type | Through hole (M5x0.8) | Hole type | Blind hole (M16x1.5) | Hole type | Blind hole (M8x1.25) |
| Thread depth | 12.5mm | Thread depth | 25mm | Thread depth | 24mm |
| Cutting speed | 12.6m/min (RPM 800) | Cutting speed | 17.6m/min (RPM 350) | Cutting speed | 30m/min (RPM 1194) |
| Coolant | Wet (Water soluble) | Coolant | Wet (Water soluble) | Coolant | Wet (Water soluble) |

Tool Life



Straight flute with spiral point (Form B: 4-5 threads chamfer)



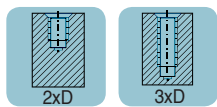
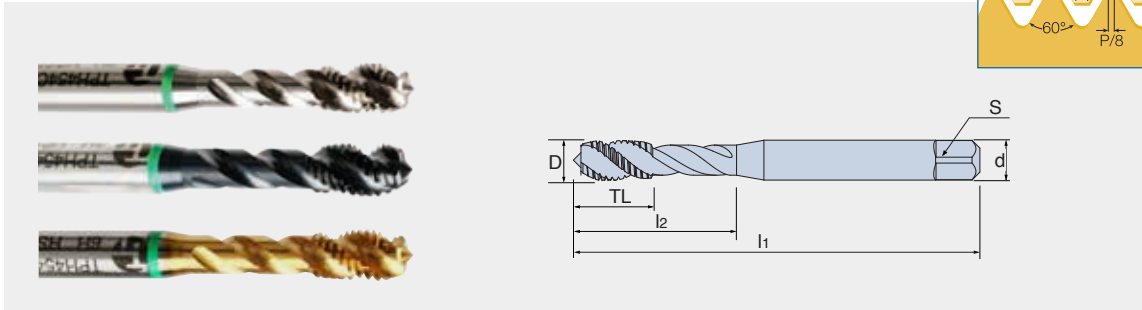
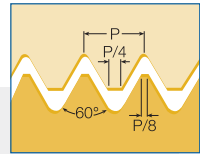
Metric ISO Standard Thread DIN 13 standard

| D | Pitch (P) | Standard (DIN) | Tolerance | Dimension (mm) | | | | | | Description | | |
|------|-----------|----------------|-----------|----------------|----|----------------|-----|-----|-----------|-------------------|---------------------|---------------------|
| | | | | l ₁ | TL | l ₂ | d | S | Core hole | Uncoated | Steam Tempered | TiN Coated |
| M2 | 0.4 | DIN371 | ISO 2-6H | 45 | 8 | - | 2.8 | 2.1 | 1.6 | TPH452B M2X0.4 | TPH452B05 M2X0.4 | TPH452B10 M2X0.4 |
| M2.5 | 0.45 | | | 50 | 9 | - | 2.8 | 2.1 | 2.05 | TPH452B M2.5X0.45 | TPH452B05 M2.5X0.45 | TPH452B10 M2.5X0.45 |
| M3 | 0.5 | | | 56 | 10 | 18 | 3.5 | 2.7 | 2.5 | TPH452B M3X0.5 | TPH452B05 M3X0.5 | TPH452B10 M3X0.5 |
| M4 | 0.7 | | | 63 | 12 | 21 | 4.5 | 3.4 | 3.3 | TPH452B M4X0.7 | TPH452B05 M4X0.7 | TPH452B10 M4X0.7 |
| M5 | 0.8 | | | 70 | 14 | 25 | 6 | 4.9 | 4.2 | TPH452B M5X0.8 | TPH452B05 M5X0.8 | TPH452B10 M5X0.8 |
| M6 | 1 | | | 80 | 16 | 30 | 6 | 4.9 | 5 | TPH452B M6X1.0 | TPH452B05 M6X1.0 | TPH452B10 M6X1.0 |
| M8 | 1.25 | | | 90 | 18 | 35 | 8 | 6.2 | 6.8 | TPH452B M8X1.25 | TPH452B05 M8X1.25 | TPH452B10 M8X1.25 |
| M10 | 1.5 | | | 100 | 20 | 39 | 10 | 8 | 8.5 | TPH452B M10X1.5 | TPH452B05 M10X1.5 | TPH452B10 M10X1.5 |
| M12 | 1.75 | DIN376 | ISO 2-6H | 110 | 22 | - | 9 | 7 | 10.2 | TPH652B M12X1.75 | TPH652B05 M12X1.75 | TPH652B10 M12X1.75 |
| M14 | 2 | | | 110 | 24 | - | 11 | 9 | 12 | TPH652B M14x2.0 | TPH652B05 M14x2.0 | TPH652B10 M14x2.0 |
| M16 | 2 | | | 110 | 26 | - | 12 | 9 | 14 | TPH652B M16X2.0 | TPH652B05 M16X2.0 | TPH652B10 M16X2.0 |
| M20 | 2.5 | | | 140 | 30 | - | 16 | 12 | 17.5 | TPH652B M20X2.5 | TPH652B05 M20X2.5 | TPH652B10 M20X2.5 |

