



ALLIED MACHINE & ENGINEERING

Holemaking Solutions for Today's Manufacturing



Drilling



Reaming



Burnishing



Threading



Boring

▶ **WOHLHAUPTER®**

High Precision Boring Systems



Specials

WOHLHAUPTER®

North America

Allied Machine
120 Deeds Drive
Dover, OH 44622
United States

Allied Machine
485 West 3rd Street
Dover, OH 44622
United States

ThreadMills USA™
4185 Crosstowne Ct #B
Evans, GA 30809
United States

Superion™
1285 S Patton St.
Xenia, OH 45385
United States

Europe

Allied Machine Europe
93 Vantage Point
Pensnett Estate
Kingswinford
West Midlands
DY6 7FR, United Kingdom

Wohlhaupter® GmbH
Maybachstrasse 4
Postfach 1264
72636 Frickenhausen
Germany

Asia

Wohlhaupter® India
B-23, 2nd Floor
B Block Community Centre
Janakpuri, New Delhi - 110058
India



Allied Machine & Engineering is a worldwide leader in holemaking and finishing solutions. We are committed to providing practical and dependable solutions to our customers through innovative designs and superior customer and technical support.

We continue to expand our product offering in order to provide new and different solutions. With Field Sales Engineers located around the world, we position ourselves to provide technical support on site, right at your spindle.



www.alliedmachine.com



Holemaking Solutions for Today's Manufacturing

Wohlhaupter® Boring Solutions

The Foundation

Since 1941, Allied Machine & Engineering has provided dependable and practical holemaking solutions to the world. What was once a small job shop in Ohio is now a worldwide leader in cutting tool technology. With three manufacturing facilities in Ohio, one in Georgia, another in Germany, and headquarters in both the United States and Europe, Allied Machine is positioned to bring innovative solutions and technical expertise directly to the customers' hands.



The Beginning

Harold E. Stokey founded Allied Machine & Engineering to aid the war effort, manufacturing taper bearing lock nuts for the production of M1 tanks. Years later, after a sales meeting gone wrong, Stokey possessed a warehouse stocked with spade drill inserts. He set forth into the industry that would become Allied Machine's thriving identity: holemaking.



The T-A®

When Harold's son, William H. Stokey, became the president and CEO, he developed the Throw Away, or T-A, spade drill insert system. The T-A revolutionized the holemaking industry, launching Allied Machine ahead of the competition. Since then, numerous innovations and advancements have been created from the T-A's inspiration.



The Innovation

Since the development of the T-A, Allied Machine has expanded its product offering to support a vast range of customer applications, including large diameter and deep hole drilling, boring, reaming, burnishing, porting, and threading.

The People

Allied Machine understands that high quality products are only one facet of success. Our customer support is crucial to what we do, and that's why we make sure the best engineers and customer service associates are in place to assist our customers around the world.

The Future

With over 75 years of experience, Allied Machine has encountered the challenges of growth and success. By investing in cutting edge technology and the brightest and sharpest minds, our knowledge and capabilities continue to expand and grow every day.



Steve Stokey
Executive Vice President

William H. Stokey
President and CEO

Mike Stokey
Executive Vice President



Replaceable Insert Drills

- Reduce costs by decreasing set-up time and utilizing a single holder for the lives of multiple inserts
- Provide flexibility to quickly switch between inserts with different geometries
- Products:
 - GEN3SYS® XT | GEN3SYS® XT Pro
 - Original T-A® | GEN2 T-A®
 - High Performance | Universal



Indexable Insert Drills

- Protect your investment and reduce your inventory with replaceable cartridges that allow the same holder to be used repeatedly
- Indexable inserts increase productivity and tool life while reducing costs
- Products:
 - 4TEX™ Drill
 - Revolution Drill®
 - Opening Drill®



Replaceable / Indexable Insert Drills

- Allow for higher spindle speeds and take advantage of the power curve on modern CNC machines
- Achieve maximum penetration rates in deep hole drilling applications
- Holders cover a range of sizes with the replaceable heads determining the cutting diameter
- Products:
 - APX Drill



Solid Carbide Drills

- Offer greater strength and stability when drilling tougher materials
- Available in diameters from 3mm - 20mm
- Can be made-to-order specifically for your application (Superion™ quoted specials)
 - ASC 320®
 - Superion™





Structural Steel Solutions

- Deliver outstanding performance and durability in structural steel applications
- Designed to produce optimal results in difficult-to-machine materials
- Available in multiple lengths and diameters
- T-A® style drills have different insert geometry options to improve performance depending on material
- Products:
 - Original T-A® | GEN2 T-A®
 - GEN3SYS® XT Pro

BTA (STS) Machining Solutions

- The internal ejection system flushes chips and debris from the hole with no interference to the cutting process
- Utilizes the advantages of the T-A® drill insert
- Designed to significantly increase penetration rates over brazed heads and traditional gun drills
- Products:
 - BT-A Drill



Hydraulic Port Contour Cutters

- Save significant time and money by performing four processes in one step
- Replaceable insert design reduces costs, inventory, and set-up times
- Available in 4 industry specifications:
 - Imperial: SAE J-1926
 - Metric: ISO 6149-1:2006
 - Military: SAE AS5202
 - John Deere: JDS-G173.1
- Products:
 - AccuPort 432®



Enhanced Special Drilling Capabilities

- Allied Machine Engineers are available to meet with you to evaluate your application and recommend the best solution for you
- Special drilling solutions can incorporate advanced features such as adjustable diameter locations, multiple steps, additional coolant designs, special lengths and diameters, and more
- Special drills can drastically reduce your cost-per-hole and increase your overall productivity by eliminating multiple processes and increasing tool life



