

## Operating Instruction Booklet

### Pneumatic Riveting and Cutting Hammer

NFK26  
NFK38  
NAFK38

811982 A  
811983 A  
811984 A

Dear Customer:

This tool is the result of more than 75 years of experience in the design and manufacturing of pneumatic tools for the industrial market.

We kindly ask that you read these operating instructions carefully so that you will be able to use this tool safely and for many years to come.

If you need additional information, please contact your DEPRAG Representative, one of our international support offices or us direct at DEPRAG. We will be happy to answer any questions. Please visit our web site: [www.deprag.com](http://www.deprag.com)

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# 1 Safety Tips

## 1.1 General Safety Tips



**Before operating tool make sure to carefully read and observe this operating instruction.**

Generally, the operator of the equipment and/or machinery is responsible for the equipment's perfect condition and operation, while observing all necessary safety regulations. The equipment and/or machinery has been constructed in accordance with the newest level of technology while recognizing all necessary safety-related requirements. Nevertheless, while operating the equipment and/or machinery there is a risk of bodily harm to the operator as well as damage to equipment and/or machinery and other property.

Operate the equipment and/or machinery only if equipment/machinery

- Is used for the task it was designed for
- is in perfect working condition and safe to use.


It is important to observe the technical data of the equipment, especially in regards to the environmental temperatures. The designated area of use for this equipment is clearly described in chapter *Designated Equipment Use* and those requirements have to be observed as well. Prerequisite for the safe conduct and the uninterrupted operation of the equipment, is the knowledge of the basic safety tips and the safety regulations. Additionally, all current regulations for a safe operational area, for accident-prevention guidelines of electrical and mechanical installations, as well as noise suppression demands must be observed. During any maintenance or repair work, a clean work surface is recommended. Also, it is not recommended to either eat or smoke during repair or maintenance. Arbitrary changes made to the equipment, which alters its designated use, voids the warranty and cancels the manufacturers liability.

- The tool is not insulated to protect against an electrical power surge.
- It is not recommended to use this tool in explosive hazardous environments, unless it was specifically designed for such a use.

The operating instruction booklet, especially the safety symbols and safety tips attached to the equipment or included in the documentation, must be observed at all times by all persons getting into contact with the equipment.

## 1.2 Safety Tips for Pneumatic Hammers



- Disconnect tool from power supply when exchanging tool inserts or servicing the tool.
  - Do not wear any loose clothing or jewelry. These may get caught by moving parts. Make sure to wear a hair-net.
  - Keep your hands off the tooling used.
  - Pay attention to possible abrupt movements of the machine due to reaction forces or breaking of used tooling or workpieces.
  - Working with hammers may produce dust and depending on the material of the working surface this may be bad for the operator's health.
  - Personal protective devices and dust vacuum systems must be provided depending on the material of the work pieces / surfaces.
  - Wear eye and ear protection; gloves and protective clothing is recommended, too.
  - Chiseling operations may cause fragmentation or even destruction of the work piece.
  - The tooling of heavy-duty hammers such as concrete breakers is exposed to especially rough treatment and after some time of use may break due to fatigue.
  - Insert tools improperly fastened or damaged may cause strong vibrations.
  - The operator's incorrect body carriage will not allow a proper reaction to normal or unexpected movements of the hammer. Therefore, please make sure to carry yourself so that you are even prepared for a possible breaking of the insert tool.
  - Holding the hammer in the hand freely may lead to vibration injuries.
-  • The maximum operating pressure (flow pressure) must not be exceeded. A pressure regulator should be integrated so that the pressure will be adjusted before reaching the hammer.
- Please note that the insert tool may turn a few more cycles after switch-off.
  - In case air supply is interrupted, make sure to release start button/lever, because otherwise tool will restart with re-installed air supply.
  - There is a risk of getting hurt by a whip-lashing air hose - please pay careful attention.
  - Permissible inserting tools with a suitable shaft diam. only must be used.
  - Do not run tools in the vicinity of inflammable liquids or gases.
  - Use lubricators recommended by DEPRAG, only.
  - Make sure to lock inserting tool against loosening/dropping out (using a holding spring, catch or flap).
  - Pay attention to firmly tighten handle with the cylinder and the presence of the locking pin on the screw cap.

## 1.3 Owner Obligation

The owner is obliged to only let persons operate the equipment, who

- are familiar with basic work environment safety rules and accident-preventing regulations. Also, those persons must have been instructed in the correct use of the equipment.
- have read and understood all safety and warning notifications in the Operating Instruction Booklet, as well as all other documentation pertaining to this equipment.
- check and confirm at regular intervals, that a safety oriented operation is guaranteed.

Only qualified and authorized personnel is allowed to operate, maintain and repair this equipment. A malfunction, which impairs operator safety, must be immediately removed.

## 1.4 Operator Obligation

Personnel, who is engaged in the operation of the equipment, must always be committed to

- observe the basic safety and accident preventing regulations,
- read and observe the safety and warning notifications of this operating instruction booklet.

