

Symbio

SG Drill Series

NACHI

SG Drill Series

SG-ESS Drill / SG-ES Drill





Added as Standard to Lineup

SG-ESS composite multi-layer coated premium powder metal HSS drills are stocked in Japan as standard sizes with incremental sizes.

SG-ESS Drill Inventory available in 0.01mm increments from 1.01 to 5.99mm

High Performance PM-HSS DRILLS

SG-ESS Drills are made from premium powder metal with the compound, multi-layered SG coating.

End mill style shanks combined with high accuracy shape of relief achieve extremely precise drill positioning and stability within 15 μ .

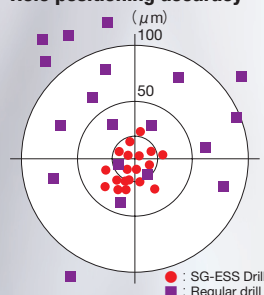
Original material, coating and geometry design, all developed by NACHI's own technology, realize a wide range of application.

Features

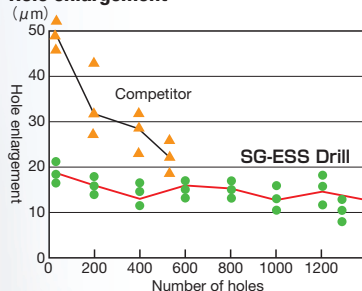
Wide applications from aluminum to heat-resistant alloys

High-accuracy drilling

Hole positioning accuracy

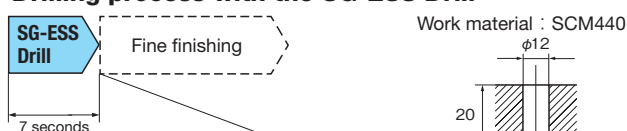


Hole enlargement

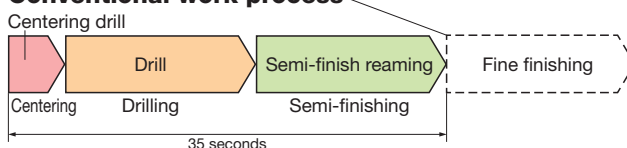


One drill can handle centering → Drilling → Semi-finishing

Drilling process with the SG-ESS Drill

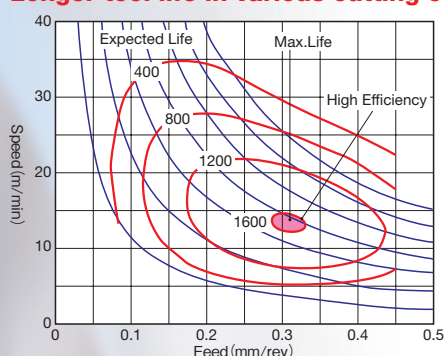


Conventional work process



Long tool life with high performance

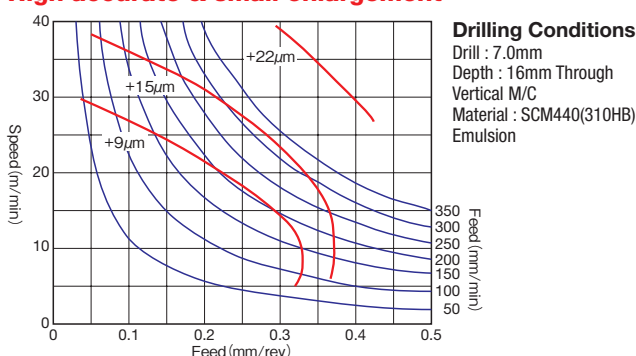
Longer tool life in various cutting conditions



Drilling Conditions
 Drill : 7.0mm
 Depth : 16mm Through
 Vertical M/C
 Material : SCM440(310HB)
 Emulsion

High accurate drilling as well as small oversize of hole is possible!!

High accurate & small enlargement

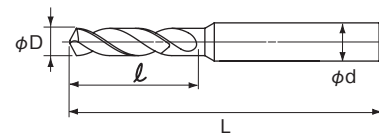


Drilling Conditions
 Drill : 7.0mm
 Depth : 16mm Through
 Vertical M/C
 Material : SCM440(310HB)
 Emulsion

Selection Chart

◎ : Excellent ○ : Good × : Not Used No mark : Not recommended

Code No.	Work Material											
	Structural Steels	Carbon Steels	Pre-Hardened Steels	Hardened Steels	Hardened Steels		Stainless Steels		Titanium Alloys/ Nickel Alloys	Cast Irons	Aluminum Alloys	Copper Alloys
	SS400	S45C S50C	SCR NAK	20~40HRC	40~50HRC	50~65HRC	SUS304 SUS316	SUS420		FCD FC	AC ADC	Cu
SGESS	◎	◎	◎	◎		×	○	○	◎	○	○	○
SGES	◎	◎	◎	◎		×	×	◎	○	○	○	○