WOHLHAUPTER®

High Precision Boring Systems

- Designs available for high volume applications that increase rigidity to improve performance
- Versatile boring heads that are flexible with changing applications while maintaining excellent performance
- Provides high precision with absolute repeatability to ensure every part is held to tolerance
- Offers an industry leading modular shank connection that maintains rigidity and reduces inventory on your boring system
- Available with both digital and analog settings
- Products:
 - Wohlhaupter® Boring Tools



CRITERION™

Modular Boring Systems

- The modular capabilities are ideal for use across multiple different projects
- Offers versatile boring heads suitable for all job shops and tooling rooms
- Provides an economical solution for low volume and/or short-term production applications
- Offers both rough and finish boring solutions
- Products:
 - Criterion™ Boring Tools

S.C.A.M.I.®

Expandable Reaming Solutions

- Expandable cutting diameters accommodate for wear, which extends tool life
- Replaceable cutting heads and rings reduce waste and improve production time versus solid high speed steel and carbide reamers
- Hold tight tolerances to ensure processes are performed to accurate specifications
- Reduce tooling costs because many items are available for recondition
- Products:
 - ALVAN® Reamers



S.C.A.M.I.®

Roller Burnishing Solutions

- Produce excellent surface finishes
- Provide accurate size control
- Increase surface hardness
- Solutions for both through hole and blind hole applications
- Products:
 - S.C.A.M.I.® Roller Burnishing Tools





Solid Carbide Thread Mills

- Available with coolant through options
- Cover a wide range of thread forms
- Provide optimal solutions for both high production projects and short-run applications
- Products
 - AccuThread™ 856
 - AccuThread™ T3
 - ThreadMills USA



Replaceable Insert Thread Mills

- 3 insert lengths are available that cover a wide range of thread forms
- Holders can utilize inserts with different pitches and thread forms
- Repeatability is achieved by both the bolt-in style and the pin style locking systems
- Increase tool life by 25 - 50% with Allied Machine's AM210® coating
- Products
 - AccuThread™ 856: Bolt-in Style
 - AccuThread™ 856: Pin Style



SPECIAL CAPABILITIES

When it comes to designing and developing special solutions for customers, Allied Machine is the top choice. If your application requires special tooling, give us a call. Our engineered specials are developed by the brightest engineers in the industry. Most of our standard tooling can be altered as specials, or we can create entirely new concepts for particularly unique applications.

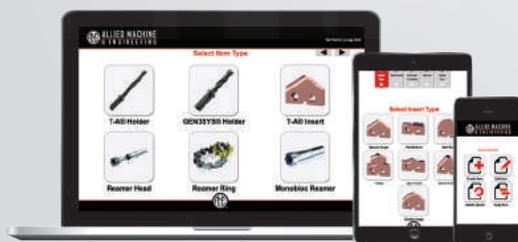
One special tooling solution is Insta-Quote™, the online system that allows you to design your own special tooling 24/7. Receive a quote and drawings within minutes just by following the steps.

And with the addition of Superior™ technology and capabilities, we can customize made-to-order solid carbide tools to achieve optimal results for your applications.

Whatever your application, Allied Machine has the answer.



Insta-Quote™ 



 SUPERION™



Wohlhaupter® High Precision Boring Systems

► Diameter Range: 0.016" - 128.150" (0.4mm - 3255mm)



Precision at Its Finest

From high precision to high production, Wohlhaupter has the right solution for your hole finishing applications. The Wohlhaupter product line offers the widest range of in-stock boring tools and the most precise and flexible modular systems on the market. With the most reliable digital readout tools and the ability to design and build special tools, Wohlhaupter is the solution for your boring challenges.

Also available to assist your application needs is the online tool modeling software, Tool-Architect. You can find your tooling, configure your system, and validate your selection all within the program. With the Wohlhaupter tool configurator, you will find the right tool with just a few clicks.

Rough and finish boring	Reliable digital readouts	Precise and flexible modular system
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Applicable Industries



Aerospace



Agriculture



Automotive



Firearms



General
Machining



Oil & Gas



Renewable
Energy

Your safety and the safety of others is very important. This catalog contains important safety messages. Always read and follow all safety precautions.



This triangle is a safety hazard symbol. It alerts you to potential safety hazards that can cause tool failure and serious injury.

When you see this symbol in the catalog, look for a related safety message that may be near this triangle or referred to in the nearby text.

There are safety signal words also used in the catalog. Safety messages follow these words.

WARNING

WARNING (shown above) means that failure to follow the precautions in this message could result in tool failure and serious injury.

NOTICE means that failure to follow the precautions in this message could result in damage to the tool or machine but not result in personal injury.

NOTE and **IMPORTANT** are also used. These are important that you read and follow but are not safety-related.

Visit www.alliedmachine.com for the most up-to-date information and procedures.

Wohlhaupter® High Precision Boring Systems Contents

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To find more information about the complete line of Wohlhaupter® High Precision Boring Systems, visit www.wohlhaupter.com.

Additional information may also be found in the Wohlhaupter® MultiBore® System Tools catalog.