## **1.5 Warranty and Liability**

Unless otherwise specified, our “General Sales and Delivery Conditions” apply. Warranty and liability claims in regards to persons or equipment damages are invalid, if one or several of the following causes apply:

- Use of the equipment in a non-designated application.
- Improper installation, operation, service or maintenance of the machine.
- Operation of the machine with either defective or removed safety and protection devices.
- Non-observance of the requirements stated in the operating instruction booklet, in regards to transportation, storage, mounting, installation, operation, maintenance and service of the equipment.
- Structural change or adjustment on the equipment to a non-designated use.
- Inadequate supervision of wear parts.
- Improper repair, inspection or maintenance.
- Catastrophic cases because of a war, acts of god or other reasons which are beyond our control.

## 1.6 Symbol Description



**Read and observe the Operating Instruction Booklet, prior to and during operation of tool.**



### **DANGER**

**Reference to an immediate danger to a person. May lead to serious injuries or even death, if unobserved!**



Properly recycle environmentally damaging grease, cooling agents or detergents.



### **RECOMMENDATIONS**

Important or additional information on the equipment or in the documentation.



Use eye protection or wear safety goggles.



Wear hearing protection.



Warning against hand-injuries.

Attention: Keep away your hands from areas, which are marked with this symbol!



Hands may be crushed, seized or otherwise injured.



ESD-protected area

Equipment may be damaged or destroyed by an electrostatic discharge.



Maintenance and repair on hydraulic and pneumatic equipment may only be performed by specially trained personnel!  
Disconnect equipment from air supply, prior to repair of pneumatic or hydraulic equipment.



Provide regular preventive maintenance on hoses and airlines. Exchange hose lines, even if there is no visible damage!  
(Observe corresponding requirements of the manufacturer!)

After repair and maintenance, check the following items:

- make sure all detached and re-attached connections are solid.
- confirm that removed covers, screens or filters were re-installed
- During disconnecting or reconnecting of an air-operated equipment, injury may occur due to a whipping air-hose

After conclusion of maintenance or repair and prior to start of operation, make sure to

- remove all materials, tools and other supplies needed for the maintenance or repair from work area of the equipment
- remove leaking liquid or oils
- make sure all safety devices on the equipment work perfectly!

## 1.7 Observe Environmental Regulations



When working on or with the equipment, it is imperative to observe all requirements in regards to waste-disposal and proper recycling.

Especially during installation, repair or maintenance, water damaging agents such as

- lubricating grease and oil
- hydraulic fluid
- cooling agents
- solvent-containing cleaning agents

must not leak into the ground or into the sewage system!

Such materials must be stored, transported, contained and recycled in suitable containers.

## 2 Designated Equipment Use

The NFK/NAFK-Hammer is used for cutting needle heads and for rejecting rivets out of steel plates of any type.

### 3 Installation

- Blow out air line and pressure hose, prior to connection it to the equipment.
- The hoses must be free of bends and kinks.
- Make sure, that all air lines have a sufficient cross-section and remove possible throttle areas.
- Best results are achieved, when machine is lubricated with 1 – 2 drops of oil per 1m<sup>3</sup>.
- The hammer **must be operated with lubricated air**. Connect the hammer as follows:

For the use with minimal lubrication connect to a filter-regulator consisting of filter with condensation reservoir and pressure regulator

| Air Consumption                | Connecting thread | Part No. |
|--------------------------------|-------------------|----------|
| 0,05 - 0,5 m <sup>3</sup> /min | G 1/4             | 822408 A |
| 0,15 – 0,9 m <sup>3</sup> /min | G 3/8             | 826981 A |
| 0,5 – 1,5 m <sup>3</sup> /min  | G 1/2             | 822409 A |
| 0,8 – 6,0 m <sup>3</sup> /min  | G 3/4             | 826982 A |

in connection with a Point-of-Use Oiler (Part No. 378077 A)

- Check air pressure at F/R/L outlet. The Regulator needs to be adjusted to an airflow of 6.3 bar (90 PSI). A higher pressure than 6.3 bar leads to increased wear and tear. Pressure below 6.3 bar leads to performance loss.

In regards to air-quality according to ISO8573-1, we recommend:

|                | CLASS | RESIDUE OF OIL            | RESIDUE OF DUST  |                                      | RESIDUE OF WATER |  |
|----------------|-------|---------------------------|------------------|--------------------------------------|------------------|--|
|                |       | Content mg/m <sup>3</sup> | Particle Size μm | Concentration max. mg/m <sup>3</sup> | Dew Point °C     | Pressure Concentration max. g/m <sup>3</sup> |
| Lubricated Air | 4     | 5                         | 15               | 8                                    | +3               | 6  |

### 4 Operation



**Caution**

**An inserting/treating tool getting loose or a loose handle may cause injuries. Before start-up, make sure to check inserting/treating tool or handle for secure holding.**

**Use permissible inserting/treating tools only!**

**Connection:**

1. Connect hose (I.D. 15 mm) onto quick release coupling.
2. Open shut-off valve (operating pressure 6,3 bar/90 PSI).

## Start:

- Actuate the pusher 809492 and the hammer starts.

## NFK26 und NFK38

### How to clamp inserting tool:

- Insert the tool into the cylinder.

