



**ALLIED MACHINE
& ENGINEERING**

Holemaking Solutions for Today's Manufacturing



Drilling



Reaming



Burnishing



Threading



Specials



Wohlhaupter[®]

▶ **BORING**

UPA Facing and Boring Heads

WOHLHAUPTER[®]

SECTION

B10-J

UPA Versatile Boring Heads

Wohlhaupter® UPA Versatile Boring Heads

UPA 3 | UPA 4 | UPA 5-S 6

▶ Diameter Range: 0.000" - 24.409" (0.00 mm - 620.00 mm)



Operation Facing and Boring

In 1936, the first model of the Wohlhaupter Universal facing and boring head was developed to launch the start of Wohlhaupter boring products. It became a staple to the boring industry.

Universal Facing and Boring heads are used on universal milling and boring machines, boring mills, and jig boring machines for machining stationary workpieces in individual and batch productions.

Applicable Industries



Aerospace



Agriculture



Automotive



Firearms



General
Machining



Oil & Gas



Renewable
Energy

Your safety and the safety of others is very important. This catalog contains important safety messages. Always read and follow all safety precautions.



This triangle is a safety hazard symbol. It alerts you to potential safety hazards that can cause tool failure and serious injury.

When you see this symbol in the catalog, look for a related safety message that may be near this triangle or referred to in the nearby text.

There are safety signal words also used in the catalog. Safety messages follow these words.

WARNING

WARNING (shown above) means that failure to follow the precautions in this message could result in tool failure and serious injury.

NOTICE means that failure to follow the precautions in this message could result in damage to the tool or machine but not result in personal injury.

NOTE and **IMPORTANT** are also used. These are important that you read and follow but are not safety-related.

Visit www.alliedmachine.com for the most up-to-date information and procedures.

Universal Versatile Boring Heads Table of Contents

Introduction

UPA Product Overview 2 - 3

UPA 3 Boring System

UPA 3 Boring Heads and Accessories 4 - 5

UPA 3 Shanks 6 - 7

UPA 4 and 5s6 Boring System

UPA 4 Boring Heads and Accessories 8 - 9

UPA 5-S 6 Boring Heads and Accessories 10 - 11

UPA 4 and 5-S 6 Shanks 12 - 13

Technical Data 14

Chip Production Values 15

UPA Boring System Diagrams 16 - 17

Series	Diameter Range	
	Imperial (inch)	Metric (mm)
UPA 3	0.000 - 10.236	0.00 - 260.00
UPA 4	0.000 - 15.748	0.00 - 400.00
UPA 5-S 6	0.000 - 24.409	0.00 - 620.00

UPA Product Overview



UPA Boring Head FACING AND BORING

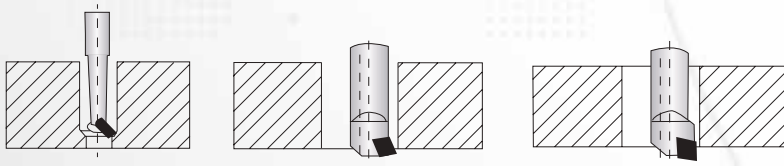
Universal Facing and Boring Heads

The versatile Wohlhaupter UPA boring heads can be used for facing, boring, and taper turning. They are available in right- or left-handed types.

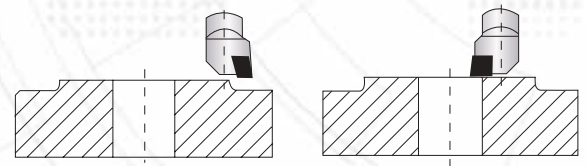
Precise and *versatile* boring heads.

- Diameter range: 0.000" - 24.409" (0.00 mm - 620.00 mm).
- Slide adjustment up to 4.410" (112.00 mm).
- Can be used in a variety of operations.

UNIVERSAL FACING and BORING Applications

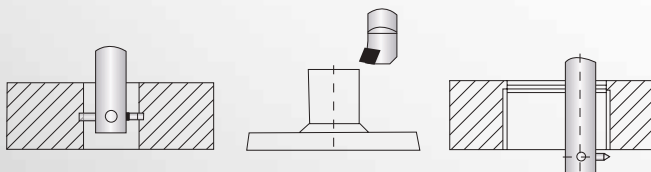


Boring with different tools



From inside
outward

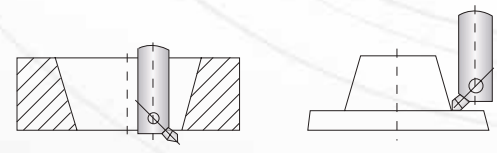
Facing
From outside
inward



Recessing

Outside Turning

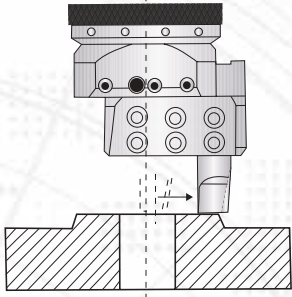
Thread Cutting



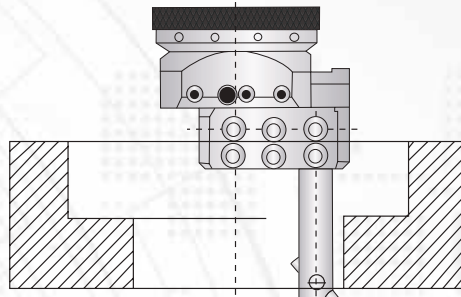
Taper Turning

UNIVERSAL

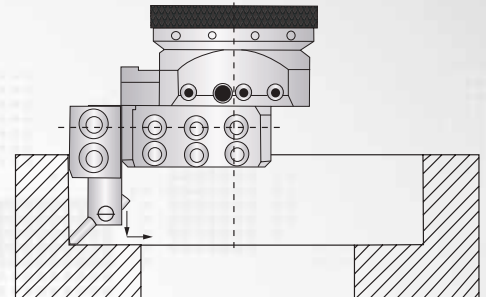
FACING and BORING Application Examples



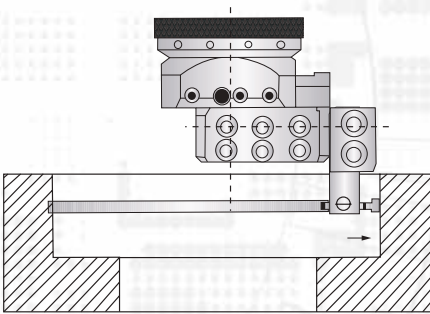
Facing with boring bar directly in slide