LIST 7572P

Unit : mm

Metric D	Flute Length ℓ	Overall Length L	Shank Dia d
1.0	6	38	3
1.01	6	38	3
1.02	6	38	3
1.03	6	38	3
1.04	6	38	3
1.05	6	38	3
1.06	6	38	3
1.07	7	39	3
1.08	7	39	3
1.09	7	39	3
1.1	7	39	3
1.11	7	39	3
1.12	7	39	3
1.13	7	39	3
1.14	7	39	3
1.15	7	39	3
1.16	7	39	3
1.17	7	39	3
1.18	7	39	3
1.19	8	40	3
1.2	8	40	3
1.21	8	40	3
1.22	8	40	3
1.23	8	40	3
1.24	8	40	3
1.25	8	40	3
1.26	8	40	3
1.27	8	40	3
1.28	8	40	3
1.29	8	40	3
1.3	8	40	3
1.31	8	40	3
1.32	8	40	3
1.33	9	41	3
1.34	9	41	3
1.35	9	41	3
1.36	9	41	3
1.37	9	41	3
1.38	9	41	3
1.39	9	41	3
1.4	9	41	3
1.41	9	41	3
1.42	9	41	3
1.43	9	41	3
1.44	9	41	3
1.45	9	41	3
1.46	9	41	3
1.47	9	41	3
1.48	9	41	3
1.49	9	41	3

Metric D	Flute Length ℓ	Overall Length L	Shank Dia d
1.5	9	41	3
1.51	10	42	3
1.52	10	42	3
1.53	10	42	3
1.54	10	42	3
1.55	10	42	3
1.56	10	42	3
1.57	10	42	3
1.58	10	42	3
1.59	10	42	3
1.6	10	42	3
1.61	10	42	3
1.62	10	42	3
1.63	10	42	3
1.64	10	42	3
1.65	10	42	3
1.66	10	42	3
1.67	10	42	3
1.68	10	42	3
1.69	10	42	3
1.7	10	42	3
1.71	11	43	3
1.72	11	43	3
1.73	11	43	3
1.74	11	43	3
1.75	11	43	3
1.76	11	43	3
1.77	11	43	3
1.78	11	43	3
1.79	11	43	3
1.8	11	43	3
1.81	11	43	3
1.82	11	43	3
1.83	11	43	3
1.84	11	43	3
1.85	11	43	3
1.86	11	43	3
1.87	11	43	3
1.88	11	43	3
1.89	11	43	3
1.9	11	43	3
1.91	12	44	3
1.92	12	44	3
1.93	12	44	3
1.94	12	44	3
1.95	12	44	3
1.96	12	44	3
1.97	12	44	3
1.98	12	44	3
1.99	12	44	3

Metric D	Flute Length ℓ	Overall Length L	Shank Dia d
2.0	12	44	3
2.01	12	44	3
2.02	12	44	3
2.03	12	44	3
2.04	12	44	3
2.05	12	44	3
2.06	12	44	3
2.07	12	44	3
2.08	12	44	3
2.09	12	44	3
2.1	12	44	3
2.11	12	44	3
2.12	12	44	3
2.13	13	45	3
2.14	13	45	3
2.15	13	45	3
2.16	13	45	3
2.17	13	45	3
2.18	13	45	3
2.19	13	45	3
2.2	13	45	3
2.21	13	45	3
2.22	13	45	3
2.23	13	45	3
2.24	13	45	3
2.25	13	45	3
2.26	13	45	3
2.27	13	45	3
2.28	13	45	3
2.29	13	45	3
2.3	13	45	3
2.31	13	45	3
2.32	13	45	3
2.33	13	45	3
2.34	13	45	3
2.35	13	45	3
2.36	13	45	3
2.37	14	46	3
2.38	14	46	3
2.39	14	46	3
2.4	14	46	3
2.41	14	46	3
2.42	14	46	3
2.43	14	46	3
2.44	14	46	3
2.45	14	46	3
2.46	14	46	3
2.47	14	46	3
2.48	14	46	3
2.49	14	46	3

Unit : mm

Metric D	Flute Length ℓ	Overall Length L	Shank Dia d
2.5	14	46	3
2.51	14	46	3
2.52	14	46	3
2.53	14	46	3
2.54	14	46	3
2.55	14	46	3
2.56	14	46	3
2.57	14	46	3
2.58	14	46	3
2.59	14	46	3
2.6	14	46	3
2.61	14	46	3
2.62	14	46	3
2.63	14	46	3
2.64	14	46	3
2.65	14	46	3
2.66	16	48	3
2.67	16	48	3
2.68	16	48	3
2.69	16	48	3
2.7	16	48	3
2.71	16	48	3
2.72	16	48	3
2.73	16	48	3
2.74	16	48	3
2.75	16	48	3
2.76	16	48	3
2.77	16	48	3
2.78	16	48	3
2.79	16	48	3
2.8	16	48	3
2.81	16	48	3
2.82	16	48	3
2.83	16	48	3
2.84	16	48	3
2.85	16	48	3
2.86	16	48	3
2.87	16	48	3
2.88	16	48	3
2.89	16	48	3
2.9	16	48	3
2.91	16	48	3
2.92	16	48	3
2.93	16	48	3
2.94	16	48	3
2.95	16	48	3
2.96	16	48	3
2.97	16	48	3
2.98	16	48	3
2.99	16	48	3
3.0	16	48	3
3.01	18	50	4
3.02	18	50	4
3.03	18	50	4

