

Cold Chamber Die Casting Machine

1600 TCM
1800 TCM
2000 TCM
2500 TCM
3000 TCM

冷室壓鑄機系列

High Efficiency, Excellent Performance,
Technological Advancement.

高效率！高品質技術的提昇！



鋁台精機廠股份有限公司
ZITAI PRECISION MACHINERY CO.,LTD.

Quality through better design with an

品質始於設計及匠心獨運的展現



ZITAI FACTORY PLANT-1 鋁台一廠

FACTORY LAYOUT 廠房分佈



QUALITY CONTROL ROOM 品管室



MACHINING PROCESS AREA 加工區

expert workforce.



ZITAI FACTORY PLANT-2 鋁台二廠

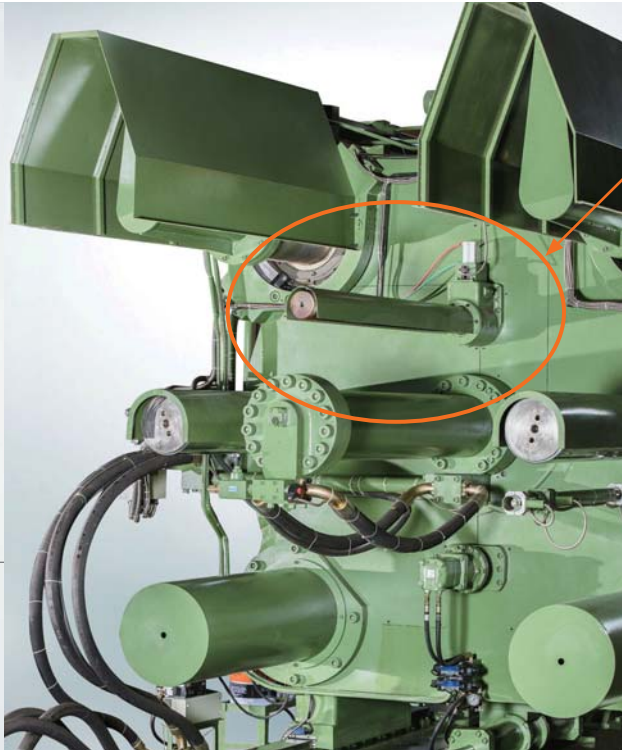


STORAGE AREA 倉庫區

ASSEMBLY AREA 組裝區

Innovative and Technological Equipment

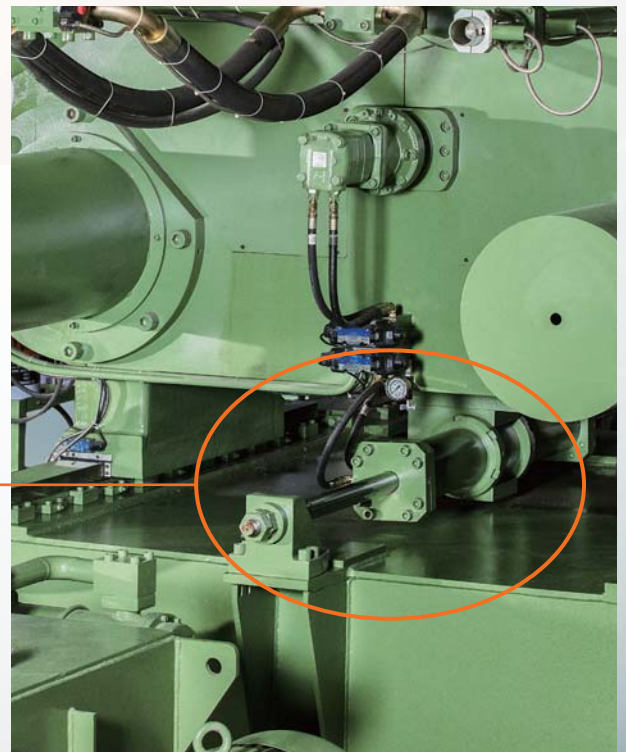
創新技術裝置



SAFETY PIN
安全梢

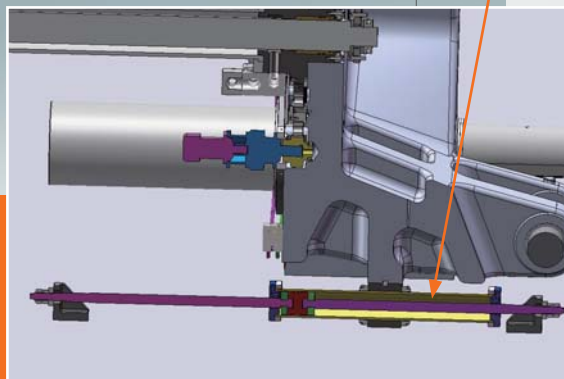
SAFETY PIN EQUIPMENT FOR DIE-CLOSE AND DIE-OPEN 關開模安全梢裝置

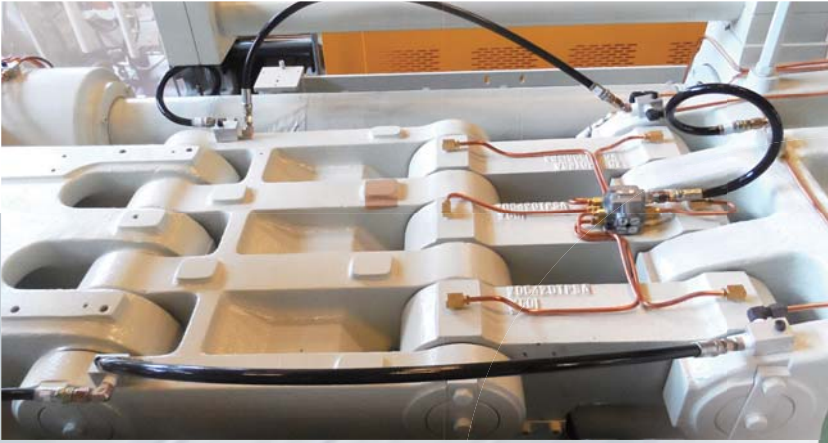
- Safety pin equipment installed in cross toggle for fail-safe, secure and reliable die closing & opening.
- 安全梢裝置於動力較小的十字曲肘上，安全可靠。



DIE-HEIGHT AND AUXILIARY HYDRAULIC CYLINDER 調模輔助油壓缸

- Die locking force adjusted more precisely with the help of auxiliary cylinder mounted on the bottom side of rear platen without stain on motor and gear system.
- 可減少調模馬達及齒輪系機構的負載。更可精準的調整鎖模力。





TOGGLE WITH OIL LESS BUSHES AND LUBRICATION

曲肘及潤滑

- Unique material used for toggle sleeve has low friction coefficient and a long life. Adopt less solid-state lubricant without leakage and pollution.
- 曲肘襯套使用特殊材料，摩擦系數低、壽命長。採固態潤滑劑用量少，不滴油、無汙染。



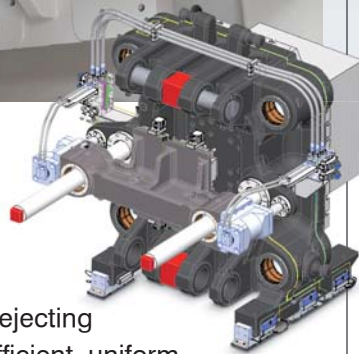
- Mirror surface treatment is adopted for toggle pin with oil less bushes for less friction and long life.
- 心軸採鏡面處理，磨耗少、壽命長。



DOUBLE-EJECTOR MECHANISM

雙押出機構

- Synchronized the double-ejecting cylinder system is more efficient, uniform and more space for replacement of dies ejecting system. Also, it is easy for maintenance.
- 採雙押出缸設計，方便安裝押出機構和容易保養。



MOVABLE DIE SIDE 活動模側



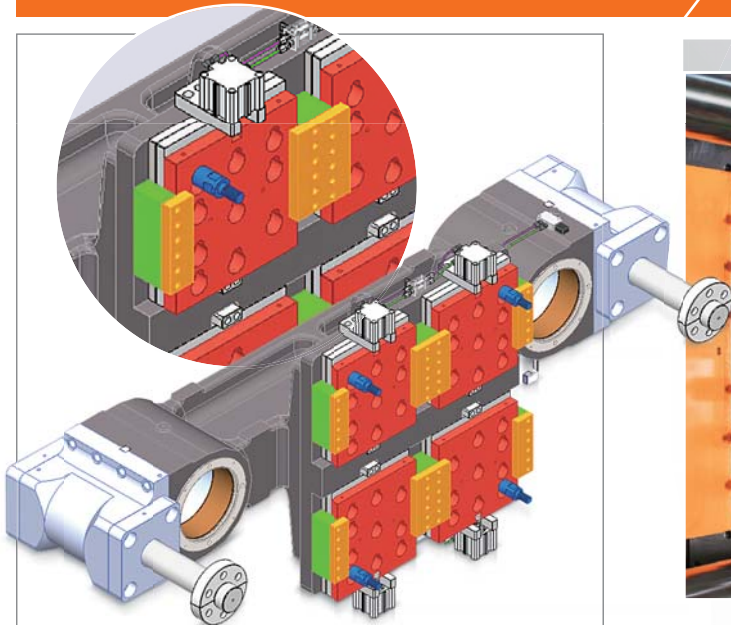
FIXED DIE SIDE 固定模側

DIE SUPPORT PLATFORM (Optional)

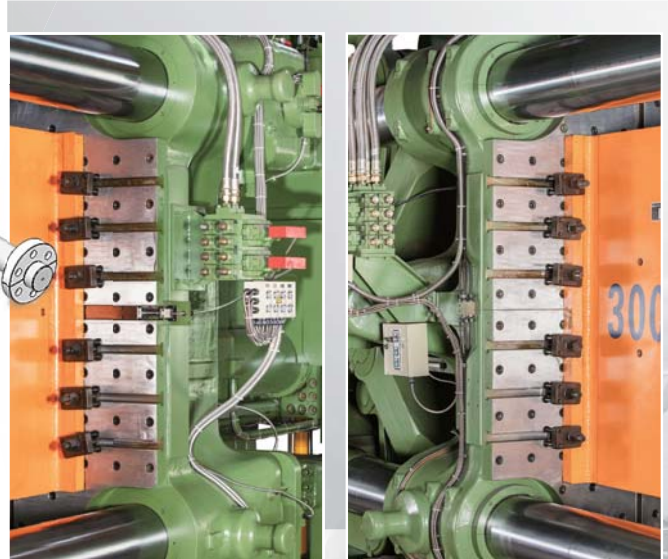
模具承台 (活動模 / 固定模) (選購配備)

- Die support system is an advantage for loading especially huge dies through SMED concept. Also, this prevents the direct load on tie bars and improves the machine life.
- 有助於上下模具方便性 減少大柱磨耗受損 延長機台壽命。