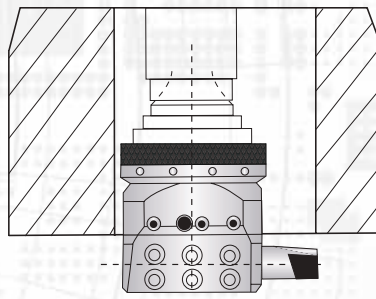
Boring with long boring bar



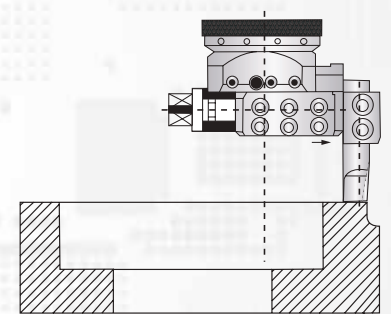
Boring and facing with short boring bar holder and a boring bar



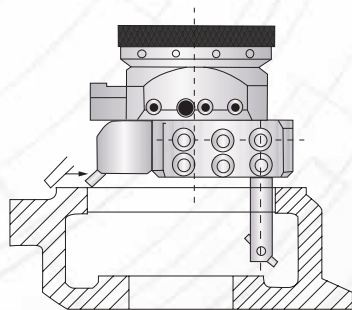
Recessing with short boring bar holder and a boring bar



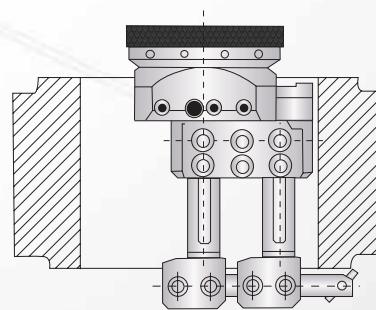
Deep hole boring with boring bar directly in slide



Large diameter facing with a long boring bar holder



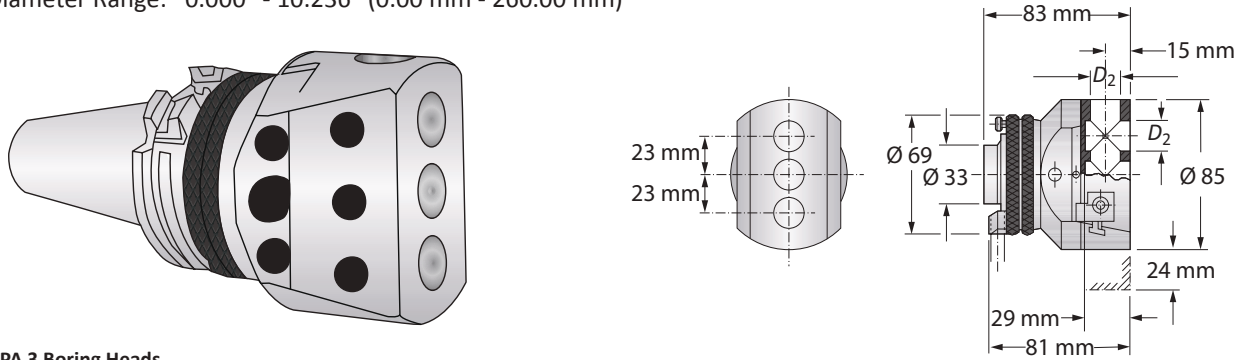
Facing in two areas with one boring bar and a boring bar holder



Facing the reverse side by using boring bar holders contained in attachment

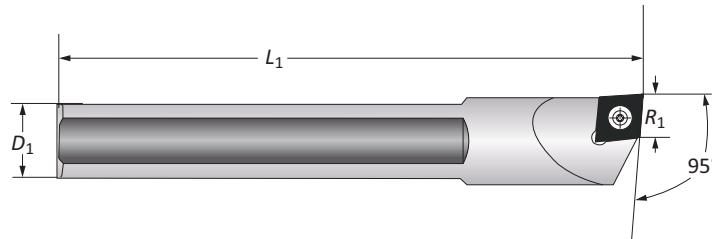
UPA 3 Boring Heads and Accessories

Diameter Range: 0.000" - 10.236" (0.00 mm - 260.00 mm)



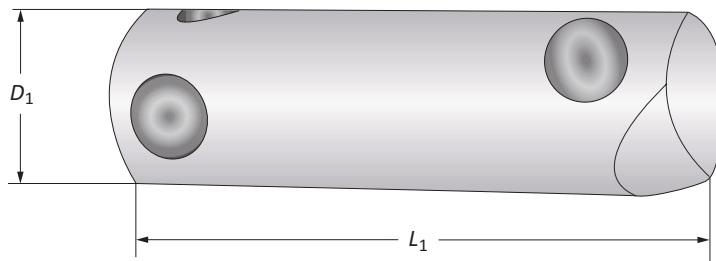
UPA 3 Boring Heads

Boring Head			
Boring Range	D_2	Weight	Part No.
i 0.000 - 10.234	0.750	4.629 (lbs)	006020
m 0.00 - 260.00	18.00	2.10 (kg)	005020



UPA 3 Boring Bars

Boring Bar						
D_1	L_1	R_1	Weight	Type	Insert Form	Part No.
i 0.750	3.149	0.531	0.220 (lbs)	Right	103	0750BFBR
0.750	3.149	0.531	0.220 (lbs)	Left	103	0750BFBL
m 18.00	80.00	13.50	0.10 (kg)	Right	103	081087
18.00	80.00	13.50	0.10 (kg)	Left	103	218088



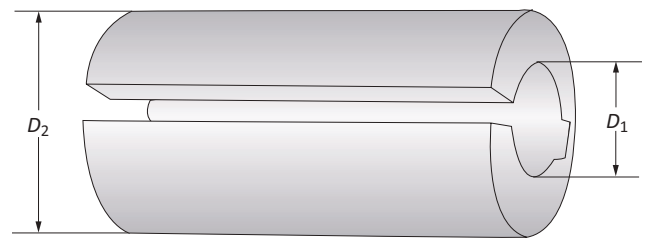
UPA 3 Boring Bars

Boring Bar				
D_1	L_1	Boring Depth	Designation	Part No.
i 0.750	2.362	1.181	B 306	074003
0.750	3.543	2.362	B 309	074004
0.750	4.724	3.543	B 312	074005
m 18.00	60.00	30.00	B 306	073003
18.00	90.00	60.00	B 309	073004
18.00	120.00	90.00	B 312	073005

i = Imperial (in)
m = Metric (mm)