Metric ISO Fine Thread DIN 13 standard

| D | Pitch (P) | Standard (DIN) | Tolerance | Dimension (mm) | | | | | | Description | | |
|-----|-----------|----------------|-----------|----------------|----|----------------|----|-----|-----------|-------------------|---------------------|---------------------|
| | | | | l ₁ | TL | l ₂ | d | S | Core hole | Uncoated | Steam Tempered | TiN Coated |
| M8 | 1 | DIN374 | ISO 2-6H | 90 | 15 | - | 6 | 4.9 | 7 | TPH552B MF8X1.0 | TPH552B05 MF8X1.0 | TPH552B10 MF8X1.0 |
| M10 | 1.25 | | | 100 | 18 | - | 7 | 5.5 | 8.8 | TPH552B MF10X1.25 | TPH552B05 MF10X1.25 | TPH552B10 MF10X1.25 |
| M12 | 1.5 | | | 100 | 18 | - | 9 | 7 | 10.5 | TPH552B MF12X1.5 | TPH552B05 MF12X1.5 | TPH552B10 MF12X1.5 |
| M14 | 1.5 | | | 100 | 18 | - | 11 | 9 | 12.5 | TPH552B MF14X1.5 | TPH552B05 MF14X1.5 | TPH552B10 MF14X1.5 |
| M16 | 1.5 | | | 100 | 18 | - | 12 | 9 | 14.5 | TPH552B MF16X1.5 | TPH552B05 MF16X1.5 | TPH552B10 MF16X1.5 |

Right hand spiral flute, 40° (Form C: 2-3 threads chamfer)



