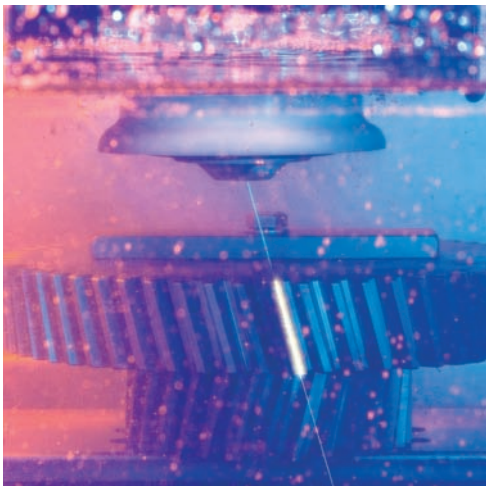




High-tech solutions for spark erosion

Reliability – Innovation – Precision

bedra
intelligent wires



Company

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Your leading edge in quality and performance

Strict quality assurance is the guarantee of reliability of our products. Our "100 % in-house" concept has proven successful. We are the only manufacturer of EDM wires to offer not only product development, sales and service, but also the complete production process: casting, rolling, drawing, annealing and electroplating. In our own foundry only metals of highest purity are used. This production process guarantees complete quality control.

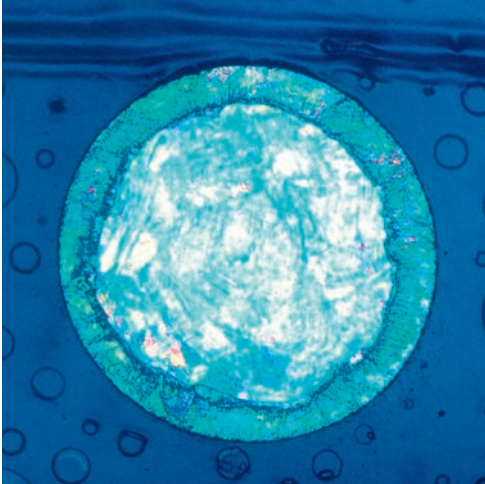
For this reason, bedra is certified in accordance with DIN EN ISO 9001:2000. Furthermore, our Environmental Management was successfully audited according to ISO 14001:2004 by the Germanischer Lloyd Certification GmbH.

We use our know-how in the fields of metallurgy and chemical and physical engineering technology to optimise the production process and assure total quality control.



Our 100% inhouse - concept offers the complete production process - casting, rolling, drawing, annealing and electroplating - from a single source.





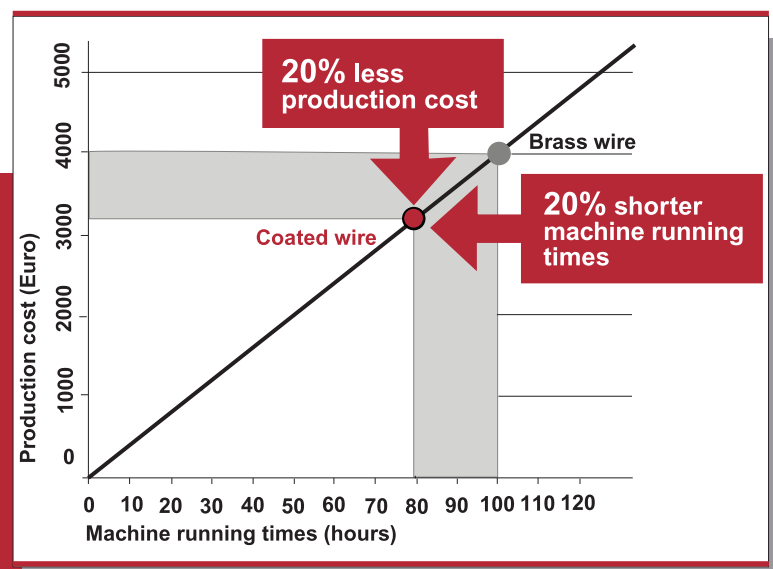
Cross-section of a coated wire electrode

Coated high-tech wires for spark erosion

Since the beginnings of spark erosion cutting, bedra has significantly contributed to the further development of technology and production processes in mould and tool making.