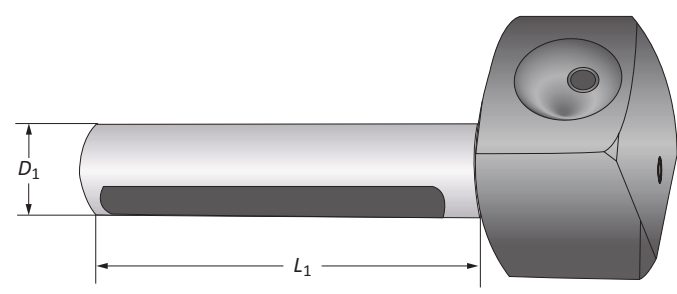
UPA 3 Accessories

Reducing Sleeves | Boring Bar Holders



UPA 3 Reducing Sleeves

Reducing Sleeve				
	D_2	D_1	Weight	Part No.
i	0.750	0.313	0.220 (lbs)	072104
	0.750	0.375	0.220 (lbs)	072105
	0.750	0.500	0.220 (lbs)	072106
	0.750	0.625	0.220 (lbs)	072107
m	18.00	8.00	0.10 (kg)	071103
	18.00	10.00	0.10 (kg)	071104
	18.00	12.00	0.10 (kg)	071105
	18.00	14.00	0.10 (kg)	071106

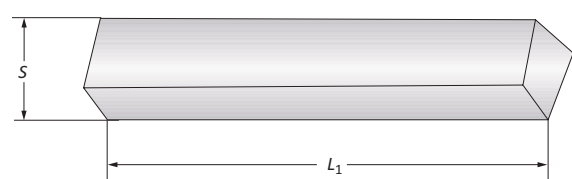


UPA 3 Boring Bar Holders

Boring Bar Holder					
	D_1	L_1	Working Diameter Range	Designation	Part No.
i	0.750	3.228	3.346 - 7.480	BH 308	076001
	0.750	4.724	6.299 - 10.236	BH 312	076002
m	18.00	82.00	85.00 - 190.00	BH 308	075001
	18.00	120.00	160.00 - 260.00	BH 312	075002

UPA 3 Square Turning Bit

Square Turning Bit				
	S	L_1	Weight	Part No.
i	0.236	1.574	0.035 (oz)	089001
m	6.00	40.00	11 (g)	089001



i = Imperial (in)
m = Metric (mm)

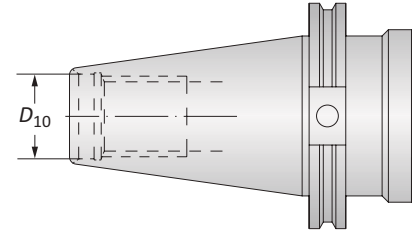
A
B
C
D
E
F
G
H
I
J
K
L
M
INDEX

UPA 3 Master Shanks

CAT | SK (DIN 69871) | DIN 2080

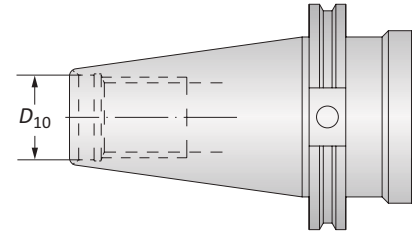
CAT Shanks

Shank				
	Style	D_{10}	Weight	Part No.
i	CAT 40	$\frac{5}{8}$ - 11	2.336 (lbs)	130001T013939
	CAT 50	1 - 8	7.054 (lbs)	130001T011624



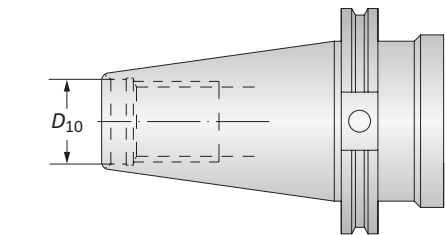
SK (DIN 69871)

Shank				
	Style	D_{10}	Weight	Part No.
m	ISO 40	M16	1.00 (kg)	130001T013815



DIN 2080

Shank				
	Style	D_{10}	Weight	Part No.
m	ISO 30	M12	0.40 (kg)	130001T003673
	ISO 40	M16 (chucking groove)	0.80 (kg)	130001T010229
	ISO 40	M16 (cap screw clamping)	1.00 (kg)	130001T003703
	ISO 50	M24	2.80 (kg)	130001T003704
	ISO 50	M24 (chucking groove)	2.80 (kg)	130001T010048



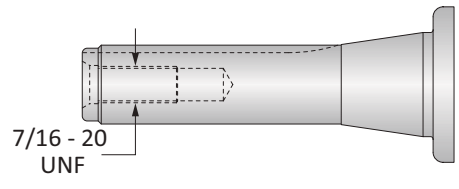
i = Imperial (in)
m = Metric (mm)

UPA 3 Master Shanks

R-8 | NMTB | Morse Taper | Norm Taper

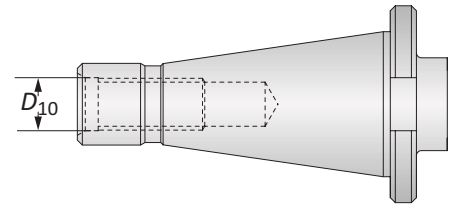
R-8 Shanks

Shank		Part No.
Weight		
i	1.058 (lbs)	130001T007166
m	0.48 (kg)	130001T007166



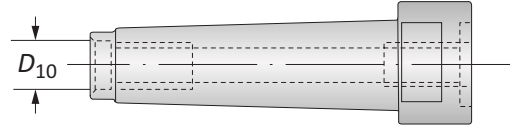
NMTB Shanks

Shank		Weight	Part No.
Style	D_{10}		
i	NMTB 40	1.984 (lbs)	130001T004498
	NMTB 50	5.798 (lbs)	130001T004480



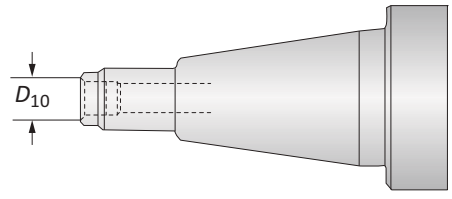
Morse Taper Shanks

Shank		Weight	Part No.
Style	Type		
i	MT 3	0.661 (lbs)	130001T004509
	MT 4	1.212 (lbs)	130001T003590
	MT 5	2.976 (lbs)	130001T003920
m	MT 3	0.30 (kg)	130001T004509
	MT 4	0.70 (kg)	130001T004256
	MT 4	1.00 (kg)	130001T004255