AUTOMATIC EJECTOR-RETRACT MECHANISM (Optional) 自動押出倒拉機構 (選購配備)

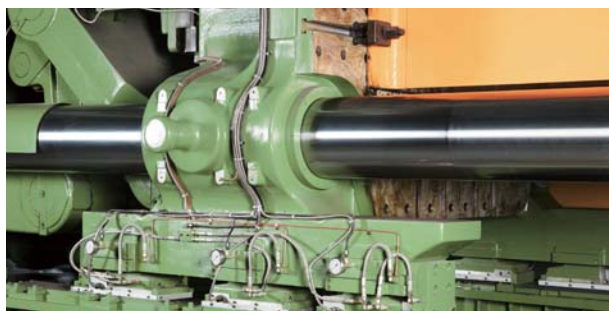


- Automatic ejector and retract bar equipment to saves die installation time and improve efficiency. Also, this gives complete freedom to design and locate the ejector pin location.
- 方便模具押出及倒拉桿的裝置，節省裝模時間提高效率。



SUB-PLATE 模板墊板

- Additional Sub-plate on moving platen to prevent surface damages on platen and in case of any damage can be restored quickly by dismantling & regrinding it.
- 中模板面增加墊板設計，方便模板面損傷時，可拆下修復。

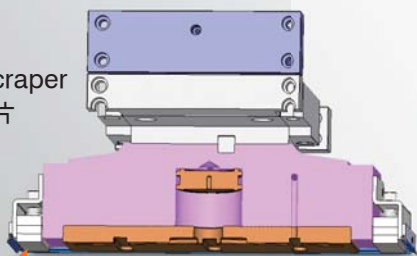


HYDRAULIC PRESSURE COMPENSATION FOR BED SHOE

中模板滑座 (液壓自動支撐補償)(鋁台專利)

- Automatic Hydraulic pressure compensation system is a patented design of ZITAI. This unique automated hydraulic pressure compensation for bed shoes prevents radial load on tie bars and ensures smooth movement of moving platen even with huge dies. During the operation, the bed shoe base automatically adjusts the shoe position. This whole system including tie bar bushes has independent lubrication system and ensures adequate lubrication to all points.
- 可有效平衡中模板及模具的載重，使四柱降低負載，減少四柱磨損。四柱襯套及滑座的潤滑系統另獨立設置，減少磨損。

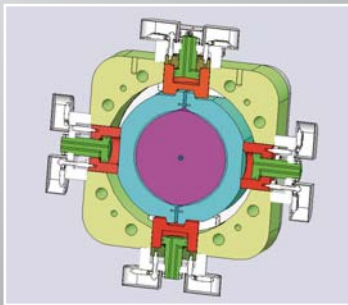
Adj. dust Scraper
可調式刮塵片



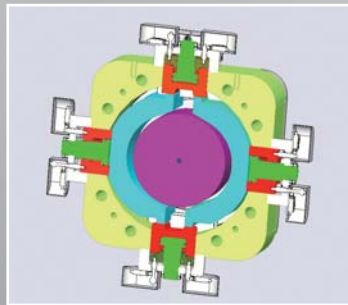
SPLIT NUT TIE BAR PULLER MECHANISM

前拆柱機構

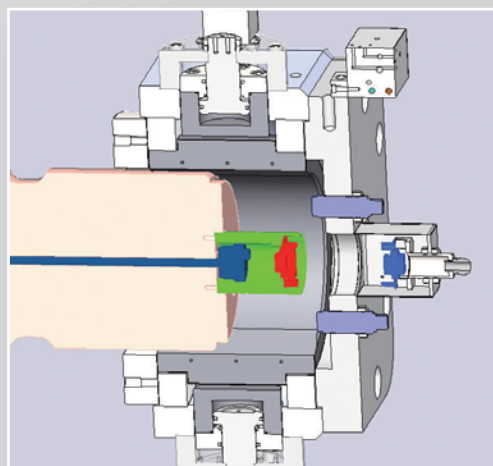
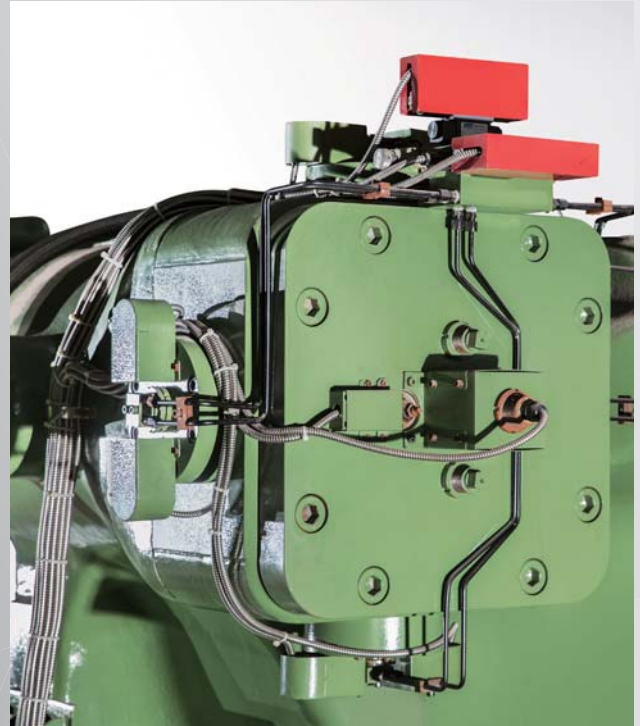
- The front side split-nut on tie bar puller system is entirely different from the conventional one. It operates through hydro-pneumatic pressure with the interlock of the pressure switch. It has four split-nut and four cylinders to manage for lock and unlock.
- 採取雙定位設計及獨立控制系統，確保重複使用精準度。



CLOSE 前拆柱閉合



OPEN 前拆柱開啓



AUTOMATIC SETTING FOR CLAMPING FORCE SENSORS (ROD Type)

鎖模力自動設定(柱塞式)

- Each tie bar has independent locking force sensor for precise locking force measurement. And locking force can be set up on the screen in addition to having automatic increase and decrease function.
- These rod-type sensors are with wireless measuring system, and it is easy to mount on removable tie bars, and this has no interference during separation and combination.
- 可在螢幕上設定所需的鎖模力，並有自動增減功能。
- 採柱塞式感測系統，無線脫離及結合。

REAR TIE BAR PULLER MECHANISM

後拆柱機構

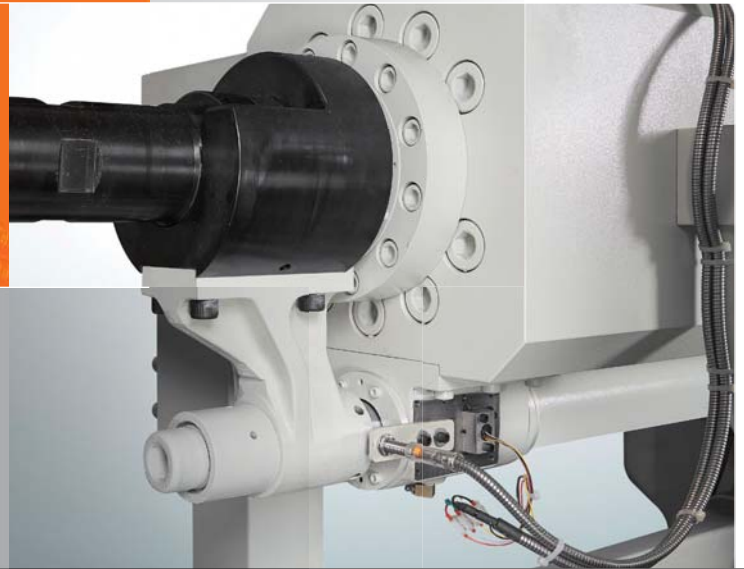
- Both top tie bars can be auto removable tie bars for easy die loading.
- 此拆柱機構方式，利於模具安裝與卸載。





Independent shaft for Shot Stroke measurement 射出行程感測採並行軸設計

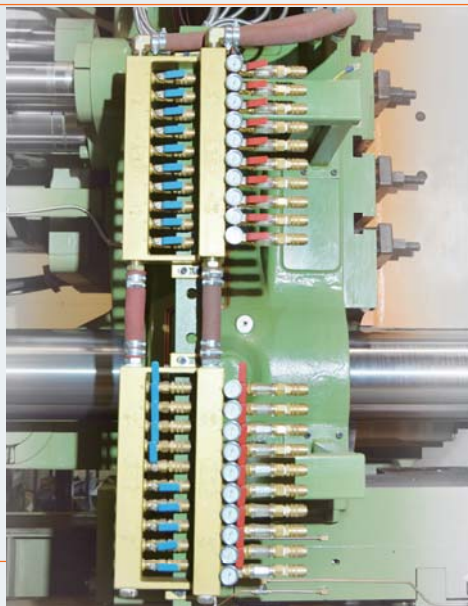
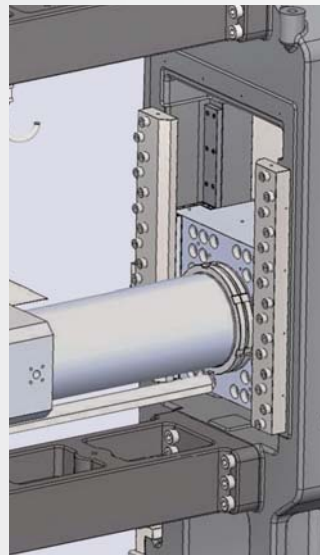
- Especially on high tonnage machine the independent shaft for shot stroke measuring system give Long life, easy maintenance, and accurate sensing precision.
- 壽命長，保養容易、感測精度高。



MULTIPLE SHOT POSITION CLAMP & DE-CLAMP BY HYDRAULIC SYSTEM (ZITAI Patent)

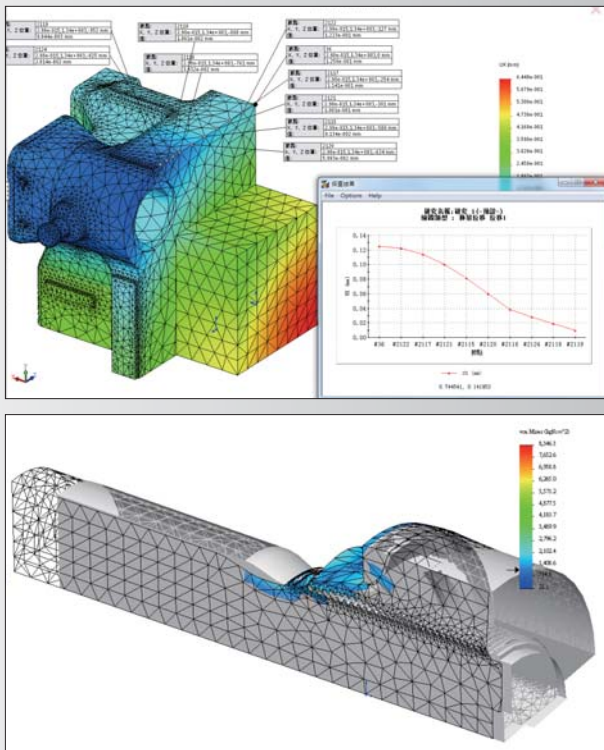
升降機構油壓式自動夾緊放鬆機構(鋁台專利)

