



nano

NIHS | M

 100% SWISS MADE



®

**THREADING**  
**TECHNOLOGY**

## nano THREAD CUTTING

*Taraud coupant en HSSE-PM  
et en carbure monobloc*  
Thread cutting tap in HSSE-PM  
and in solid carbide



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## nano THREAD FORMING

*Taraud à refouler en HSSE-PM*  
Thread forming tap in HSSE-PM



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## nano THREAD WHIRL CUTTER

*Fraise à tourbillonner*  
Thread whirl cutter



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## nano THREAD PLUG GAUGES

*Jauge tampon filetée*  
Thread plug gauges



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## nano THREAD RING GAUGES

*Jauge bague filetée*  
Thread ring gauges



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## nano SOFT RIGID TAPPING

*Mandrin de taraudage*  
Tapping chucks



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# TABELLE D'UTILISATION - APPLICATION CHART

## TARAUD COUPANT THREAD CUTTING TAPS

## TARAUD À REFOULER THREAD FORMERS

### Utilisation - Use

- S** Optimale avec huile de coupe      **E** Optimale avec émulsion      **L** Optimale avec air
- S** Fonctionnelle avec huile de coupe      **E** Fonctionnelle avec émulsion      **L** Fonctionnelle avec air
- S** Optimal with cutting oil      **E** Optimal with emulsion      **L** Optimal with air
- S** Suitable with cutting oil      **E** Suitable with emulsion      **L** Suitable with air

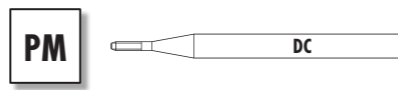
### Classification des matières - Material classification

Groupes de matières Material groups	Désignation des matières	Material designation	Dureté Hardness (HB)	Résistance Tensile strength Rm (N/mm <sup>2</sup> )	Allongement Elongation A (%)
10 Aciers Steels	11 Aciers de décolletage	Free-cutting steels	< 200	< 700	< 10
	12 Aciers de construction / cémentation	Structural / cementation steels	< 200	< 700	< 30
	13 Aciers au carbone	Carbon steels	< 300	< 1000	< 20
	14 Aciers alliés < 850 N/mm <sup>2</sup>	Alloy steels < 850 N/mm <sup>2</sup>	< 250	< 850	< 30
	15 Aciers alliés / traités > 850 - < 1150 N/mm <sup>2</sup>	Alloy steels hard./temp. > 850 - < 1150 N/mm <sup>2</sup>	> 250	> 850	< 30
20 Aciers inoxydables Stainless Steels	21 Aciers inoxydables / soufrés	Free machining stainless steels	< 250	< 850	< 25
	22 Austénitiques	Austenitic stainless steels	< 250	< 850	> 20
	23 Ferritiques et martensitiques < 850 N/mm <sup>2</sup>	Ferritic and martensitic < 850 N/mm <sup>2</sup>	< 250	< 850	> 20
	24 Ferritiques et martens. > 850 - < 1150 N/mm <sup>2</sup>	Ferritic and martens. > 850 - < 1150 N/mm <sup>2</sup>	> 250	> 850	> 15
40 Titan - Titanium	41 Titane pur	Pure titanium	< 250	< 850	> 20
	42 Alliage au Titane	Titanium alloys	> 250	> 850	< 20
50 Nickel - Nickel	51 Alliage au Nickel 1 < 850 N/mm <sup>2</sup>	Nickel alloys 1 < 850 N/mm <sup>2</sup>	< 250	< 850	> 25
60 Cuivre Copper	61 Cuivre pur (électrolytique)	Pure copper (electrolytic copper)	< 120	< 400	> 12
	62 Laiton, bronze (copeaux courts)	Short chip brass, phosphor bronze, gun metal	< 200	< 700	< 12
	63 Laiton (copeaux longs)	Long chip brass	< 200	< 700	> 12
70 Aluminium Magnésium Aluminium Magnesium	71 Al non allié	Al unalloyed	< 100	< 350	> 15
	72 Al allié Si < 1.5 %	Al alloyed Si < 1.5 %	< 150	< 500	> 15
	73 Al allié Si > 1.5 % - < 10 %	Al alloyed Si > 1.5 % - < 10 %	< 120	< 400	< 15
	74 Al allié Si > 10 %, Alliages Magnésium	Al alloyed Si > 10 %, Mg-Alloys	< 120	< 400	< 10
80 Plastique Plastic comp.	81 Matières thermoplastiques	Thermoplastics	-	-	-
	83 Matières plastiques renforcées par fibres	Glass fibre reinforced plastics	-	-	-
90 Métaux précieux Precious metal	91 Or jaune	Yellow Gold	-	-	-
	92 Or rose	Red Gold	-	-	-
	93 Or gris	White Gold	-	-	-
	94 Argent	Silver	-	-	-