## NAFK38

### How to clamp the inserting tool:

1. Unscrew the spring 809503 from the cylinder.
2. Insert the tool into the cylinder and reassemble the spring.

## 5 Handling

Use the equipment only while observing all safety tips and maintenance regulations. Don't let push the machine without load, because the stop of the piston can be damaged.



**Don't keep the inserted tool by your free hand!**  
**This can have adverse effects by vibrations.**

With a weighted acceleration  $a_{h,w}$  (in accordance with DIN EN 28662-2) over  $2,5 \text{ m/s}^2$  use the following formula. The permissible daily time of exposition  $T$  (in relations with the 8 standard-working hours) with the use of a machine can be approximated for one operator with the following formula:

$$T[h] = \left( \frac{5}{a_{h,w}} \right)^2 \cdot 8$$

$T$  = time of exposition

$a_{h,w}$  = Value of weighted acceleration (look at techn. Data: Vibration)

## 6 Disassembly - Assembly

**Disassembly:** (see Spare Parts Drawing)



**Prior to disassembly, disconnect equipment from air supply ! Only experienced maintenance personnel may assemble or disassemble this equipment.**

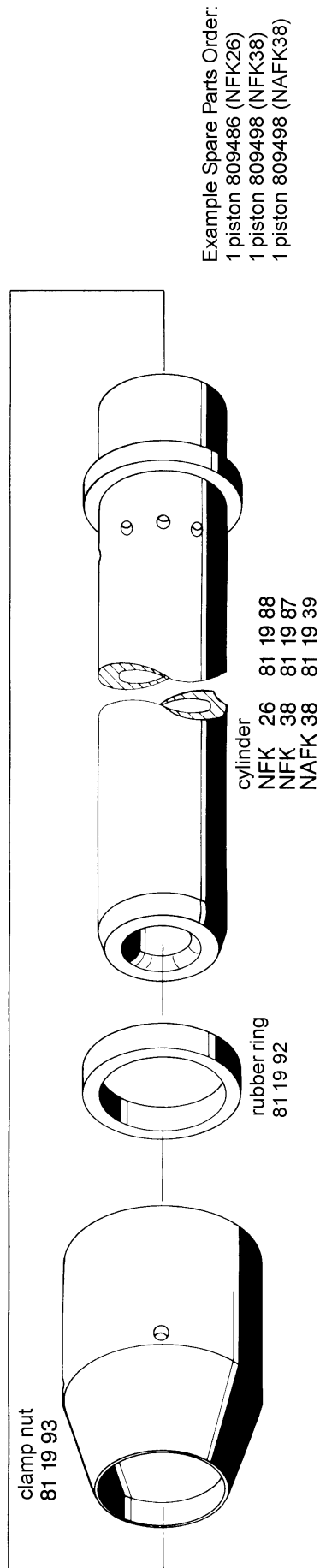
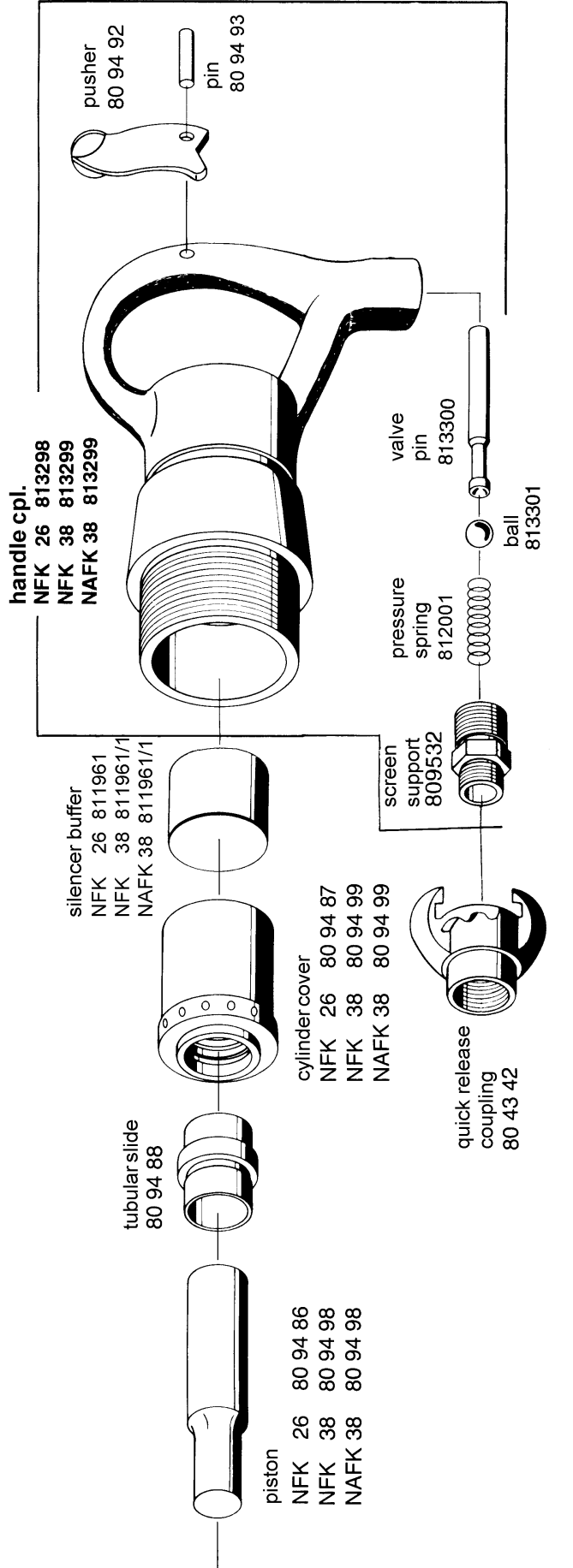
After repair or maintenance, verify that equipment runs to specification!