- The clamp and de-clamp system for multiple shot position is a unique and patented design of ZITAI. It is very fast and easy to adjust the numerous shot positions with the help of automatic hydraulic clamp & de-clamp mechanism.
- 更換射出口位置時，不需使用人工鎖固螺絲方式來作業，採用自動液壓釋放和鎖定機構。



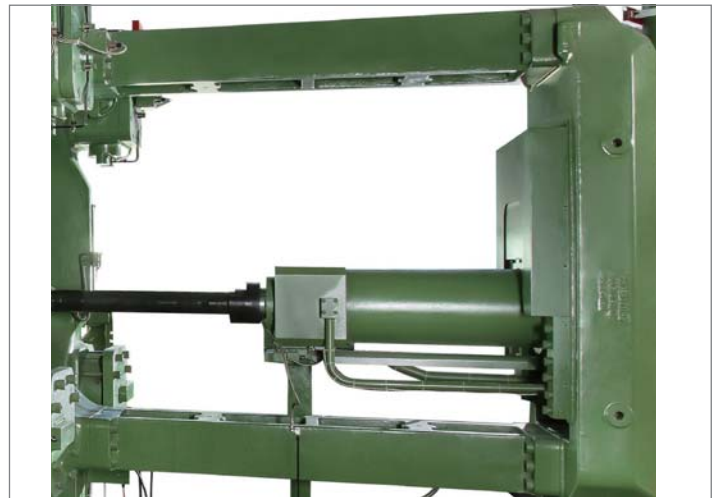
DIE COOLING SYSTEM (Optional) 模具冷卻水控制(選購配備)

- Measure die cooling volume and temperature display precisely.
- 精確量測冷卻水流量與溫度顯示。



ANALYSIS OF MECHANICAL PROPERTIES OF PLATEN STRAIN 機械模板應力分析

- Software of CAE mechanical analysis and calculation is applied to control design characteristic effectively.
- 應用CAE機械分析計算軟體，有效掌握設計特性與壽命。



DOUBLE FRAME DESIGN FOR SHOT END

射出機構的連結採門型結構

- The double frame design provides high rigidity for the complete shot end. This design Ensures no deformation and perfect alimnt of the shot piston with shot sleeve thereby effective shot force.
- 保證在射出作動時結構不變形，射出力傳達確實。

Peripherals 週邊設備



Extractor robot 取出機械人
Equipped with 搭配型號:
R-2000iC/165F



Nozzle numbers: left and right side each 30 pieces.
噴頭數量：左右2側各30個。

Sprayer robot 噴霧機械人
Equipped with 搭配型號:
R-2000iC/165R



Max. Melted Alu. taking amount: 35 kgs.
最大取湯量：35 Kgs。

Auto ladler 自動給湯機
Equipped with 搭配型號:
ZLB-80B/120B

Control system unit

控制系統單元

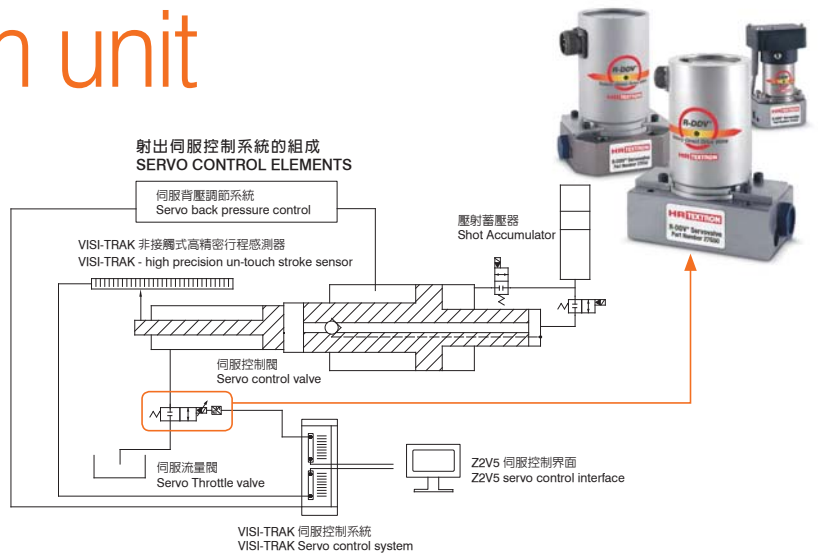


TOUCH SCREEN AND INDUSTRIAL KEYBOARD
觸控螢幕與工業鍵盤

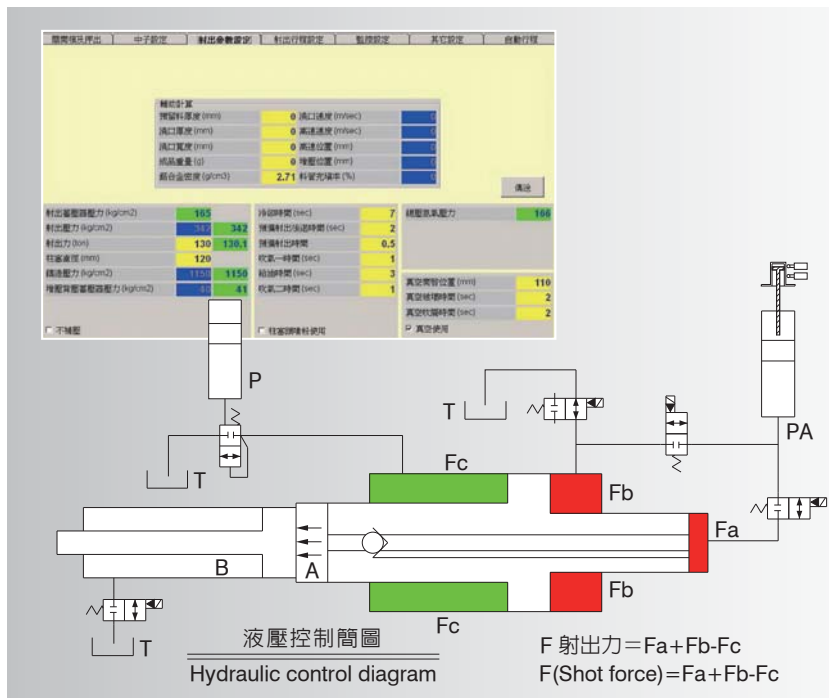


INSPECTION OF AVERAGE LOAD FOR CLAMPING FORCE
鎖模力平均負載檢測

- Ensure four tie bars to have average force.
- 確保四支大柱平均受力。



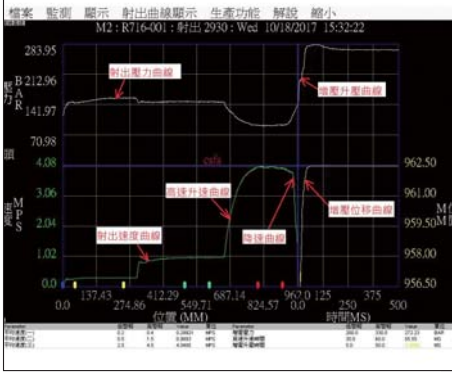
HYDRAULIC AND SERVO FUNCTION
油壓伺服功能



INTERPRETATION OF SHOT FORCE CONTROL

射出力控制說明

- To overcome shot sleeves with diverse diameters and different requirements of casting pressure, needful casting pressure can be set up in screen straightaway.
- 因應不同的料管直徑及不同的鑄造壓力需求，可直接在螢幕上設定所需鑄造壓力。



ANALYSIS OF SHOT CURVE 射出曲線分析

- The shot curve display shows the actual casting data about shot stroke, velocity, and pressure. This, in turn, reflects the part produced & helps to analyse the casting quality.
- 依實際壓鑄射出資料轉換成行程、速度、壓力曲線，以利鑄件成型良品分析判斷。

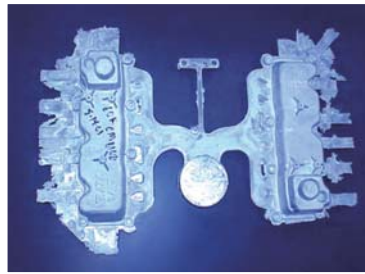


OPERATION SETTING SCREEN FOR SHOT PARAMETER 射出操作畫面

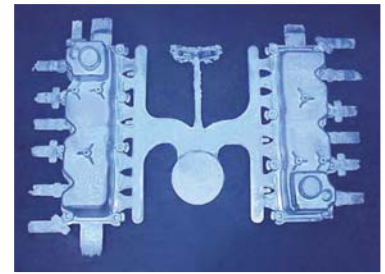
- Shot setting can be transformed to diagrams of stroke and linear velocity in order to determine die casting possibilities.
- 射出設定可轉換成圖示行程速度線型，以利判斷考量壓鑄之可行性。

COMPARISON BETWEEN NORMAL AND SERVO SHOT 鑄件的優勢對比

- Benefits from servo shot are with less flash, less shot impact on die and more accuracy on casting profile.
- 有效降低鑄件飛邊，減緩模具衝擊，提高鑄件外形尺寸精度。



conventional shot sample
傳統控制壓鑄產品



servo shot sample
伺服控制壓鑄產品

COMPLETE SERVICES FOR DIE CASTING TECHNOLOGY 整體壓鑄技術之提供與服務

Manufacture Flow 製作流程：



ZDC - 1600TCM

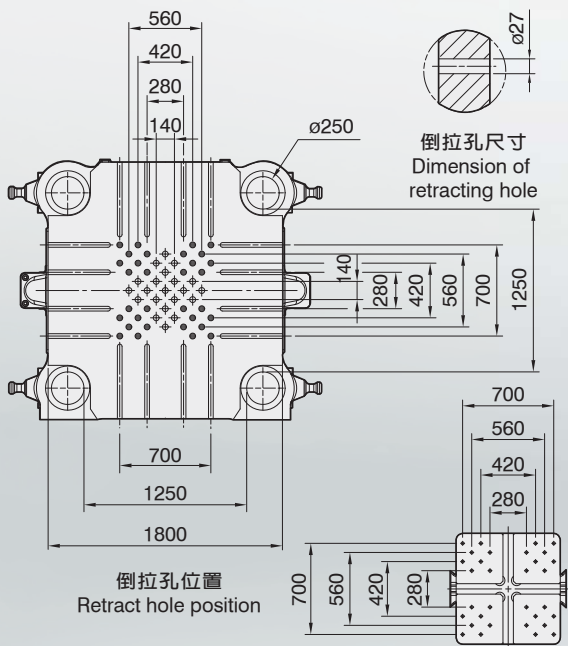
Powerful Design With Full - Featured Machine