With the functional coatings for wire electrodes developed by bedra, an enormous increase in removal performance – and hence in productivity – can be achieved. Moreover, a reproducible high precision and surface quality is attained.

For decades, renowned customers throughout the world have relied on coated wires from bedra. They successfully showed that the quality products **topas® plus**, **cobracut®**, **broncocut®**, **megacut®** and **microcut®** achieved sustained success.



Coated wire electrodes from bedra perform significantly faster than brass wires.

Wire electrodes at a glance

Get a general view of the appropriate wire electrodes for your EDM machine. Or visit the bedra internet site at www.bedra.com to find the right wire for your application.

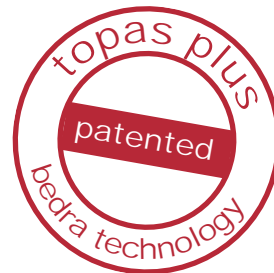


MANUFACTURER OF EDM MACHINES	Agie	topas® plus H	topas® plus D	cobracut®	cobracut® Typ A	cobracut® Typ G	cobracut® Typ D	cobracut® Typ S	cobracut® Typ V	microcut®
	AC 100 D	•			•		•			•
	AC x20, x50, x70	•			•		•			•
	AC HSS	•			•	•	•	•		•
	AC Evolution	•	•		•	•	•	•		•
	AC Classic	•	•		•	•	•	•		•
	AC Excellence	•	•		•	•	•	•		•
	AC Challenge	•	•		•	•	•	•		•
	AC Progress	•	•		•	•			•	
	AC Vertex			•	•	•				•
AgieCharmilles	AC Classic V	•	•		•	•			•	
	AC Challenge V	•	•		•	•			•	
	AC Progress V/VP	•	•		•	•			•	
	AC Vertex II/III	•	•	•	•	•				•
Charmilles	Cut 20P / Cut 30P	•			•					•
	Cut 1000 / 1000 Oil					•				•
further	Charmillles	topas® plus X	topas® plus H	topas® plus S	bruncocut® Typ X	cobracut® Typ W	microcut®	cobracut® Typ A	cobracut®	
	x00/x000	•	•	•	•	•		•	•	•
	x020/x030/x050	•	•	•	•	•	•	•	•	•
	290/3x0/5x0/690	•	•	•	•	•		•	•	•
	290F/3x0F/5x0F	•			•	•				•
	x40cc/x40ccs	•	•	•	•	•		•	•	•
	x40/x40 SL/x40SLP	•	•	•	•	•		•	•	•
	x050TW / TWO	•	•	•	•	•	•	•	•	•
Vollmer	further	topas® plus D	topas® plus H	topas® plus S	megacut® Typ A	megacut® Typ T	megacut Typ D	megacut plus	microcut®	
	Brother	•	•	•	•	•	•	•	•	•
	Fanuc	•	•	•	•	•	•	•	•	•
	Hitachi	•	•	•	•	•	•	•	•	•
	Makino	•	•	•	•	•	•	•	•	•
	Mitsubishi	•	•	•	•	•	•	•	•	•
	ONA	•	•	•	•	•	•	•	•	•
	Seibu	•	•	•	•	•	•	•	•	•
	Sodick	•	•	•	•	•	•	•	•	•
	Vollmer					cobracut				

topas® plus

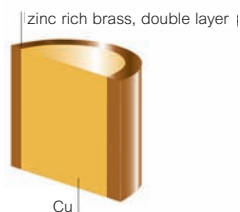


With **topas®** plus bedra has developed a high speed cutting wire that combines an excellent price-performance ratio with universal application on all standard EDM machines while ensuring highest quality.