Vc (m/min)	TAN40				TAN50				Vc (m/min)	CMS50	Vc (m/min)	FA80VS/83VS		
	TAN40	TAN40VS	TAN50	TAN50VS	TAN40	TAN40VS	TAN50	TAN50VS				FA80VS	FA83VS	
11	0.75 - 4		<b>S E</b>			<b>S E</b>			11	<b>S E</b>	11	1 - 6	<b>S</b>	<b>S</b>
12	0.75 - 4		<b>S E</b>			<b>S E</b>			12		12	1 - 6	<b>S E</b>	<b>S E</b>
13	0.75 - 4		<b>S E</b>			<b>S E</b>			13		13	1 - 6	<b>S E</b>	<b>S E</b>
14	0.75 - 4		<b>S E</b>			<b>S E</b>			14		14	1 - 6	<b>S E</b>	<b>S E</b>
15									15		15	1 - 6	<b>S</b>	<b>S</b>
21	0.75 - 4		<b>S E</b>			<b>S E</b>			21		21	1 - 6	<b>S E</b>	<b>S E</b>
22									22		22	1 - 6	<b>S E</b>	<b>S E</b>
23									23		23	1 - 6	<b>S E</b>	<b>S E</b>
24									24		24	1 - 6	<b>S</b>	
41	0.75 - 4		<b>S</b>			<b>S</b>			41		41			
42									42		42			
51									51		51	1 - 6	<b>S</b>	
61									61		61	1 - 6	<b>S E</b>	<b>S E</b>
62	0.75 - 4	<b>S E</b>	<b>S E</b>	<b>S E</b>	<b>S E</b>	<b>S E</b>	<b>S E</b>		62	<b>L B S</b>	62			
63	0.75 - 4	<b>S E</b>		<b>S E</b>					63	<b>L B S</b>	63	1 - 6	<b>S E</b>	<b>S E</b>
71	0.75 - 4		<b>S</b>			<b>S</b>			71		71	1 - 6	<b>S E</b>	<b>S E</b>
72	0.75 - 4		<b>S E</b>			<b>S E</b>			72		72	1 - 6	<b>S E</b>	<b>S E</b>
73	0.75 - 4		<b>S E</b>			<b>S E</b>			73	<b>S E</b>	73	1 - 6	<b>S E</b>	<b>S E</b>
74	0.75 - 4		<b>S E</b>			<b>S E</b>			74	<b>S E</b>	74			
81	0.75 - 4	<b>E</b>	<b>E</b>	<b>E</b>	<b>E</b>				81		81			
83	0.75 - 4								83	<b>L</b>	83			
91	0.75 - 4	<b>S E</b>		<b>S E</b>					91	<b>S E</b>	91	1 - 6	<b>S E</b>	<b>S E</b>
92	0.75 - 4		<b>S E</b>			<b>S E</b>			92	<b>S E</b>	92	1 - 6	<b>S E</b>	<b>S E</b>
93	0.75 - 4		<b>S</b>			<b>S</b>			93	<b>S E</b>	93	1 - 6	<b>S</b>	
94	0.75 - 4		<b>S E</b>			<b>S E</b>			94	<b>S E</b>	94	1 - 6	<b>S E</b>	<b>S E</b>

