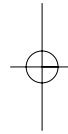
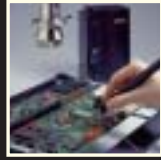


METCAL

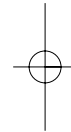
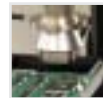
Precision Systems for the Electronics Bench

SOLDERING, DESOLDERING AND REWORK SYSTEMS



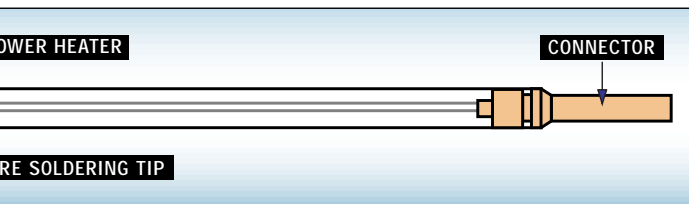
SmartHeat® Technology	0 2
600 Soldering, Desoldering & Rework System	0 4
Soldering Tip Cartridges	0 7
Desoldering Tip Cartridges	1 0
Rework Tip Cartridges	1 1
Speciality Tip Cartridges	1 4
Microfine Rework Tip Cartridges	1 5
Accessories & Spare Parts	1 6
800 Soldering System	1 8
900 Self-Contained Desoldering System	2 0
950 Convection Rework System	2 2
960 Hot Air Pencil	2 7

Contents



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01

the heater (a copper bar coated with a magnetized iron/nickel alloy
Curie Point), it stops absorbing energy and the temperature becomes



power supply feeds a steady current to the coil. This creates an electrical
r absorbs energy, turns it into heat and transfers it to the iron/nickel
rawn heat from the heater to the extent that the tip begins to cool, the
more energy in order to reheat the tip. In this way, SmartHeat® self-
ure to within $\pm 1.1^{\circ}\text{C}$ of a set point regardless of thermal load and
ment.

Replacement

plied with the unit
and remove the tip
this process ensures
activity, no need for
son for two soldering
e same time.

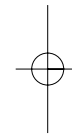


Route To Lead-Free Hand Soldering

soldering does not necessarily mean that you will have to invest in new
existing process. As SmartHeat's variable power and fixed temperature
temperature under a wide variety of thermal loads, the system can easily
temperatures demanded by lead-free applications without any need for

Required For Easy ISO 9000 Compliance

r soldering with a SmartHeat® system, simply record the tip cartridge
's alloy dictates the temperature, calibration is not required. Indeed,
or calibration tools, typical of other systems, with which you can adjust
his avoids all risk of unauthorized operator intervention. Throughout the
ature drift is less than a few degrees. A letter to confirm SmartHeat's
available on request.



And Simplicity

ce, characteristic of the Metcal hand-piece, improves process precision.
lications. The easy-squeeze design of Metcal's Talon® tweezers has been
uperior performance, unmatched comfort and optimum control.

MX-500S SMT SOLDERING/REWORK SYSTEM

20 VAC, Solder System

40 VAC, Solder System

able Power Supply with Power Cord*

iece with Cord

val Pad



MX-500TS SMT REWORK/TALON® SYSTEM

20 VAC, Solder/Talon® System

40 VAC, Solder/Talon® System

able Power Supply with Power Cord*

iece with Cord

iece with Cord

val Pad (2)



TALON® UPGRADE KITS

e Kit

iece with Cord

val Pad

e with Switchbox for Older STSS Systems

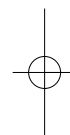
iece with Cord

val Pad

Storage Tray

ately from all systems. *220/240 VAC systems do not include power cords.

MX-500



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05

Soldering Tip Cartridges

are for use with the MX and the STSS soldering/rework hand-pieces only.
the SP systems, the Talon® or desoldering hand-pieces.

FREQUENTLY USED TIP CARTRIDGES

STTC-X36* Chisel 30° .10" (2.5mm)

For medium to heavy load joints requiring extra reach.

STTC-X37* Chisel 30° .07" (1.78mm)

For a wide variety of tasks. If you are choosing the first tip for your Metcal system, the STTC-037 is ideal.