topas® plus X

- gamma phase wire with up to 35 % higher cutting speed as compared to brass wire and, at that, with high precision.
- developed especially for the X technology on Charmilles machines.
- can be used immediately without modifying the machine settings



	core material	coating material	tensile strength	elongation	colour
topas® plus X	Cu	zinc rich brass, double layer	500 N/mm ²	1%	brown
Ø [mm]	0,25	0,30	0,33		
spools / kg bedra8 bedra16	• •	• •	• •		
spools / kg K250 / 25,0 K355 / 45,0	• •	• •	• •		
spools / kg P10 / 10,0 P15 / 20,0	• •	• •			

topas® plus S

- soft gamma phase wire with high elongation
- universally applicable on Charmilles machines
- perfectly suited for taper cutting on all other machine types
- up to 20% higher cutting speed as compared to brass wire



	core material	coating material	tensile festigkeit	elongation	colour
topas® plus S	CuZn36	special layer	500 N/mm ²	>10%	grey-gold
Ø [mm]	0,25	0,30			
spools / kg bedra8 bedra16	• •	• •			
spools / kg K250 / 25,0	•	•			

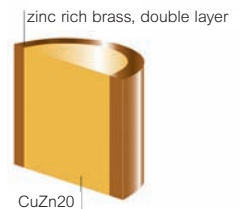


topas® plus

	core material	coating material	tensile strength	elongation	colour
topas® plus D	CuZn20	zinc rich brass, double layer	800 N/mm ²	>1%	brown
Ø [mm]	0,25	0,30	0,33		
spools / kg bedra8 bedra16	• •	• •	•		
spools / kg K250 / 25,0 K355 / 45,0	• •	• •	• •		
spools / kg P5 / 5,0 P10 / 10,0 P15 / 20,0	• • •	• • •			

topas® plus D

- new high performance wire for all machines which require straightened wires for threading
- hard gamma phase wire, specially suited for tall parts
- attractive price-performance ratio with significant time and cost saving benefits



	core material	coating material	tensile strength	elongation	colour
topas® plus H	CuZn36	special layer	800 N/mm ²	>1%	grey-gold
Ø [mm]	0,20	0,25	0,30	0,33	
spools / kg bedra8 bedra16	• •	• •	• •	•	
spools / kg K250 / 25,0 K355 / 45,0	•	• •	• •	• •	
spools / kg P5 / 5,0 P10 / 10,0 P15 / 20,0	• • •	• • •	• • •		

topas® plus H

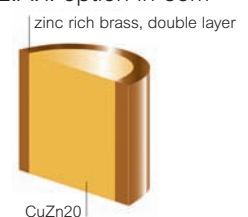
- gamma phase wire with high tensile strength
- particularly suited for machines which require straightened wires for threading
- up to 20 % higher cutting speed as compared to brass wire



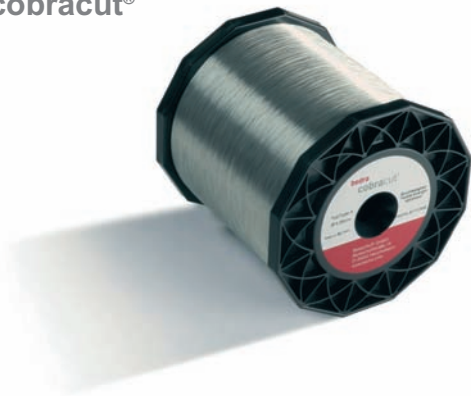
	core material	coating material	tensile strength	elongation	colour
topas® H.E.A.T.	CuZn20	zinc rich brass, double layer	800 N/mm ²	>1%	grau-gold
Ø [mm]	0,25	0,30			
spools / kg bedra8 bedra16	• •	• •			
spools / kg P5 / 5,0 P10 / 10,0 P15 / 20,0	• • •	• • •			

topas® H.E.A.T.