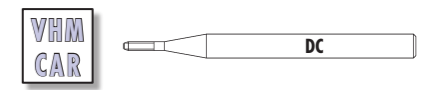
### Pictogrammes - Pictographs

- PM** HSSE-PM      **VHM CAR** Carbure monobloc
- HSSE-PM      Solid carbide
- Tarauds à refoiler      **R15** Goujures hélicoïdales, hélice à 15° à droite
- Thread former      15° right hand spiral flutes
- Nombre de lèvres (Z)      **R25** Goujures hélicoïdales, hélice à 25° à droite
- Number of flutes (Z)      25° right hand spiral flutes
- Diamètre d'avant-trou      **L20** Goujures hélicoïdales, hélice à 20° à gauche
- Core hole diameter      20° left hand spiral flutes
- E** 1.5 - 2 filets d'entrée, forme E      Trou traversant < 2 x D, copeaux longs
- 1.5 x P 1.5 - 2 chamfered threads, form E      Through hole < 2 x D, long chipping materials
- C** 2 - 3 filets d'entrée, forme C      Trou borgne < 2 x D, copeaux longs
- 2.5 x P 2 - 3 chamfered threads, form C      Blind hole < 2 x D, long chipping materials
- 4HX** Classe de tolérance 4HX      Trou traversant / borgne, copeaux longs < 2.5 x D
- Tolerance class 4HX      Through / blind hole, long chipping materials < 2.5 x D
- NIHS** Classe de tolérance NIHS      Trou traversant / borgne, copeaux courts < 3 x D
- Norm of Swiss Watch Industry      Through / blind hole, short chipping materials < 3 x D
- Trou traversant / borgne < 2.5 x D
- Through / blind hole < 2.5 x D
- VS** Protection contre l'usure **DC**      "Entre" / "N'entre pas"
- DC** wear-protective coating      "Go" / "No-Go"
- Certificat
- Certificate

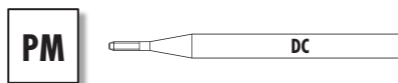


nano THREAD CUTTING								TAN40	TAN40VS	TAN50	TAN50VS
<p>TAN40  Packing 10 </p> <p>TAN40VS  VS Packing 10 </p> <p>TAN50  Packing 10 </p> <p>TAN50VS  VS Packing 10 </p>											
								<b>4H</b>	<b>4H</b>	<b>4H</b>	<b>4H</b>
$\varnothing d_1$ M	P mm	$l_1$ mm	$l_2$ mm	$d_2$ mm			ID	ID	ID	ID	
0.5	0.125	25	1.5	2.0	3	0.41 *	161817	161748	161818	161749	
0.6	0.150	25	1.8	2.0	3	0.50 *	152512	152511	152545	151766	
0.7	0.175	25	2.1	2.0	3	0.58 *	152516	152515	152548	152547	
0.8	0.200	25	2.4	2.0	3	0.66 *	152520	152519	152552	152551	
0.9	0.225	25	2.7	2.0	3	0.74 *	152524	152523	152555	152554	
1.0	0.250	40	3.0	2.5	3	0.75 *	152528	152527	152558	151557	
1.2	0.250	40	3.6	2.5	3	0.95 *	152531	151463	152562	152561	
1.4	0.300	40	4.2	2.5	3	1.10 *	152534	151756	152565	151757	
								<b>NIHS</b>	<b>NIHS</b>	<b>NIHS</b>	<b>NIHS</b>
$\varnothing d_1$ S	P mm	$l_1$ mm	$l_2$ mm	$d_2$ mm			ID	ID	ID	ID	
0.5	0.125	25	1.5	2.0	3	0.41 *	161816	157021	159301	158384	
0.6	0.150	25	1.8	2.0	3	0.50 *	152510	152509	151567	152544	
0.7	0.175	25	2.1	2.0	3	0.58 *	152514	152513	151768	152546	
0.8	0.200	25	2.4	2.0	3	0.66 *	152518	152517	152550	152549	
0.9	0.225	25	2.7	2.0	3	0.74 *	152522	152521	152553	151563	
1.0	0.250	40	3.0	2.5	3	0.82 *	152526	152525	152557	152556	
1.2	0.250	40	3.6	2.5	3	1.02 *	152530	152529	152560	152559	
1.4	0.300	40	4.2	2.5	3	1.18 *	152533	152532	152564	152563	

