

One of a family of rugged, heavy-duty flange facers with facing AND milling capabilities.

Rugged Machine Design

- Large, heavy duty construction-grade bearings provide powerful, rigid performance throughout the entire machine facing range, even machining over bolt hole patterns.
- Oversized ring gear accommodates extremely high torque levels for challenging flange repair applications, and these machines are able to generate a phonographic finish.

Flexible and Versatile

- Both radial and axial feed is achieved with a pneumatic feedbox. Manual feeding for rapid positioning is also possible.
- Feed rate is adjusted remotely at the pneumatic conditioning unit, providing the ultimate in operator safety and the flexibility for feed rate adjustments even during machining operations.
- Infinitely variable feed rates from 0.002 - 0.035 inches (0.0508 - 0.889 mm)/rev provides operational flexibility.
- Reversible feed box can be mounted to provide either radial or axial feed.
- Turning and counterweight arms can both be adjusted for the desired swing clearance and machining range.
- Tool head can be rotated a full 360° providing the ability to create a variety of



chamfers, O-Ring grooves, lens rings and other angular surfaces as needed.

- Pneumatic & hydraulic drive options available.
- Chucking system can be removed to allow the flange facer to be face-mounted.
- Can be mounted both OD and ID or surface-mounted
- Milling option available with precision downfeed ball screw
- Back facing attachment available for heat exchanger repair.

Quick and Easy Setup

- Modular design allows many of the machine components to be removed to facilitate easier setup and storage.
- Unique chucking system minimizes parts to greatly simplify machine setup and tear down.
- Quick-adjust leveling feet make setup quick and easy.



FF6300 Flange Facer
Range 12-60" (304-1524mm)



FF7200 Flange Facer
Range 30-72" (762-1829mm)



FF8200 Flange Facer
Range 45-120" (1143-3048mm)

SPECIFICATIONS

	US	Metric
Machine Performance Ranges		
ID: Mounting range	45 - 120 inches	1143.0 - 3048.0 mm
Facing diameter range	45 - 120 inches	1143.0 - 3048.0 mm
Milling diameter range	45 - 120 inches	1143.0 - 3048.0 mm
Grinding diameter range	45 - 120 inches	1143.0 - 3048.0 mm
Swing diameter @ minimum with feedbox on end of arm	84.7 inches	2151.4 mm
Radial tool slide travel	12 inches	304.8 mm
Axial tool head travel	4 inches	101.6 mm
Depth required inside bore for ID chuck (± 0.25 inches (± 6.4 mm) is travel of leveling foot)	12.13 \pm 0.25 inches	308.1 \pm 6.4 mm
Feed Rate	0.002 - 0.040 in/rev	0.051 - 1.016 mm/rev
OD: Mounting range *	89.8 - 136.4 inches	2280.9 - 3464.6 mm
Facing diameter range	45 - 120 inches	1143.0 - 3048.0 mm
Milling diameter range	45 - 113.5 inches	1143.0 - 2882.9 mm
Grinding diameter range (w/ feed box)	45 - 118 inches	1143.0 - 2997.2 mm
Grinding diameter range (w/o feed box)	45 - 120 inches	1143.0 - 3048.0 mm
Refer to ID for specifications not listed		
Surface Mount: minimum machining diameter	36.0 inches	914.4 mm
Milling Option:		
Vertical Stroke, milling head	8 inches	203.2 mm
Rotational Drive System		
Drive type	Pneumatic or hydraulic drive with pinion and internal ring gear	
Pinion gear to ring gear reduction	7.429:1	
Single point turning speed range:		
Pneumatic	5 - 29 RPM	
Hydraulic (based on motor choice)	1.8 - 18 RPM	
Milling & grinding speed ranges (with 150:1 reducer):		
Pneumatic	0.004 - 0.173 RPM	
Feed rate at 120 inch (3048.0 mm) diameter	1.5 - 65.2 inches/minute	38.1 - 1656.1 mm/minute
Hydraulic (based on motor choice)	0.002 - 0.374 RPM	
Power input requirements		
Pneumatic - 3.5 Hp (2.6 kW)	50 ft ³ /min @ 90 psi	1.42 m ³ /min @ 620 kPa
Hydraulic	10 gpm@1200 psi	37.9 L/min @ 8273 kPa
Measures		
For machine dimensions, please refer to dimensional drawings		
ID machine weight, approximate	4000 lb	1814.4 kg
ID machine weight with mill, approximate	4150 lbs	1882.4 kg
OD machine weight, approximate	3775 lb	1712.3 kg
ID machine weight with mill, approximate	3925 lbs	1780.4 kg
Chuck crate dimensions, (for ID and OD machines) (WxDxH)		
Wood, approx.	93 x 40.5 x 40 in	2362 x 1029 x 1016 mm
Metal, approx.	90.2 x 40.2 x 36.2 in	2291 x 1021 x 920 mm
Leg crate dimensions (for ID and OD machines) (WxDxH)		
Wood, approx.	94 x 43.5 x 19 in	2388 x 1105 x 483 mm
Metal, approx.	94.2 x 42.7 x 19.2 in	2393 x 1085 x 488 mm
OD mount hardware crate dimensions (for OD machine only) (WxDxH)		
Wood, approx.	94 x 43.5 x 19 in	2388 x 1105 x 483 mm
Metal, approx.	94.2 x 42.7 x 19.2 in	2393 x 1085 x 488 mm