Metric D	Flute Length ℓ	Overall Length L	Shank Dia d
3.04	18	50	4
3.05	18	50	4
3.06	18	50	4
3.07	18	50	4
3.08	18	50	4
3.09	18	50	4
3.1	18	50	4
3.11	18	50	4
3.12	18	50	4
3.13	18	50	4
3.14	18	50	4
3.15	18	50	4
3.16	18	50	4
3.17	18	50	4
3.18	18	50	4
3.19	18	50	4
3.2	18	50	4
3.21	18	50	4
3.22	18	50	4
3.23	18	50	4
3.24	18	50	4
3.25	18	50	4
3.26	18	50	4
3.27	18	50	4
3.28	18	50	4
3.29	18	50	4
3.3	18	50	4
3.31	18	50	4
3.32	18	50	4
3.33	18	50	4
3.34	18	50	4
3.35	18	50	4
3.36	20	52	4
3.37	20	52	4
3.38	20	52	4
3.39	20	52	4
3.4	20	52	4
3.41	20	52	4
3.42	20	52	4
3.43	20	52	4
3.44	20	52	4
3.45	20	52	4
3.46	20	52	4
3.47	20	52	4
3.48	20	52	4
3.49	20	52	4
3.5	20	52	4
3.51	20	52	4
3.52	20	52	4
3.53	20	52	4
3.54	20	52	4
3.55	20	52	4
3.56	20	52	4
3.57	20	52	4

Metric D	Flute Length ℓ	Overall Length L	Shank Dia d
3.58	20	52	4
3.59	20	52	4
3.6	20	52	4
3.61	20	52	4
3.62	20	52	4
3.63	20	52	4
3.64	20	52	4
3.65	20	52	4
3.66	20	52	4
3.67	20	52	4
3.68	20	52	4
3.69	20	52	4
3.7	20	52	4
3.71	20	52	4
3.72	20	52	4
3.73	20	52	4
3.74	20	52	4
3.75	20	52	4
3.76	22	54	4
3.77	22	54	4
3.78	22	54	4
3.79	22	54	4
3.8	22	54	4
3.81	22	54	4
3.82	22	54	4
3.83	22	54	4
3.84	22	54	4
3.85	22	54	4
3.86	22	54	4
3.87	22	54	4
3.88	22	54	4
3.89	22	54	4
3.9	22	54	4
3.91	22	54	4
3.92	22	54	4
3.93	22	54	4
3.94	22	54	4
3.95	22	54	4
3.96	22	54	4
3.97	22	54	4
3.98	22	54	4
3.99	22	54	4
4.0	22	54	4
4.01	22	66	6
4.02	22	66	6
4.03	22	66	6
4.04	22	66	6
4.05	22	66	6
4.06	22	66	6
4.07	22	66	6
4.08	22	66	6
4.09	22	66	6
4.1	22	66	6

NEXT

Unit : mm

Metric D	Flute Length ℓ	Overall Length L	Shank Dia d
4.11	22	66	6
4.12	22	66	6
4.13	22	66	6
4.14	22	66	6
4.15	22	66	6
4.16	22	66	6
4.17	22	66	6
4.18	22	66	6
4.19	22	66	6
4.2	22	66	6
4.21	22	66	6
4.22	22	66	6
4.23	22	66	6
4.24	22	66	6
4.25	22	66	6
4.26	24	68	6
4.27	24	68	6
4.28	24	68	6
4.29	24	68	6
4.3	24	68	6
4.31	24	68	6
4.32	24	68	6
4.33	24	68	6
4.34	24	68	6
4.35	24	68	6
4.36	24	68	6
4.37	24	68	6
4.38	24	68	6
4.39	24	68	6
4.4	24	68	6
4.41	24	68	6
4.42	24	68	6
4.43	24	68	6
4.44	24	68	6
4.45	24	68	6
4.46	24	68	6
4.47	24	68	6
4.48	24	68	6
4.49	24	68	6
4.5	24	68	6
4.51	24	68	6
4.52	24	68	6
4.53	24	68	6
4.54	24	68	6
4.55	24	68	6
4.56	24	68	6
4.57	24	68	6
4.58	24	68	6
4.59	24	68	6
4.6	24	68	6
4.61	24	68	6
4.62	24	68	6
4.63	24	68	6
4.64	24	68	6