Norm Taper

Shank		Weight	Part No.
Style	D_{10}		
m	40 x S 20 x 2 with bolts DECKEL	1.00 (kg)	130001T005070



Differential Screw

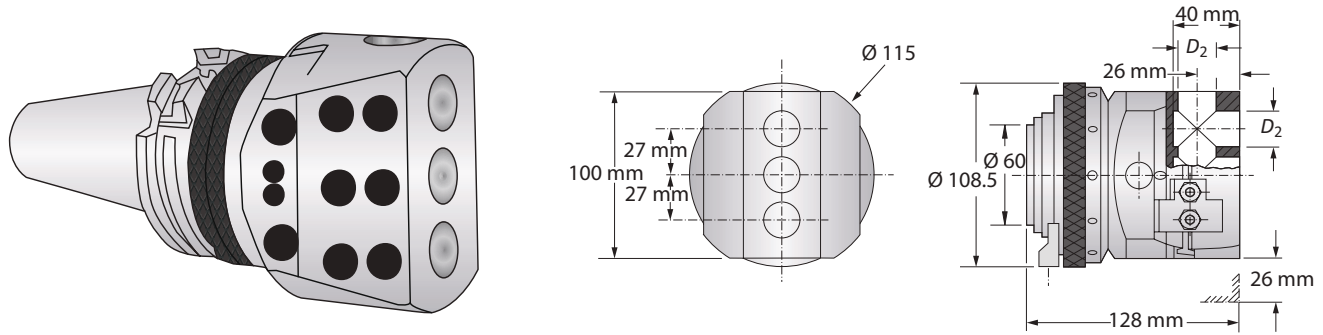
Thread	Weight	Part No.
i	M16 x 2	KW9208
m	M16 x 2	KW9208

i = Imperial (in)
m = Metric (mm)

A
B
C
D
E
F
G
H
I
J
K
L
M
INDEX

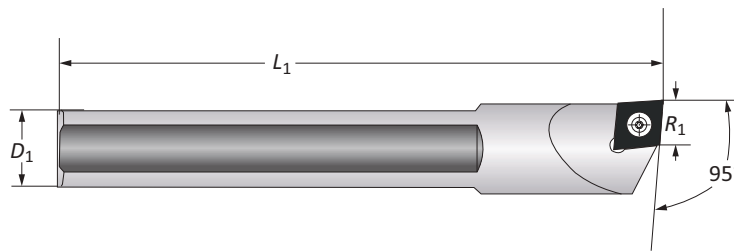
UPA 4 Boring Heads and Accessories

Diameter Range: 0.000" - 15.748" (0.00 mm - 400.00 mm)



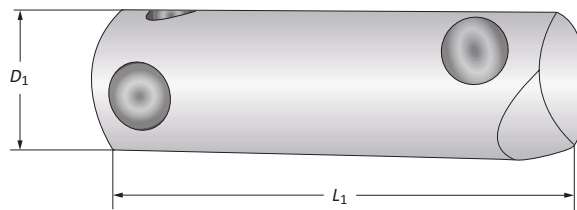
UPA 4 Boring Heads

		Boring Head		
	Boring Range	D ₂	Weight	Part No.
i	0.000 - 15.748	0.875	14.330 (lbs)	008020
m	0.00 - 400.00	22.00	6.50 (kg)	007020



UPA 4 Boring Bars

		Boring Bar					
	D ₁	L ₁	R ₁	Weight	Type	Insert Form	Part No.
i	0.875	3.937	0.531	0.220 (lbs)	Right	103	0875BFBR
	0.875	3.937	0.531	0.220 (lbs)	Right	103	0875BFBL
m	22.00	100.00	13.50	0.10 (kg)	Right	103	081092
	22.00	100.00	13.50	0.10 (kg)	Left	103	218089



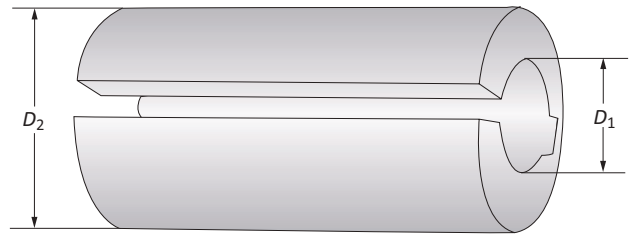
UPA 4 Boring Bars

		Boring Bar				
	D ₁	L ₁	Boring Depth	Designation	Part No.	
i	0.875	3.346	1.771	B 408	074006	
	0.875	4.921	3.346	B 412	074007	
	0.875	6.496	4.921	B 416	074008	
m	22.00	85.00	45.00	B 408	073006	
	22.00	125.00	85.00	B 412	073007	
	22.00	165.00	125.00	B 416	073008	

i = Imperial (in)
m = Metric (mm)

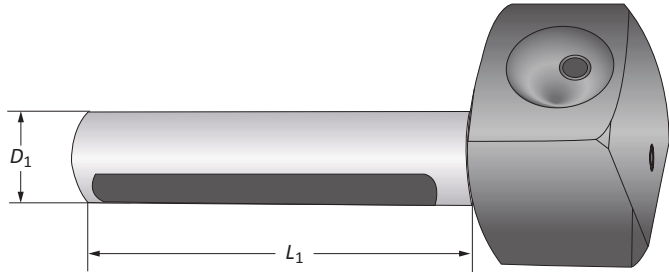
UPA 4 Accessories

Reducing Sleeves | Boring Bar Holders



UPA 4 Reducing Sleeves

		Reducing Sleeve			
	D_2	D_1	Weight	Part No.	
i	0.875	0.312	0.220 (lbs)	072108	
	0.875	0.375	0.220 (lbs)	072109	
	0.875	0.500	0.220 (lbs)	072110	
	0.875	0.625	0.176 (lbs)	072111	
	0.875	0.750	0.176 (lbs)	072112	
m	22.00	8.00	0.10 (kg)	071107	
	22.00	10.00	0.10 (kg)	071108	
	22.00	12.00	0.10 (kg)	071109	
	22.00	14.00	0.08 (kg)	071110	
	22.00	18.00	0.08 (kg)	071111	