\* Aciers / Steels + 0.02 mm



nano THREAD CUTTING								CMS50
<p>CMS50  Packing 5 </p>								
								<b>NIHS</b>
$\varnothing d_1$ S	P mm	$l_1$ mm	$l_2$ mm	$d_2$ mm			ID	
0.3	0.080	32	1.1	1.5	3	0.24	178257	
0.35	0.090	32	1.3	1.5	3	0.28	178260	
0.4	0.100	32	1.5	1.5	3	0.33	178263	
0.5	0.125	32	1.9	1.5	3	0.41	178266	
0.6	0.150	32	2.3	1.5	3	0.50	178269	
0.7	0.175	32	2.6	1.5	3	0.58	178272	
0.8	0.200	32	3.0	1.5	3	0.66	178275	
0.9	0.225	32	3.4	1.5	3	0.74	178278	
1.0	0.250	32	3.8	2.0	3	0.82	178281	
1.2	0.250	32	4.5	2.0	3	1.02	178284	
1.4	0.300	32	5.3	2.0	3	1.18	178287	



**nano** THREAD FORMING

FA80VS



11	12	13	14
15	21	22	23
61	63	71	72
73	91	92	94

FA83VS

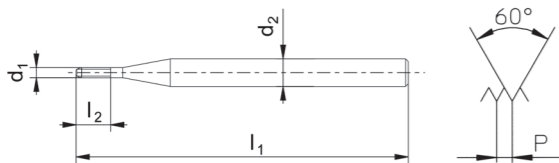


11	12	13	14
15	21	22	23
24	51	61	63
71	72	73	91
92	93	94	

FA80VS FA80VS FA83VS FA83VS

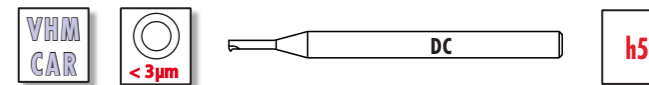


4HX NIHS 4HX NIHS



$\varnothing d_1$ M	P mm	$l_1$ mm	$l_2$ mm	$d_2$ mm		Tol.	ID	ID
0.5	0.125	25	1.5	2.0	0.44	+0.02 mm	161750	173719
0.6	0.150	25	1.8	2.0	0.53	+0.02 mm	152412	173720
0.7	0.175	25	2.1	2.0	0.62	+0.02 mm	152415	173721
0.8	0.200	25	2.4	2.0	0.71	+0.02 mm	152418	173722
0.9	0.225	25	2.7	2.0	0.80	+0.02 mm	152421	173723
1.0	0.250	40	3.0	2.5	0.88	+0.02 mm	151559	173729
1.2	0.250	40	3.6	2.5	1.08	+0.02 mm	151565	173730
1.4	0.300	40	4.2	2.5	1.25	+0.02 mm	152429	173731

$\varnothing d_1$ S	P mm	$l_1$ mm	$l_2$ mm	$d_2$ mm		Tol.	ID	ID
0.5	0.125	25	1.5	2.0	0.44	+0.02 mm	158977	173724
0.6	0.150	25	1.8	2.0	0.53	+0.02 mm	151561	173725
0.7	0.175	25	2.1	2.0	0.62	+0.02 mm	151742	173726
0.8	0.200	25	2.4	2.0	0.71	+0.02 mm	151564	173727
0.9	0.225	25	2.7	2.0	0.80	+0.02 mm	151562	173728
1.0	0.250	40	3.0	2.5	0.88	+0.02 mm	151542	173732
1.2	0.250	40	3.6	2.5	1.08	+0.02 mm	151543	173733
1.4	0.300	40	4.2	2.5	1.25	+0.02 mm	152427	173734



**GW** THREAD WHIRL CUTTER

GW1016



GW1016VS



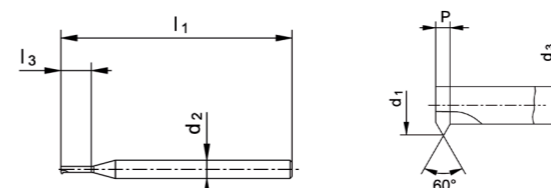
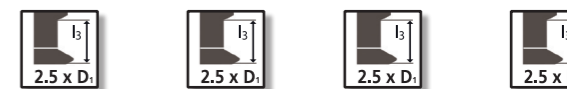
GW2016