Principally, use only DEPRAG original spare parts. Otherwise, a reduction in equipment power-output and an increased maintenance-requirement occurs. If NON-DEPRAG parts are installed, DEPRAG is justified to void any existing warranty and liability obligations.

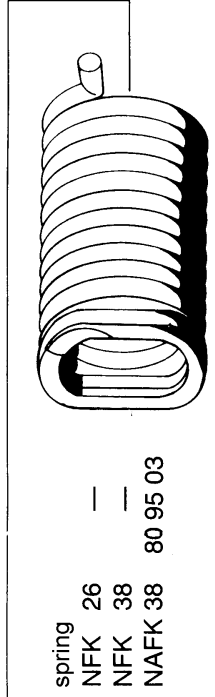
**Assembly:** (see Spare Parts Drawing)

For assembly proceed logically in reverse order with reference to disassembly!

**6.1 Spare Parts Drawing**



Example Spare Parts Order:  
 1 piston 809486 (NFK26)  
 1 piston 809498 (NFK38)  
 1 piston 809498 (NAFK38)



## 7 Maintenance and Upkeep

Testing and maintenance can be provided by Operator. Incorrect assembly or disassembly may lead to injury of operators and damage the tool.

The tool requires little maintenance. If the following service instructions are observed, the tool will have a long life expectancy and will remain in a safe condition.

- Check tool on a regular basis for external damage.
- Check your maintenance unit on a regular basis, make sure that sufficient oil is in the lubricator (if lubrication is used) and that the adjustment is correct. We recommend for your lubricator DEPRAGOL, part 790081 E (250 cm<sup>3</sup>).
- We recommend to service the tool once a year or after 300 hours of operation.
- After assembly, fill 2 – 3 drops of DEPRAGOL into the air inlet nipple.
- In case of tool malfunctions, we recommend to send the machine to DEPRAG.
- Corrosion and filth are the major source of problems with the tool. When moving or storing the hammer, pay attention to the fact that no filth nor water may get into the tool through the air inlet, the chisel bush or the exhaust openings.
- Blow through the hoses before connecting them and check whether the screen in the screen support is clean.
- During operations only little lubrication is needed – however, after completion of the job protection by some oil layer is required.
- **We recommend:** Put some drops of oil into the air inlet.
- The inserting ends of the tool must be within dimension tolerances and clean and the impacting surface must be plane. Blunt inserting/treating tools will result in reduced performance and higher fatigue of hammer and operator.
- Normally the main lubricator on the compressor should suffice to lubricate the tools. When working with long-range hoses or at different height levels we would recommend to include an additional lubricator in the air lines.
- When operating tool in winter, use defrosting agent (such as Kilfrost).
- Preventive servicing will limit repair cost and avoid expensive breakdown.
- If you don't use the motor for a longer time period or if motor has not been used for a longer time period, drip a couple drops of Oil into the air inlet and let the tool resp. hammer run for 5 – 10 seconds.

**7.1 Wear Parts**

| QUANTITY | NAME          | PART No. |
|----------|---------------|----------|
| 1        | Piston NFK26  | 809486   |
| 1        | Piston NFK38  | 809498   |
| 1        | Piston NAFK38 | 809488   |

**8 Trouble Shooting**

In case of a malfunction please check and observe all instructions contained in this technical documentation. If necessary, adjust equipment as needed.

Possible faults and their causes are shown below:

| ERROR   | REASON  | SOLUTION   |
|---|---|--|
| Insufficient Power                                      | Air pressure too low  | Minimum air pressure should be 90 PSI for maximum performance                                    |
|   | Restriction in air hose   | Remove bends or other restrictions   |
|   | Hose I.D. is too small  | Use required hose I.D.   |
|   | Screen Support clogged (if applicable)  | Clean screen support or exchange with new one  |
| Tool does not work after being out of use for some time | Gummy oil deposits, tool filthy   | Flush tool, start it and then relubricate  |
|   | Tubular slide or piston may be rusty  | Disassemble tool, clean parts, repolish rusty spots. Relubricate all parts and re-assemble them. |
| „Dead“ impacts  | Inserting end / bushing worn off  | Replace parts  |
|   | Piston's or inserting end's space of impact damaged or not absolutely plane and rectangular | Replace damaged parts  |
|   | Handle loose  | Retighten handle   |
| Tool stops abruptly                                     | Seizing of piston or tubular slide.   | Polish all possible points of contact and thoroughly lubricate parts.                            |

If necessary, please send tool to DEPRAG for service.