Die fitting diagram

模面關係尺寸

射出中心降 Shot position: (*0), 250, 500 mm

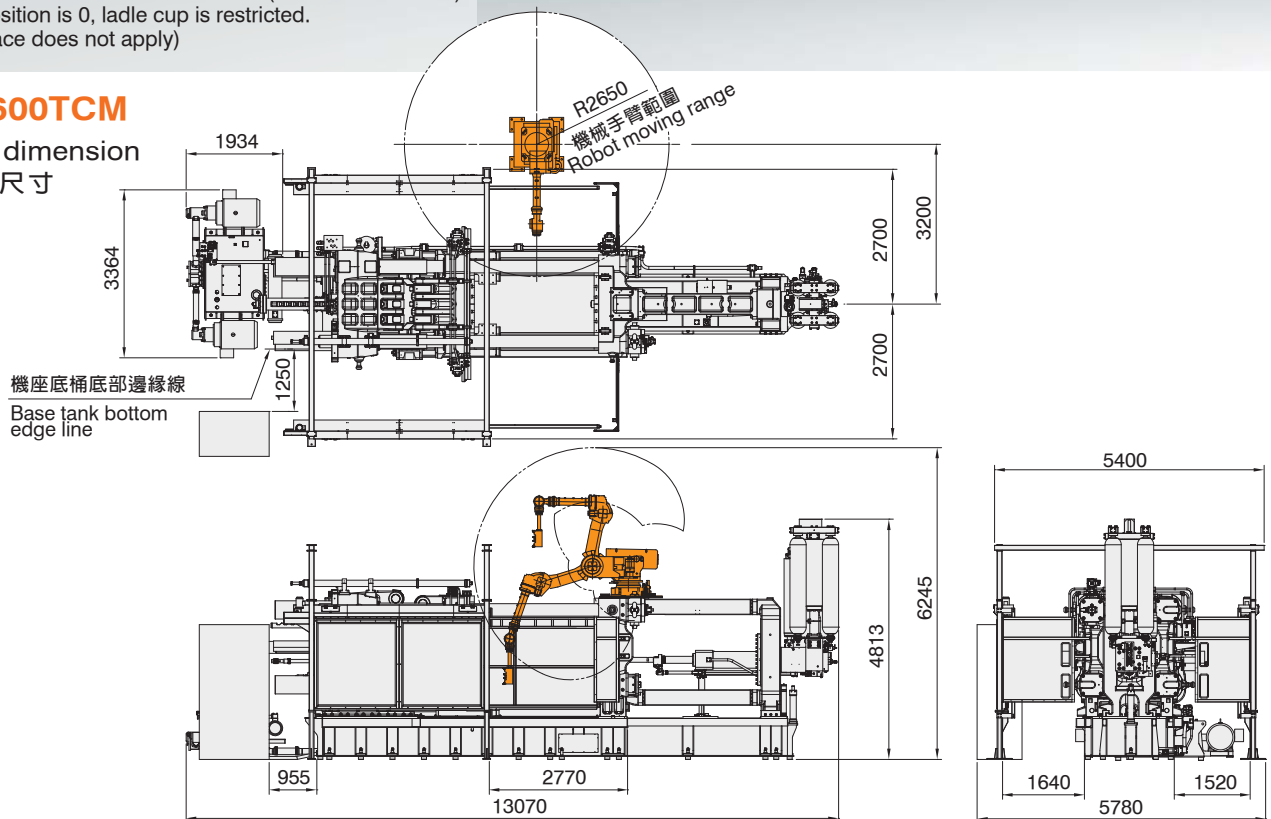
- 押出孔 $\phi 45 \times 21$ 孔 Eject hole $\phi 45 \times 21$ bore
- 倒拉孔 $\phi 45 \times 32$ 孔 Retract hole $\phi 45 \times 32$ bore



- * 中心降為0時，給湯機料勺大小有限制。(定量爐不在此規範)
- * when shot position is 0, ladle cup is restricted. (Dosing furnace does not apply)

ZDC-1600TCM

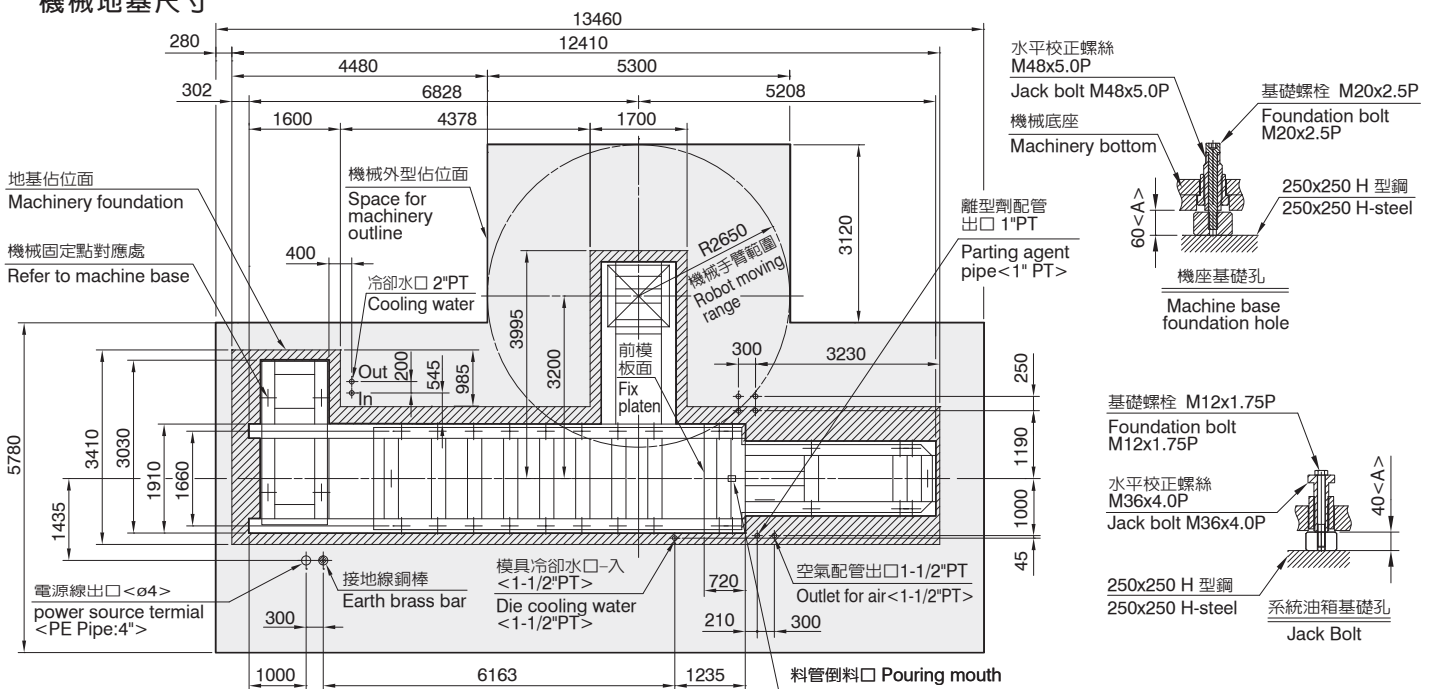
Machine dimension
機械外型尺寸





■ Foundation work diagram

機械地基尺寸



ZDC - 1800TCM

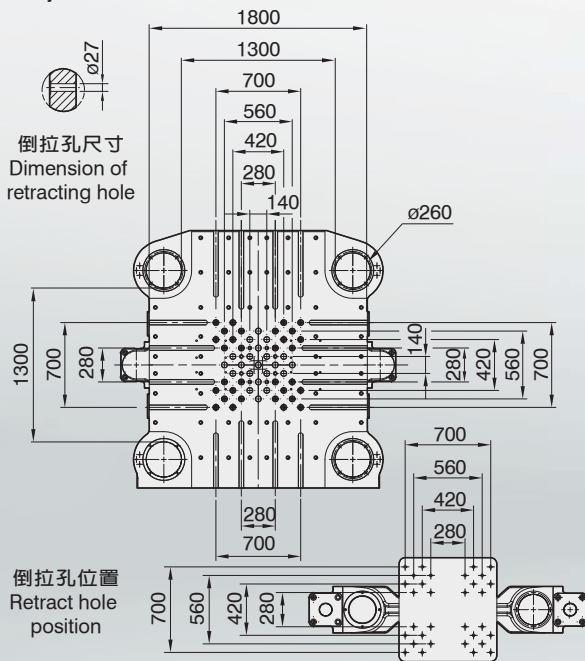
Powerful Design With Full - Featured Machine

Die fitting diagram

模面關係尺寸

射出中心降 Shot position: (*0), 250, 500 mm

- 押出孔 $\phi 45 \times 21$ 孔 Eject hole $\phi 45 \times 21$ bore
- 倒拉孔 $\phi 45 \times 32$ 孔 Retract hole $\phi 45 \times 32$ bore