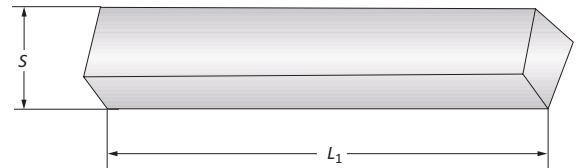


UPA 4 Boring Bar Holders

		Boring Bar Holder			
	D_1	L_1	Designation	Working Diameter Range	Part No.
i	0.875	3.858	BH 410	4.527 - 9.448	076003
	0.875	7.086	BH 418	8.661 - 15.748	076004
m	22.00	98.00	BH 410	115.00 - 240.00	075003
	22.00	180.00	BH 418	220.00 - 400.00	075004

UPA 4 Square Turning Bit

		Square Turning Bit		
	S	L_1	Weight	Part No.
i	0.236	1.574	0.035 (oz)	089001
m	6.00	40.00	11 (g)	089001

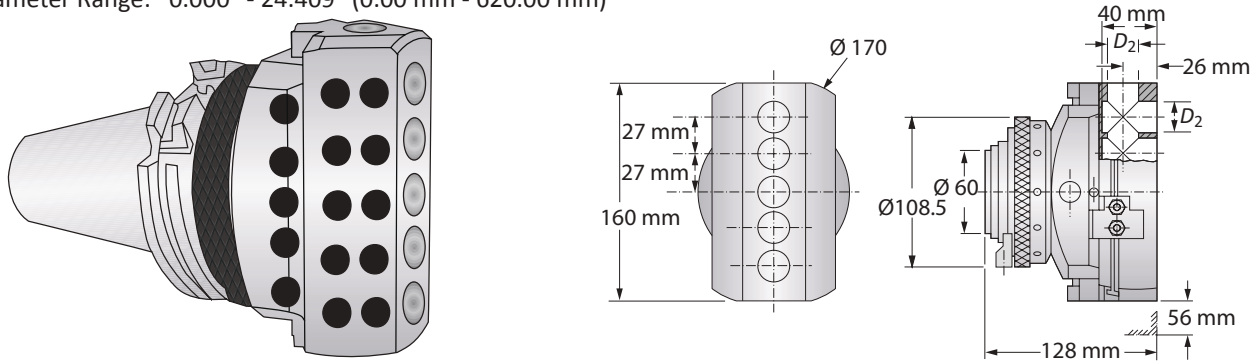


i = Imperial (in)
m = Metric (mm)

A
B
C
D
E
F
G
H
I
J
K
L
M
INDEX

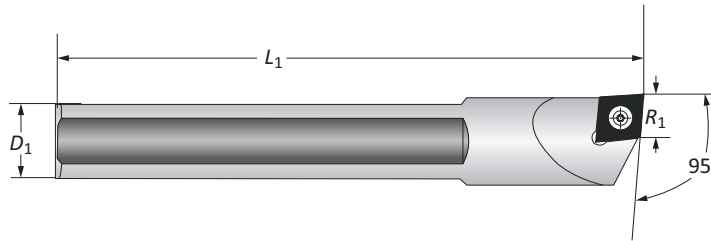
UPA 5-S 6 Boring Heads and Accessories

Diameter Range: 0.000" - 24.409" (0.00 mm - 620.00 mm)



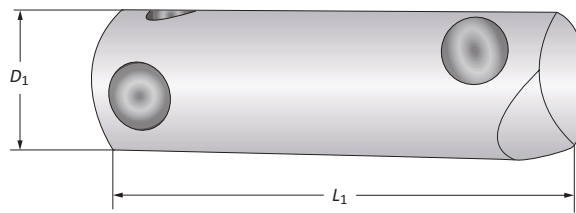
UPA 5-S 6 Boring Heads

		Boring Head		
	Boring Range	D ₂	Weight	Part No.
i	0.000 - 24.409	0.875	17.416 (lbs)	014020
m	0.00 - 620.00	22.00	7.90 (kg)	013020



UPA 5-S 6 Boring Bars

		Boring Bar					
	D ₁	L ₁	R ₁	Weight	Type	Insert Form	Part No.
i	0.875	3.937	0.531	0.220 (lbs)	Right	103	0875BFBR
	0.875	3.937	0.531	0.220 (lbs)	Left	103	0875BFBL
m	22.00	100.00	13.50	0.10 (kg)	Right	103	081092
	22.00	100.00	13.50	0.10 (kg)	Left	103	218089



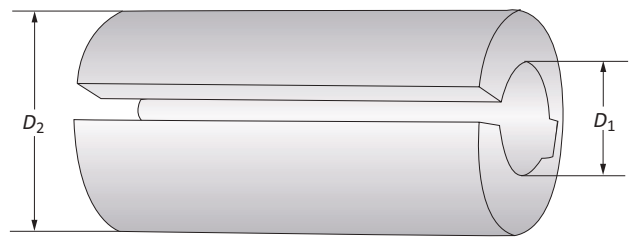
UPA 5-S 6 Boring Bars

		Boring Bar				
	D ₁	L ₁	Boring Depth	Designation	Part No.	
i	0.875	3.346	1.771	B 408	074006	
	0.875	4.921	3.346	B 412	074007	
	0.875	6.496	4.921	B 416	074008	
m	22.00	85.00	45.00	B 408	073006	
	22.00	125.00	85.00	B 412	073007	
	22.00	165.00	125.00	B 416	073008	

i = Imperial (in)
m = Metric (mm)

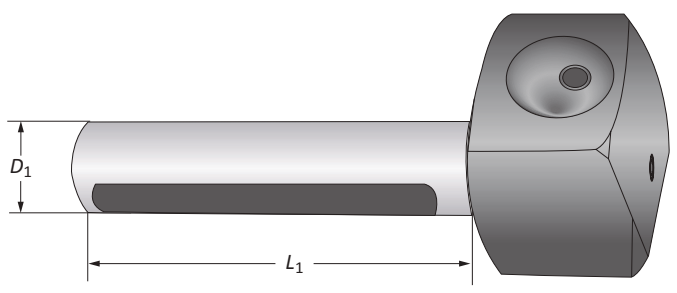
UPA 5-S 6 Accessories

Reducing Sleeves | Boring Bar Holders



UPA 5-S 6 Reducing Sleeves

		Reducing Sleeve			
		D_2	D_1	Weight	Part No.
i		0.875	0.312	0.220 (lbs)	072108
		0.875	0.375	0.220 (lbs)	072109
		0.875	0.500	0.220 (lbs)	072110
		0.875	0.625	0.176 (lbs)	072111
		0.875	0.750	0.176 (lbs)	072112
m		22.00	8.00	0.10 (kg)	071107
		22.00	10.00	0.10 (kg)	071108
		22.00	12.00	0.10 (kg)	071109
		22.00	14.00	0.08 (kg)	071110
		22.00	18.00	0.08 (kg)	071111