Testing Data

Flatness at 82 inch (2083 mm) diameter: .0068 inches (0.17 mm)

On a dedicated fixture made of A-36 steel in a controlled environment with single point machine, after warm-up.

* OD mount minimum arm swing is 84.7 inches (2151.4 mm) diameter. An additional customer supplied structure will be required to chuck below the minimum swing diameter with the feedbox attached..

All dimensions should be considered reference. Contact your Climax Representative for precision dimensions. Specifications are subject to change without notice. There are no systems or components on this machine that are capable of producing hazardous EMC, UV or other radiation hazards. The machine does not use lasers nor does it create hazardous materials such as gasses or dust.

TOOL CONFIGURATIONS

The FF8200 can be configured in several ways to meet your specific machining needs.

Select **OPTION 1** for **single pointing only**

Select **OPTION 2** for **milling only**

Select **OPTION 3** for **BOTH milling and single pointing**

OPTION 1: To configure your FF8200 for **Single Pointing Only**

Please follow these steps, select:

- | | |
|-------------------------|---------------------------|
| 1. Base Package | 6. Counterweight Assembly |
| 2. Feed Assembly | 7. Chuck Assembly |
| 3. Drive Motor Assembly | 8. Shipping Container |
| 4. Hydraulic Motor | |
| 5. Turning Arm Assembly | |

1. Base Package	
Rotary table, tool kit, operator's manual	58187
2. Feed Assembly	
Pneumatic Feed Assembly w/ Remote Air Control	58671
3. Drive Motor Assembly	
Pneumatic Motor and Drive Assembly (Pneumatic drive system includes: Pneumatic motor w/fittings and mount, rotary union, hoses, feed trip valve, cam, and pneumatic conditioning unit with low pressure drop out.)	58186
Hydraulic Drive Assy w/ Feed Conditioning Unit for 60 Series QD - DOES NOT INCLUDE MOTOR (Hydraulic drive system includes: Hyd motor mount, hoses, fittings, rotary union, feed trip valve, cam, and feed pneumatic conditioning unit.)	58180
Hydraulic Drive Assy w/ Feed Conditioning Unit for ISO 16028 QD - DOES NOT INCLUDE MOTOR (Hydraulic drive system includes: Hyd motor mount, hoses, fittings, rotary union, feed trip valve, cam, and feed pneumatic conditioning unit.)	84105
4. Hydraulic Motor for Rotary Table Drive (If Hydraulic drive is selected in step 3). Rated at 10 gpm, 1200 PSI	
14.9 cu in (244.2 cu cm), 3.6 - 18 RPM	69216
18.7 cu in (306.4 cu cm), 2.8 - 14 RPM	69217
24.0 cu in (393.3 cu cm), 2.2 - 11 RPM	69218
29.8 cu in (488.3 cu cm), 1.8 - 9 RPM	69219
* Multiple units may be ordered.	
5. Turning Arm Assembly	
Turning Arm Assembly with Single Point Tool Head	57872
Milling Arm Assembly with Single Point Tool Head	62578
6. Counterweight Assembly	
Counterweight Assembly	58066
Counterweight Milling Arm Assembly	62515
7. Chuck Assembly	
ID Chuck Assembly	57881
OD Chuck Assembly, Standard Turning Arm	61372
ID/OD Chuck Assembly, Standard Turning Arm	61454
OD Chuck Assembly, Turning with Milling Arm	62666
ID/OD Chuck Assembly, Turning with Milling Arm	62674
8. Shipping Container	
Wooden Crate for ID Mount Machine	58421
Metal Container for ID Mount Machine	59936
Wooden Crate Set for ID/OD Mount Machine	62679
Metal Container Set for ID/OD Mount Machine	61724

Hydraulic Power Units (for single pointing)