Metric D	Flute Length ℓ	Overall Length L	Shank Dia d
4.65	24	68	6
4.66	24	68	6
4.67	24	68	6
4.68	24	68	6
4.69	24	68	6
4.7	24	68	6
4.71	24	68	6
4.72	24	68	6
4.73	24	68	6
4.74	24	68	6
4.75	24	68	6
4.76	26	70	6
4.77	26	70	6
4.78	26	70	6
4.79	26	70	6
4.8	26	70	6
4.81	26	70	6
4.82	26	70	6
4.83	26	70	6
4.84	26	70	6
4.85	26	70	6
4.86	26	70	6
4.87	26	70	6
4.88	26	70	6
4.89	26	70	6
4.9	26	70	6
4.91	26	70	6
4.92	26	70	6
4.93	26	70	6
4.94	26	70	6
4.95	26	70	6
4.96	26	70	6
4.97	26	70	6
4.98	26	70	6
4.99	26	70	6
5.0	26	70	6
5.01	26	70	6
5.02	26	70	6
5.03	26	70	6
5.04	26	70	6
5.05	26	70	6
5.06	26	70	6
5.07	26	70	6
5.08	26	70	6
5.09	26	70	6
5.1	26	70	6
5.11	26	70	6
5.12	26	70	6
5.13	26	70	6
5.14	26	70	6
5.15	26	70	6
5.16	26	70	6
5.17	26	70	6
5.18	26	70	6

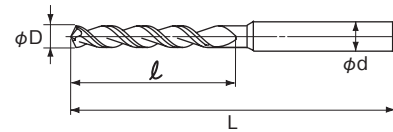
Metric D	Flute Length ℓ	Overall Length L	Shank Dia d
5.19	26	70	6
5.2	26	70	6
5.21	26	70	6
5.22	26	70	6
5.23	26	70	6
5.24	26	70	6
5.25	26	70	6
5.26	26	70	6
5.27	26	70	6
5.28	26	70	6
5.29	26	70	6
5.3	26	70	6
5.31	28	72	6
5.32	28	72	6
5.33	28	72	6
5.34	28	72	6
5.35	28	72	6
5.36	28	72	6
5.37	28	72	6
5.38	28	72	6
5.39	28	72	6
5.4	28	72	6
5.41	28	72	6
5.42	28	72	6
5.43	28	72	6
5.44	28	72	6
5.45	28	72	6
5.46	28	72	6
5.47	28	72	6
5.48	28	72	6
5.49	28	72	6
5.5	28	72	6
5.51	28	72	6
5.52	28	72	6
5.53	28	72	6
5.54	28	72	6
5.55	28	72	6
5.56	28	72	6
5.57	28	72	6
5.58	28	72	6
5.59	28	72	6
5.6	28	72	6
5.61	28	72	6
5.62	28	72	6
5.63	28	72	6
5.64	28	72	6
5.65	28	72	6
5.66	28	72	6
5.67	28	72	6
5.68	28	72	6
5.69	28	72	6
5.7	28	72	6
5.71	28	72	6
5.72	28	72	6

Unit : mm

Metric D	Flute Length ℓ	Overall Length L	Shank Dia d
5.73	28	72	6
5.74	28	72	6
5.75	28	72	6
5.76	28	72	6
5.77	28	72	6
5.78	28	72	6
5.79	28	72	6
5.8	28	72	6
5.81	28	72	6
5.82	28	72	6
5.83	28	72	6
5.84	28	72	6
5.85	28	72	6
5.86	28	72	6
5.87	28	72	6
5.88	28	72	6
5.89	28	72	6
5.9	28	72	6
5.91	28	72	6
5.92	28	72	6
5.93	28	72	6
5.94	28	72	6
5.95	28	72	6
5.96	28	72	6
5.97	28	72	6
5.98	28	72	6
5.99	28	72	6
6.0	28	72	6
6.1	31	75	8
6.2	31	75	8
6.3	31	75	8
6.4	31	75	8
6.5	31	75	8
6.6	31	75	8
6.7	31	75	8
6.8	34	78	8
6.9	34	78	8
7.0	34	78	8

Metric D	Flute Length ℓ	Overall Length L	Shank Dia d
7.1	34	78	8
7.2	34	78	8
7.3	34	78	8
7.4	34	78	8
7.5	34	78	8
7.6	37	81	8
7.7	37	81	8
7.8	37	81	8
7.9	37	81	8
8.0	37	81	8
8.1	37	87	10
8.2	37	87	10
8.3	37	87	10
8.4	37	87	10
8.5	37	87	10
8.6	40	90	10
8.7	40	90	10
8.8	40	90	10
8.9	40	90	10
9.0	40	90	10
9.1	40	90	10
9.2	40	90	10
9.3	40	90	10
9.4	40	90	10
9.5	40	90	10
9.6	43	93	10
9.7	43	93	10
9.8	43	93	10
9.9	43	93	10
10.0	43	93	10
10.1	43	100	12
10.2	43	100	12
10.3	43	100	12
10.4	43	100	12
10.5	43	100	12
10.6	43	100	12
10.7	47	104	12
10.8	47	104	12