Metric ISO Standard Thread DIN 13 standard











| D | Pitch (P) | Standard (DIN) | Tolerance | Dimension (mm) | | | | | | Description | | |
|------|-----------|----------------|-----------|----------------|----|----------------|-----|-----|-----------|-------------------|---------------------|---------------------|
| | | | | l ₁ | TL | l ₂ | d | S | Core hole | Uncoated | Steam Tempered | TiN Coated |
| M2 | 0.4 | DIN371 | ISO 2-6H | 45 | 6 | 10 | 2.8 | 2.1 | 1.6 | TPH454C M2X0.4 | TPH454C05 M2X0.4 | TPH454C10 M2X0.4 |
| M2.5 | 0.45 | | | 50 | 6 | 12 | 2.8 | 2.1 | 2.05 | TPH454C M2.5X0.45 | TPH454C05 M2.5X0.45 | TPH454C10 M2.5X0.45 |
| M3 | 0.5 | | | 56 | 7 | 18 | 3.5 | 2.7 | 2.5 | TPH454C M3X0.5 | TPH454C05 M3X0.5 | TPH454C10 M3X0.5 |
| M4 | 0.7 | | | 63 | 8 | 21 | 4.5 | 3.4 | 3.3 | TPH454C M4X0.7 | TPH454C05 M4X0.7 | TPH454C10 M4X0.7 |
| M5 | 0.8 | | | 70 | 10 | 25 | 6 | 4.9 | 4.2 | TPH454C M5X0.8 | TPH454C05 M5X0.8 | TPH454C10 M5X0.8 |
| M6 | 1 | | | 80 | 12 | 30 | 6 | 4.9 | 5 | TPH454C M6X1.0 | TPH454C05 M6X1.0 | TPH454C10 M6X1.0 |
| M8 | 1.25 | | | 90 | 15 | 35 | 8 | 6.2 | 6.8 | TPH454C M8X1.25 | TPH454C05 M8X1.25 | TPH454C10 M8X1.25 |
| M10 | 1.5 | | | 100 | 18 | 39 | 10 | 8 | 8.5 | TPH454C M10X1.5 | TPH454C05 M10X1.5 | TPH454C10 M10X1.5 |
| M12 | 1.75 | DIN376 | ISO 2-6H | 110 | 18 | - | 9 | 7 | 10.2 | TPH654C M12X1.75 | TPH654C05 M12X1.75 | TPH654C10 M12X1.75 |
| M14 | 2 | | | 110 | 20 | - | 11 | 9 | 12 | TPH654C M14x2.0 | TPH654C05 M14x2.0 | TPH654C10 M14x2.0 |
| M16 | 2 | | | 110 | 20 | - | 12 | 9 | 14 | TPH654C M16X2.0 | TPH654C05 M16X2.0 | TPH654C10 M16X2.0 |
| M20 | 2.5 | | | 140 | 25 | - | 16 | 12 | 17.5 | TPH654C M20X2.5 | TPH654C05 M20X2.5 | TPH654C10 M20X2.5 |

Metric ISO Fine Thread DIN 13 standard

| D | Pitch (P) | Standard (DIN) | Tolerance | Dimension (mm) | | | | | | Description | | |
|-----|-----------|----------------|-----------|----------------|----|----------------|----|-----|-----------|-------------------|---------------------|---------------------|
| | | | | l ₁ | TL | l ₂ | d | S | Core hole | Uncoated | Steam Tempered | TiN Coated |
| M8 | 1 | DIN374 | ISO 2-6H | 90 | 15 | - | 6 | 4.9 | 7 | TPH554C MF8X1.0 | TPH554C05 MF8X1.0 | TPH554C10 MF8X1.0 |
| M10 | 1.25 | | | 100 | 18 | - | 7 | 5.5 | 8.8 | TPH554C MF10X1.25 | TPH554C05 MF10X1.25 | TPH554C10 MF10X1.25 |
| M12 | 1.5 | | | 100 | 18 | - | 9 | 7 | 10.5 | TPH554C MF12X1.5 | TPH554C05 MF12X1.5 | TPH554C10 MF12X1.5 |
| M14 | 1.5 | | | 100 | 18 | - | 11 | 9 | 12.5 | TPH554C MF14X1.5 | TPH554C05 MF14X1.5 | TPH554C10 MF14X1.5 |
| M16 | 1.5 | | | 100 | 18 | - | 12 | 9 | 14.5 | TPH554C MF16X1.5 | TPH554C05 MF16X1.5 | TPH554C10 MF16X1.5 |

Cutting Speed Recommendation

(V=m/min)