STTC-X38* Chisel 30° .06" (1.5mm)

A finer version of the STTC-037. Ideal for medium to light through-hole and general surface mount touch-up.

STTC-X25 Chisel 30° .04" (1.0mm)

Good for a variety of light soldering tasks. Looking for a surface mount touch-up tip? The STTC-025 should be your first choice.

STTC-X07 Conical Sharp .04" (1.0mm)

General-purpose SMT and through-hole tip when access is limited.

STTC-X22 Conical Sharp .016" (0.4mm)

Sharp tip cartridges for soldering SMT components or fine wire applications (not for general through-hole tasks).

STTC-X06 Conical Sharp .016" (0.4mm)

For limited access SMT rework.

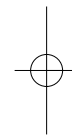
STTC-X40 Sharp Bent 30° .016" (0.4mm)

Tip for soldering SMT components. The bend makes it much easier to work on small circuits and PLCCs.

STTC-X45 Bevel 60° .016" (0.4mm)

An extended length fine tip for surface mount or fine wire applications (not for general through-hole tasks).

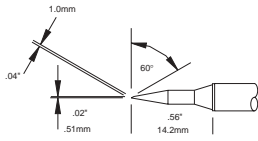
MX Tips



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07

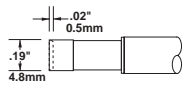
OTHER STANDARD TIP CARTRIDGES

STTC-X15
Bevel 30°
.05" (1.3mm)



STTC-X46
Long Reach
Bevel 60°
.04" (1.0mm)

STTC-X24
Bevel 30°
.04" (1.0mm)



STTC-X70
Heat Staking
.19" (4.8mm)

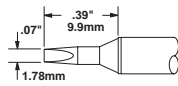
STTC-X97
Grooved Semi-Rigid
Coax

Series X=0 700 Series X=1 800 Series X=8, WHEN FOLLOWED BY AN *

SRTC ROBOTIC TIP CARTRIDGES

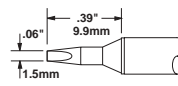
SRTC Cartridges are designed for use with MX-RM5E or MX-RM8E handles only. Similar to STTC tip cartridges, SRTC Cartridges have a shaft length of 3.15" (80mm) and, therefore, are not compatible with the MX-RM5E handle.

SRTC-X17*
Extra Large Chisel
.20" (5.0mm)



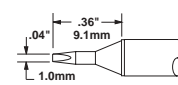
SRTC-X37
Chisel 30°
.07" (1.78mm)

SRTC-X13
Chisel 90°
.12" (3.0mm)



SRTC-X38
Chisel 30°
.06" (1.5mm)

SRTC-X36
Chisel 30°
.10" (2.5mm)



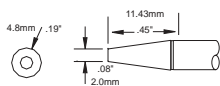
SRTC-X25
Chisel 30°
.04" (1.0mm)

Series X=7 800 Series X=8, WHEN FOLLOWED BY AN *

PTTB BONDING TIP CARTRIDGES

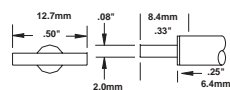
For plastic bonding applications, these aluminum tips can be used with all MX-RM5E or MX-RM8E handles.

PTTB-501
Bonding Tip



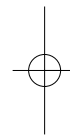
PTTB-503
Bonding Tip

PTTB-502
Bonding Tip



PTTB-504
Bonding Tip

MX Tips



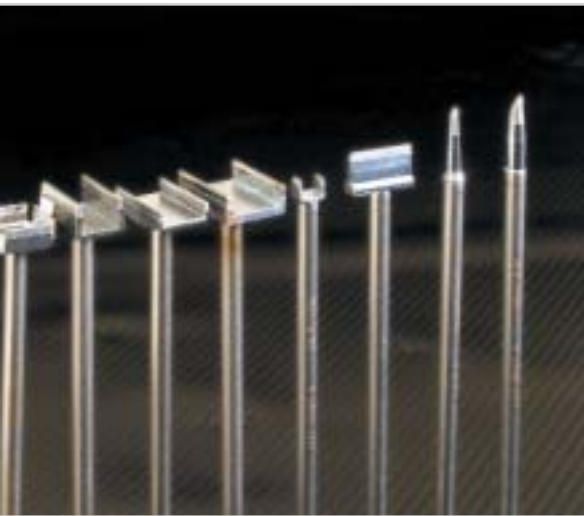
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SMTC