(Literature Order Number: WOHLCAT)



A
DRILLING
B
BORING
C
REAMING
D
BURNISHING
E
THREADING
X
SPECIALS

RUN THE GAMUT:

*from the most advanced to
the toughest, we have the
solution you need.*



Find the perfect solution



Decrease cost-per-hole



Reduce set-up times

*With a complete range of
boring tooling from*

WOHLHAUPT®

*you'll find exactly what
you need to increase your
productivity.*



Versatile Tooling



Standard



Balance



Digital Balance



Combi-Line

Plus many more



THE COMPLETE RANGE

Ø 0.016" - 128.15"
(Ø 0.4mm - 3255mm)



A

DRILLING

B

BORING

C

REAMING

D

BURNISHING

E

THREADING

X

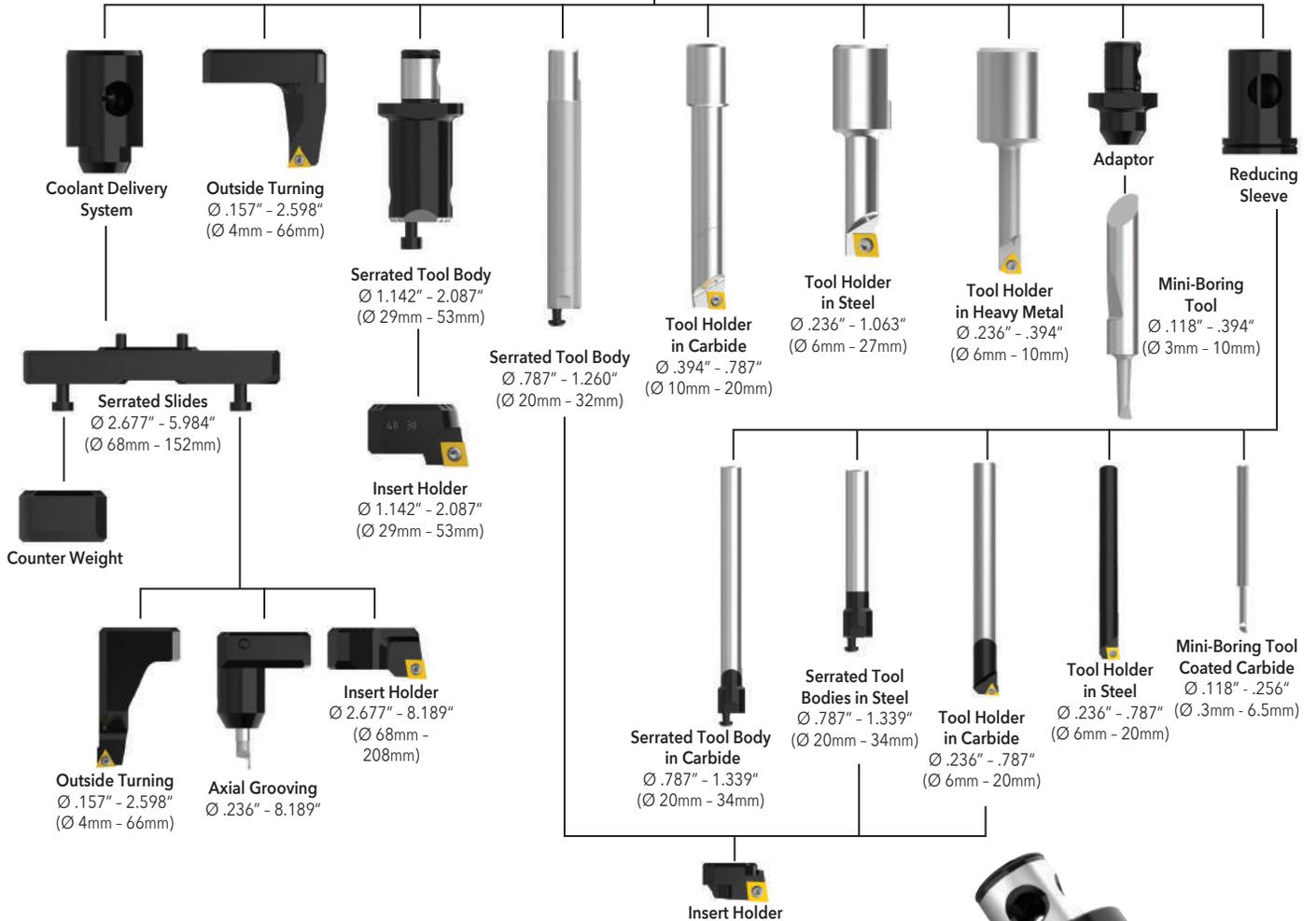
SPECIALS

Versatile Tooling

PRIME BORE



PrimeBore Head



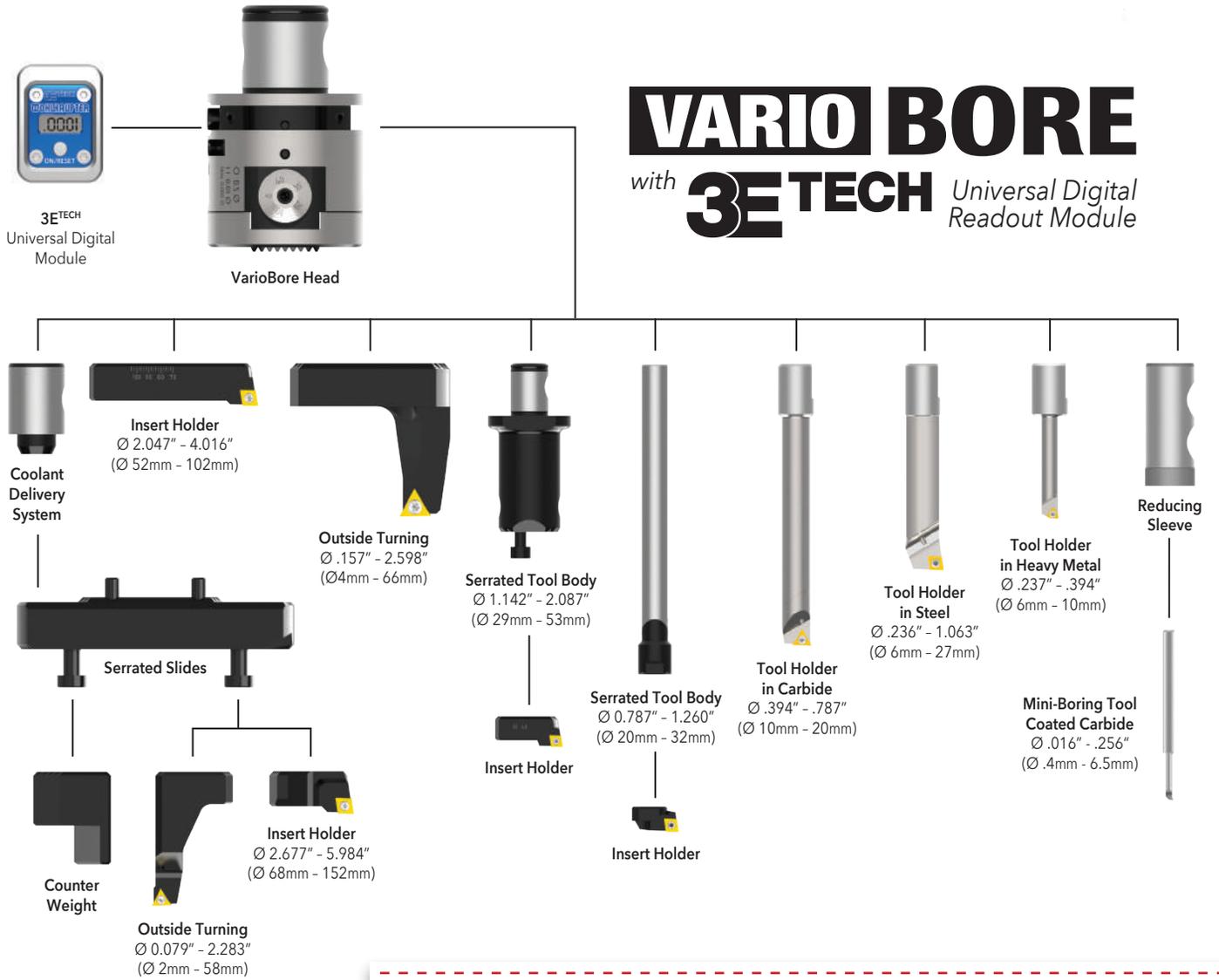
OPERATION VERSATILITY

from **.118"** to **8.189"** (3mm to 208mm)
plus outside turning



A DRILLING
B BORING
C REAMING
D BURNISHING
E THREADING
X SPECIALS

Versatile Tooling



OPERATION VERSATILITY
 from **.016"** to **5.984"** (0.4mm to 152mm)
plus outside turning