| Series | Spiral Point Tap | | | Spiral Flute Tap | | | Application | Lubrication | |
|----------|---|---|---|--|---|---|-------------|--------------|--------------|
| | Uncoated | Steam Tempered | TiN Coated | Uncoated | Steam Tempered | TiN Coated | | | |
| |  |  |  |  |  |  | | | |
| |  |  | |  |  | | | | |
| P | Non-alloy steel, cast steel, free cutting steel | < 0.25 %C Annealed | 5-25 | 5-25 | 15-45 | 5-25 | 5-25 | 15-45 | E/O |
| | | >= 0.25 %C Annealed | 5-20 | 5-20 | 10-40 | 5-20 | 5-20 | 10-40 | E/O |
| | | < 0.55 %C Quenched and tempered | - | 2-15 | 5-25 | - | 2-15 | 5-25 | E/O |
| | | >= 0.55 %C Annealed | 5-20 | 5-20 | 10-40 | 5-20 | 5-20 | 10-40 | E/O |
| | | Quenched and tempered | - | 2-15 | 5-25 | - | 2-15 | 5-25 | E/O |
| | | Low alloy steel and cast steel (less than 5% alloying elements) | Annealed | 5-25 | 5-25 | 15-45 | 5-25 | 5-25 | 15-45 |
| | Quenched and tempered | - | 2-15 | 5-20 | - | 2-15 | 5-20 | E/O | |
| K | High alloy steel, cast steel and tool steel | Annealed | 5-20 | 5-20 | 10-40 | 5-20 | 5-20 | 10-40 | E/O |
| | | Quenched and tempered | - | - | 5-20 | - | - | 5-20 | O/S |
| M | Stainless steel and cast steel | Ferritic/martensitic | - | 2-10 | 5-20 | - | 2-10 | 5-20 | E/O |
| | | Martensitic | - | 2-10 | 5-20 | - | 2-10 | 5-20 | E/O |
| | | Austenitic | - | 2-10 | 5-20 | - | 2-10 | 5-20 | E/O |
| K | Gray cast iron (GG) | Ferritic | 10-15 | 10-25 | 15-45 | 10-15 | 10-25 | 15-45 | E/D |
| | | Pearlitic | 10-15 | 10-25 | 10-40 | 10-15 | 10-20 | 10-40 | E/D |
| | Cast iron nodular (GGG) | Ferritic | 8-12 | 5-20 | 10-30 | 8-12 | 5-20 | 10-30 | E/D |
| | | Pearlitic | 8-12 | 5-15 | 10-25 | 8-12 | 5-15 | 10-25 | E/D |
| K | Malleable cast iron | Ferritic | 10-15 | 10-25 | 15-45 | 10-15 | 10-25 | 15-45 | E/D |
| | | Pearlitic | 10-15 | 10-20 | 10-40 | 10-15 | 10-20 | 10-40 | E/D |
| N | Aluminum-wrought alloy | Not cureable | 15-25 | 15-25 | 15-25 | 15-25 | 15-25 | 15-25 | E/O |
| | | Cured | 15-25 | 15-25 | 15-25 | 15-25 | 15-25 | 15-25 | E/O |
| | Aluminum-cast, alloyed | <=12% Si Not cureable | 15-20 | 10-20 | 15-40 | 15-20 | 10-20 | 15-40 | E/O |
| | | Cured | 15-20 | 10-20 | 15-40 | 15-20 | 10-20 | 15-40 | E/O |
| | Copper alloys | >12% Si High temp. | 15-20 | 15-20 | 10-30 | 15-20 | 15-20 | 10-30 | E/O |
| | | >1% Pb Free cutting | 15-25 | 15-25 | 10-30 | 15-25 | 15-25 | 10-30 | E/O |
| N | Non metallic | Brass | 10-40 | 10-40 | 20-60 | 10-40 | 10-40 | 50-60 | E/O |
| | | Electrolytic copper | 10-15 | 2-10 | 5-25 | 10-15 | 2-10 | 5-25 | E/O |
| | | Duroplastics, fiber plastics | - | 10-20 | 10-20 | - | 10-20 | 10-20 | D |
| | | Hard rubber | - | 10-20 | 10-20 | - | 10-20 | 10-20 | D |
| S | High temp. alloys | Fe based Annealed | - | - | 3-5 | - | - | 3-5 | S |
| | | Cured | - | - | 3-5 | - | - | 3-5 | S |
| | | Ni or Co based Annealed | - | - | 2-4 | - | - | 2-4 | S |
| | | Cured | - | - | 2-4 | - | - | 2-4 | S |
| | Titanium, Ti alloys | Cast | - | - | 2-4 | - | - | 2-4 | S |
| | | Alpha+beta alloys cured | - | - | 4-6 | - | - | 4-6 | S |