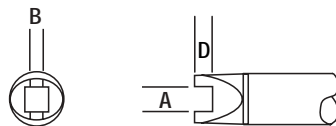
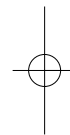
SMT Rework Tip Cartridges

SMT components, SMTC tip cartridges do it all – assembly, removal and rework. The SMTC range also includes slot, tunnel and quad tip cartridges. The SMTC range also includes blade tips to remove residual solder from pads, and knife tips for reworking PLCCs in tight places.

SMTC tip cartridges are for use with the MX-RM3E soldering/rework hand-pieces only. They cannot be used with SP systems, Talon® hand-pieces or



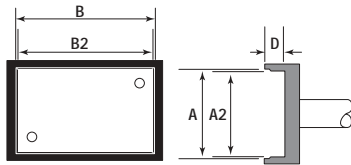
MX Tips



DIMENSIONS IN INCHES (mm)

A	B	D	Part No.
.090 (2.29)	.050 (1.27)	.070 (1.79)	SMTC-X01
.140 (3.56)	.060 (1.52)	.070 (1.79)	SMTC-X02
.190 (4.83)	.080 (2.03)	.075 (1.91)	SMTC-X03
.135 (3.43)	.080 (2.03)	.120 (3.05)	SMTC-X35
.150 (3.81)	.095 (2.41)	.100 (2.54)	SMTC-X32
.190 (4.83)	.110 (2.79)	.160 (4.06)	SMTC-X36
.250 (6.35)	.095 (2.41)	.130 (3.30)	SMTC-X33*
.300 (7.62)	.100 (2.54)	.140 (3.56)	SMTC-X34*
.068 (1.73)	.100 (2.54)	.050 (1.27)	SMTC-X05
.110 (2.80)	.250 (6.35)	.080 (2.03)	SMTC-X08
.080 (2.03)	.050 (1.27)	.060 (1.52)	SMTC-X88
.070 (1.78)	.040 (1.02)	.040 (1.02)	SMTC-X96

700 SERIES X=0 700 SERIES X=1 * = NOT AVAILABLE FOR 500 SERIES



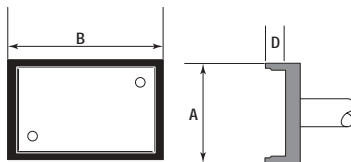
P

DIMENSIONS IN INCHES (mm)

	A	B	B2	D	Part No.
.38)	.330 (8.38)	.330 (8.38)	.330 (8.38)	.100 (2.54)	SMTC- X 121
.18)	.440 (11.18)	.440 (11.18)	.440 (11.18)	.100 (2.54)	SMTC- X 120
.18)	.480 (12.19)	.480 (12.19)	.520 (13.21)	.110 (2.79)	SMTC- X 159
.32)	.525 (13.34)	.485 (12.32)	.525 (13.34)	.110 (2.79)	SMTC- X 132
.97)	.550 (13.97)	.550 (13.97)	.550 (13.97)	.130 (3.30)	SMTC- X 115
.48)	.610 (15.49)	.570 (14.48)	.610 (15.49)	.110 (2.79)	SMTC- X 118
.75)	.620 (15.75)	.860 (21.84)	.860 (21.84)	.130 (3.30)	SMTC- X 133
.13)	.635 (16.13)	.635 (16.13)	.635 (16.13)	.130 (3.30)	SMTC- X 21
.51)	.650 (16.51)	.885 (22.48)	.885 (22.48)	.130 (3.30)	SMTC- X 43
.15)	.675 (17.15)	.910 (23.11)	.910 (23.11)	.130 (3.30)	SMTC- X 15
.45)	.805 (20.45)	.805 (20.45)	.805 (20.45)	.190 (4.83)	SMTC- X 45*
.45)	.840 (21.34)	.805 (20.45)	.840 (21.34)	.075 (1.91)	SMTC- X 122
.02)	1.020 (25.91)	.985 (25.02)	1.020 (25.91)	.125 (3.18)	SMTC- X 86
.42)	1.040 (26.42)	1.040 (26.42)	1.040 (26.42)	.130 (3.30)	SMTC- X 44*
.58)	1.770 (44.96)	1.125 (28.58)	1.170 (44.96)	.114 (2.90)	SMTC- X 81
.59)	1.200 (30.48)	1.165 (29.59)	1.200 (30.48)	.120 (3.05)	SMTC- X 48
.77)	1.330 (33.78)	1.290 (32.77)	1.330 (33.78)	.110 (2.79)	SMTC- X 125
.64)	1.650 (41.91)	1.650 (41.91)	1.600 (40.64)	.200 (5.08)	SMTC- X 158**