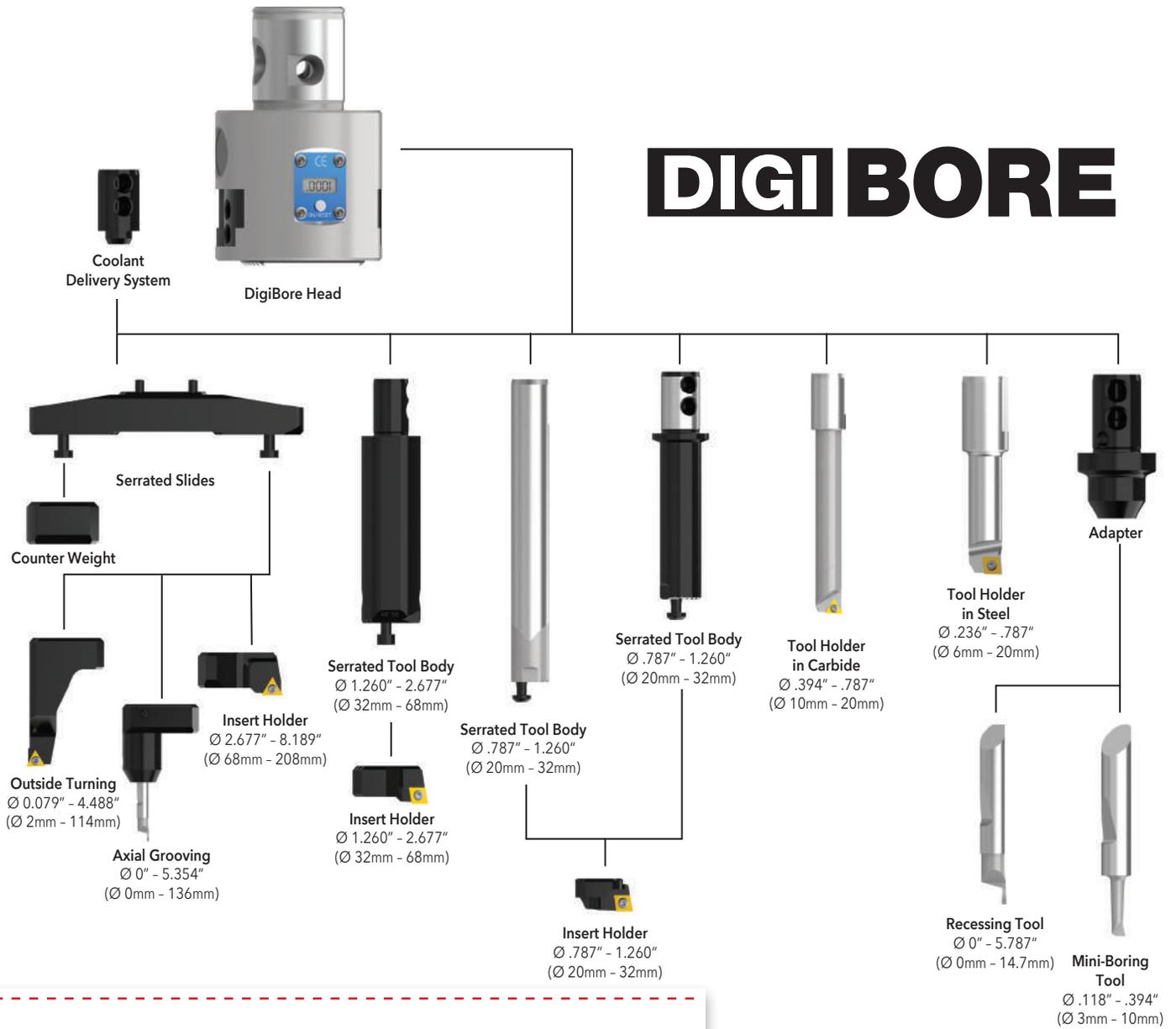


A
DRILLING
B
BORING
C
REAMING
D
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E
THREADING
X
SPECIALS

Versatile Tooling

A DRILLING
B BORING
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D BURNISHING
E THREADING
X SPECIALS

DIGI BORE



OPERATION **VERSATILITY**

from **.118" to 8.189" (3mm to 208mm)**

plus outside turning



WHY?

WE HAVE A **KIT** FOR THAT

Kits aren't for everyone, but if you work on different projects from day to day, you need to **be prepared for the work tomorrow will bring.**

VERSATILE SETUPS AND IMPROVED READINESS

BROAD SELECTION OF DIAMETER RANGES

EASY CONVENIENT STORAGE AND ORGANIZATION

COST SAVINGS OVER BUYING INDIVIDUAL COMPONENTS

DIGI BORE

Ultimate Accuracy



- Kits are available in imperial and metric
- Internal digital display for 0.0001" (0.002mm) adjustments
- Internal automatic balancing
- Standard ISO insert CC..0602..

Additional kits available, please inquire



.394" - 1.260"
(10mm - 32mm)

i # 104 061
m # 103 061 | \$3,526.52



1.260" - 2.677"
(32mm - 68mm)

i # 104 063
m # 103 063 | \$3,374.56



2.677" - 5.984"
(68mm - 152mm)

i # 104 065
m # 103 065 | \$3,442.68



3.780" - 8.189"
(96mm - 208mm)

i # 104 081
m # 103 081 | \$3,819.96

VARIO BORE

Versatile Accuracy



- Kits are available in imperial and metric
- Vernier scale for 0.0001" (0.002mm) adjustments
- **3E TECH** digital readout module compatible*
- Standard ISO insert CC..0602..

Additional kits available, please inquire



.394" - 1.181"
(10mm - 30mm)

i # 104 046
m # 103 046 | \$2,068.49



.394" - 4.016"
(10mm - 102mm)

i # 104 048
m # 103 048 | \$3,365.39



*Sold separately

Portable Digital Display

Use with multiple boring heads equipped with a **3E TECH** port

i # 563 010
m # 536 010 | \$423.13



MASTER SHANKS WITH MVS (sold separately)

CAT | BT | HSK | PSC | NMTB | MT

Boring Tools

249 (248) Boring Head

Ø 0.118" - 1.189" (3mm - 30.2mm)



Features

- Compact construction
- 0.0005" (0.010mm) dial adjustment on diameter
- Variable length adjustment with accessories
- Coolant through



511 (510) Boring Head

Ø 0.016" - 0.472" (0.4mm - 12.0mm)



Features

- 0.0001" (0.02mm) digital adjustment on diameter
- Lengths and diameters achieved through the use of boring tools and bars
- 4 balancing elements for precision
- Coolant through



A DRILLING
B BORING
C REAMING
D BURNISHING
E THREADING
X SPECIALS

320 (310) Boring Head

Ø 0.787" - 8.070" (20mm - 205mm)



Features

- 0.0001" (0.002mm) Vernier adjustment on diameter
- Tools with Ø 0.787" - 4.05" (20mm - 103mm) are made of steel
- Tools with Ø 3.937" - 8.070" (100mm - 205mm) are made of aluminum
- Insert holder can be rotated for reverse machining
- Coolant through
- Can be used with AluLine serrated slides for large diameter OD turning



365 (364) Boring Head *Balance*

Ø 0.787" - 8.070" (20mm - 205mm)



Features

- 0.0001" (0.002mm) Vernier adjustment on diameter
- Internal auto-balancing
- Tools with Ø 0.787" - 2.579" (20mm - 65.5mm) are made of steel
- Tools with Ø 2.559" - 8.070" (65mm - 205mm) are made of aluminum
- Insert holder can be rotated for reverse machining
- Coolant through
- Can be used with AluLine serrated slides for large diameter OD turning



Boring Tools

565 (564) Boring Head *Balance* **DIGITAL**

Ø 1.968" - 8.070" (50mm - 205mm)



Features

- 0.0001" (0.002mm) digital adjustment on diameter
- Internal auto-balancing
- Tools with Ø 1.968" - 2.579" (50mm - 65.5mm) are made of steel
- Tools with Ø 2.559" - 8.070" (65mm-205mm) are made of aluminum
- Coolant through
- Insert holder can be rotated for reverse machining
- Can be used with AluLine serrated slides for large diameter OD turning



338 (337) Boring Head

Ø 3.937" - 128.150" (100mm - 3255mm)



Features

- 0.0001" (0.002mm) Vernier adjustment on diameter
- Aluminum light-weight construction
- Ø 3.937" - 8.071" (100mm - 205mm) on serrated tool body
- Ø 7.870" - 128.150" (200mm - 3255mm) on AluLine slides
- Insert holder can be rotated for reverse machining