Steel Stainless Steel Cast Iron Nonferrous High Temp. Alloys

***Bold**: Recommended

• **Lubrication** E: Emulsion O: Cutting Oil S: Special Cutting Oil D: Dry/Air

TaeguTec Standard Tap Chucking system

Quick change & torque safety type provided with tension and compression

Tap Holder



Tap Adapter

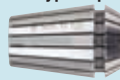


Tension & compression with radial floating function

GTI Tap Attachment



ER Type Tap Collet



GTI ER Collet Chuck



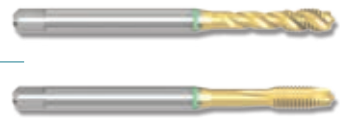
Collet(ER)



ER Collet Chuck



GTIN ER Collet

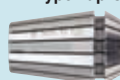


Rigid tap holders

ER Collet Chuck



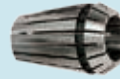
ER Type Tap Collet



TSK Collet Chuck



Collet(ER)



T-HYCHUCK



TSK Collet



THC Collet



TaeguTec Global Network

World Headquarters

TaeguTec Ltd.
1040 Gachang-ro, Gachang-myeon,
Dalseong-gun, Daegu 42936, KOREA
Tel: +82-53-760-7640
Web: <http://www.taegutec.com>

Argentina

TaeguTec Argentina SA
11 de septiembre 4237- Piso 7
(C1429BJC) Ciudad Autónoma
Buenos Aires, Argentina
Tel: +54-11-4702-6222
E-mail: ventas@taegutec.com.ar

Australia

TaeguTec Tools Pty Ltd.
Unit 36, 7 Anella Avenue,
Castle Hill, NSW 2154, Australia
Tel: +61-2-8850-2197
E-mail: sales@taegutec.com.au

Belarus Rep.

Twing-M
3/2 Klumova Str, Minsk, 220009,
Republic of Belarus
Tel: +375-17-506-3238
E-mail: info@twing.by

Belgium

Ust-Tools S.P.R.L.
Parc Industriel Des Hauts
Sarts1 Avenue,145
4040 Herstal, Belgium
Tel: +32-42-480-481
+32-475-783-204
E-mail: ustools@skynet.be

Brazil

TaeguTec Brasil Ltda.
Rua Tito, 104-Lapa-Cep 05051-000
São Paulo, Brasil
Tel: +55-11-3868-6032
E-mail: vendas@taegubrasil.com.br

Bulgaria

Tekotek BG Ltd.
Alexander Stamboliyski No 31,
7700 Targovishte, Bulgaria
Tel: +359-878-05-1818
E-mail: tekotekbg@gmail.com

Chile

Cutting Tools Chile E.I.R.L.
Alcalde Pedro Alarcón N° 765,
San Miguel, Santiago - Chile
Tel: +56-2-553 6944
+56-2-552 1181
E-mail: ventas@cuttingtools.cl

China

TaeguTec China
RM 1205, Huishang Office Building,
No.1286 of Minsheng RD,
Pudong New District, Shanghai, China
PC: 200135
Tel: +86-21-5106-1260
E-mail: mail@taegutec.com.cn

Croatia

Intehna Zagreb d.o.o.
Samoborska cesta 255, 10090
Zagreb-Susedgrad, Croatia
Tel: +385-1-3436-919
E-mail: info@intehna.hr

Czech Rep.

TaeguTec ČR s.r.o.
Domažlická 180a, CZ-31800 Plzeň,
Czech Rep.
Tel: +420 373 720 999
E-mail: top@taegutec.cz

Denmark

TaeguTec Scandinavia A/S.
Omogade 8, DK-2100 Copenhagen,
Denmark
Tel: +45-7022-0103
E-mail: tts@taegutec.dk

Finland

Knorring OY AB
Mestarinie 4 FI-01730 Vantaa, Finland
Tel: +358 9 560 41
E-mail: knorring@knorring.fi

France

Ingersoll France
22 Rue Albert Einstein
77420 Champs Sur Marne, France
Tel: +33 (0)1 64 68 45 36
E-mail: info@ingersoll-imc.fr

Germany

Ingersoll Werkzeuge GmbH
Kalteiche Ring 21-25, D-35708
Haiger, Germany
Tel: +49-2773-742 146
E-mail: info@ingersoll-IMC.de