- High performance EDM wire specially developed for Makino machines with H.E.A.T. option
- Double cutting speed with topas H.E.A.T. on machines with H.E.A.T. option in comparison to plain wire



cobracut®



The **cobracut®** series of coated wire electrodes was developed together with AGIE. They are suitable for a number of different machine models and practical applications.

cobracut®
THE ORIGINAL
bedra top quality

cobracut®

- zinc-coated wire electrode
- particularly suitable for high tapering due to its high elongation
- limited suitability for secure automatic threading



	core material	coating material	tensile strength	elongation	colour
cobracut®	CuZn36	Zn treated	500 N/mm ²	>15%	light grey
Ø [mm]	0,20	0,25			
spools / kg bedra4 bedra8 bedra16	• • •	• • •			
spools / kg K160 / 6,0 K250 / 25,0	• •	• •			

cobracut® type A

- the original made by bedra
- our recommendation hard zinc-coated wire electrode
- for highest demands on reproducible precision and surface quality
- high straightness for proper automatic threading



	core material	coating material	tensile strength	elongation	colour
cobracut® type A	CuZn36	Zn	900 N/mm ²	1%	bright silver
Ø [mm]	0,15	0,20	0,25	0,30	
spools / kg bedra 4 bedra 8 bedra16	• ¹ •	• •	• ¹ •	• ¹ •	
spools / kg K250 / 25,0 K355 / 45,0		•	• •	• •	

¹ automatic threading not guaranteed

cobracut® type G

- harder surface than type A
- particularly suited for taper cutting on AGIE machines with toroid guides
- excellent cylindricities, particularly with higher workpieces on machines of the Evolution and Vertex series



	core material	coating material	tensile strength	elongation	colour
cobracut® type G	CuZn36	Zn treated	900 N/mm ²	1%	light grey
Ø [mm]	0,15	0,20	0,25	0,30	
spools / kg bedra 8 bedra16	•	• •	• ¹ •	• ¹ •	
spools / kg K250 / 25,0 K355 / 45,0		•	• •	• •	

¹ automatic threading not guaranteed

cobracut®


	core material	coating material	tensile strength	elongation	colour
cobracut® type D	CuZn20	CuZn50	800 N/mm ²	1%	yellow brown
Ø [mm]	0,15	0,20	0,25	0,30	
spools / kg bedra8 bedra16	•	•	•	•	
spools / kg K250 / 25,0 K355 / 45,0		•	•	•	

cobracut® type D

- classic high-speed cutting wire for Agie machines
- developed for high-power generators
- high thermal and electrical conductivity
- for speed cutting as well as contour precision enables cutting
- enables automatic threading

CuZn50



CuZn20

	core material	coating material	tensile strength	elongation	colour
cobracut® type S	CuZn20	CuZn50	800 N/mm ²	1%	yellow brown
Ø [mm]	0,30	0,33			
spools / kg bedra16	•	•			
spools / kg K250 / 25,0 K355 / 45,0	•	•			

cobracut® type S

- improvement of the **cobracut® type D**: better removal performance due to its thicker diffusion layer
- particularly suitable for EDM mass production
- enables automatic threading

CuZn50



CuZn20

	core material	coating material	tensile strength	elongation	colour
cobracut® type W	CuZn20	CuZn50	430 N/mm ²	>30%	yellow brown
Ø [mm]	0,25				
spools / kg bedra4 bedra8 bedra16	• • •				

cobracut® type W

- developed for AGIECUT Progress machines
- highest cutting rate on EDM machines with most advanced high-power generators
- particularly suited for component production and machining of high workpieces

CuZn50



CuZn20



The high quality coated **megacut®** electrodes were especially developed for Japanese EDM machines.