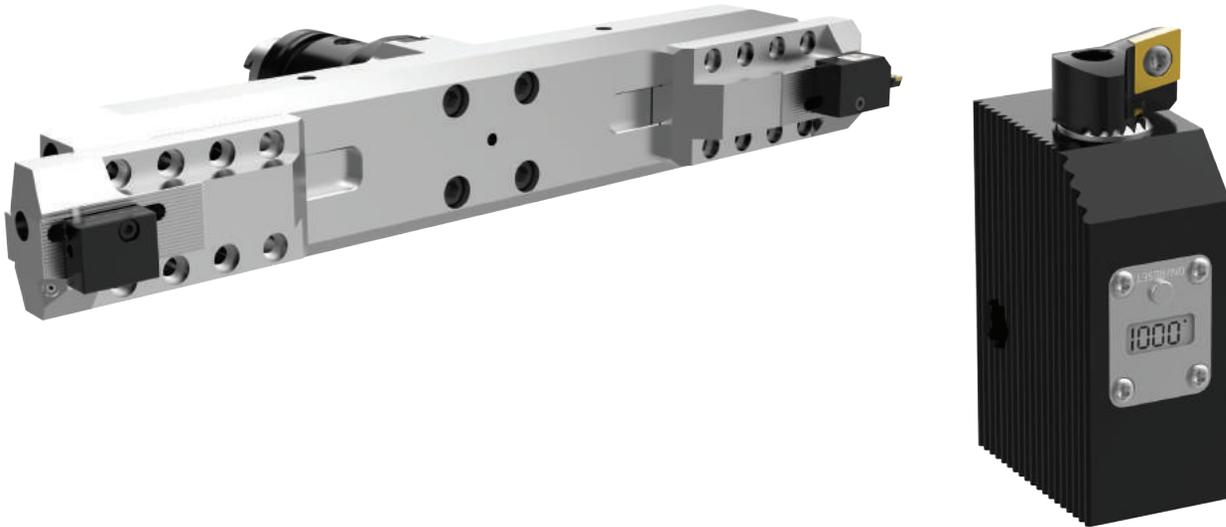
A DRILLING
B BORING
C REAMING
D BURNISHING
E THREADING
X SPECIALS

538 (537) Boring Head

Ø 3.937" - 128.15" (100mm - 3255mm)

Features

- 0.0001" (0.002mm) digital adjustment on diameter
- Aluminum light-weight construction
- Ø 3.937" - 8.071" (100mm - 205mm) on serrated tool bodies
- Ø 7.870" - 128.150" (200mm - 3255mm) on AluLine slides
- Insert holders can be rotated for reverse machining



COMBI LINE

Ø 0.965" - 7.913" (24.5mm - 201mm)

A true rough and finish 1-pass boring tool

Features

- Rough and finish boring in one operation
- 0.0001" (0.002mm) Vernier adjustment on finishing insert holder
- Available in height displaced and same level cutting
- Coolant through
- Standard ISO inserts



Cuts processing time in half!



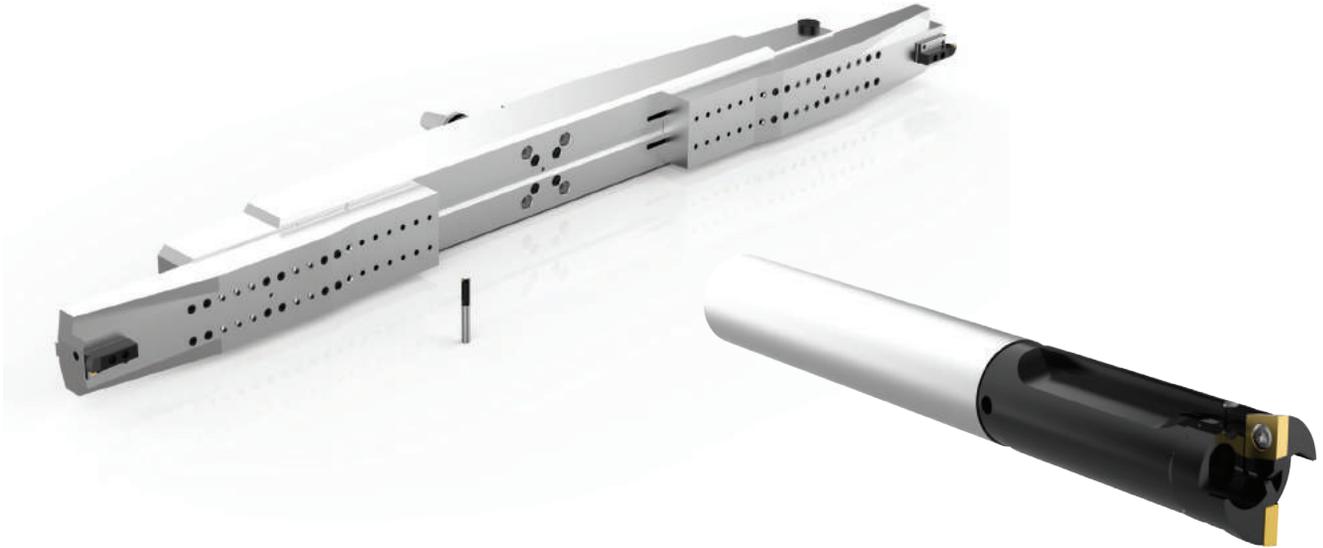
Boring Tools

Twin Cutter Roughing

Ø 3.937" - 128.15" (100mm - 3255mm)