## 9 Delivery Capacity

Please check the delivery capacity in regards to its completeness.

| <b>QUANTITY</b> | <b>NAME</b>                   | <b>PART No.</b>              |
|-----------------|-------------------------------|------------------------------|
| 1               | Operating Instruction Booklet | 010271EN                     |
| 1               | Riveting and Cutting Hammer   | 811982 A, 811983 A, 811984 A |

## 10 Accessories - Optional Equipment

See leaflet D 5110

## 11 Storage

Unused machines should be stored in a dry, locked area.

## 12 Technical Data

**Manufacturer** DEPRAG SCHULZ GMBH u. CO.  
**Address** Kurfürstenring 12 - 18 Postfach 1352  
 D-92224 Amberg D-92203 Amberg  
**Phone** 09621/371-0  
**Fax** 09621/371-120

### Technical Data:

| TYPE   | NFK26    | NFK38    | NAFK38   |
|--|----------|----------|----------|
| PART No.   | 811982 A | 811983 A | 811984 A |
| Spring   | No       | No       | Yes      |
| Shank design for inserting tool – Round Shank (mm)                         | R31x70   |          |          |
| Rivet-Ø steel construction max. (mm)                                       | 25       | 37       | 25       |
| Rivet-Ø boiler construction max. (mm)                                      | 22       | 33       | 25       |
| No. of impacts (min <sup>-1</sup> )  | 1150     | 750      | 750      |
| Air Consumption (m <sup>3</sup> /min)                                      | 0,72     | 0,95     | 0,95     |
| Piston-Ø (mm)  | 30       |          |          |
| Piston length (mm)   | 95       | 110      | 110      |
| Piston stroke (mm)   | 183      | 300      | 300      |
| Length (mm)  | 490      | 620      | 690      |
| Weight (kg)  | 11       | 13,2     | 14,1     |
| Hose I.D. (mm)   | LW 15    |          |          |
| Thread size  | G ¾“     |          |          |
| Noise level (dB(A))  | 94       |          |          |
| Vibration according to DIN EN 28622-2 m/s <sup>2</sup> (a <sub>h,w</sub> ) | 5,4      |          |          |
| Air pressure (bar/PSI)   | 6,3 / 90 |          |          |

## 13 Disposal

Unused machines should be stored in a dry, locked area. Disassemble the machine for the required disposal complete. Observe local and environmental regulations for the separation and recycling of materials.



**Recycle waste oil to avoid environmental contamination!**

## 14 Conformity Declaration

### EC-Conformity Declaration according to the EC-Machine-Guidelines 98/37/EC, Amendment IIA

We,

DEPRAG SCHULZ GMBH & CO.  
PO Box 1352  
D-92203 Amberg

hereby confirm, that the design of the  
riveting and cutting hammer

**NFK26**

**NFK38**

**NAFK38**

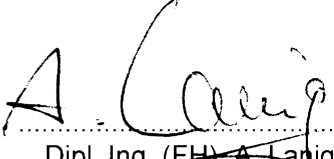
conforms to the following, relevant regulation:

- EC-Machine-Guidelines, Version 98/37/EC, Amendment No. 1 and No. 2.2.

Applicable Standard:

- EN 292

Amberg, 25.10. 2006

  
Dipl. Ing. (FH) A. Lanig  
Mr. Design Dept.

## 15 Service Locations and Authorized Partners

**ARGENTINA****ERIN s.a.**

Av. Constituyentes 5751  
RA-1431 Buenos Aires  
Tel./Fax: +54 (0) 11 / 4573.1313

**AUSTRIA****Amersin Olschinsky GmbH**

Kastnerweise 1  
A-2441 Mitterndorf a.d. Fischa  
Tel.: +43 (0)1 / 8 69 87 66  
Fax: +43 (0)1 / 8 65 16 97  
Internet: <http://www.amersin.at>  
e-mail: [information@amersin.at](mailto:information@amersin.at)

**AUSTRALIA****ASSEMBLY TECHNOLOGIES P/L**

Postal address  
PO Box 4918  
North Rocks NSW 2151, Australia

Delivery address  
Unit 22, 2-8 Daniel St.  
Wetherill Park  
NSW 2164

Tel.: 0061 / 1300 76 92 90  
Fax: 0061 / 2 / 8569 1721  
e-mail: [paul@assemblytech.com.au](mailto:paul@assemblytech.com.au)

**BELGIUM****AWP-P**

Parelhoenstraat 24  
9080 Lochristi  
BELGIUM  
Tel.: +32 9232 0678  
Mobil: +32 473 345907  
Fax: +32 9342 0678  
Internet: <http://www.awp-p.com>  
e-mail: [willems@awp-p.com](mailto:willems@awp-p.com)

**Aijkens en Zumpolle B.V.**

Postbus 29  
NL-5306 ZG  
Brakel/Niederlande  
Tel.: +31 (0)4 18 / 67 18 16  
Fax: +31 (0)4 18 / 67 32 17  
Internet: <http://www.zumpolle.net>  
e-mail: [info@zumpolle.net](mailto:info@zumpolle.net)