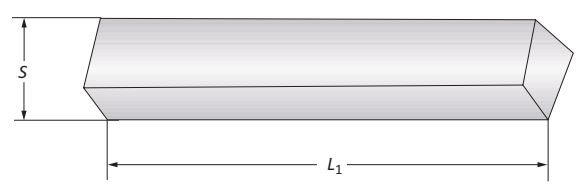


UPA 5-S 6 Boring Bar Holders

		Boring Bar Holder				
		D_1	L_1	Designation	Working Diameter Range	Part No.
i		0.875	5.039	BH 513	4.724 - 15.748	076003
		0.875	9.055	BH 523	10.630 - 24.408	076004
m		22.00	228.00	BH 513	120.00 - 400.00	075003
		22.00	230.00	BH 523	270.00 - 620.00	075004

UPA 5-S 6 Square Turning Bit

		Square Turning Bit			
		S	L_1	Weight	Part No.
i		0.236	1.574	0.035 (oz)	089001
m		6.00	40.00	11 (g)	089001



i = Imperial (in)
m = Metric (mm)

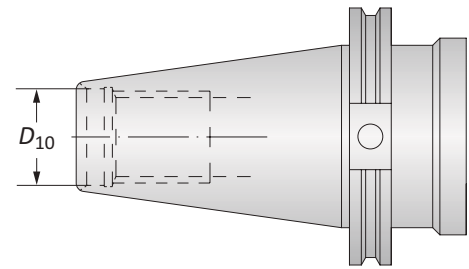
A
B
C
D
E
F
G
H
I
J
K
L
M
INDEX

UPA 4 and 5-S 6 Master Shanks

CAT | SK (DIN 69871) | DIN 2080

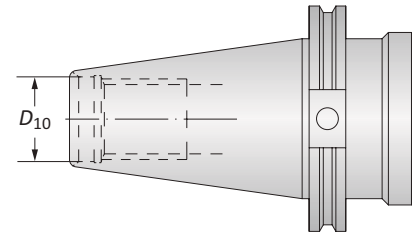
CAT Shanks

Shank				
	Style	D_{10}	Weight	Part No.
i	CAT 40	5/8 - 11	3.196 (lbs)	130005T013939
	CAT 50	1 - 8	7.054 (lbs)	130005T011624



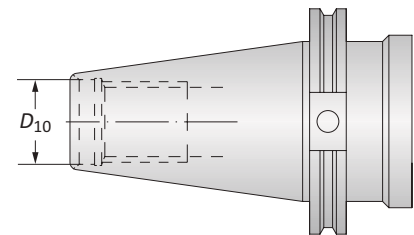
SK (DIN 69871)

Shank				
	Style	D_{10}	Weight	Part No.
m	ISO 40	M16	1.60 (kg)	130005T013815
	ISO 40	M24	3.00 (kg)	130005T013960



DIN 2080

Shank				
	Style	D_{10}	Weight	Part No.
m	ISO 40	M16 (cap nut clamps)	1.20 (kg)	130005T003703
	ISO 50	M24	2.90 (kg)	130005T003704
	ISO 40	M16 (chucking groove)	1.20 (kg)	130005T010229
	ISO 50	M24 (chucking groove)	3.00 (kg)	130005T010048



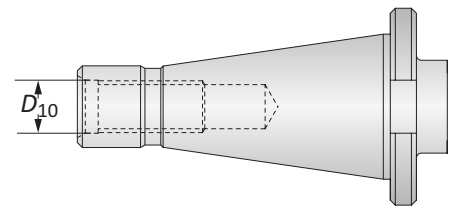
i = Imperial (in)
m = Metric (mm)

UPA 4 and 5-S 6 Master Shanks

NMTB | Morse Taper | Norm Taper

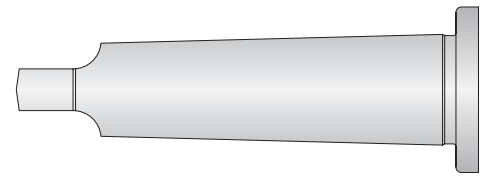
NMTB Shanks

Shank				
	Style	D_{10}	Weight	Part No.
i	NMTB 40	$\frac{5}{8}$ - 11	2.866 (lbs)	130005T004498
	NMTB 40	$\frac{5}{8}$ - 11	2.866 (lbs)	130005T010327
	NMTB 50	1 - 8	6.393 (lbs)	130005T004480



Morse Taper Shanks (DIN 1806)

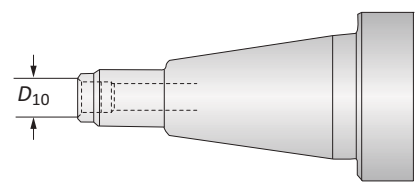
Shank			
	Style	Weight	Part No.
i	MT 4	1.895 (lbs)	130005T003590*
	MT 5	3.639 (lbs)	130005T003920
m	MT 4	0.86 (kg)	130005T003590*
	MT 5	1.65 (kg)	130005T003920



*Shank can only be used with UPA 4 boring heads.

Norm Taper

Shank				
	Style	D_{10}	Weight	Part No.
m	40 x S 20 x 2 with bolts DECKEL	M12 x 1	1.20 (kg)	130005T005070



Differential Screw

	Thread	Weight	Part No.
i	M20 x 2.5	0.154 (lbs)	KW9209
m	M20 x 2.5	0.07 (lbs)	KW9209

i = Imperial (in)
m = Metric (mm)

A
B
C
D
E
F
G
H
I
J
K
L
M
INDEX



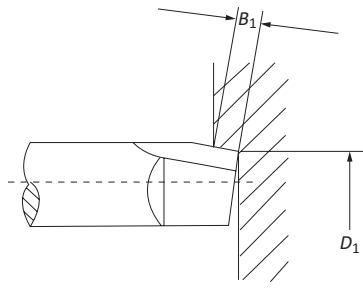
Technical Information

Technical Data

Type	UPA 3	UPA 4	UPA 5-S 6
Working accuracy	±0.005	±0.005	±0.005
Diameter range	25.00	35.00	45.00
MT shank	3.00	4.00	5.00
ISO shank	30.00	40.00	40.00
Facing and boring range	0.00 - 260.00	0.00 - 400.00	0.00 - 620.00
Adjustment of slide (max)	48.00	52.00	112.00
Self-activated feed of slide per revolution	0.05	0.02, 0.04, 0.06, 0.08, 0.10, 0.12, 0.14, 0.16, 0.18, 0.20, 0.22, 0.24	0.02, 0.04, 0.06, 0.08, 0.10, 0.12, 0.14, 0.16, 0.18, 0.20, 0.22, 0.24
^m Fine adjustment of one division	0.01	0.01	0.01
Fine adjustment of one revolution	1.00	0.40	0.40
Rapid return per revolution	1.00	–	–
Rapid return setting per revolution	–	6.00	6.00
Largest diameter of slide	85.00	115.00	170.00
Height of boring head without shank	81.00	128.00	128.00
Tool locations in slide	18.00	22.00	22.00
Max permissible revolutions	1000	600	600
End cut off accuracy	±0.05	±0.05	±0.05