Metric D	Flute Length ℓ	Overall Length L	Shank Dia d
10.9	47	104	12
11.0	47	104	12
11.1	47	104	12
11.2	47	104	12
11.3	47	104	12
11.4	47	104	12
11.5	47	104	12
11.6	47	104	12
11.7	47	104	12
11.8	47	104	12
11.9	51	108	12
12.0	51	108	12
12.1	51	108	12
12.2	51	108	12
12.3	51	108	12
12.4	51	108	12
12.5	51	108	12
12.6	51	108	12
12.7	51	108	12
12.8	51	108	12
12.9	51	108	12
13.0	51	108	12
13.5	72	132	16
14.0	72	132	16
14.5	76	136	16
15.0	76	142	20
15.5	80	146	20
16.0	80	146	20
16.5	84	150	20
17.0	84	150	20
17.5	87	153	20
18.0	87	153	20
18.5	90	156	20
19.0	90	164	25
19.5	94	168	25
20.0	94	168	25



LIST 7570P

Unit : mm

Metric D	Flute Length ℓ	Overall Length L	Shank Dia d
2.0	24	56	3
2.1	24	56	3
2.2	25	56	3
2.3	25	56	3
2.4	30	61	3
2.5	30	61	3
2.6	30	61	3
2.7	33	64	3
2.8	33	64	3
2.9	33	64	3
3.0	33	64	3
3.1	36	68	4
3.2	36	68	4
3.3	36	68	4
3.4	39	71	4
3.5	39	71	4
3.6	39	71	4
3.7	39	71	4
3.8	43	75	4
3.9	43	75	4
4.0	43	75	4
4.1	43	85	6
4.2	43	85	6
4.3	47	89	6
4.4	47	89	6
4.5	47	89	6
4.6	47	89	6
4.7	47	89	6
4.8	52	94	6
4.9	52	94	6
5.0	52	94	6
5.1	52	94	6
5.2	52	94	6
5.3	52	94	6
5.4	57	99	6
5.5	57	99	6
5.6	57	99	6
5.7	57	99	6
5.8	57	99	6
5.9	57	99	6
6.0	57	99	6
6.1	63	107	8
6.2	63	107	8
6.3	63	107	8
6.4	63	107	8
6.5	63	107	8
6.6	63	107	8
6.7	63	107	8
6.8	69	113	8
6.9	69	113	8

Metric D	Flute Length ℓ	Overall Length L	Shank Dia d
7.0	69	113	8
7.1	69	113	8
7.2	69	113	8
7.3	69	113	8
7.4	69	113	8
7.5	69	113	8
7.6	75	119	8
7.7	75	119	8
7.8	75	119	8
7.9	75	119	8
8.0	75	119	8
8.1	75	125	10
8.2	75	125	10
8.3	75	125	10
8.4	75	125	10
8.5	75	125	10
8.6	81	131	10
8.7	81	131	10
8.8	81	131	10
8.9	81	131	10
9.0	81	131	10
9.1	81	131	10
9.2	81	131	10
9.3	81	131	10
9.4	81	131	10
9.5	81	131	10
9.6	87	137	10
9.7	87	137	10
9.8	87	137	10
9.9	87	137	10
10.0	87	137	10
10.1	87	144	12
10.2	87	144	12
10.3	87	144	12
10.4	87	144	12
10.5	87	144	12
10.6	87	144	12
10.7	94	151	12
10.8	94	151	12
10.9	94	151	12
11.0	94	151	12
11.1	94	151	12
11.2	94	151	12
11.3	94	151	12
11.4	94	151	12
11.5	94	151	12
11.6	94	151	12
11.7	94	151	12
11.8	94	151	12
11.9	101	158	12

Metric D	Flute Length ℓ	Overall Length L	Shank Dia d
12.0	101	158	12
12.1	101	158	12
12.2	101	158	12
12.3	101	158	12
12.4	101	158	12
12.5	101	158	12
12.6	101	158	12
12.7	101	158	12
12.8	101	158	12
12.9	101	158	12
13.0	101	158	12
13.5	108	168	16
14.0	108	168	16
14.5	114	173	16
15.0	114	180	20
15.5	120	185	20
16.0	120	185	20
16.5	125	189	20
17.0	125	189	20
17.5	130	194	20
18.0	130	194	20
18.5	135	198	20
19.0	135	206	25
19.5	140	210	25
20.0	140	210	25
20.5	145	214	25
21.0	145	214	25
21.5	150	218	25
22.0	150	218	25
22.5	155	223	25
23.0	155	223	25
23.5	155	223	25
24.0	160	237	32
24.5	160	237	32
25.0	165	241	32
25.5	165	241	32
26.0	165	241	32
26.5	165	241	32
27.0	170	245	32
27.5	170	245	32
28.0	170	245	32
28.5	175	248	32
29.0	175	248	32
29.5	175	248	32
30.0	175	248	32
30.5	180	252	32
31.0	180	252	32
31.5	180	252	32
32.0	185	255	32