Greece

Technotools-Fakitsas Georgios Co.
25th Martiou & Thrakis 15, 15235 Vrillisia,
Athens, Greece
Tel: +30-2-10-832-0752
E-mail: Giorgos@technotools.gr

Hungary

TaeguTec Hungary Kft.
1142 Budapest, Kassai u.151.
Tel: +36-1-273-29-52
E-mail: info@taegutec.hu
Web: <http://www.taegutec.hu>

India

TaeguTec India Pvt. Ltd.
No.120, Bommasandra Industrial Area,
Phase IV, Bangalore -560 099, India
Tel: +91-08-49013000
E-mail: sales@taegutec-india.com

Indonesia

PT. TaeguTec Indonesia
Easton Commercial Center
Jl. Gunung Panderman Blok B no. 12
Cikarang Selatan-Bekasi 17550, Indonesia
Tel: +62-21-29093176/778/79
E-mail: sales@taegutec.co.id

Ireland

Hardmetal Machine Tools Ireland Ltd.
Dargan House, Duncairn Terrace,
Bray Co. Wicklow, Ireland
Tel: +353-1-286-2466
E-mail: sales@hardmetal.ie

Italy

Ingersoll TaeguTec Italia S.R.L.
Via Montegrappa 78, 20020 Arese (MI), Italy
Tel: +39 02.99.76.67.00
E-mail: taegutec@taegutec.it

Japan

TaeguTec Japan Ltd.
- Osaka / Head office
Senri Asahi Hankyu Bldg. 15F
1-5-3 Shinsenri-Higashimachi
Toyonaka-shi Osaka 560-0082, Japan
Tel: +81-6-6835-7731
E-mail: taegutec@taegutec.co.jp
Website: <http://www.taegutec.co.jp>

- Nagoya / Branch office
Tel: +81-52-745-2451

- Tokyo / Branch office
Tel: +81-3-5753-6281

Lithuania

UAB TTMT
R.Kalantos str. 161
LT-52315 Kaunas, Lithuania
Tel: +370-37-328487
E-mail: sigitas@ttmt.lt

Malaysia

TaeguTec Tooling Systems Malaysia Sdn. Bhd
No.23-1&2, Jalan Anggerik Vanilla
BF 31/BF Kota Kemuning, Seksyen 31
40460 Shah Alam Selangor Darul, Malaysia
Tel: +603-5131-7514
E-mail: info@taegutec.com.my

The Netherlands

T.C.E.
Kennedylaan 14, 5466 AA, Veghel,
The Netherlands
Tel: +31 (413) 88 83 10
E-mail: info@taegutec.nl
Website: <http://www.taegutec.nl>

New Zealand

TT Pacific
1/501 Mt. Wellington Highway
Sylvia Park, Auckland, New Zealand 1060
Tel: +64-9-573-1280
E-mail: sales@iscar.co.nz

Norway

Svea Service AS
Graaterudveien 20 No-3036 Drammen,
Norway
Tel: +47-32-277-750
E-mail: per.martin.bakken@svea.no

Pakistan

Dynamic Tooling Services
Office No. 304, 3rd Floor, Azeem
Mansion, Fazal-ul-Haque Road,
Blue Area, Islamabad-44000, Pakistan
Tel: +92-51-2150382
+92-51-2150383
E-mail: info@dts.com.pk

Philippines

Colt Commercial Inc.
Suite 508 Padilla delos Reyes Bldg,
232 Juan Luna St., Binondo, Manila
Philippines
Tel: +63-2-244-9756
E-mail: cyrus@colt.com.ph

Poland

TaeguTec Polska Sp. z o.o.
Ul.Nenckiego 136
52-223 Wroclaw, Poland
Tel: +48 71 785 40 85
E-mail: sales@taegutec.pl

Portugal

Hexatool, S.A.
Rua Casal Galego, No. 40.44
2430 Marinha Grande, Portugal
Tel: +351-244-550424/5
E-mail: hexatool@hexatool.com