TIPS X=1 FOR ALL QUADS USE 700 SERIES TIP CARTRIDGES
600 SERIES **= NOT AVAILABLE FOR 600 SERIES

require two power supply units and two hand-pieces. A Dual Hand-Piece is recommended.



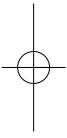
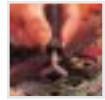
(INSIDE SOCKET)

A	B	D	Part No.	Recommended Part No.
.860 (9.14)	.360 (9.14)	.115 (2.91)	SMTC- X 144	SMTC-1144
.556 (11.58)	.556 (14.12)	.120 (3.05)	SMTC- X 109	SMTC-1109
.160 (40.64)	1.160 (40.64)	.115 (2.91)	SMTC- X 145	SMTC-1145

TIPS X=1 FOR ALL QUADS USE 700 SERIES TIP CARTRIDGES

require two power supply units and two hand-pieces. A Dual Hand-Piece is recommended.

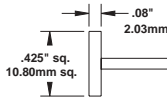
MX Tips



OTHER SPECIALITY TIP CARTRIDGES

SMTC-X98**

SMT Connector
28 Pin



SMTC-X136**

Hot Plate
.425" sq. (10.8mm sq.)

SMTC-X100

Micro XMT
Small Package
Co-Axial Tip

SERIES X=0 700 SERIES X=1 800 SERIES X=8

700 OR 800 SERIES

Microfine Rework Tip Cartridges

This cartridge series is designed for reworking 0201 and 0402 or microfine components with the help of a microscope. This series includes tips that can be used to remove components from the topside approach or can also be used for multi-lead components, LCC and QFP components with access problems. Depending on your application, these tips will meet your micro component rework needs.

SMTC-X171

Use to remove 0201 and 0402 components from a "topside" angle. This design increases microscope viewing when reworking/removing micro chip capacitors/components.

SMTC-X172

Designed for fine drag soldering and point-to-point soldering. This tip increases access between components and allows for lead to lead or solder bridge clean-up.

SMTC-X174

Long reach micro hoof tip designed with a smaller surface area than the mini-hoof for optimal drag soldering of components in tight spots.

SMTC-X175

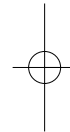
Micro-hoof tip designed with a smaller surface area than the mini-hoof for drag soldering of small/micro leaded components.

STTC-X90

Microfine tip designed for soldering and touch-up of micro components such as 0201s and 0402s.