**BRAZIL****METALFEMA Ltda.**

Rua Saõ Pedro, 786  
Saõ Leopoldo – RS –  
BRAZIL  
ZIP 93.010-260  
Tel.: +55 (0) 51 / 3592.4050  
Fax: +55 (0) 51 / 3590.1856  
Internet: <http://www.metalfema.com.br>  
e-mail: [metalfema@metalfema.com.br](mailto:metalfema@metalfema.com.br)

**PR CHINA****DEPRAG China**

DEPRAG Assembly Technologies  
(Suzhou) Co., Ltd.  
No. 111, Hong Ye Rd, Blk. 4 Unit D  
Suzhou 215001, P.R. China  
Tel.: +86 (0) 512 – 6251 2500  
Fax: +86 (0) 512 – 6251 2700  
Internet: [www.deprag.com.cn](http://www.deprag.com.cn)  
e-mail: [biz@deprag.com.cn](mailto:biz@deprag.com.cn)  
e-mail: [d.hua@deprag.com.cn](mailto:d.hua@deprag.com.cn)

**CROATIA****SM AUTOMATIKA D.O.O**

Trg i. Kukuljevica 6  
HR-10090 Zagreb  
Tel.: +385(0)13 89 41 79  
Fax: +385(0)13 87 89 78  
Internet: [www.sm-automatika.hr](http://www.sm-automatika.hr)  
e-mail: [info@sm-automatika.hr](mailto:info@sm-automatika.hr)

**CZECHIA/SLOWAKIA****DEPRAG CZ a.s.**

ul. T.G. Masaryka 113  
CZ -50781 Lázně Bělohrad  
Tel.: +420 (0) 4 93 / 79 24 11  
Fax: +420 (0) 4 93 / 79 25 12  
Internet: <http://www.deprag.com>  
e-mail: [info@deprag.cz](mailto:info@deprag.cz)

**DENMARK****DEPRAG Scandinavia AB**

Gap Sundins väg 3  
SE-63346 Eskilstuna  
Tel.: +45 (0) 98 57 22 50  
Fax: +45 (0) 98 57 22 53  
Internet: <http://www.deprag.com>  
e-mail: [keld.branner@get2net.dk](mailto:keld.branner@get2net.dk)

**ESTONIA****Pneumacon OY**

Kankurinkatu 4 – 6  
FI-05800 Hyvinkää  
Tel.: +358 (0) 10 / 7781 400  
Fax: +358 (0) 10 / 7781 401  
Internet: <http://www.pneumacon.fi>  
e-mail: [info@pneumacon.fi](mailto:info@pneumacon.fi)  
e-mail: [harri.lindroos@pneumacon.fi](mailto:harri.lindroos@pneumacon.fi)

Tallinn office:

PK 2841, Kose PK  
EE-12001 Tallinn  
Tel.: +372 (0) 6 41 94 91  
Fax: +371 (0) 6 41 94 92  
e-mail: [rauno.kolga@pneumacon.fi](mailto:rauno.kolga@pneumacon.fi)

**FINLAND****Pneumacon OY**

Kankurinkatu 4 – 6  
FI-05800 Hyvinkää  
Tel.: +358 (0) 10 / 7781 400  
Fax: +358 (0) 10 / 7781 401  
Internet: <http://www.pneumacon.fi>  
e-mail: [info@pneumacon.fi](mailto:info@pneumacon.fi)  
e-mail: [harri.lindroos@pneumacon.fi](mailto:harri.lindroos@pneumacon.fi)

**FRANCE****DEPRAG S.A.R.L.**

30 Z.I. du Ried  
F-67590 SCHWEIGHOUSE sur Moder  
Tel.: +33 388 / 06.14.17  
Fax: +33 388 / 93.01.08  
e-mail: [depragfrance@evc.net](mailto:depragfrance@evc.net)

**GERMANY****Werk Amberg**

Kurfürstenring 12-18,  
D-92224 Amberg  
Postfach 1352,  
D-92203 Amberg  
Tel.: +49 (0) 9621 / 3 71-0  
Fax: +49 (0) 9621 / 3 71-1 20  
Internet: <http://www.deprag.com>  
e-mail: [info@deprag.de](mailto:info@deprag.de)

**GREAT BRITAIN****DEPRAG Ltd.**

Unit B4, Pegasus Court  
Ardglen Industrial Estate  
Whitchurch  
Hants  
RG28 7BP  
Tel.: +44 (0) 1256 895 074  
Fax: +44 (0) 1256 895 274  
Internet: [www.deprag.co.uk](http://www.deprag.co.uk)  
e-mail: [sales@deprag.co.uk](mailto:sales@deprag.co.uk)

**GREECE****D. Panayotidis – J. Tsatsis s.a.**

6 Pireos Street – Moschaton  
Athen  
Tel.: +30 (0) 1 / 4810.817-8-9  
Fax: +30 (0) 1 / 482 96 73

**HUNGARY****ADLER '91**

Export/Import Kereskedelmi  
Takarék u. 18/B  
H-8800 Nagykanizsa  
Tel./Fax: +36 (0) 93 / 314 633  
e-mail: [adler91adlovits@chello.hu](mailto:adler91adlovits@chello.hu)