Romania

SC TaeguTec Tools SRL
Splaiul Unirii, nr. 4, Bl. B3, 5th Floor,
Office 5.1, District 4., Bucharest,
Romania, 040031
Tel: +4021 210 3108
E-mail: marian.luca@taegutec.ro

Russia

TaeguTec Russia
123290, Russia, Moscow,
2nd Magistralnaya str, 8A, building 5
Tel: +7-495-269-7917
E-mail: sales@taegutec.ru

Saudi Arabia

Khusheim Co.
Building - A, Al Nakheel Tower, Al Khaleej
Road, Al Shataea Area, Dammam 31411,
Kingdom of Saudi Arabia
Tel: +966-13-8333574 Ext : 1500
E-mail: bd@khusheim.com

Serbia

Intehna Beo d.o.o.
Autoput 22, 11080 Zemun, Serbia
Tel: +381-11-3149-092
E-mail: info@intehna.rs

Singapore

TT Tooling Systems
BK502, #03-823, Jurong West Avenue 1,
Singapore 640502
Tel: +65-6-4254918
E-mail: kltan@sinotool.com.sg

Slovakia

TaeguTec Slovakia, s.r.o.
Bytická 2/44 010 01 Žilina Slovak Republic
Tel: +421 41 7000056
E-mail: matus@taegutec.sk

Slovenia

Intehna d.o.o.
Špruha 40, SI-1236, Trzin, Slovenia
Tel: +386-1-580-9260
E-mail: info@intehna.si

South Africa

TaeguTec South Africa (Pty) Ltd.
P.O. Box 3121, Springs, 1560
43 South Main Reef Road,
New Era Springs Gauteng, South Africa
Tel: +2711-362-1500
E-mail: info@taegutec.co.za

Spain

TaeguTec Spain S.L
Miquel Servet, 35 P.I.Bufalvent
08243 Manresa (Barcelona), Spain
Tel: +34-93-878-7309-10
E-mail: info@taegutec.es

Sweden

SMV Verktyg AB
Parkgatan 6
SE-333 31 Smalandsstenar, Sweden
Tel: +46-371-343-48
E-mail: verktyg@smv.se

Taiwan

TaeguTec Taiwan
3F, No.56, Min Tai St., Ku-Shan Dist.,
Kaohsiung City 804, Taiwan (R.O.C.)
Tel: +886-7-5505966
E-mail: info@tw.taegutec.com

Thailand

TaeguTec(Thailand) Co.,Ltd.
6/177 M.7 Srinakarin Rd.,
T.Bangmuang, A.Muangsamutprakarn,
Samutprakarn 10270, Thailand
Tel: +662-759-9300
+662-759-9172
E-mail: info@taegutecthai.co.th

Turkey

**TOŞB Otomotiv Yan Sanayi İhtisas
Organize Sanayi Bölgesi**
1.Cad. 15.Sokak No:9 41420 Şekerpınar
Çayırova/KOCAELİ, Türkiye
Tel: +90-850-201-69-00
E-mail: info@taegutec.com.tr

Ukraine

TaeguTec Ukraine
40-b, Pushkina avenue, Dnepropetrovsk
Ukraine, 49006
Tel: +38-056-790-84-09
E-mail: td@taegutec.com.ua

United Arab Emirates

A.F.Husain
Al Ghurair W/H Shed No. 60
Al Quoz Industrial Area
P.O. Box: 4007 Dubai, UAE
Tel: +971-4-3400034
E-mail: info@afh-tools.com

United Kingdom

TaeguTec UK Ltd.
Waterside, Grange Park, Wetherby,
Leeds, LS22 5NB, United Kingdom
Tel: +44-1937-589-828
E-mail: info@taegutec.co.uk

U.S.A.

Ingersoll Cutting Tools
845 S Lyford Road Rockford,
IL 61108-2749 U.S.A.
Tel: +1-815-387-6600
E-mail: info@ingersoll-imc.com

Vietnam

DMC Technology Co., Ltd.
No. 109, Cong Hoa Street, Ward 12,
Tan Binh District, Ho Chi Minh City,
Vietnam.
Tel: +84-8-62925556
E-mail: info@dmctech.com.vn



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