megacut® type A

- zinc-coated precision wire
- suitable for extra-fine surfaces
- excellent cutting results – particularly for carbide machining



	core material	coating material	tensile strength	elongation	colour
megacut® type A	CuZn36	Zn treated	900 N/mm ²	1%	light grey
Ø [mm]	0,15	0,20	0,25	0,30	
spools / kg bedra8 bedra16	•	•	•	•	
spools / kg P5 / 5,0 P10 / 10,0 P15 / 20,0	•	•	•	•	

megacut® type T

- particularly suitable for high tapering
- limited suitability for automatic threading



	core material	coating material	tensile strength	elongation	colour
megacut® type T	CuZn36	Zn treated	500 N/mm ²	>15%	light grey
Ø [mm]	0,20	0,25			
spools / kg bedra8 bedra16	•	•			
spools / kg P5 / 5,0 P10 / 10,0 P15 / 20,0	•	•			

megacut® type D

- high-performance cutting characteristics due to its special coating
- particularly effective when operating under poor flushing conditions (tall workpieces, interrupted cuts, staked parts)



	core material	coating material	tensile strength	elongation	colour
megacut® type D	CuZn20	CuZn50	800 N/mm ²	1%	yellow brown
Ø [mm]	0,20	0,25	0,30		
spools / kg bedra8 bedra16	•	•	•		
spools / kg K355 / 45,0		•	•		
spools / kg P5 / 5,0 P10 / 10,0 P15 / 20,0	•	•	•		

megacut®


	core material	coating material	tensile strength	elongation	colour
megacut® plus	CuZn36	Gamma-brass	900 N/mm ²	1%	yellow gold
Ø [mm]	0,25				
Spule / kg K160 / 8	•				
Spule / kg P5 / 5,0 P10 / 10,0 P15 / 20,0	• • •				

megacut® plus

- Gamma phase wire for all standard brass wire technologies
- For high cutting speed and precision
- Very good wire threading
- significant time and cost savings compared to pure brass wire

Gamma-brass



CuZn36

	core material	coating material	tensile strength	elongation	colour
megacut® type HS	CuZn50	800 N/mm ²	1%	yellow	brown
Ø [mm]	0,30	0,33			
spools / kg bedra8 bedra16	• •	• •			
spools / kg K355 / 45,0	•	•			
spools / kg P10 / 10,0 P15 / 20,0	• •	• •			

megacut® type HS

- improvement of **megacut®** type D
- the thicker diffusion layer provides better removal performance
- particularly suitable for economical EDM mass production

CuZn50



CuZn20

broncocut®



broncocut® type X

- classic high-speed cutting wire for Charmilles machines
- high-performance, multipurpose wire electrode with CuZn coating
- particularly suited for precision cutting as well as high-speed cutting



	core material	coating material	tensile strength	elongation	colour
broncocut® type X	Cu	CuZn50	520 N/mm ²	1%	brown
Ø [mm]	0,25	0,30			
spools / kg bedra4 bedra8 bedra16	• • •	• •			
spools / kg K250 / 25,0 K355 / 45,0	• •	• •			
spools / kg P5 / 5,0 P10 / 10,0 P15 / 25,0	• • •	• •			

bercocut®



bercocut® special

- classic high-speed cutting wire for Charmilles machines
- high-performance, multipurpose wire electrode with CuZn coating
- particularly suited for precision cutting as well as high-speed cutting



Our programme of high-performance wires covers the full spectrum and with the **bercocut®** series it also comprises plain brass wires. Like the coated products, the brass EDM wires are subject to strict production standards and therefore enable reliable cutting performances.