HP1000, 208 - 230 Volts				
Cordset/hose length		Quick Connect Style		P/N
Feet	Meters	60 Series QD	ISO 16028 CE	
20	6	✓		93687
50	15	✓		93724
100	30	✓		94021
20	6		✓	94022
50	15		✓	94023
100	30		✓	93980
HP1000, 380 - 415 Volts				
Cordset/hose length		Quick Connect Style		P/N
Feet	Meters	60 Series QD	ISO 16028 CE	
20	6	✓		94024
50	15	✓		93725
100	30	✓		94025
20	6		✓	94026
50	15		✓	94027
100	30		✓	94028
HP1000, 460 Volts (440 - 480 volts)				
Cordset/hose length		Quick Connect Style		P/N
Feet	Meters	60 Series QD	ISO 16028 CE	
20	6	✓		94029
50	15	✓		93770
100	30	✓		94030
20	6		✓	94031
50	15		✓	94032
100	30		✓	94033
HP1000, 575 Volts				
Cordset/hose length		Quick Connect Style		P/N
Feet	Meters	60 Series QD	ISO 16028 CE	
20	6	✓		94034
50	15	✓		93744
100	30	✓		94035
20	6		✓	94036
50	15		✓	93745
100	30		✓	94037

TOOL CONFIGURATIONS

OPTION 2: To configure your FF8200 for **Milling Only**

Please follow these steps, select:

1. Base Package
2. Drive Motor Assembly
3. Hydraulic Motor
4. Turning Arm Assembly
5. Counterweight Assembly
6. Milling Head
7. Tooling
8. Milling Head Swivel Assembly
9. Hydraulic Motor for Milling Head
10. Chuck Assembly
11. Shipping Container

1. Base Package		
Rotary table, tool kit, drag brake assembly, operator's manual		62673
2. Drive Motor Assembly		
Pneumatic Motor and Drive Assembly (Pneumatic drive system includes: Pneumatic motor w/fittings and mount, gearbox, rotary union, hoses, feed trip valve, and pneumatic conditioning unit with low pressure drop out.)		62571
Hydraulic Drive Assy w/Gearbox & Feed Conditioning Unit for 60 Series QD - DOES NOT INCLUDE MOTOR (Hydraulic drive system includes: Hyd motor mount, gearbox, hoses, fittings, and rotary union.)		62585
Hydraulic Drive Assy w/Gearbox & Feed Conditioning Unit for ISO 16028 QD - DOES NOT INCLUDE MOTOR (Hydraulic drive system includes: Hyd motor mount, gearbox, hoses, fittings, and rotary union.)		84107
3. Hydraulic Motor for Rotary Table Drive (If Hydraulic drive is selected in step 2). Rated at 10 gpm, 1200 PSI (Multiple units may be ordered)		
4.9 cu in (80.3 cu cm), 0.1 - 0.35 RPM		69213
8.0 cu in (131.1 cu cm), 0.05 - 0.20 RPM		69214
14.9 cu in (244.2 cu cm), 0.02 - 0.11 RPM		69216
29.8 cu in (488.3 cu cm), 0.012 - 0.06 RPM		69219
4. Turning Arm Assembly		
Milling Arm Assembly (does not include tool head)		72698
5. Counterweight Assembly		
Counterweight Milling Arm Assembly		62415

6. Milling Head			
Milling Head Assembly Inch #50 Taper NMTB			62282
Milling Head Assembly Inch #50 Taper CATV			62734
Milling Head Assembly Metric #50 Taper NMTB			62644
Milling Head Assembly Metric #50 Taper CATV			62735
7. Tooling (for inch milling head assembly only)			
#50, NBTB 4 in (101.6 mm) Face Mill w/ Inserts			47383
#50, NBTB 5 in (127.0 mm) Face Mill w/ Inserts			47384
#50, NBTB 6 in (152.4 mm) Face Mill w/ Inserts			47385
#50, NBTB 8 in (203.2 mm) Face Mill w/ Inserts			47386
#50, NBTB 10 in (254.0 mm) Face Mill w/ Inserts			56175
Carbide Inserts			47229
8. Milling Head Swivel Assembly			
Milling Head Swivel Plate Assembly Kit			83125
9. Hydraulic Motor for Milling Head			
Cubic in	Cubic cm	60 Series QD	ISO 16028 QD
8.0	131.1	53459	69498
9.6	157.3	53458	69499
11.9	195.0	46950	69500
14.9	244.2	46375	69501
18.7	24.0	46550	69502
24.0	393.3	46550	69503
10. Chuck Assembly			
ID Chuck Assembly			57881
OD Chuck Assembly for Milling			62669
ID/OD Chuck Assembly for Milling			62677
11. Shipping Container			
Wooden Crate for ID Mount Machine			58421
Metal Container for ID Mount Machine			59936
Wooden Crate Set for ID/OD Mount Machine			62679
Metal Container Set for ID/OD Mount Machine			61724

Hydraulic Power Units (for milling only)