ⁱ = Imperial (in)
^m = Metric (mm)

Chip Production Values



Chip Production Values

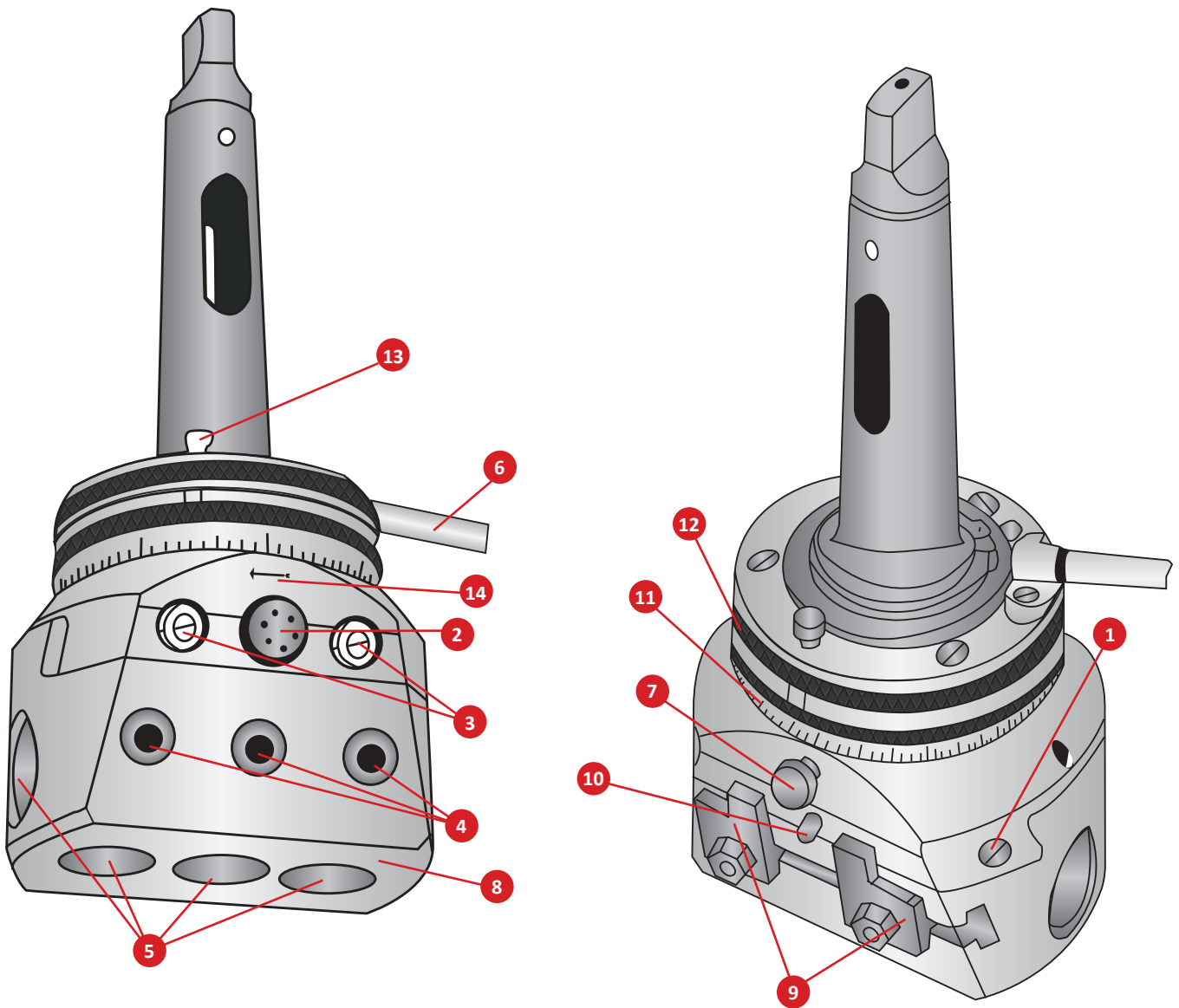
Chip Cutting Guide	Type	UPA 3	UPA 4	UPA 5-S 6
Max load	KW	2.50	7.00	9.50
With slide feed	mm/rev.	0.05	0.08, 0.12, 0.24	0.08, 0.12, 0.24
For smaller working \varnothing	D_1	60.00	150.00	200.00
m Maximum width of chip	B_1	4.00	7.00, 6.00, 4.00	8.00, 7.00, 5.00
Maximum working \varnothing	D_1	260.00	400.00	500.00 / 620.00
Max width of chip without reinforcement rings	B_1	2.00	2.20, 2.00, 1.50	2.50, 2.00, 1.50
Max width of chip with reinforcement rings*	B_1	-	4.50, 4.00, 3.00	5.00, 4.00, 3.00

*By using the reinforcement rings contained in the normal attachment, chip cutting capacity is increased by 100%.

i = Imperial (in)
m = Metric (mm)