	material	tensile strength	elongation	colour
bercocut® spezial	CuZn36	900 N/mm ²	1%	gold
Ø [mm]	0,15	0,20	0,25	0,30
spools / kg bedra4 bedra8 bedra16	• •	• •	• •	• •
spools / kg K250 / 25,0 K355 / 45,0			• •	•
spools / kg P5 / 5,0 P10 / 10,0 P15 / 20,0	•	•	• • •	

bercocut®


bercocut® pro 500

- soft, paraffin-free brass wire
- suitable for taper cutting



CuZn36

	core material	surface	tensile strength	elongation	colour
bercocut® pro 500	CuZn36	paraffin-free	500 N/mm ²	>15%	gold
Ø [mm]	0,25				
spools / kg					
K125 / 4,0	•				
K160 / 8,0	•				
K200 / 16,0	•				

	core material	surface	tensile strength	elongation	colour
bercocut® pro 900	CuZn36	paraffin-free	900 N/mm ²	1%	gold
Ø [mm]	0,20	0,25	0,30		
spools / kg					
K160 / 8,0	•	•	•		
K200 / 16,0		•	•		
K250 / 25,0		•	•		
K355 / 25,0		•	•		
spools / kg					
P5 / 5,0	•	•	•		
P10 / 10,0		•	•		
P15 / 20,0		•	•		

bercocut® pro 900

- hard, straightened brass wire
- paraffin-free grade
- recommended for use on all Japanese machines



CuZn36

	core material	surface	tensile strength	elongation	colour
megacut® pro	CuZn36	paraffin-free	900 N/mm ²	1%	gold
Ø [mm]	0,25				
spools / kg					
K160 / 8,0	•				
K200 / 16,0	•				
spools / kg					
P5 / 5,0	•				
P10 / 10,0	•				
P15 / 20,0	•				

megacut® pro

- Reliable brass wire as economical alternative for Japanese machines
- Precise automatic threading
- Paraffin free, specially refined quality



CuZn36

microcut®

Microerosion makes highest demands on precision and process stability. The fine wires of the **microcut®** family combine highest tensile strength with tightest tolerances, and, at that, with diameters thinner than a human hair.



Diameter of human hair:
approx. 0,06 mm



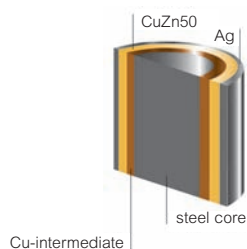
This shows **microcut®** in cross-section
Diameter: 0,03 mm, thus only half a hair's breadth
as compared to the human hair.

**worldwide
patented!**



microcut®

- a high-tensile steel core reliably sustains high wire pre-loads, even with the smallest diameters
- functional layer composition for finest machining with absolute reproducibility



	core material	coating material	tensile strength	elongation	colour
microcut®	steel, Cu-treated	CuZn50, Ag	2.000 N/mm²	1%	gold
Ø [mm]	0,02	0,03	0,04	0,05	0,06
spools BK100 5.000 m 10.000 m	•	•	•	•	•
Ø [mm]	0,07	0,08	0,09	0,10	
spools BK100 5.000 m 10.000 m	•	•	•	•	
spools bedra4 20.000 m 30.000 m	•	•	•	•	

microcut® CCA

- combines the best properties of **cobracut®** and **microcut®**, thereby providing reproducible results with best surface quality, even in the case of very small energy pulses.
- due to its high tensile strength and minimal tolerance of the wire diameter particularly suited for precise fine contours



	core material	coating material	tensile strength	elongation	colour	
microcut® CCA	CuZn36	Zn treated	1.000 N/mm²	1%	grey	
Ø [mm]	0,05	0,06	0,07	0,08	0,09	0,10
spools bedra4						
10.000 m	•	•				
20.000 m	•	•				
30.000 m			•	•	•	•
60.000 m			•	•	•	•

microcut® BR

- for standard requirements in microerosion



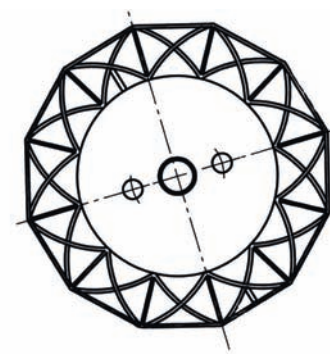
	core material	tensile strength	elongation	colour		
microcut® BR	CuZn36	1.000 N/mm²	1%	gold		
Ø [mm]	0,05	0,06	0,07	0,08	0,09	0,10
spools bedra4						
10.000 m	•	•				
20.000 m	•	•	•	•	•	•
30.000 m			•	•	•	•
60.000 m						•