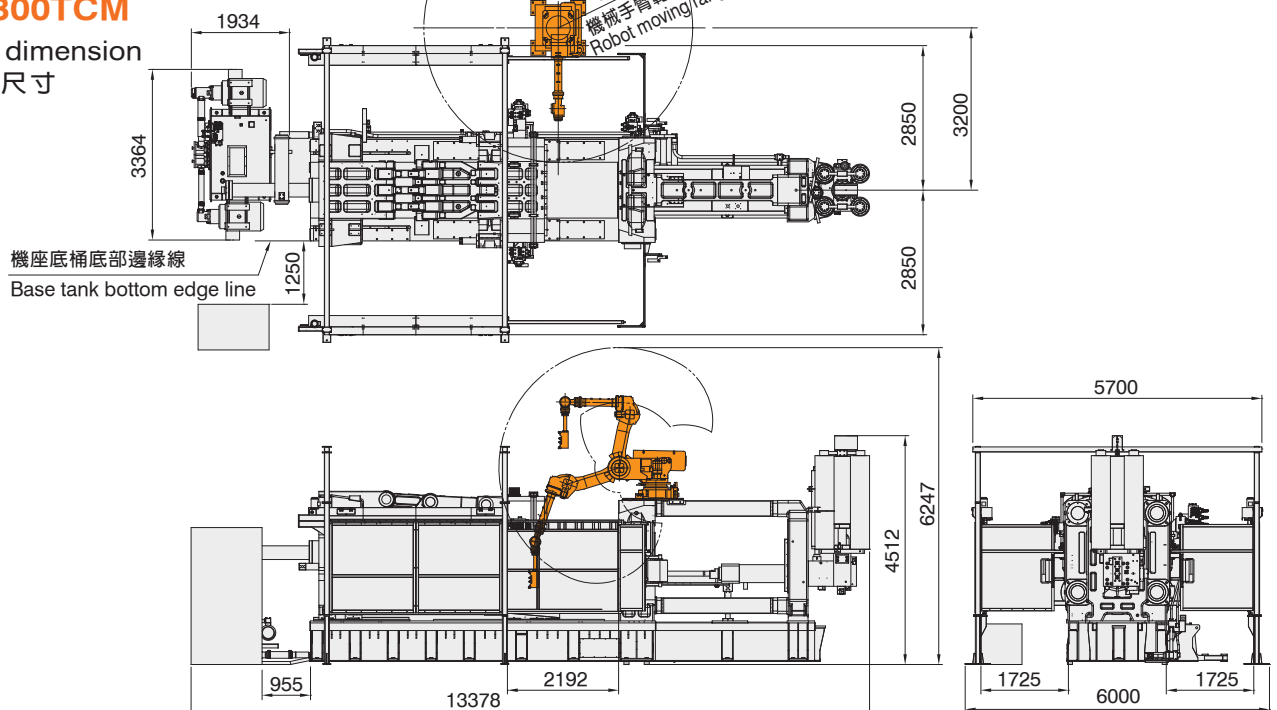


* 中心降為0時，給湯機料勺大小有限制。(定量爐不在此規範)
 * when shot position is 0, ladle cup is restricted.
 (Dosing furnace does not apply)



ZDC-1800TCM

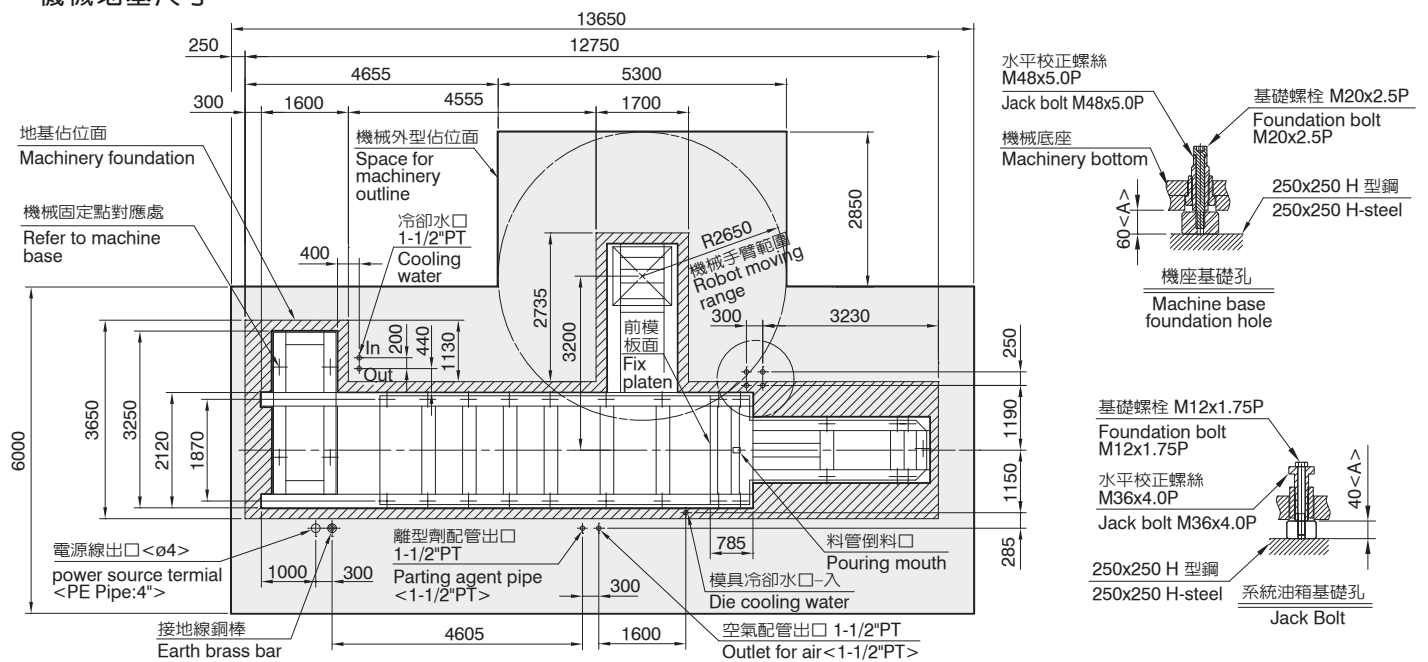
Machine dimension
機械外型尺寸





■ Foundation work diagram

機械地基尺寸



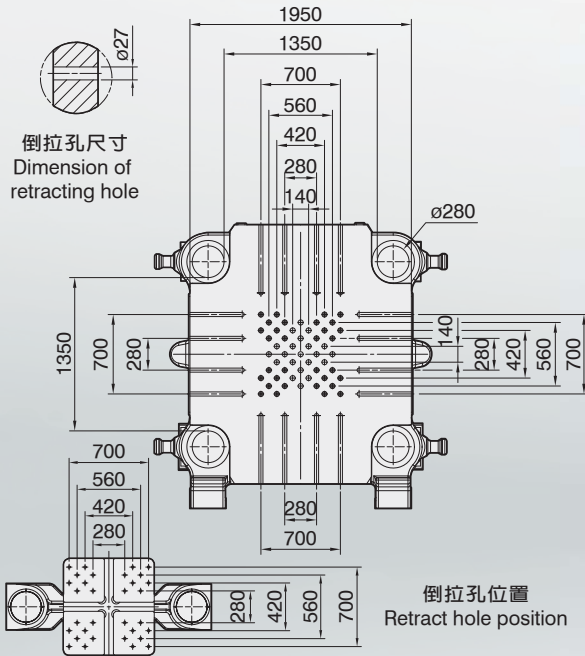
ZDC - 2000TCM

Powerful Design With Full - Featured Machine

Die fitting diagram 模面關係尺寸

射出中心降 Shot position: (*0), 250, 500 mm

- 押出孔 $\phi 45 \times 21$ 孔 Eject hole $\phi 45 \times 21$ bore
- 倒拉孔 $\phi 45 \times 32$ 孔 Retract hole $\phi 45 \times 32$ bore

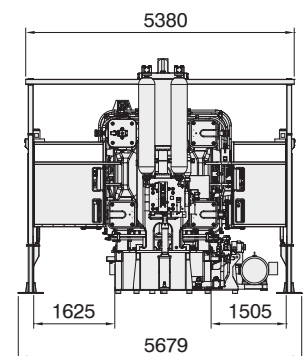
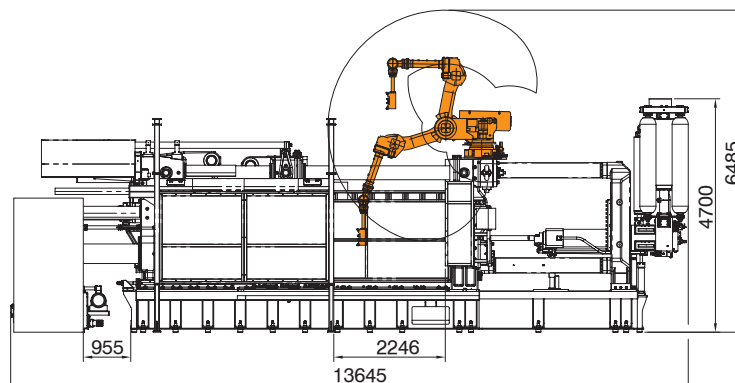
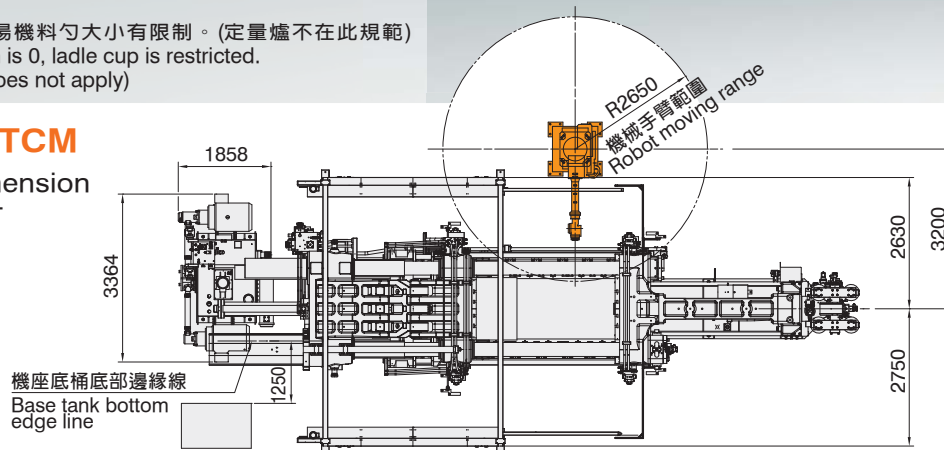


* 中心降為0時，給湯機料勺大小有限制。(定量爐不在此規範)
* when shot position is 0, ladle cup is restricted. (Dosing furnace does not apply)