HP2500, Dual Pump, 208 - 230 Volts				
Cordset/hose length		Quick Connect Style		P/N
Feet	Meters	60 Series QD	ISO 16028 CE	
20	6	✓		90274
50	15	✓		90976
100	30	✓		90977
20	6		✓	90987
50	15		✓	90988
100	30		✓	90989
HP2500, Dual Pump, 380 - 415 Volts				
Cordset/hose length		Quick Connect Style		P/N
Feet	Meters	60 Series QD	ISO 16028 CE	
20	6	✓		90978
50	15	✓		90979
100	30	✓		90980
20	6		✓	90990
50	15		✓	90991
100	30		✓	90992

HP2500, Dual Pump, 460 Volts (440 - 480 volts)				
Cordset/hose length		Quick Connect Style		P/N
Feet	Meters	60 Series QD	ISO 16028 CE	
20	6	✓		90981
50	15	✓		90982
100	30	✓		90983
20	6		✓	90993
50	15		✓	90994
100	30		✓	90995
HP2500, Dual Pump, 575 Volts				
Cordset/hose length		Quick Connect Style		P/N
Feet	Meters	60 Series QD	ISO 16028 CE	
20	6	✓		90984
50	15	✓		90985
100	30	✓		90986
20	6		✓	90996
50	15		✓	90997
100	30		✓	90998

TOOL CONFIGURATIONS

OPTION 3: To configure your FF8200 for **Milling, or Milling with Single Pointing**

Please follow these steps, select:

1. Base Package
2. Feed Assembly
3. Drive Motor Assembly
4. Hydraulic Motor
5. Turning Arm Assembly
6. Counterweight Assembly
7. Milling Head
8. Tooling
9. Milling Head Swivel Assembly
10. Hydraulic Motor for Milling Head
11. Chuck Assembly
12. Shipping Container

1. Base Package	
Rotary table, tool kit, drag brake assembly, operator's manual	62670
2. Feed Assembly	
Pneumatic Feed Assembly w/ Remote Air Control	58671
3. Drive Motor Assembly	
Pneumatic Motor and Drive Assembly (Pneumatic drive system includes: Pneumatic motor w/fittings and mount, gearbox, rotary union, hoses, feed trip valve, and pneumatic conditioning unit with low pressure drop out.)	62591
Hydraulic Drive Assy w/Gearbox & Feed Conditioning Unit for 60 Series QD - DOES NOT INCLUDE MOTOR (Hydraulic drive system includes: Hydraulic motor mount, gearbox, hoses, fittings, feed trip valve, cam, and feed pneumatic conditioning unit.)	62594
Hydraulic Drive Assy w/Gearbox & Feed Conditioning Unit for ISO 16028 QD - DOES NOT INCLUDE MOTOR (Hydraulic drive system includes: Hydraulic motor mount, gearbox, hoses, fittings, feed trip valve, cam, and feed pneumatic conditioning unit.)	84109
4. Hydraulic Motor for Rotary Table Drive (If Hydraulic drive is selected in step 3). Rated at 10 gpm, 1200 PSI (Multiple units may be ordered)	
4.9 cu in (80.3 cu cm), 0.1 - 0.35 RPM (Milling Only)	69213
8.0 cu in (131.1 cu cm), 0.05 - 0.20 RPM (Milling Only)	69214
14.9 cu in (244.2 cu cm), 3.6 - 18 RPM / 0.02 - 0.11 RPM	69216
18.7 cu in (306.4 cu cm), 2.8 - 14 RPM / 0.018 - 0.09 RPM	69217
24.0 cu in (393.3 cu cm), 2.2 - 11 RPM / 0.014 - 0.07 RPM	69218
29.8 cu in (488.3 cu cm), 1.8 - 9 RPM / 0.012 - 0.06 RPM	69219
5. Turning Arm Assembly	
Milling Arm Assembly with Single Point Tool Head	62578

6. Counterweight Assembly	
Counterweight Milling Arm Assembly	62527
7. Milling Head	
Milling Head Assembly Inch #50 Taper NMTB	62282
Milling Head Assembly Inch #50 Taper CATV	62734
Milling Head Assembly Metric #50 Taper NMTB	62644
Milling Head Assembly Metric #50 Taper CATV	62735
8. Tooling (for inch milling head assembly only)	
#50, NBTB 4 in (101.6 mm) Face Mill w/ Inserts	47383
#50, NBTB 5 in (127.0 mm) Face Mill w/ Inserts	47384
#50, NBTB 6 in (152.4 mm) Face Mill w/ Inserts	47385
#50, NBTB 8 in (203.2 mm) Face Mill w/ Inserts	47386
#50, NBTB 10 in (254.0 mm) Face Mill w/ Inserts	56175
Carbide Inserts	47229
9. Milling Head Swivel Assembly	
Milling Head Swivel Plate Assembly Kit	83125
10. Hydraulic Motor for Milling Head	
Cubic in	Cubic cm
8.0	131.1
9.6	157.3
11.9	195.0
14.9	244.2
18.7	24.0
24.0	393.3
60 Series QD	ISO 16028 QD
53459	69498
53458	69499
46950	69500
46375	69501
46549	69502
46550	69503
11. Chuck Assembly	
ID Chuck Assembly	57881
OD Chuck Assembly for Milling	62669
ID/OD Chuck Assembly for Milling	62677
12. Shipping Container	
Wooden Crate for ID Mount Machine	58421
Metal Container for ID Mount Machine	59936
Wooden Crate Set for ID/OD Mount Machine	62679
Metal Container Set for ID/OD Mount Machine	61724