SERIES X=0 700 SERIES X=1 800 SERIES X=8

MX-Tips



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DESOLDERING ACCESSORIES

Q	MX-DCF1	DS1 Filter Pack: 15 chamber liners, 6 fume filters
	MX-DCF1L	DS1 Chamber Liners (Pack of 40)**
	MX-DCF1F	DS1 Fume Filters (Pack of 20)**
R	MX-DAR1	Air Regulator and Filter with Fittings
S	AC-TC-P	Desolder Tip Cleaner (Pack of 12)
T	AC-CB1-P	Desolder Chamber Cleaning Brush (Pack of 25)
U	AC-CB2-P	Desolder Tube Cleaning Brush (Pack of 6)
V	MX-DVC1	Venturi Cartridge for Desolder Gun
W	MX-DSL1	DS1 Chamber Seal
X	MX-DSL2	DS1 Cartridge Seal
Y	MX-DSB	Desolder Gun Swivel Bushing

DESOLDERING MAINTENANCE KIT

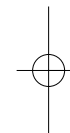
MX-DMK1 DS1 Maintenance Kit

INCLUDES

Z	Long Phillips Screws (Pack of 2)***
AA	Short Phillips Screws (Pack of 4)***
BB	MX-DSB Desolder Gun Swivel Bushing
CC	Hex Screws (Pack of 2)***
DD	MX-DLA Desolder Gun Latch Adjustment (Pack of 10)
EE	Large Springs (Pack of 2)***
FF	Nylon Screws (Pack of 2)***
GG	MX-DSL2 DS1 Cartridge Seal (Pack of 2)
HH	Hinge Pins (Pack of 4)***
II	O-Rings (Pack of 2)***
JJ	MX-DSL1 DS1 Chamber Seal (Pack of 2)
KK	Small Springs (Pack of 6)***
	MX-DUC DS1 Upper Chamber (Type II Desolder Tool)**

** Not shown *** Not sold separately

MX-500



OTHER SYSTEM COMPONENTS

POWER SUPPLY AND POWER METER

MX-500P-11	Two Port 100/120 VAC Power Supply
MX-500P-21	Two Port 220/240 VAC Power Supply*
MX-NPM	Net Power Meter

*220/240 VAC Power Supply does not include power cord.

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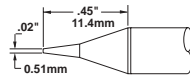
Soldering Applications

's tip cartridges are designed to suit a wide range of soldering applications. Operators should select the tip that allows maximum contact with the work. You start with a 600 series tip cartridge.

SP200 SOLDER TIP CARTRIDGES

SSC-X17A

Extra Large Chisel
 .21" (5.3mm)

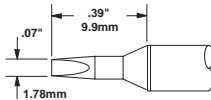


SSC-X22A

Conical Sharp
 .02" (0.51mm)

SSC-X13A

Chisel 90°
 .13" (3.3mm)

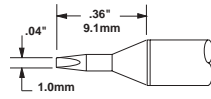


SSC-X72A

Conical Chisel
 .07" (1.78mm)

SSC-X46A

Long Reach Chisel
 .12" (3.0mm)

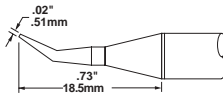


SSC-X71A

Conical Chisel
 .04" (1.0mm)

SSC-X36A

Chisel 30°
 .10" (2.5mm)

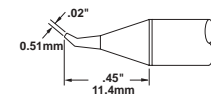


SSC-X54A

Sharp Bent 30°
 .02" (0.51mm)

SSC-X42A

Long Reach Chisel 60°
 .07" (1.78mm)

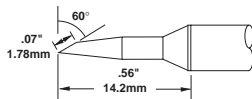


SSC-X26A

Sharp Bent 30°
 .02" (0.51mm)

SSC-X70A

Long Chisel
 .07" (1.78mm)

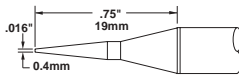


SSC-X47A

Bevel 60°
 .07" (1.78mm)

SSC-X37A

Chisel 30°
 .07" (1.78mm)

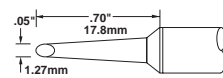


SSC-X45A

Bevel 60°
 .016" (0.4mm)

SSC-X38A

Chisel 30°
 .06" (1.5mm)

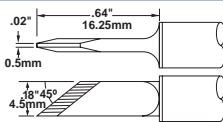


SSC-X67A

Drag Soldering Tip
 (Mini-Hoof)

SSC-X25A

Chisel 30°
 .04" (1.0mm)