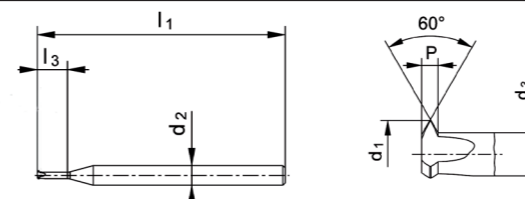
GW2016VS



GW1016 GW1016VS GW2016 GW2016VS



$\varnothing D_1$ S	P mm	$d_1$ mm	$l_1$ mm	$l_3$ mm	$d_2$ h5 mm	$d_3$ mm			ID	ID
0.3	0.080	0.21	39	0.9	3	0.10	1	0.23 *	166930	166940
0.4	0.100	0.29	39	1.2	3	0.15	1	0.32 *	166931	166941
0.5	0.125	0.36	39	1.5	3	0.19	1	0.40 *	166932	166942
0.6	0.150	0.43	39	1.7	3	0.23	1	0.48 *	166933	166943
0.7	0.175	0.50	39	2.0	3	0.27	1	0.56 *	166934	166944
0.8	0.200	0.57	39	2.3	3	0.31	1	0.64 *	166935	166945
0.9	0.225	0.64	39	2.6	3	0.34	1	0.72 *	166936	166946
1.0	0.250	0.71	39	2.9	3	0.38	1	0.80 *	166937	166947
1.2	0.250	0.91	39	3.4	3	0.58	1	1.00 *	166938	166948
1.4	0.300	1.06	39	3.9	3	0.66	1	1.15 *	166939	166949



$\varnothing D_1$ S	P mm	$d_1$ mm	$l_1$ mm	$l_3$ mm	$d_2$ h5 mm	$d_3$ mm			ID	ID
0.5	0.125	0.36	39	1.5	3	0.19	3	0.40 *	181410	181413
0.6	0.150	0.43	39	1.7	3	0.22	3	0.48 *	181374	180947
0.7	0.175	0.50	39	2.0	3	0.26	3	0.56 *	181375	181378
0.8	0.200	0.57	39	2.3	3	0.29	3	0.64 *	166969	166988
0.9	0.225	0.64	39	2.6	3	0.33	3	0.72 *	166970	166989
1.0	0.250	0.71	39	2.9	3	0.36	3	0.80 *	166971	166990
1.2	0.250	0.91	39	3.4	3	0.56	3	1.00 *	166972	166991
1.4	0.300	1.06	39	3.9	3	0.64	3	1.15 *	166973	166992