Hydraulic Power Units (milling with single pointing) for milling only see page 4

HP2500, 208 - 230 Volts				
Cordset/hose length		Quick Connect Style		P/N
Feet	Meters	60 Series QD	ISO 16028 CE	
20	6	✓		93743
50	15	✓		93748
100	30	✓		94039
20	6		✓	93897
50	15		✓	94040
100	30		✓	94041
HP2500, 380 - 415 Volts				
Cordset/hose length		Quick Connect Style		P/N
Feet	Meters	60 Series QD	ISO 16028 CE	
20	6	✓		93810
50	15	✓		93811
100	30	✓		94042
20	6		✓	94043
50	15		✓	93719
100	30		✓	94044

HP2500, 460 Volts (440 - 480 volts)				
Cordset/hose length		Quick Connect Style		P/N
Feet	Meters	60 Series QD	ISO 16028 CE	
20	6	✓		94045
50	15	✓		93761
100	30	✓		94046
20	6		✓	94047
50	15		✓	94048
100	30		✓	94049
HP2500, 575 Volts				
Cordset/hose length		Quick Connect Style		P/N
Feet	Meters	60 Series QD	ISO 16028 CE	
20	6	✓		94050
50	15	✓		94051
100	30	✓		94052
20	6		✓	94053
50	15		✓	94054
100	30		✓	93696

ACCESSORIES, MACHINE OVERVIEW

Get even more out of your Flange Facer
with these accessories:

Surface mount PN 79540

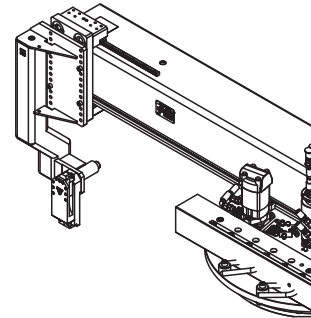
Backfacing attachment PN 69711
(requires milling arm PN 62578 and counterweight
arm PN 62527)

Surface mount retrofit kit PN 80046
(for existing machines)

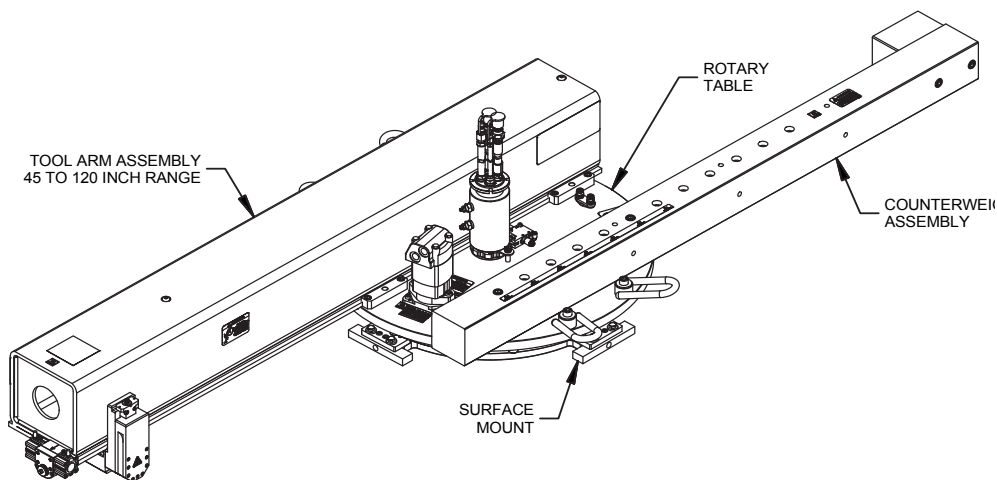
*Air powered grinding head (2 variants)