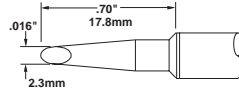


SSC-X61A

Drag Soldering Tip
 (Knife)

SSC-X74A

Conical Sharp
 .055" (1.4mm)

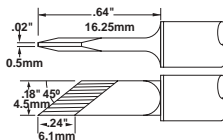


SSC-X39A

Drag Soldering Tip
 (Hoof)

SSC-X01A

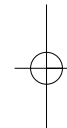
Conical Sharp
 .04" (1.0mm)



SSC-X73A

Drag Soldering Tip
 (Increased Tinned Area, .24" 6.1mm)

SP200



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ing And Safety Features

Desoldering System has a number of features, which combine to ensure and cost-effective solution available for self-contained desoldering. The switches off the power supply after a 30-minute redundancy period, thus life and conserving energy.

s are elements that reflect our dedication to operator and process safety. Desoldering System's ESD cable and vacuum line are burn-proof, which injury and prevents damage to expensive process elements. The unit's der collection chamber renders the former glass cartridges obsolete and cess.

Desoldering System's tips are available in two temperature ranges: 600 the best results, choose a tip with an interior diameter only slightly larger e component to be desoldered.



SP440 DESOLDERING SYSTEM

System Includes Power Supply With Power Cord*, Hand-Piece Assembly, Workstand Kit With Sponge, Tip Cleaners And Cartridge Removal Pad

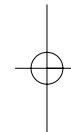
SP440-11	115 VAC Self-Contained Desoldering System
SP440-21	220/240 VAC Self-Contained Desoldering System*

*220/240 VAC system does not include power cords

ACCESSORIES & SPARE PARTS

SP-PW3-11	Power Supply with Power Cord
SP-PW3-21	Power Supply with Power Cord*
DP-DSG2	Hand-Piece Assembly (handle, cord, vac line, coil assembly)
DP-WSK2	SP440 Workstand Kit with YS3 Sponge
DP-SL3	Front Seal for DSG2
AC-TC-P	Tip Cleaners (Pack of 12)
AC-CP2	Cartridge Removal Pad
DP-CA2	Coil Assembly
DP-CC	Solder Collection Chamber for DSG2
DP-CF	Filter Pack (12 fume filters, 24 chamber liners)
DP-LF	Filter Pack (5 inline filters)
DP-VB1	Valve Body Assembly (clip, valve, ESD vac. hose)
DP-VL1	Vacuum Line, ESD
DP-WSC2	SP440 Cradle
AC-YS3-P	Workstand Sponge (Pack of 50)

*220/240 VAC system does not include power cords



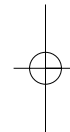


ation

ork System's vacuum pick-up gently removes components after reflow. cycle is stored and displayed as a guide to help operators quickly establish onent placement. The system then automatically turns off the heat to al shock to adjacent components or to the PCB itself. An integrated also available to prevent the warping of large boards during rework.

e power by adjusting the airflow rate, but to minimize thermal stress, the ins the heater exhaust temperature while maintaining a consistently low accommodate any process change, including the use of new soldering engineer can easily reprogram this set temperature.

QX2



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Rework Nozzles

A range of nozzles for the QX2 Convection Rework System. For non-standard nozzle program. Please contact your local Metcal representative for more nozzles.

STANDARD NOZZLE RANGE

DIMENSIONS IN INCHES (mm)