SG-ESS Drills

Work Material		Structural Steels		Alloy Steels Pre-Hardened Steels		Mold Steels Stainless Steels Hardened Steels (35~45HRC)		Cast Irons		Aluminum Alloys Nonferrous Metals	
Drilling Condition		Rotation (min ⁻¹)	Feed (mm/min)	Rotation (min ⁻¹)	Feed (mm/min)	Rotation (min ⁻¹)	Feed (mm/min)	Rotation (min ⁻¹)	Feed (mm/min)	Rotation (min ⁻¹)	Feed (mm/min)
Drill Dia. (mm)	2	5700	360	4600	240	2400	135	6300	490	9700	760
	3	4200	460	3400	320	1600	145	4700	640	7200	980
	5	2500	430	2000	290	960	100	2800	600	4300	920
	8	1600	370	1300	250	600	100	1800	530	2700	790
	10	1300	340	1000	230	480	100	1400	460	2200	730
	12	1100	310	850	210	400	90	1200	430	1800	670
	16	800	290	640	200	300	80	880	390	1400	610
	20	640	260	510	180	240	75	700	350	1100	550

SG-ES Drills

Work Material		Carbon Steels		Structural Steels		Alloy Steels Pre-Hardened Steels		Mold Steels Stainless Steels Hardened Steels (35~45HRC)		Cast Irons		Aluminum Alloys Nonferrous Metals	
Drilling Condition		Rotation (min ⁻¹)	Feed (mm/min)	Rotation (min ⁻¹)	Feed (mm/min)	Rotation (min ⁻¹)	Feed (mm/min)	Rotation (min ⁻¹)	Feed (mm/min)	Rotation (min ⁻¹)	Feed (mm/min)	Rotation (min ⁻¹)	Feed (mm/min)
Drill Dia. (mm)	2	5700	300	5300	340	4600	200	2400	150	6300	410	9700	630
	3	4200	380	3500	340	3400	260	1600	160	4700	530	7200	820
	5	2500	360	2100	340	2000	240	960	90	2800	500	4300	770
	8	1600	310	1300	340	1300	210	600	90	1800	440	2700	660
	10	1300	280	1050	340	1000	190	480	90	1400	390	2200	610
	12	1100	260	880	300	850	180	400	80	1200	360	1800	560
	16	800	240	660	240	640	160	300	75	880	330	1400	500
	20	640	220	530	200	510	150	240	70	700	300	1100	460

SG-ES is not applied to Austenitic Stainless Steels.

Plants and Offices

Sales Companies

AMERICA

NACHI AMERICA INC. HEADQUARTERS

17500 Twenty-Three Mile Road, Macomb, Michigan, 48044, U.S.A.
Tel: +1-586-226-5151 Fax: +1-888-383-8665
URL: <http://www.nachi-america.com/>

INDIANA BRANCH

715 Pushville Road, Greenwood, Indiana, 46143, U.S.A.
Tel: +1-317-535-5527 Fax: +1-317-535-3659

WEST COAST BRANCH

12652 E. Alondra Blvd. Cerritos, California, 90703, U.S.A.
Tel: +1-562-802-0055 Fax: +1-562-802-2455

MIAMI BRANCH - LATIN AMERICA DIV.

2315 N.W. 107th Ave., Doral, Florida, 33172, U.S.A.
Tel: +1-305-591-0054/0059/2604
Fax: +1-305-591-3110

ATLANTA OFFICE

Six Concourse Parkway, Suite 2995 Atlanta, GA 30328, U.S.A.
Tel: +1-770-393-0270 Fax: +1-770-393-0271

NACHI ROBOTIC SYSTEMS INC.

22285 Roethel Drive, Novi, Michigan, 48375, U.S.A.
Tel: +1-248-305-6545 Fax: +1-248-305-6542
URL: <http://www.nachi-robotics.com/>

NACHI CANADA INC.

89 Courtland Ave., Unit 2, Concord, Ontario, L4K 3T4, CANADA
Tel: +1-905-660-0088 Fax: +1-905-660-1146
URL: <http://www.nachi-canada.com/>

NACHI MEXICANA, S.A. DE C.V.