**Pneumatic conditioning unit

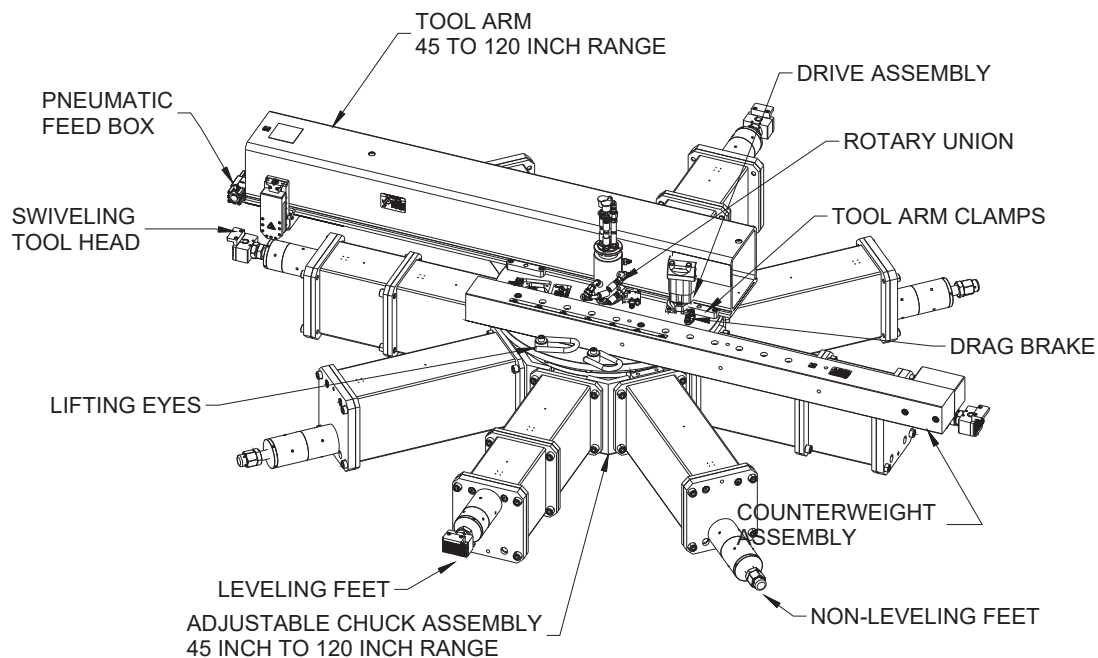
Backfacing Attachment



Machine Overview, Surface Mount Configuration



Machine Overview, ID-Mount Configuration

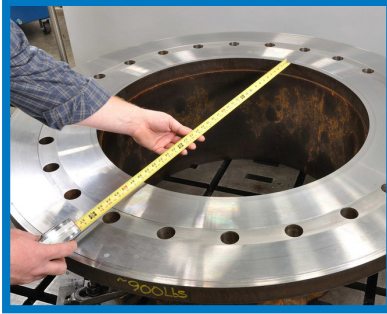


SETUP AND OPERATION

A Fast Eight-Step Process

This model is so fast and easy to set up that an experienced operator can usually mount the machine into the flange bore, align it, and start cutting in less than an hour. ID-mounting steps shown.

- 1** Measure the bore diameter. This will be used to determine the leg length.



- 5** Set machine onto flange using setup fingers. Lightly tighten leveling feet in the flange.



- 2** Select the appropriate leg length and foot.



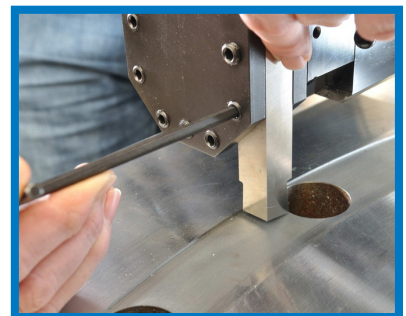
- 6** Extend feet into flange. Indicate, level and tighten leveling feet and stationary feet.



- 3** Install setup fingers.



- 7** Install tool bit. Connect to power.



- 4** Tighten legs.