**Nóniusz Tool Trading House Ltd.**

Kőbányai út. 47/6  
H-1101 Budapest  
Tel.: +36 (0) 1 / 260 030 30  
Fax: +36 (0) 1 / 260 060 83  
Internet: <http://www.noniusz.hu>  
e-mail: [noniusz@noniusz.hu](mailto:noniusz@noniusz.hu)

**INDIA**

LEAPTECH Corporation  
812 Cosmos, Sector – 11  
CBD Belapur  
New Mumbai – 400 614  
Tel.: +91 / 22 / 2756.2822/2849  
Fax: +91 / 22 / 2756.2881  
Internet: [www.leaptechcorp.com](http://www.leaptechcorp.com)  
e-mail: [leaptech@vsnl.net](mailto:leaptech@vsnl.net)

DELHI office:

C-332, Sector – 10  
Noida – 201 301  
Tel.: +91 / 120 / 253.1393  
Fax: +91 / 120 / 253.1060

BANGALORE office:

# 53, Anchor  
Suddagundapalaya  
C.V. Raman Nagar  
Bangalore – 560 093  
e-mail: [leaptechbg@vsnl.net](mailto:leaptechbg@vsnl.net)

**IRAN****FARA SANAT Co.**

No. 117, Abzar & Yaragh passage  
Postcode 1136748173  
Tehran  
Tel.: +98 (0) 21 / 673.2918 / 670.6340  
Fax: +98 (0) 21 / 673.4757

**NACCARSON AIR TOOLS Co., Ltd.**

Azadi Ave. No. 625  
IR-Tehran 14 588  
Tel.: +98 (0) 21 / 66006602 + 66015656  
Fax: +98 (0) 21 / 66009451

**IRELAND**

**Production Equipment Ltd.**  
Riverside Commercial Estate  
IRL-Galway  
Tel.: +353 (0) 91 / 745 100  
Fax: +353 (0) 91 / 751 299  
e-mail: [sales@productionequipment.ie](mailto:sales@productionequipment.ie)

**ITALY**

**ATAX S.r.l.**  
Via Carolina Romani, 23  
I-20091 Bresso/Mi  
Tel.: 0039 02/ 61.03.48.61  
Fax: 0039 02/ 61.03.48.60  
e-mail: [info@atax.it](mailto:info@atax.it)  
Internet: [www.atax.it](http://www.atax.it)

**JAPAN**

**NIPPON GESCO Ltd.**  
P.O. Box 255 Kyobashi Tokyo  
Ginza Matsuyoshi Bldg.  
17 - 8, 7-Chome, Ginza,  
Chuo-Ku, Tokyo  
Tel.: +81 (0) 3 / 3542.2400  
Fax: +81 (0) 3 / 3542.2420  
e-mail: [mail@gesco.co.jp](mailto:mail@gesco.co.jp)

**KOREA (South)**

**Handtools**  
**DONG WON POWER-TECH.INC.**  
108-10 Moonjung-Dong  
Songpa-Ku  
Seoul, Korea  
Tel.: +82 (0) 2 / 409.1344  
Fax: +82 (0) 2 / 409.1345  
e-mail: [kilpyungdw@dreamwiz.com](mailto:kilpyungdw@dreamwiz.com)

**Screwdriving / Assembly Technology**

**Fatec Co.Ltd.**  
#717 LG Palace B/D  
165-8 Dongkyo-dong  
Mapo-gu Seoul,  
Korea  
Tel.: +82 (0) 2 / 2 688.2152  
Fax: +82 (0) 2 / 2 688.2893  
Internet: [www.fatec.co.kr](http://www.fatec.co.kr)  
e-mail: [fatec@fatec.co.kr](mailto:fatec@fatec.co.kr)

**LITHUANIA**

**HIDROTEKA**  
P.O. Box 572  
LT-3028 KAUNAS  
Tel.: +370 (0) 37 / 352195  
Fax: +370 (0) 37 / 351952  
e-mail: [hidroteka@hidroteka.lt](mailto:hidroteka@hidroteka.lt)

**LUXEMBOURG**

**AWP**  
Parelhoenstraat 24  
9080 Lochristi  
**BELGIUM**  
Tel.: +32 9232 0678  
Mobil: +32 473 345907  
Fax: +32 9342 0678  
Internet: <http://www.awp-p.com>  
e-mail: [willems@awp-p.com](mailto:willems@awp-p.com)

**Comptoir Technique et Industriel**

321, Route d'Arlon  
L-8011 Strassen  
Tel.: +352 / 31 31 40  
Fax: +352 / 31 31 95

**MALAYSIA**

**FI INNOVATION ENTERPRISE**  
175, MK D Jalan Bahru  
Balik Pulau 11000  
Penang, MALAYSIA  
Tel. +60/13/ 449.0386 / +60/16/ 403.6797  
Fax: +60/4/ 866.0785  
e-mail: [farisfi@tm.net.my](mailto:farisfi@tm.net.my)

**NETHERLANDS**

**Zumpolle B.V.**  
Postbus 29  
NL-5306 ZG  
Brakel/Niederlande  
Tel.: +31 (0) 4 18 / 67 18 16  
Fax: +31 (0) 4 18 / 67 32 17  
Internet: <http://www.zumpolle.net>  
e-mail: [info@zumpolle.net](mailto:info@zumpolle.net)