Urbina No 54, Parque Industrial Naucalpan, Naucalpan de Juarez, Estado de Mexico, C.P. 53370, MEXICO
Tel: +52-55-3604-0832 / 0842 / 0881 Fax: +52-55-3604-0882/

NACHI ENGINEERING CENTER

1171A, Calle Julio Diaz Torre, Fracc. Ciudad Industrial, Aguascalientes, C.P. 20290, MEXICO
Tel: +52-449-971-1689 Fax: +52-449-971-1689

EUROPE

NACHI EUROPE GmbH

Bischofstrasse 99, 47809, Krefeld, GERMANY
Tel: +49-(0)2151-65046-0 Fax: +49-(0)2151-65046-90
URL: <http://www.nachi.de/>

SOUTH GERMANY OFFICE

Roetestrasse 18, 74321, Bietigheim-Bissingen, GERMANY
Tel: +49-(0)7142-77418-0 Fax: +49-(0)7142-77418-20

SPAIN BRANCH

Av. Alberto Alcocer 28, 1-A, 28036, Madrid, SPAIN
Tel: +34-(0)91-302-6440 Fax: +34-(0)91-383-9486

BARCELONA OFFICE

Josep Tarradellas, 58, 1-5, 08029 Barcelona, SPAIN
Tel: +34-(0)93-430-6247 Fax: +34-(0)93-419-0897

CZECH BRANCH

Mostni 73, Kolin 4, 28002, CZECH
Tel: +420-321-710-200 Fax: +420-321-710-200

U.K. BRANCH

Unit 7, Junction Six Industrial Estate, Electric Avenue, Birmingham B6 7JJ, U.K.
Tel: +44-(0)121-250-1890 Fax: +44-(0)121-250-1899

ASIA and OCEANIA

NACHI-FUJIKOSHI CORP.

THAILAND REPRESENTATIVE OFFICE

Chai-ho Wongwaiwat Bldg. 889 Srinakarin Road, Samutprakarn, 10270, THAILAND
Tel: +66-2-748-7322~4 Fax: +66-2-748-7325

NACHI SINGAPORE PTE. LTD.

No.2 Joo Koon Way, Jurong Town, Singapore 628943, SINGAPORE
Tel: +65-65587393 Fax: +65-65587371

VIETNAM OFFICE

614 Hong Bang Street, Ward 16, Dist 11, Ho Chi Minh City, VIETNAM
Tel: +84-8-9602-303 Fax: +84-8-9602-187

FUJIKOSHI-NACHI (MALAYSIA) SDN. BHD.

No.17, Jalan USJ 21/3, 47630 UEP Subang Jaya, Selangor Darul Ehsan, MALAYSIA
Tel: +60-(0)3-80247900 Fax: +60-(0)3-80235884

P.T.NACHI INDONESIA

Jl.H.R.Rasuna Said Kav.X-O Kuningan, Jakarta 12950, INDONESIA
Tel: +62-021-527-2841 Fax: +62-021-527-3029

那智不二越 (上海) 贸易有限公司

NACHI (SHANGHAI) CO.,LTD.

Yitong Industry Zone258, Fengmao Rd. Malu Town, Jiading, Shanghai 201801, CHINA
Tel: +86-(0)21-6915-2200 Fax: +86-(0)21-6915-5427

NACHI-FUJIKOSHI CORP.

TAIPEI REPRESENTATIVE OFFICE

3F No.276, Sec3, Chung Ching N.Road, Taipei, TAIWAN
Tel: +886-(0)2-2596-0118 Fax: +886-(0)2-2596-5346

NACHI-FUJIKOSHI CORP.

KOREA REPRESENTATIVE OFFICE

2F Dongsan Bldg. 276-4, Sungsu 2GA-3DONG Sungdong-Ku. Seoul 133-831, KOREA
Tel: +82-(0)2-469-2254 Fax: +82-(0)2-469-2264

NACHI-FUJIKOSHI CORP.

INDIA REPRESENTATIVE OFFICE

A/9A, Sector-16, Noida-201301, Distt. Gautam Budh Nagar, U.P. INDIA
Tel: +91-120-4272257 Fax: +91-120-4272256

NACHI (AUSTRALIA) PTY. LTD.

Unit 1, 23-29 South Street, Rydalmere, N.S.W, 2116, AUSTRALIA
Tel: +61-(0)2-9898-1511 Fax: +61-(0)2-9898-1678
URL: <http://www.nachi.com.au/>



NACHI MACHINING TECHNOLOGY CO.

Established : 1929 Products : Cutting Tools

NACHI AMERICA INC.

Established : 1962 Products : Cutting Tools, Machine Tools, Bearings, Hydraulic Equipment and Special Steels



NACHI EUROPE GmbH

Established : 1967

Products : Cutting Tools, Machine Tools, Robots, Bearings, Hydraulic Equipment and Special Steels



NACHI BRASIL LTDA.

Established : 1972

Products : Bearings and Cutting Tools

Manufacturing Companies

AMERICA

NACHI TECHNOLOGY INC.

713 Pushville Road, Greenwood, Indiana, 46143, U.S.A.
Tel: +1-317-535-5000 Fax: +1-317-535-8484
URL: <http://nachitech.com/>

NACHI MACHINING TECHNOLOGY CO.

17500 Twenty-three Mile Road, Macomb, Michigan, 48044, U.S.A.
Tel: +1-586-263-0100 Fax: +1-586-263-4571
URL: <http://www.nachimtc.com/>

NACHI PRECISION NORTH CAROLINA INC.