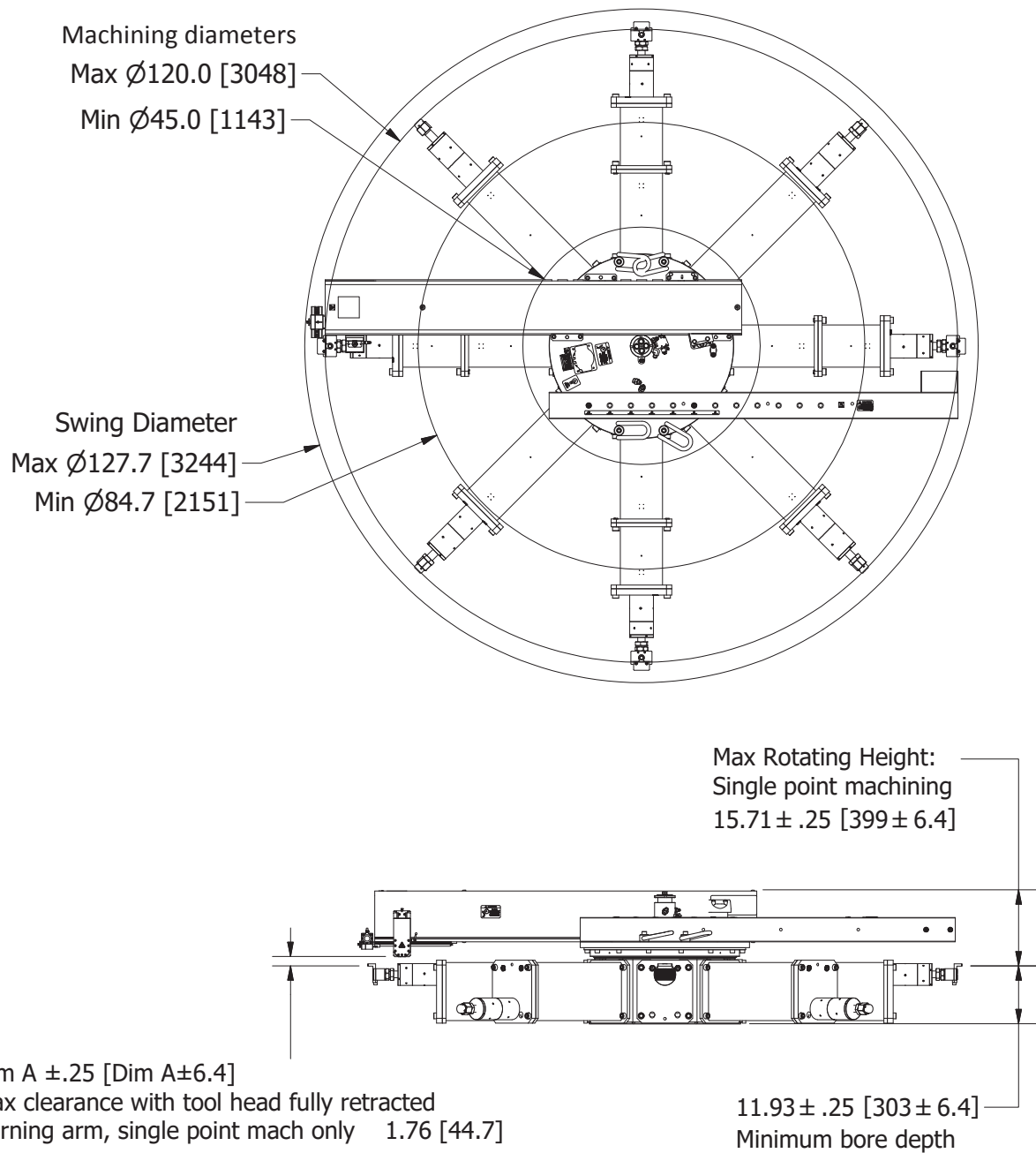
- 8** You are ready to begin machining!



OPERATIONAL DIMENSIONS

Dimensions in Inch (mm)

ID Chuck Assembly, ID-Mount Configuration, Single-Point Machining



NOTE: $\pm .25$ is travel of leveling foot

OPERATIONAL DIMENSIONS

Dimensions in Inch (mm)

ID Chuck Assembly, ID-Mount Configuration, Milling

Machining diameters (CL of spindle)