\*Tol. +0.02 mm  
0

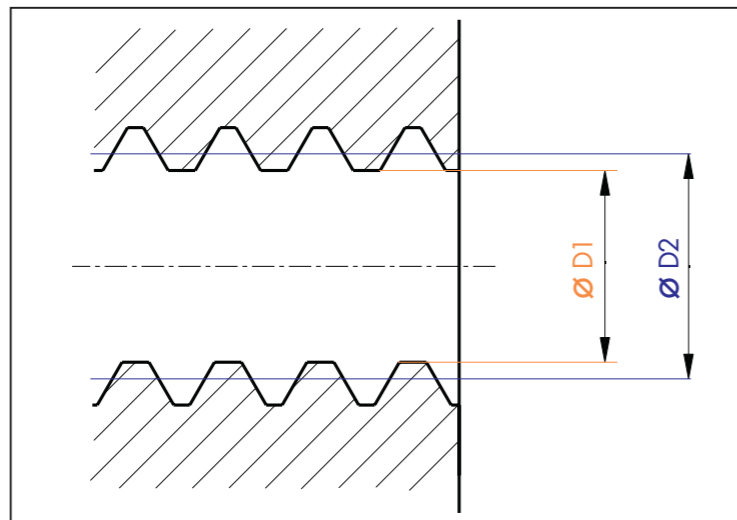


# CERTIFICAT DE CONTRÔLE - TEST CERTIFICATE



**S** NIHS 06-02  
NIHS NT

<u>Client / Customer</u>	<u>Spécimen / Specimen</u>	
<u>Type de jauge / Gauge type</u>	<b>Passe / DN5704 Go</b>	
<u>Numéro d'ID / ID number</u>	<b>XXXX/YZ</b>	
<u>Désignation du filet / Thread designation</u>	<b>S0.6 NIHS</b>	
<u>Pas / Pitch</u>	<b>0.15 mm</b>	
<u>ø sur flancs (D2) / Flank ø (D2)</u>	<b>mini 0.497 mm</b>	<b>maxi 0.503 mm</b>
<u>Genre de contrôle / Measuring instrument</u>	<b>Tampons rapporteurs / Master plug gauge</b>	
<u>Identification des tampons</u>	<b>Entre:</b>	<b>N'entre pas:</b>
<u>Identification N° of Master plug gauge</u>	<b>Go:</b>	<b>No-Go:</b>
<u>ø intérieur (D1) / Core ø (D1)</u>	<b>mini 0.461 mm</b>	<b>maxi 0.467 mm</b>
<u>Traçabilité / Traceability</u>	<b>DIN EN ISO 9001:2008</b>	



\_\_\_\_\_  
Date & Place

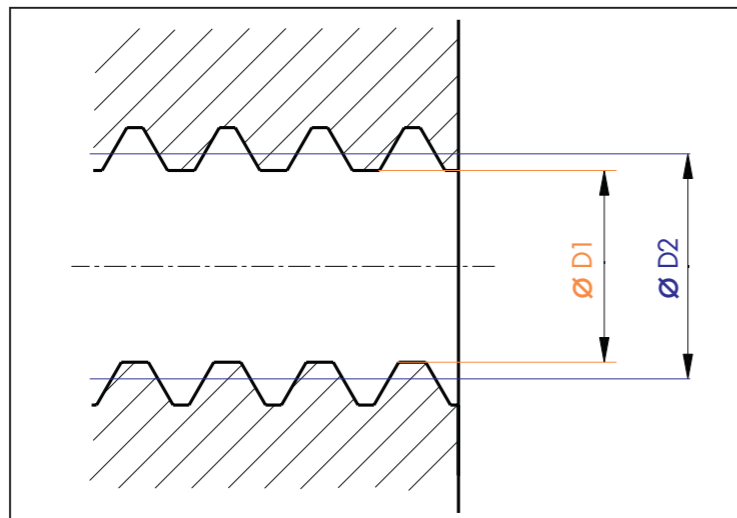
\_\_\_\_\_  
Quality Manager

Certificat CH07/0649

nano THREAD RING GAUGES		DN5704	DN5714	DN5704	DN5714				
DN5704									
DN5714									
DN5704				<b>NEW</b>	<b>NEW</b>				
DN5714									
		Certificat inclus Certificate included							
ø D S	P mm	l <sub>1</sub> mm	d <sub>2</sub> mm	l <sub>2</sub> mm	D <sub>3</sub> mm	ID	ID	ID	ID
0.5	0.125	6.0	20	0.75	2.0	175100	175101	177894	177915
0.6	0.150	6.0	20	0.90	2.0	171818	171825	177895	177916
0.7	0.175	6.0	20	1.00	2.0	171819	171826	177896	177917
0.8	0.200	6.0	20	1.20	2.0	171820	171827	177897	177918
0.9	0.225	6.0	20	1.30	2.0	171821	171828	177898	177919
1.0	0.250	6.0	20	1.50	2.0	171822	171829	177899	177920
1.2	0.250	6.0	20	1.80	2.0	171823	171830	177900	177921
1.4	0.300	6.0	20	2.10	2.0	171824	171831	177901	177922