The unique bedra EDM wire spool



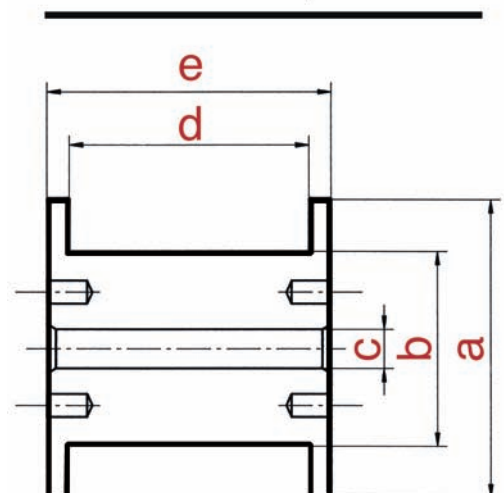
The bedra EDM wire spool was developed in close cooperation with machine manufacturers and users. Its shape facilitates its handling and storage. It also prevents the wire from tangling and breaking. Its unique 12-sided (dodecagon) shape prevents the spool from rolling and allows proper horizontal storage. Thus stored correctly, the wire layers can no longer entangle.

The spools are made of shockproof, recyclable ABS plastic.



type of spool (K-spools DIN 46339)	dimensions flange a [mm]	core b [mm]	bore hole c [mm]	inner size d [mm]	outer size e [mm]
bedra4	130	80	16	105	125
bedra8	160	100	22	135	160
bedra16	200	125	22	164	200
K100	100	63	16	80	100
K125	125	80	16	100	125
K160	160	100	22	128	160
K200	200	125	22	160	200
K250	250	160	22	160	200
K355	355	224	36	160	200
P3	130	81	20	90	110
P5	160	90	20	90	115
P10	200	90	25	110	134
P15	250	110	34	110	140

Further spool types on request.



Data for your production planning

type of spool	wire diameters mm	nominal weight per spool, approx. kg (approx.)	nominal length per spool ¹ (m)	run-off times per spool at run-off time speeds			
				6 m/min (h)	9 m/min (h)	12 m/min (h)	15 m/min (h)
bedra4	0,15	4	26.800	74	50	37	30
	0,20	4	15.000	42	28	21	17
	0,25	4	9.600	27	18	13	11
	0,30	4	6.600	18	12	9	7
bedra8 and K160 - 8 kg	0,15	8	53.600	149	99	74	60
	0,20	8	30.000	83	56	42	33
	0,25	8	19.200	53	36	27	21
	0,30	8	13.200	37	24	18	15
	0,33	8	10.700	30	20	15	12
bedra16	0,20	16	60.000	167	111	83	67
	0,25	16	38.400	107	71	53	43
	0,30	16	26.400	73	49	37	29
	0,33	16	21.400	59	40	30	24
K100	0,15	1.6	10.500	29	19	15	12
	0,20	1.6	6.000	17	11	8	7
	0,25	1.6	3.700	10	7	5	4
	0,30	1.6	2.600	7	5	4	3
K125	0,15	3.5	23.000	64	43	32	26
	0,20	3.5	12.500	35	23	17	14
	0,25	3.5	8.000	22	15	1	9
	0,30	3.5	5.500	5	10	8	6
K160 - 6 kg	0,15	6	39.000	108	72	54	43
	0,20	6	22.000	61	41	31	24
	0,25	6	14.000	39	26	19	16
	0,30	6	9.800	27	18	14	11
K200	0,20	15.7	57.500	160	106	80	64
	0,25	15.7	37.000	103	69	51	41
	0,30	15.7	25.800	72	48	36	29
	0,33	15.7	21.200	59	39	29	24
K250	0,20	25	93.750	260	174	130	104
	0,25	25	60.000	167	111	83	67
	0,30	25	41.250	115	76	57	46
	0,33	25	33.500	93	62	47	37
K355	0,20	45	165.000	458	306	229	183
	0,25	45	106.000	294	196	147	118
	0,30	45	73.500	204	136	102	82
	0,33	45	60.700	167	112	84	67
P3	0,15	3	19.700	55	36	27	22
	0,20	3	11.000	31	20	15	12
	0,25	3	7.000	19	13	10	8
	0,30	3	4.900	14	9	7	5
P5	0,15	5	32.600	91	60	45	36
	0,20	5	18.300	51	34	25	20
	0,25	5	11.700	33	22	16	13
	0,30	5	8.100	23	15	11	9
	0,33	5	6.740	19	12	9	7
P10	0,20	10	36.600	102	68	51	41
	0,25	10	23.400	65	43	33	26
	0,30	10	16.200	45	30	23	18
	0,33	10	13.500	36	25	19	15
P15	0,20	20	73.500	204	136	102	82
	0,25	20	46.800	130	87	65	52
	0,30	20	32.400	90	60	45	36
	0,33	20	27.000	75	50	37	30
BK100	0,02 - 0,10		5.000	14	9	7	5
bedra4	0,02 - 0,10		10.000	28	18	14	11
			20.000	56	36	28	22