ZDC-2000TCM

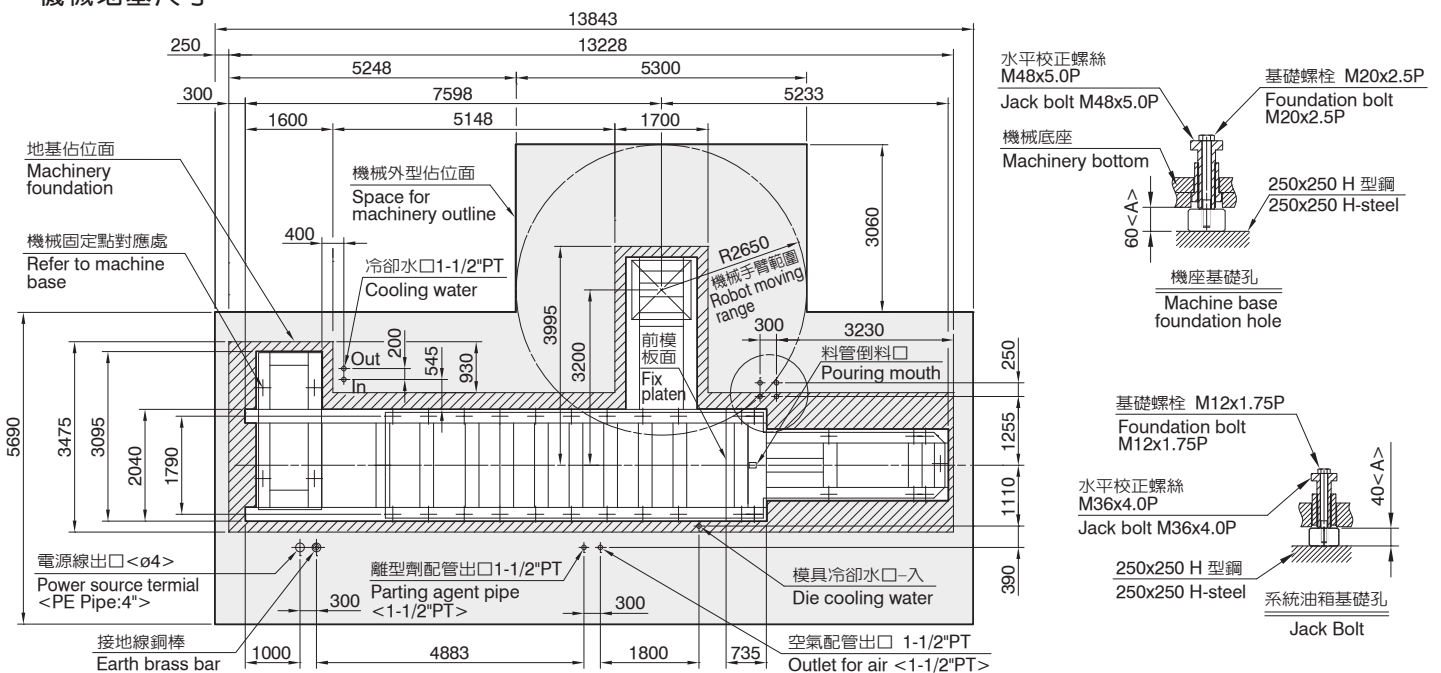
Machine dimension
機械外型尺寸





Foundation work diagram

機械地基尺寸



ZDC - 2500TCM

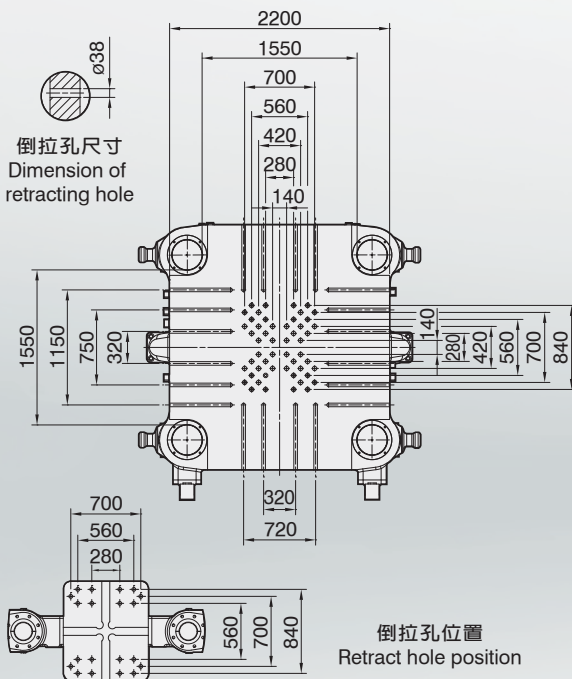
Powerful Design With Full - Featured Machine

Die fitting diagram

模面關係尺寸

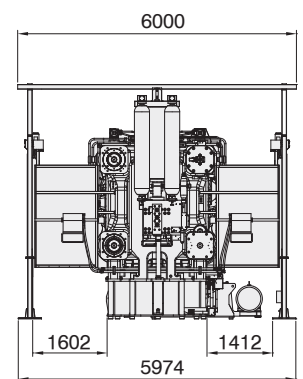
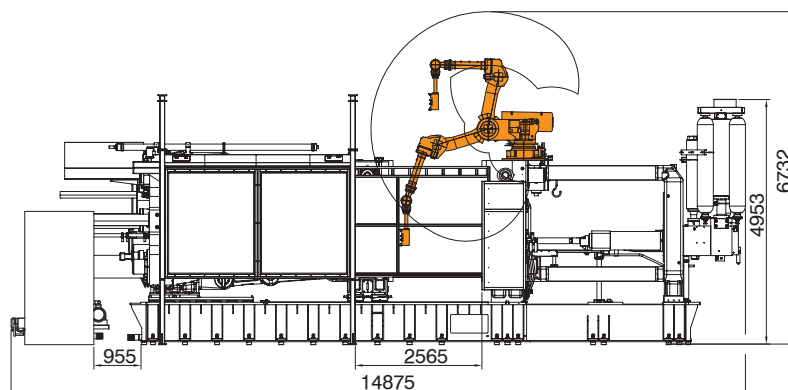
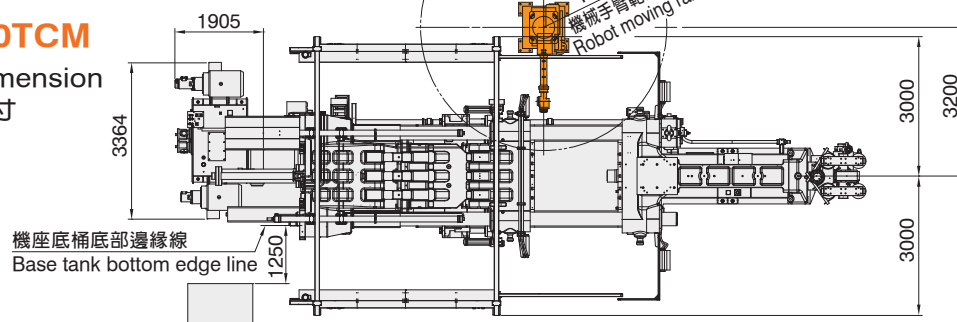
射出中心降 Shot position: 50, 250, 500 mm

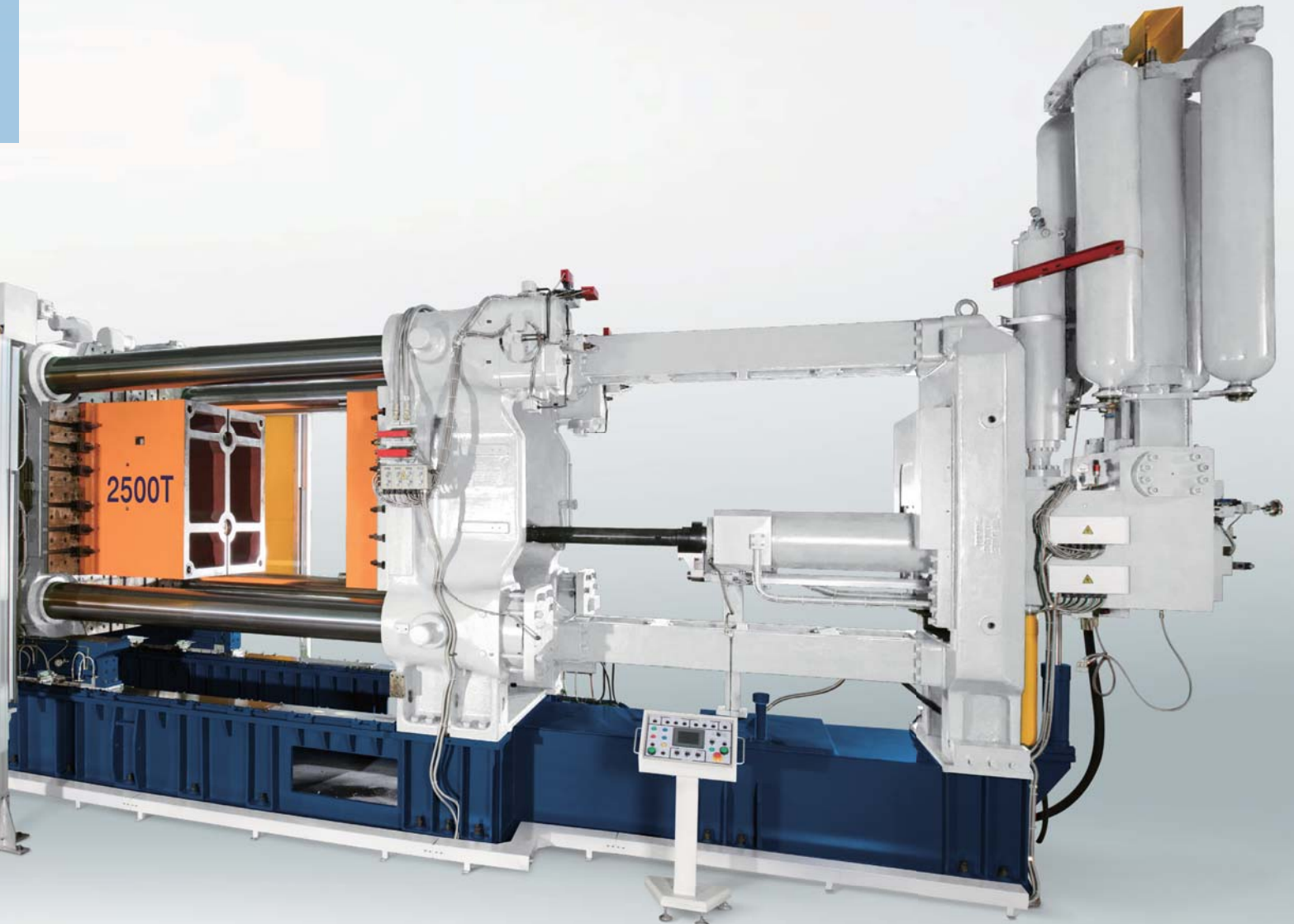
- 押出孔 $\phi 45 \times 32$ 孔 Eject hole $\phi 45 \times 32$ bore
- 倒拉孔 $\phi 45 \times 20$ 孔 Retract hole $\phi 45 \times 20$ bore