1836 Lindbergh Street Suite 400, Charlotte, North Carolina, 28208, U.S.A.
Tel: +1-704-391-1511 Fax: +1-704-391-1648

NACHI BRASIL LTDA.

Avenida João XXIII, No.2330, Jardim São Pedro, Mogi das Cruzes, S.P., BRASIL, CEP 08830-000
Tel: +55-11-4793-8800 Fax: +55-11-4793-8870
URL: <http://www.nachi.com.br/>

EUROPE

NACHI CZECH S.R.O. NEW

Prumyslova 2732, 44001 Louny, CZECH
Tel: +420-415-930-930 Fax: +420-415-930-940

ASIA and OCEANIA

NACHI TECHNOLOGY (THAILAND) CO., LTD.

3/16 M, 2, Rojana Industrial Estate Nongbua, Ban Khai, Rayong, 21120, THAILAND
Tel: +66-38-961-682 Fax: +66-38-961-683

NACHI INDUSTRIES PTE. LTD.

No.2 Joo Koon Way, Jurong Town, Singapore 628943, SINGAPORE
Tel: +65-68613944 Fax: +65-68611153
URL: <http://www.nachinip.com.sg/>

NACHI PILIPINAS INDUSTRIES, INC.

1st Avenue, Manalac Compound, Sta. Maria Industrial Estate, Bagumbayan, Taguig, Metro Manila, PHILIPPINES
Tel: +63-(0)2-838-3620 Fax: +63-(0)2-838-3623

MANILA OFFICE

Km23 East Service Road, Capang Muntinlupa, City Metro Manila, PHILIPPINES
Tel: +63-(0)2-850-0864 Fax: +63-(0)2-850-0864

建越工業股份有限公司

NACHI C.Y. CORP.

No.109, Kao Young North Rd, Lung-Tan Hsin, Tao-Yuan Hsien, TAIWAN
Tel: +886-(0)3-471-7651 Fax: +886-(0)3-471-8402

东莞建越精密轴承有限公司

DONGGUAN NACHI C.Y. CORPORATION

Dangyong Village, Hongmei Town Dongguan City, Guangdong, CHINA
Tel: +86-(0)769-8843-1300 Fax: +86-(0)769-8843-1330

那智不二越(上海)精密工具有限公司

NACHI (SHANGHAI) PRECISION TOOLS CO., LTD.

Yitong Industry Zone 258, Fengmao Rd. Malu Town, Jiading, Shanghai 201801, CHINA
Tel: +86-(0)21-6915-7200 Fax: +86-(0)21-6915-7669

上海不二越精密轴承有限公司

SHANGHAI NACHI BEARINGS CO.,LTD.

Yitong Industry Zone 258, Fengmao Rd. Malu Town, Jiading, Shanghai 201801, CHINA
Tel: +86-(0)21-6915-6200 Fax: +86-(0)21-6915-6202

耐锯(上海)精密刀具有限公司

SHANGHAI NACHI SAW CORP.

Yitong Industry Zone 258, Fengmao Rd. Malu Town, Jiading, Shanghai 201801, CHINA
Tel: +86(0)21-6915-5899 Fax: +86(0)21-6915-5898

대성나찌 유압공업(주)

DAESUNG-NACHI HYDRAULICS CO., LTD.

289-22, Yousan-Dong, Yangsan-Si Kyungnam 626-800, KOREA
Tel: +82-(0)55-385-7891~3 Fax: +82-(0)55-384-3270

NACHI MOTHERSON TOOL TECHNOLOGY LTD.

D-59-60, Sector-6, Noida-201301, Distt. Gautam Budh Nagar, U.P. INDIA
Tel: +91-120-425-8372 Fax: +91-120-425-8374



SHANGHAI NACHI BEARINGS CO., LTD.

Established : 2004 Products : Bearings

NACHI (SHANGHAI) PRECISION TOOLS CO., LTD.

Established : 2005 Products : Cutting Tools



NACHI INDUSTRIES PTE. LTD.

Established : 1979 Products : Cutting Tools

NACHI SINGAPORE PTE. LTD.

Established : 1975 Products : Cutting Tools, Bearings and Hydraulic Equipment



NACHI (AUSTRALIA) PTY. LTD.

Established : 1970 Products : Cutting Tools, Machine Tools, Robots, Bearings and Hydraulic Equipment

NACHI-FUJIKOSHI CORP.

URL:<http://www.nachi-fujikoshi.co.jp> E-mail:webmaster@nachi-fujikoshi.co.jp

Tokyo Head Office

Shiodome Sumitomo Bldg. 17F 1-9-2 Higashi-shinbashi, Minato-ku, Tokyo 105-0021, JAPAN
Tel: +81-(0)3-5568-5111 Fax: +81-(0)3-5568-5206

Toyama Head Office

1-1-1 Fujikoshi-Honmachi, Toyama 930-8511, JAPAN
Tel: +81-(0)76-423-5111 Fax: +81-(0)76-493-5211



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