Part No.	Component Types	A	B
NZ-D1113	Nozzle Dual	0.43 (11)	0.51 (13)
NZ-D1116	Nozzle Dual (for SOL 28)	0.43 (11)	0.63 (16)
NZ-D1420	Nozzle Dual	0.55 (14)	0.79 (20)
NZ-D2109	Nozzle Dual	0.35 (09)	0.83 (21)
NZ-D2113	Nozzle Dual	0.51 (13)	0.83 (21)
NZ-Q11	Nozzle Quad (for PLCC 20)	0.43 (11)	0.43 (11)
NZ-Q13	Nozzle Quad (for PLCC 28)	0.51 (13)	0.51 (13)
NZ-Q1415	Nozzle Quad	0.55 (14)	0.60 (15)
NZ-Q17	Nozzle Quad	0.67 (17)	0.67 (17)
NZ-Q18	Nozzle Quad (for QFP 80)	0.71 (18)	0.71 (18)
NZ-Q19	Nozzle Quad (for PLCC 44)	0.75 (19)	0.75 (19)
NZ-Q1925	Nozzle Quad (for QFP 100)	0.75 (19)	0.98 (25)
NZ-Q22	Nozzle Quad	0.87 (22)	0.87 (22)
NZ-Q23	Nozzle Quad	0.91 (23)	0.91 (23)
NZ-Q27	Nozzle Quad (for PLCC 68)	1.06 (27)	1.06 (27)
NZ-Q28	Nozzle Quad	1.10 (28)	1.10 (28)
NZ-Q32	Nozzle Quad (for PLCC 84, QFP 208)	1.26 (32)	1.26 (32)
NZ-Q33	Nozzle Quad (for QFP 120/128/144/160)	1.30 (33)	1.30 (33)
NZ-Q35	Nozzle Quad	1.38 (35)	1.38 (35)
NZ-Q38	Nozzle Quad	1.50 (38)	1.50 (38)
NZ-Q43	Nozzle Quad	1.70 (43)	1.70 (43)

ES

A range of standard nozzles, we also offer a range of box reflow nozzles of shielding cans, connectors and other square components.

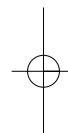


BOX REFLOW NOZZLES

INTERNAL DIMENSIONS IN INCHES (mm)

Part No.	Component Types	A	B
NZ-B23	Nozzle Box	0.91 (23)	0.91 (23)
NZ-B27	Nozzle Box	1.06 (27)	1.06 (27)
NZ-B33	Nozzle Box	1.30 (33)	1.30 (33)
NZ-B35	Nozzle Box	1.38 (35)	1.38 (35)
NZ-B40	Nozzle Box	1.57 (40)	1.57 (40)
NZ-B44	Nozzle Box	1.73 (44)	1.73 (44)

QX2



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T-1160

-1160 Hot Air Pencil

Air Rework Station

Convection, Metcal's SMT-1160 Hot Air Pencil is designed for those rework applications requiring low thermal stress, including SMDs and temperature-sensitive ceramic components. The SMT system, with variable temperature flow, can also capably remove SMT components.

The SMT-1160 is equipped with a broad range of features for assured effectiveness and reliability. These include an ESD-safe housing and hand-piece, variable airflow control, top temperature control, a nitrogen input facility to suit inert soldering applications and split, fan and fine nozzle options.

The SMT-1160's capacity for non-contact soldering avoids alignment disruption and mechanical shock to components.

0 HOT AIR PENCIL

Hand-Piece, 3 Piece Nozzle Kit
Temperature Module

Hand-Piece Rework Station
Hand-Piece Rework Station



ES & SPARE PARTS

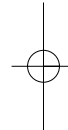
Hand-Piece
Hand-Piece with Nozzle kit
Temperature Module
0.025" (0.64mm)
0.037" x 0.030" (8.8mm x 0.76mm)
0.065" (6.7mm)
0.028" (10.9mm)
Kit (includes 16812, 16813, 16846)

Assembly SHP-1060A
Assembly SHP-1060A

Workstand Cradle
0.01" (2.57mm)
0.080" (2.03mm)
0°, .080" (2.03 mm)



SMT
1160



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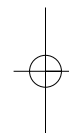
Global

Metcal Global Locations

California, is home to Metcal's corporate headquarters, and the central location for development, manufacturing and administration.

To serve its customers throughout the world, Metcal has sales, service and distribution offices in North America, Asia, and Europe. Drawing on its organizational strengths and industry expertise, Metcal's distribution network offers seamless, proactive support and access to the full range of products - around the globe.

Metcal's electronics manufacturing facilities are located, Metcal's network of expertly trained technicians are here, to supply essential technical support and advanced process solutions.



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