**NORWAY**

**Deprag Scandinavia AB**  
Gap Sundins väg 3  
SE-63346 Eskilstuna  
Universal Import  
Tel.: +47 (0) 2 / 2681.530  
Fax: +47 (0) 2 / 2199.127

**POLAND**

**INTEGRATOR - RHC**  
ul. Wielki Rów 40 B  
87-100 Torun  
Tel. +48 / 56 66 93 841  
Fax +48 / 56 66 93 805  
Internet: [www.integrator-rhc.pl](http://www.integrator-rhc.pl)  
e-mail: [leszek.wojtowicz@rhc.com.pl](mailto:leszek.wojtowicz@rhc.com.pl)  
e-mail: [marek.sobocinski@rhc](mailto:marek.sobocinski@rhc)

**PORTUGAL**

**Anibal Pires Lda.**  
EN 1 - Mourisca do Vouga Ap. 23  
P-3750-907 TROFA AGD  
Tel.: +351 (0) 234 / 690 080  
Fax: +351 (0) 234 / 690 090  
Internet: <http://www.anibalpires.pt>  
e-mail: [anibalpires@anibalpires.pt](mailto:anibalpires@anibalpires.pt)

**SINGAPORE**

**Testel Systems Pte Ltd**  
1200 Depot Road # 04-07/09  
Singapore 109675  
Tel.: +65 / 6271-3688  
Fax: +65 / 6271-8866  
Internet: <http://www.testel.com.sg>  
e-mail: [sunny@testel.com.sg](mailto:sunny@testel.com.sg)

**SLOVENIA**

**MB-NAKLO D.O.O.**  
Toma Zupana 16  
SLO-4202 NAKLO  
Tel.: +386 (0) 4 / 277 17 00  
Fax: +386 (0) 4 / 277 17 17  
e-mail: [mb-naklo@siol.net](mailto:mb-naklo@siol.net)

**SPAIN**

**ALCOTAN SISTEMAS S.A.**  
p° de la Direccion, nmro. 95,  
local  
E-28039 Madrid  
Tel.: +34 91 / 311.17.84 + 311.18.01  
Fax: +34 91 / 311.60.53  
e-mail: [alcotansis@jazzfree.com](mailto:alcotansis@jazzfree.com)

BARCELONA office:  
Passeig de la Mare de Déu del  
Coll, 122-124  
E-08023 Barcelona  
Tel.: +34 93 / 2 85 50 34

**SWEDEN**

**DEPRAG Scandinavia AB**  
Gap Sundins Väg 3  
S-633 46 Eskilstuna  
Tel.: +46 (0) 16-12 61 10  
Fax: +46 (0) 16-13 31 88  
Internet: <http://www.deprag.se>  
e-mail: [info@deprag.se](mailto:info@deprag.se)

**SWITZERLAND**

**AFAG AG**  
Business division LIMATEC  
Burgunderstr. 13  
CH-4562 Biberist  
Tel.: +41 (0) 32 / 6542900  
Fax: +41 (0) 32 / 6542901  
Internet: <http://www.limatec.ch>  
e-mail: [office@limatec.ch](mailto:office@limatec.ch)

**TAIWAN**

**I HEN MACHINE Co.Ltd.**  
6F-9, No. 12, Lane 609, Sec. 5  
Chung-Hsin Road,  
San-Chung City  
241 Taipei Hsen  
Tel.: +886 (0) 2 / 2999.6766  
Fax: +886 (0) 2 / 2999.6236

**TURKEY**

**MEKA AUTOMOTIVE ASSEMBLY  
EQUIPMENTS**  
Dicle Caddesi, Tunca Sokak No : 6  
Beysukent - Beytepe - Ankara -  
TURKEY  
Tel.: +90 / 312 / 236 2558  
Tel.: +90 / 312 / 236 2559  
Fax: +90 / 312 / 236 0991  
Internet: [www.me-ka.com](http://www.me-ka.com)  
e-mail: [melih@me-ka.com](mailto:melih@me-ka.com)

**USA, MEXICO, CANADA**

**DEPRAG INC.**  
640 Hembry St. / P.O. Box 1554  
Lewisville, TX 75057-4726  
Tel.: +1 / 972 / 221 - 8731  
Fax: +1 / 972 / 221 - 8163  
Toll Free: (800) 4 DEPRAG  
Internet: <http://www.deprag.com>  
e-mail: [deprag@depragusa.com](mailto:deprag@depragusa.com)

**VENEZUELA**

**Suministros Tecnicos SUMTEC C.A.**  
Av. Francisco de Miranda, Centro Plaza  
Torre C, Piso 16, Oficina C16 A-B  
Urb. Los Palos Grandes  
Caracas 1060  
Tel.: +58 (0) 212 - 28 56 41 0  
Fax.: +58 (0) 212 - 28 51 94 7

# DEPRAG

**DEPRAG SCHULZ GMBH u. CO.**

Postfach 1352, D-92203 Amberg

Kurfürstenring 12-18, D-92224 Amberg

☎ (09621) 371-0

Fax (09621) 371-120

Internet: <http://www.deprag.com>

e-mail: [info@deprag.de](mailto:info@deprag.de)



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