ZDC-2500TCM

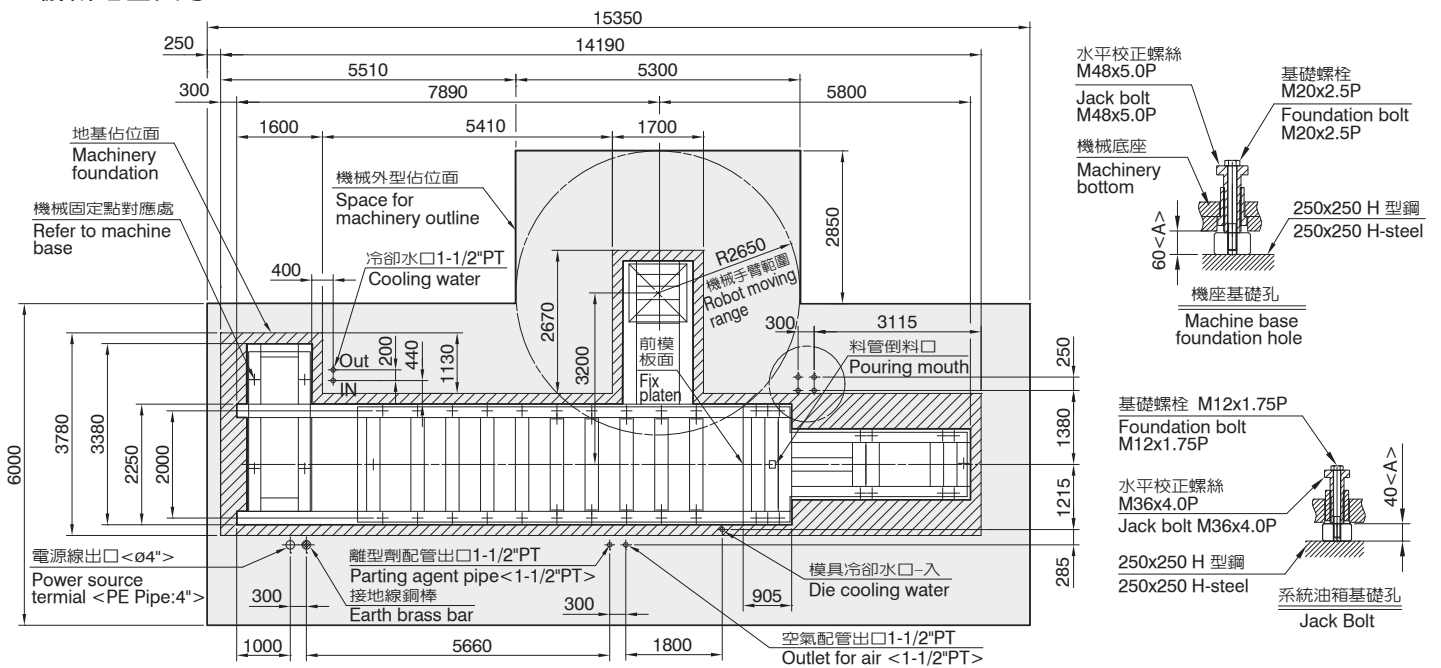
Machine dimension
機械外型尺寸





Foundation work diagram

機械地基尺寸



ZDC - 3000TCM

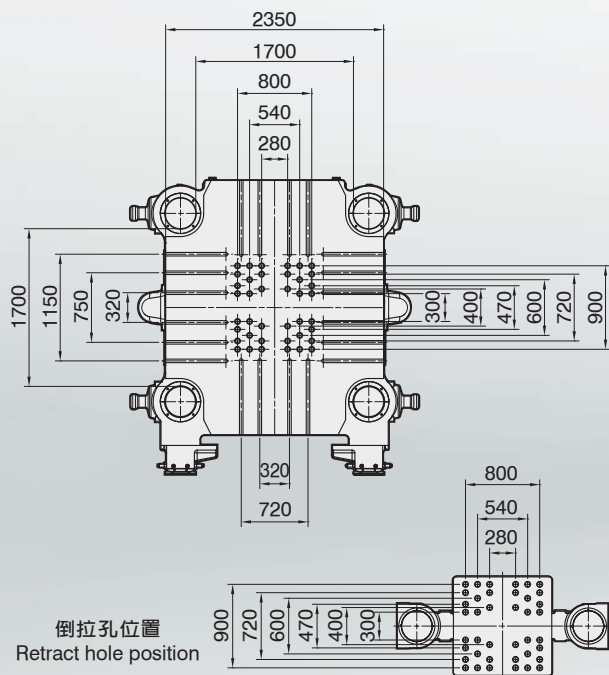
Powerful Design With Full - Featured Machine

■ Die fitting diagram

模面關係尺寸

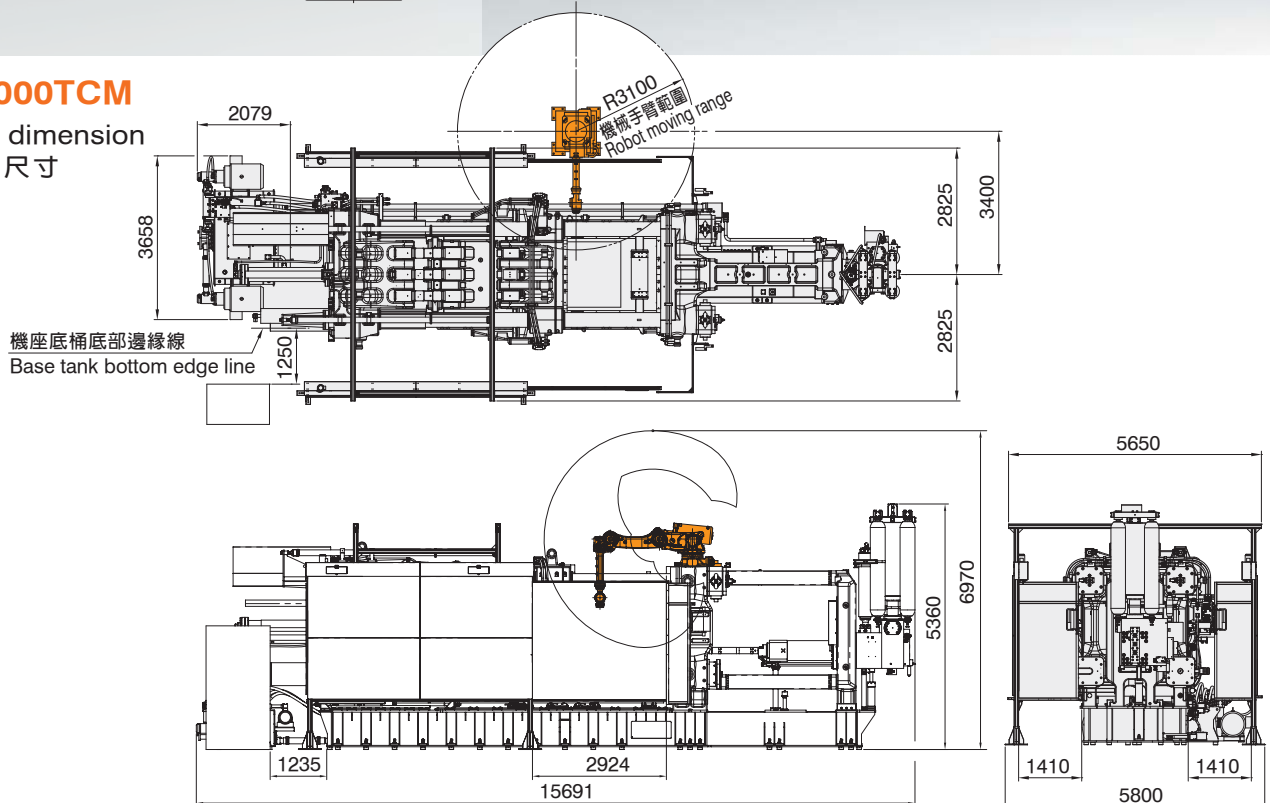
射出中心降 Shot position: 50, 250, 500 mm

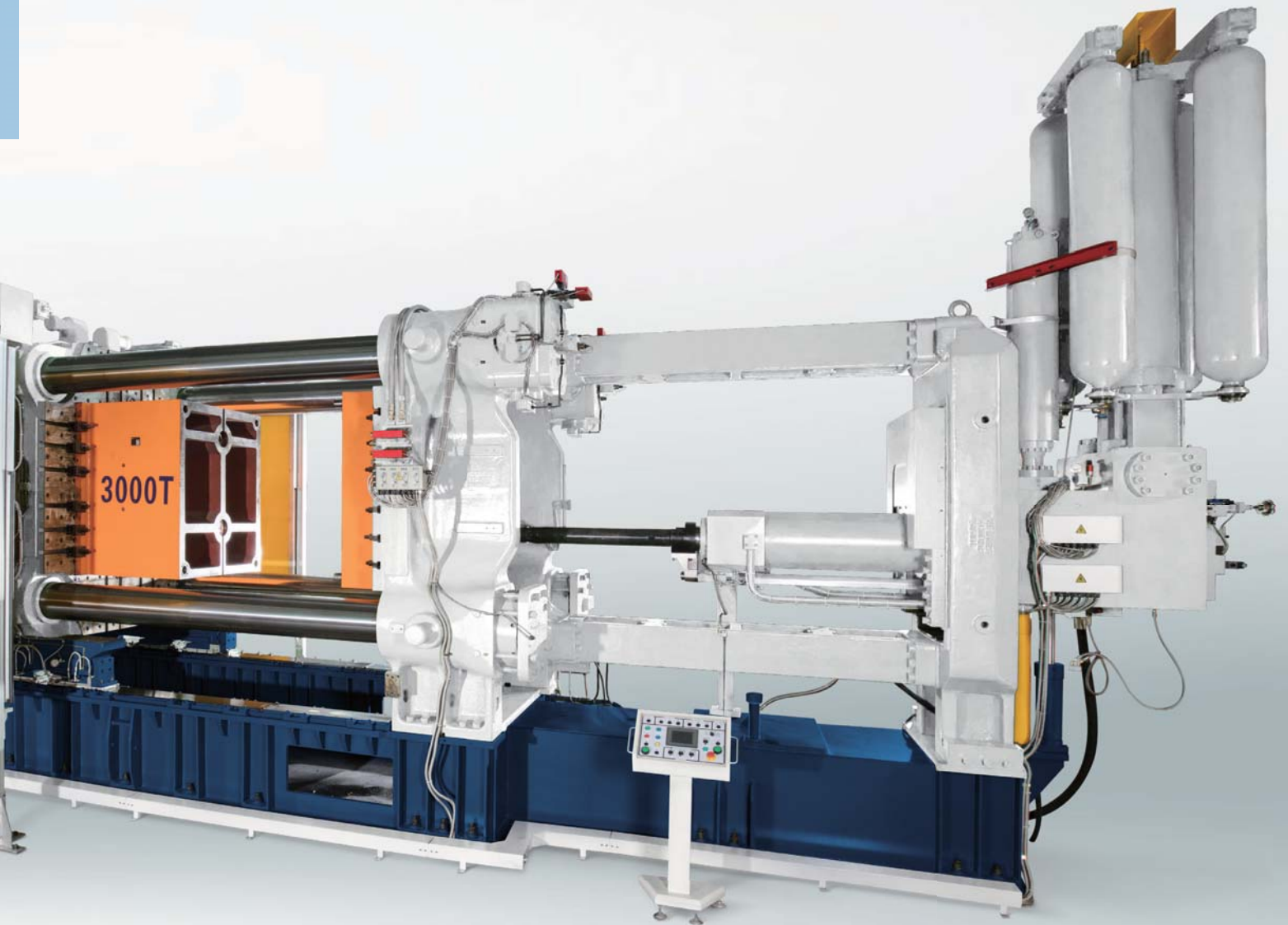
- $\phi 55 \times 40$ <用於押出孔或倒拉孔>
- $\phi 55 \times 40$ bore <For eject hole or Retract hole>