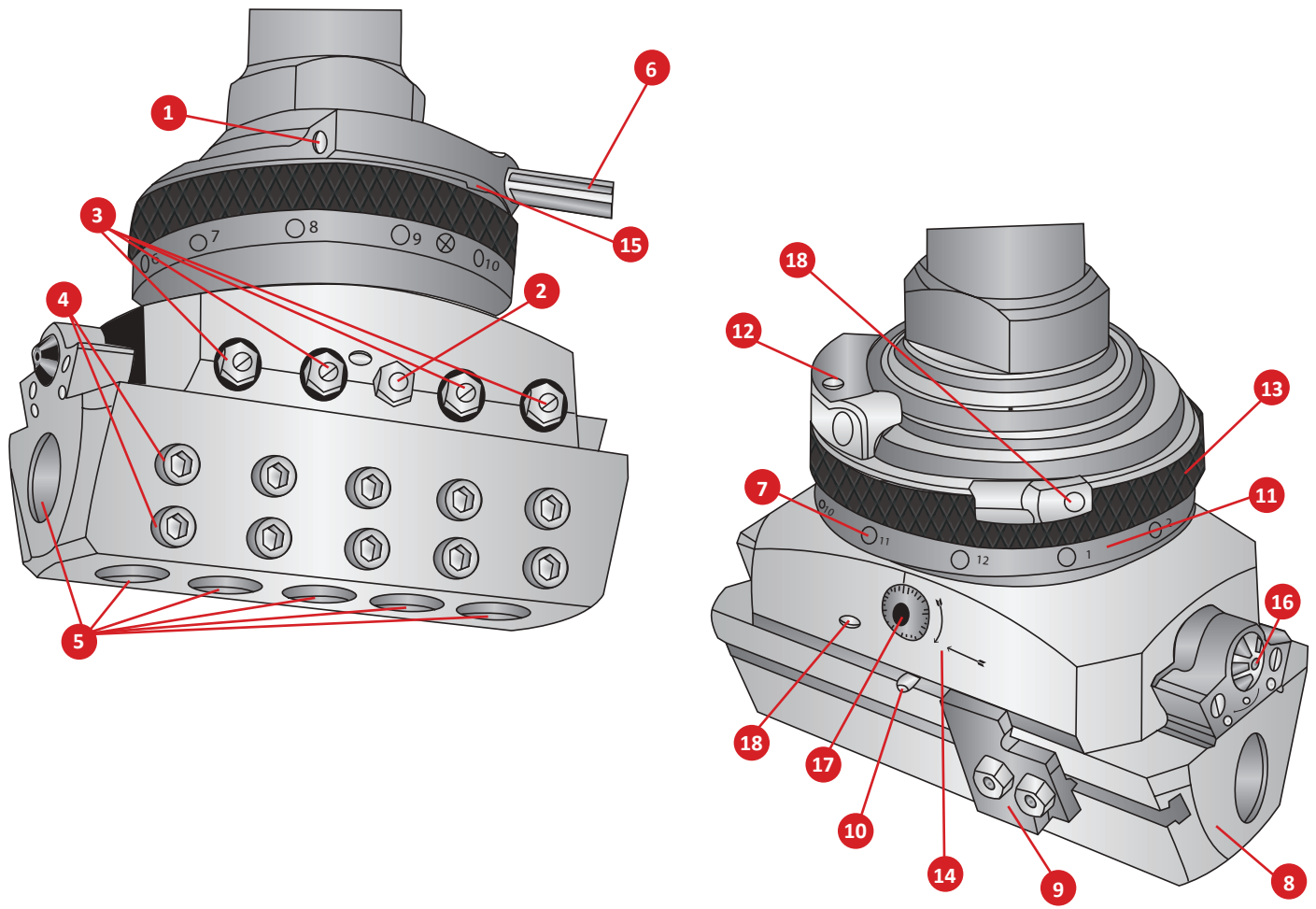
A
B
C
D
E
F
G
H
I
J
K
L
M
INDEX

UPA 3 Boring Head Diagram



No.	Part	No.	Part
1	Regulating screw	8	Slide
2	Locking screw	9	Stop
3	Setting screws	10	Fixed pin
4	Fastening screw	11	Scale ring
5	Tool post holes	12	Holding ring
6	Holding rod	13	Button for return movement
7	Feed button	14	Arrow

UPA 4 / 5-S 6 Boring Heads Diagram



No.	Part	No.	Part
1	Regulating screw	10	Fixed pin
2	Locking screw	11	Scale ring
3	Setting screws	12	Retaining pin
4	Fastening screws	13	Feed ring
5	Tool post holes	14	Arrow
6	Holding rod	15	Recess
7	Feed buttons	16	Quick setting dial
8	Slide with rotation bores	17	Fine setting dial
9	Stop	18	Release ring

A
B
C
D
E
F
G
H
I
J
K
L
M
INDEX

Guaranteed Test / Demo Application Form

Distributor PO #

The following must be filled out completely before your test will be considered.

IMPORTANT: For processing, send purchase order to your Allied Field Sales Engineer (FSE). Please clearly mark the paperwork as "Test Order."

Distributor Information

Company Name: _____
Contact: _____
Account Number: _____
Phone: _____
Email: _____

End User Information

Company Name: _____
Contact: _____
Industry: _____
Phone: _____
Email: _____

Current Process List all tooling, coatings, substrates, speeds and feeds, tool life, and any problems you are experiencing.

Test Objective List what would make this a successful test (i.e. penetration rate, finish, tool life, hole size, etc.).

Application Information

Hole Diameter: _____ in/mm Tolerance: _____ Material: _____
(4150, A36, cast iron, etc.)
Preexisting Diameter: _____ in/mm Depth of Cut: _____ in/mm Hardness: _____
(BHN, Rc)
Required Finish: _____ RMS State: _____
(Casting, hot rolled, forging)

Machine Information

Machine Type: _____ Builder: _____ Model #: _____
(Lathe, screw machine, machine center, etc.) (Haas, Mori Seiki, etc.)
Shank Required: _____ Power: _____ HP/KW
(CAT50, Morse taper, etc.)
Rigidity: Orientation: Tool Rotating: Thrust: _____ lbs/N
 Excellent Vertical Yes
 Good Horizontal No
 Poor

Coolant Information

Coolant Delivery: _____ Coolant Pressure: _____ PSI / bar
(Through tool, flood)
Coolant Type: _____ Coolant Volume: _____ GPM / LPM
(Air mist, oil, synthetic, water soluble, etc.)

Requested Tooling

QTY	Item Number

QTY	Item Number



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Warranty Information



Allied Machine & Engineering ("Allied Machine") warrants to original equipment manufacturers, distributors, industrial and commercial users of its products for one year from the original date of sale that each new product manufactured or supplied by Allied Machine shall be free from defects in material and workmanship.

Allied Machine's sole and exclusive obligation under this warranty is limited to, at its option, without additional charge, replacing or repairing this product or issuing a credit. For this warranty to be applied, the product must be returned freight prepaid to the plant designated by an Allied Machine representative and which, upon inspection, is determined by Allied Machine to be defective in material and workmanship.

Complete information as to operating conditions, machine, setup, and the application of cutting fluid should accompany any product returned for inspection. This warranty shall not apply to any Allied Machine products which have been subjected to misuse, abuse, improper operating conditions, improper machine setup or improper application of cutting fluid or which have been repaired or altered if such repair or alteration, in the judgement of Allied Machine, would adversely affect the performance of the product.

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