Features

- Available with cylindrical shanks or MVS shanks
- Same level to double feed
- Height displacement to double material removal
- Coolant through
- Standard ISO inserts



Grooving Tools



Grooving Tools for Circular Milling
Ø > 0.787" (20mm)

- Groove widths from 0.050" (1.27mm)
- 2 - 8 inserts (depending on diameter)
- 2-sided inserts
- Coolant through



Axial Grooving Tools
0.787" - 8.070 (20mm - 205mm)

- Groove widths from 0.137" - 0.295" (3.5mm - 7.5mm)
- 3-sided inserts
- Utilizes the same serrated tool body as other roughing tools

A DRILLING
B BORING
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E THREADING
X SPECIALS

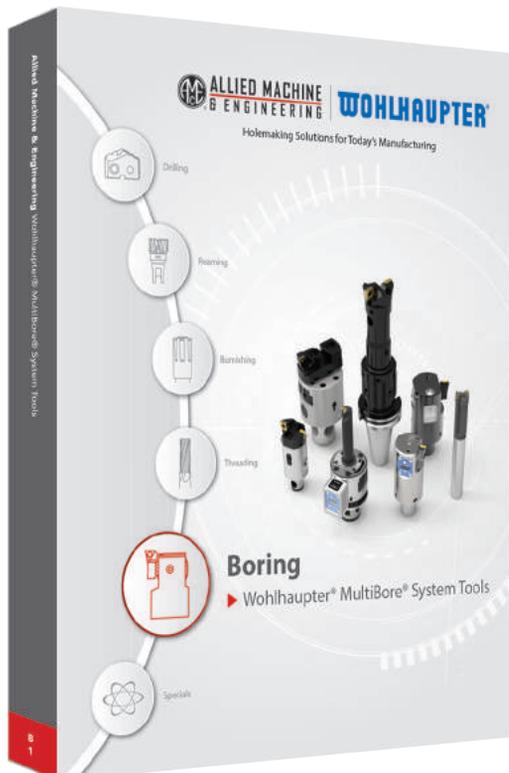
Chamfering Tools

$\varnothing > 0.748''$ (19mm)



Features

- Utilizes the same serrated tool holder as other roughing tools
- Chamfer angle of 15°, 20°, 30°, and 45°
- Coolant through
- Standard ISO inserts



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(Literature Order Number: WOHLCAT)

Tool-Architect

www.tool-architect.com



Design Your Own Solutions

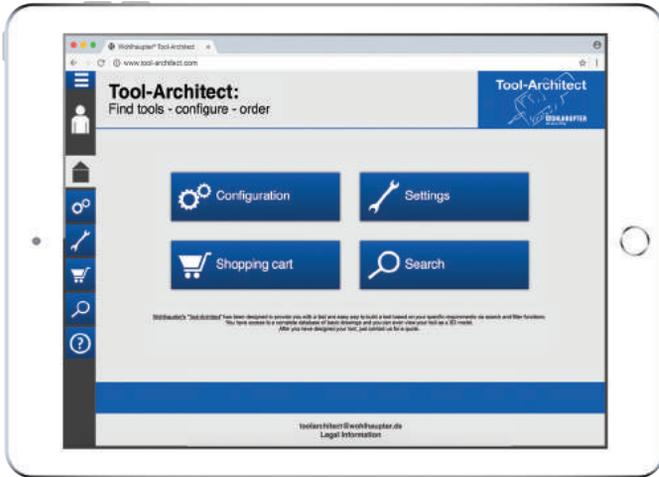
Tool-Architect is a configurator for Wohlhaupter modular tooling systems that allows customers to virtually build their own solution. This online-based simulator puts the entire Wohlhaupter inventory at your fingertips. It provides a digital bank of every individual part that Wohlhaupter manufactures in either inch or metric measurements.

Once you select a component, you will be guided by a series of user-friendly prompts to select the next components until you have built your tooling system. Throughout the process, you can monitor the size of your custom tool and ensure what you're building matches your real-life specifications. Once a complete system is virtually assembled, the program will render the tool in either a 2D or 3D drawing to view on your device. Each project can be saved for future editing.

Designing your tools with Tool-Architect saves you time and allows you to instantly obtain the right tool for the job.



Design anytime from anywhere.
Available online 24/7.

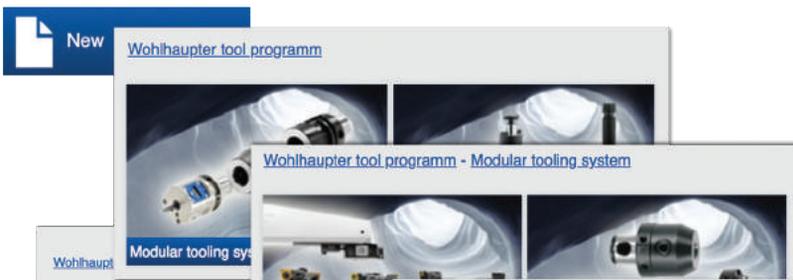


Find the right Wohlhafter® solution for your application

1. Configure your complete tool assembly
2. Compile an order list to be quoted
3. Search and quickly find components using various criteria
4. Adjust your language and measurement preferences



Find specific item details and download 2D and 3D drawings



Quickly navigate through the entire Wohlhafter product inventory to find the right tooling solution for your job