# CERTIFICAT DE CONTRÔLE - TEST CERTIFICATE

<u>Client / Customer</u>	<u>Spécimen / Specimen</u>	
<u>Type de jauge / Gauge type</u>	<b>DN5724</b>	
<u>Numéro d'ID / ID number</u>	<b>XXXX/YZ</b>	
<u>Désignation du filet / Thread designation</u>	<b>S0.6 NIHS</b>	
<u>Pas / Pitch</u>	<b>0.15 mm</b>	
<u>∅ sur flancs (D2) / Flank ∅ (D2)</u>	<b>mini 0.497 mm</b>	<b>maxi 0.503 mm</b>
<u>Genre de contrôle / Measuring instrument</u>	<b>Tampons rapporteurs / Master plug gauge</b>	
<u>Identification des tampons</u>	<b>Entre:</b>	<b>N'entre pas:</b>
<u>Identification N° of Master plug gauge</u>	<b>Go:</b>	<b>No-Go:</b>
<u>∅ intérieur (D1) / Core ∅ (D1)</u>	<b>mini 0.461 mm</b>	<b>maxi 0.467 mm</b>
<u>Traçabilité / Traceability</u>	<b>DIN EN ISO 9001:2008</b>	



\_\_\_\_\_  
Date & Place

\_\_\_\_\_  
Quality Manager

Certificat CH07/0649

**nano** THREAD RING GAUGES

DN5724

DN5724

$\varnothing D$	P	$l_1$	$d_2$	$l_2$	ID	ID
S	mm	mm	mm	mm		
0.5	0.125	40.0	6.0	0.75	177113	177938
0.6	0.150	40.0	6.0	0.90	177114	177939
0.7	0.175	40.0	6.0	1.00	177115	177940
0.8	0.200	40.0	6.0	1.20	177116	177941
0.9	0.225	40.0	6.0	1.30	177117	177942
1.0	0.250	40.0	6.0	1.50	177118	177174
1.2	0.250	40.0	6.0	1.80	177119	177325
1.4	0.300	40.0	6.0	2.10	177120	177330

DN5724	DN5724		
	<b>NEW</b>		
Certificat inclus Certificate included			

**Mandrins de taraudage SRT et pinces de serrage**  
**Tapping chucks SRT and collets**



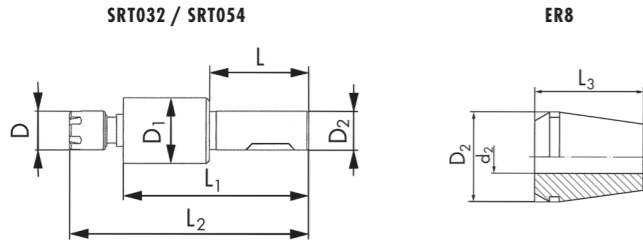
Uniquement pour taraudage synchrone  
 Only for rigid tapping

**nano** SOFT RIGID TAPPING

SRT032-D6

SRT054-D12

ER8



	D mm	D <sub>1</sub> mm	D <sub>2</sub> mm	L mm	L <sub>1</sub> mm	L <sub>2</sub> mm	Weldon DIN 1835	ID	ID
M0.3 - M2	12	11	6	25	40	56.0	B	157610	
M0.5 - M4	12	20	12	33	59	75.0	B		127413

No	D <sub>2</sub> mm	L <sub>3</sub> mm	d <sub>2</sub> mm	ID
ER8-0200	8.5	13.5	2.0	118895
ER8-0250	8.5	13.5	2.5	118896

**Assemblage vissé sécurisé à 100%**  
**100% Self-locking thread system**

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Micro  
**Safelock**<sup>®</sup>

Member of **DC** Group

### **Avertissement**

*Une défaillance technique ou la négligence peuvent être à l'origine de la casse partielle ou totale d'un outil de filetage et atteindre à la santé de l'opérateur. Il est impératif de suivre scrupuleusement les dispositions de sécurité et de santé des entreprises actives dans le traitement du métal. Le port de lunettes de protection est indispensable.*

*Le ré-affûtage des outils de filetage provoque de la poussière dangereuse pour la santé et ne peut être exécuté que selon des instructions de sécurité précises.*

### **Warning**

Thread tools can break or shatter either through technical failure or negligence, and can endanger the health of the operator. Always obey the safety and health regulations, also the wearing of safety glasses is compulsory.

The grinding of threading tools causes hazardous particles, and must be performed only under most rigorous safety standards.

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