¹Valid for full spools with CuZn alloys with a density of 8,67 kg/dm³

Packing units

	wire / spool (kg)	spools / carton	weight / carton (kg)	cartons / layer	weight 1 layer (kg)	weight 2 layers (kg)	weight 3 layers (kg)	weight 4 layers (kg)
bedra4	4	4	16	6	96	192	288	384
bedra8	8	2	16	10	160	320	480	640
bedra16	16	1	16	12	192	384	576	
K125	3,5	4	14	6	84	168	252	336
K160	8	2	16	10	160	320	480	640
K200	16	1	16	12	192	384	576	
K250	25	1	25	12	300	600		
K355	45	1	45	3	135			
P5	5	4	20	8	160	320	480	640
P10	10	2	20	8	160	320	480	640
P15	20	1	20	16	320	640		

standard palett = EURO PALETT (processed timber)

Wire storage

Please note:

1. Always store spools in their original packaging in a dry area

The spools are packed in shock, dust and oxidation-proof material to protect the wire from shipping damage and contamination. The wire should be stored in the original packaging until ready for use. This will ensure the highest quality for your EDM applications.

2. Used spools handling procedures

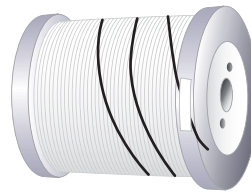
It is very important to properly secure the loose end of the wire on partially used spools. This will prevent the wire from shifting on the spool and becoming tangled. Improper handling and storage techniques can cause unwinding problems and unnecessary wire breakage. Figures 1 and 2 show two correct ways to secure the loose end of the wire.

Figures 3 and 4 show incorrect ways and should definitely be avoided. Partially used spools should be stored in their original packaging material when not in use. This will minimize contamination and shifting of the wire on the spool.

Warranty will be voided in case of improper storage!

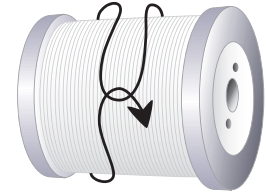
Proper handling of partially used spools:

Figure 1



Attach wire to spool flange with tape.

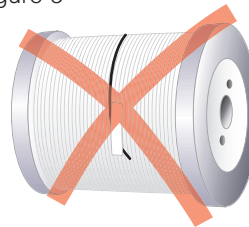
Figure 2



Attach wire by making a loop and securing it to itself. Make sure that the wire is snug.

Strictly avoid:

Figure 3



Do not tape wire to the spooled material!

Figure 4



Do not thread the wire underneath itself so as to overlap!

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