■ ZDC-3000TCM

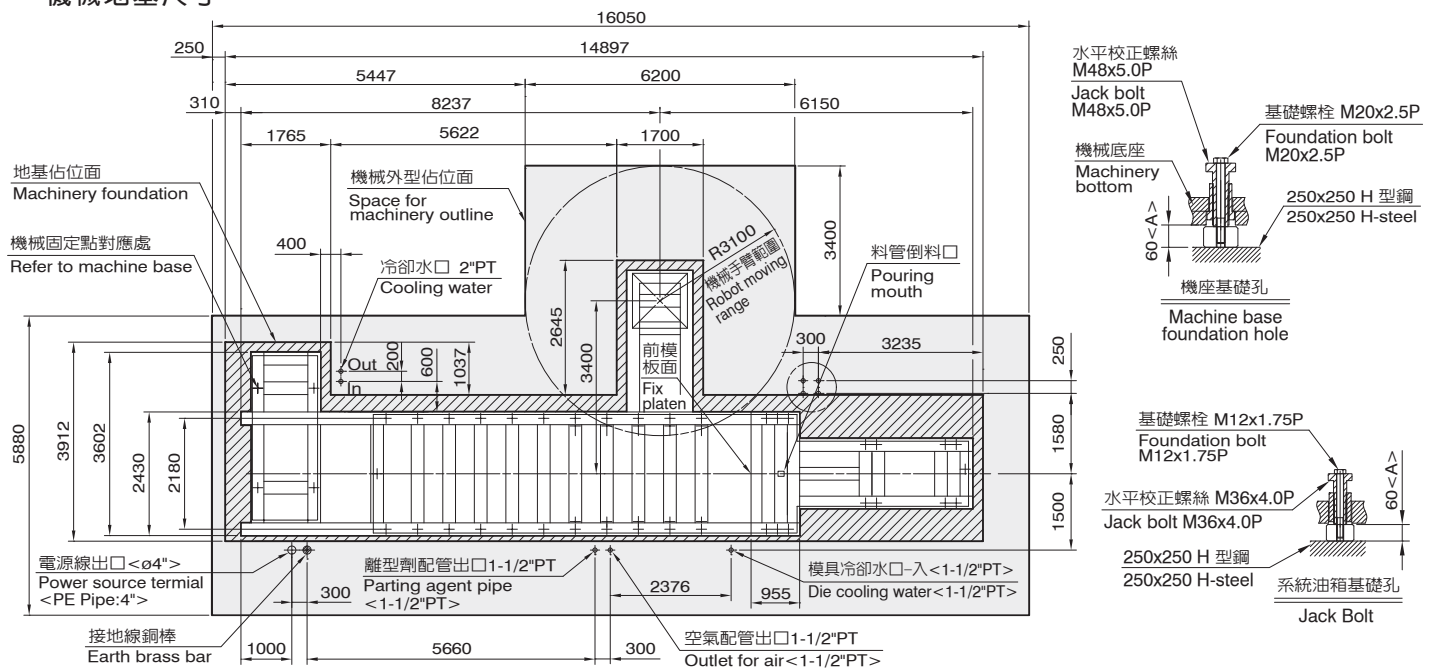
Machine dimension
機械外型尺寸





■ Foundation work diagram

機械地基尺寸



Specifications 規格表

MAIN ITEM 主要項目	unit 單位	ZDC-1600TCM				ZDC-1800TCM			
LOCKING UNIT 鎖模部分									
Locking force 鎖模力	ton	1600				1800			
Die platen dimension 模板外型	mm	1800 x 1970				1800 x 2060			
Tie bar distance 柱內尺寸	mm	1250 x 1250				1300 x 1300			
Die height distance 夾模厚度	mm	500~1400				550 ~ 1450			
Die stroke 開模行程	mm	1200				1350			
Tie bar diameter 導柱直徑	mm	ø250				ø260			
Die adjustment speed 調模速度	mm/min	66 (50HZ) / 79 (60HZ)				66 (50HZ) / 79 (60HZ)			
EJECTING UNIT 押出部分									
Ejecting force 押出力	ton	65				65			
Ejecting stroke 押出行程	mm	250				260			
CORE UNIT 中子部分									
Electromagnetic valve 中子電磁閥	PT	3/4" x 6 (sets)				3/4" x 6 (sets)			
Oil outlet 出油口	PT	3/4" x 12 (sets)				3/4" x 12 (sets)			
ELECTRIC SYSTEM 電器部分									
Motor capacity voltage 電動機容量電壓	KW	幫浦用 Pump 56.25 x 2 (sets)				幫浦用 Pump 56.25 x 2 (sets)			
Power source 電源	V	220/380/415 (50/60HZ)				220/380/415 (50/60HZ)			
Capacity of power source 電源容量	KVA	190				190			
SHOT UNIT 射出部分									
Shot force 射出力	ton	85~120				100~130			
Max. shot speed 最高速射	M/sec	6.0				6.0			
Plunger stroke 射出桿行程	mm	1100				1100			
Plunger tip penetration 射出桿凸長度	mm	550				550			
Plunger tip diameter 柱塞直徑	mm	最小Min. ø110	標準 Med. ø120 ø130		最大Max. ø140	最小Min. ø110	標準 Med. ø120 ø130		最大Max. ø140
Casting pressure 鑄造壓力	Kgf/cm ²	893~1263	750~1061	639~904	551~780	1052~1368	884~1150	753~979	649~845
Casting area 鑄造面積	cm ²	1793~1267	2133~1508	2504~1770	2904~2052	1711~1316	2036~1566	2390~1838	2772~2131
Net shot weight 實射出重量	Kgf	16.3	19.4	22.8	26.4	16.3	19.4	22.8	26.4
COOLING WATER SYSTEM 冷卻水部分									
Cooling water inlet pipe diameter 冷卻水出入口	PT	2"				2"			
Die cooling water outlet pipe diameter (in & out) 模具用冷卻水 (入口 & 出口)	PT	1-1/4" x 1 (入口 inlet) 2-1/2" x 1 (出口 outlet)				1-1/4" x 1 (入口 inlet) 2-1/2" x 1 (出口 outlet)			
Number of dia cooling water adjusting valve cooling water 模具冷卻水水閥門數	PC	15 (入口 inlet) 15 (出口 outlet)				20 (入口 inlet) 20 (出口 outlet)			
Die cooling water 模具冷卻水量	Ltr/min	100~150				100~150			
HYDRAULIC SYSTEM 油壓部分									
Die & ejecting pressure 開關模 & 押出壓力	Kgf/cm ²	180				180			
Max. intensified pressure of injection 最高射出增壓壓力	Kgf/cm ²	270~382				262~342			
Cycling oil volume 循環作動油量	Ltr	2296				2296			
Cooling water 冷卻水量	Ltr/min	150 (水溫 Water temp 25°C)				200 (水溫 Water temp 25°C)			
MACHINE MEASUREMENT 機械關係									
Machine size 機械外型尺寸 (BxWxH)	mm	13070 x 5780 x 6245				13378 x 6000 x 6247			
Machine weight 機械重量	ton	110				130			
TIE BAR PULLER MECHANISM 拆柱機構	Standard: Single tie bar puller 標準：單拆柱								

Note : Specifications and design features are subject to change without notice in advance.

ZDC-2000TCM				ZDC-2500TCM				ZDC-3000TCM				
2000				2500				3000				
1950 x 2170				2200 x 2350				2350 x 2650				
1350 x 1350				1550 x 1550				1700 x 1700				
650~1600				800~1800				1000~2000				
1400				1500				1500				
ø280				ø300				ø330				
66 (50HZ) / 79 (60HZ)				60~70 (油壓馬達 Hyd. motor)				60~70 (油壓馬達 Hyd. motor)				
65				70				90				
300				320				320				
3/4" x 6 (sets)				3/4" x 8 (sets)				3/4" x 8 (sets)				
3/4" x 12 (sets)				3/4" x 16 (sets)				3/4" x 16 (sets)				
幫浦用 Pump 56.25 x 2 (sets)				幫浦用 Pump 56.25 x 2 (sets)				幫浦用 Pump 75 x 2 (sets)				
220/380/415 (50/60HZ)				220/380/415 (50/60HZ)				220/380/415 (50/60HZ)				
190				190				200				
110~140				110~150				140~210				
6.0				6.0				6.0				
1100				1200				1200				
550				600				550				
最小Min. ø120	標準 Med.		最大Max. ø150	最小Min. ø130	標準 Med.		最大Max. ø160	最小Min. ø140	標準 Med.		最大Max. ø170	最大Max. ø180
	ø130	ø140			ø140	ø150			ø150	ø160		
971~1237	828~1054	714~909	622~792	828~1132	714~976	622~850	547~747	908~1364	791~1188	695~1044	616~925	549~825
2059~1617	2416~1898	2802~2201	3217~2527	3019~2209	3501~2562	4019~2941	4572~3347	3304~2199	3793~2525	4315~2873	4872~3243	5462~3636
19.4	22.8	26.4	30.3	24.8	28.8	33.1	37.6	28.8	33.1	37.6	42.5	47.6
2"				2"				2"				
1-1/4" x 1 (入口 inlet) 2-1/2" x 1 (出口 outlet)				1-1/4" x 1 (入口 inlet) 2-1/2" x 1 (出口 outlet)				1-1/4" x 1 (入口 inlet) 2-1/2" x 1 (出口 outlet)				
20 (入口 inlet) 20 (出口 outlet)				25 (入口 inlet) 25 (出口 outlet)				30 (入口 inlet) 30 (出口 outlet)				
150~200				150~200				250~300				
180				180				180				
289~368				243~332				227~341				
2296				2296				3453				
250 (水溫 Water temp 25°C)				300 (水溫 Water temp 25°C)				350 (水溫 Water temp 25°C)				
13645 x 5679 x 5275				14875 x 5974 x 5433				15691 x 5800 x 7300				
140				185				220				
Standard: Single tie bar puller 標準: 單拆柱							Standard: Twin tie bar puller 標準: 雙拆柱					

註：本公司對產品規格，設計特性均不斷研究改進，上述規格若有變更，恕不另行通知。



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