Image	Order No	Description	Order No	Description	Order No	Description	Order No	Description	Order No	Description	Order No	Description	Order No	Description	Order No	Description	Order No	Description
Wohlhafter tool programm - Modular tooling system - Cutting tools																		
Tools for rough machining																		
Tools for rough and finish machining																		
Tools for finish machining																		
Boring tools > 200 mm																		
Serrated tool bodies / Serrated slides																		
	248011	Precision boring tool	M8x1	20	TP10G0525..	46	24,5	30,2	yes	analog	metr.	8000	Steel	0,13	-			
	248012	Precision boring tool	M8x1	101	CC..0602..	42	15,9	20,1	yes	analog	metr.	20000	Steel	0,06	-			
	248021	Precision boring tool	M8x1	101	CC..0602..	46	19,9	24,8	yes	analog	metr.	15000	Steel	0,09	-			
	248022	Precision boring tool	M8x1	101	CC..0602..	46	24,5	30,2	yes	analog	metr.	8000	Steel	0,13	-			
	248023	Precision boring tool	M8x1	101	CC..0602..	46	24,5	30,2	yes	analog	metr.	8000	Steel	0,13	-			
	310011	Precision boring tool	MVS25-14	20	TP10G0525..	56	29	37	yes	analog	metr.	5500	Steel	0,2	-			

Guaranteed Test / Demo Application Form

Distributor PO # _____

The following must be filled out completely before your test will be considered

Distributor Information

Company Name: _____
 Contact: _____
 Account Number: _____
 Phone: _____
 Email: _____

End User Information

Company Name: _____
 Contact: _____
 Industry: _____
 Phone: _____
 Email: _____

Current Process List all tooling, coatings, substrates, speeds and feeds, tool life, and any problems you are experiencing

Test Objective List what would make this a successful test (i.e. penetration rate, finish, tool life, hole size, etc.)

Application Information

Hole Diameter: _____ in/mm	Tolerance: _____	Material: _____ (4150 / A36 / Cast Iron / etc.)
Pre-existing Diameter: _____ in/mm	Depth of Cut: _____ in/mm	Hardness: _____ (BHN / Rc)
Required Finish: _____ RMS	State: _____ (Casting / Hot rolled / Forging)	

Machine Information

Machine Type: _____ (Lathe / Screw machine / Machine center / etc.)	Builder: _____ (Haas, Mori Seiki, etc.)	Model #: _____
Shank Required: _____ (CAT50 / Morse taper, etc.)		Power: _____ HP/KW
Rigidity: _____	Orientation: _____	Tool Rotating: _____
<input type="checkbox"/> Excellent	<input type="checkbox"/> Vertical	<input type="checkbox"/> Yes
<input type="checkbox"/> Good	<input type="checkbox"/> Horizontal	<input type="checkbox"/> No
<input type="checkbox"/> Poor		Thrust: _____ lbs/N

Coolant Information

Coolant Delivery: _____ (Through tool / Flood)	Coolant Pressure: _____ PSI / bar
Coolant Type: _____ (Air mist, oil, synthetic, water soluble, etc.)	Coolant Volume: _____ GPM / LPM

Requested Tooling

QTY	Item Number	QTY	Item Number



**ALLIED MACHINE
& ENGINEERING**

Allied Machine & Engineering
 120 Deeds Drive
 Dover, OH 44622

Telephone: (330) 343-4283
 Toll Free USA & Canada: (800) 321-5537
 Fax: (330) 602-3400

Warranty Information



Allied Machine & Engineering warrants to original equipment manufacturers, distributors, industrial and commercial users of its products that each new product manufactured or supplied by Allied Machine shall be free from defects in material and workmanship.

Allied Machine's obligation under this warranty is limited to furnishing without additional charge a replacement or, at its option repairing or issuing credit for any product which shall within one year from the date of sale be returned freight prepaid to the plant designated by an Allied Machine representative and which upon inspection is determined by Allied Machine to be defective in materials or workmanship.

Complete information as to operating conditions, machine, set-up, and application of cutting fluid should accompany any product returned for inspection. The provisions of this warranty shall not apply to any Allied Machine products which have been subjected to misuse, improper operating conditions, machine set-up or application of cutting fluid or which have been repaired or altered if such repair or alteration in the judgment of Allied Machine would adversely affect performance of the product.

THIS WARRANTY IS IN LIEU OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. Allied Machine shall have no liability or responsibility on any claim of any kind, whether in contract, tort or otherwise, for any loss or damage arising out of, connected with, or resulting from the manufacture, sale, delivery or use of any product sold hereunder, in excess of the cost of replacement or repair as provided herein.

ALL PRICES, DELIVERIES, DESIGNS, AND MATERIALS ARE SUBJECT TO CHANGE WITHOUT NOTICE.



Allied Machine & Engineering
Registered to ISO 9001
10001329

United States

Allied Machine & Engineering

120 Deeds Drive
Dover OH 44622
United States

Phone:
+1.330.343.4283

Fax:
+1.330.602.3400

Toll Free USA and Canada:
800.321.5537

Toll Free USA and Canada:
800.223.5140

Allied Machine & Engineering

485 W Third Street
Dover OH 44622
United States

Phone:
+1.330.343.4283

Fax:
+1.330.364.7666
(Engineering Dept.)

Toll Free USA and Canada:
800.321.5537

Europe

Allied Machine & Engineering Co. (Europe) Ltd.

93 Vantage Point
Pensnett Estate
Kingswinford
West Midlands
DY6 7FR England

Phone:
+44 (0) 1384.400900

Wohlhaupter GmbH

Maybachstrasse 4
Postfach 1264
72636 Frickenhausen
Germany

Phone:
+49 (0) 7022.408.0

Fax:
+49 (0) 7022.408.212

Asia

Wohlhaupter India Pvt. Ltd.

B-23, 2nd Floor
B Block Community Centre
Janakpuri, New Delhi - 110058
India

Phone:
+91 (0) 11.41827044

Your local Allied Machine representative:

www.alliedmachine.com

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