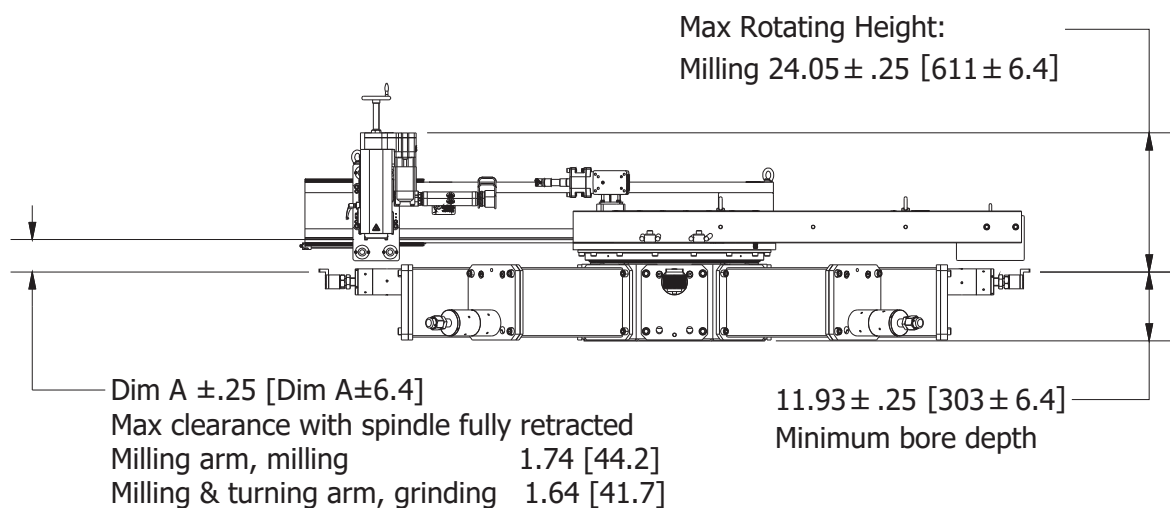
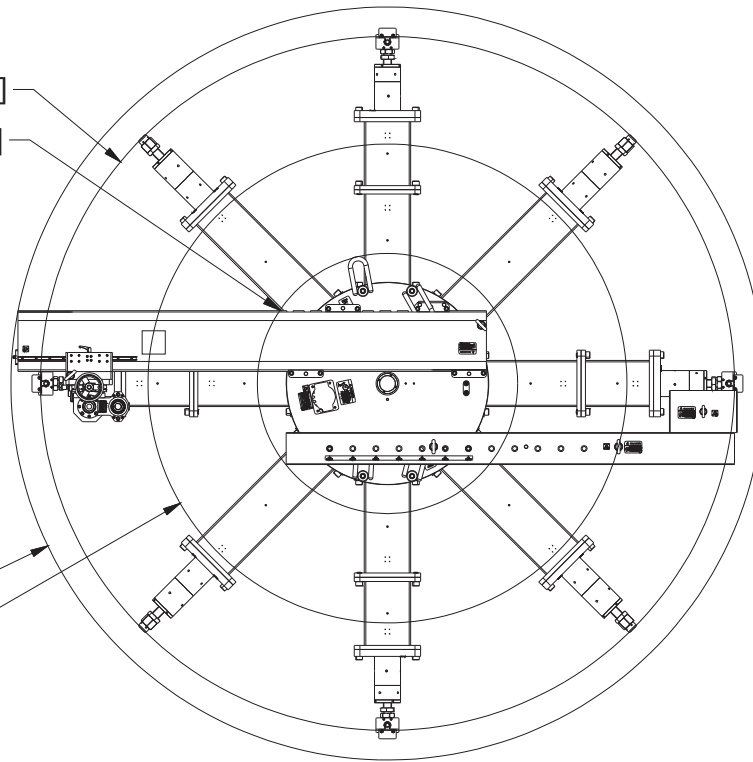
Max $\varnothing 120.0$ [3048]

Min $\varnothing 45.0$ [1143]

Swing Diameter

Max $\varnothing 130.2$ [3307]

Min $\varnothing 82.8$ [2103]

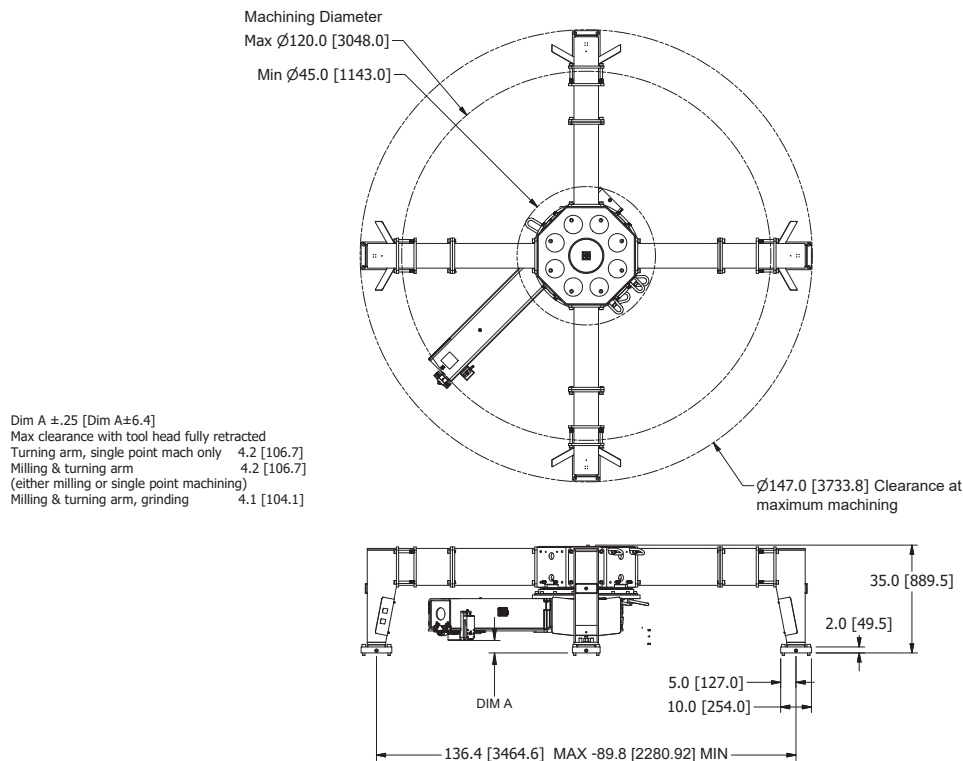


NOTE: $\pm .25$ is travel of leveling foot

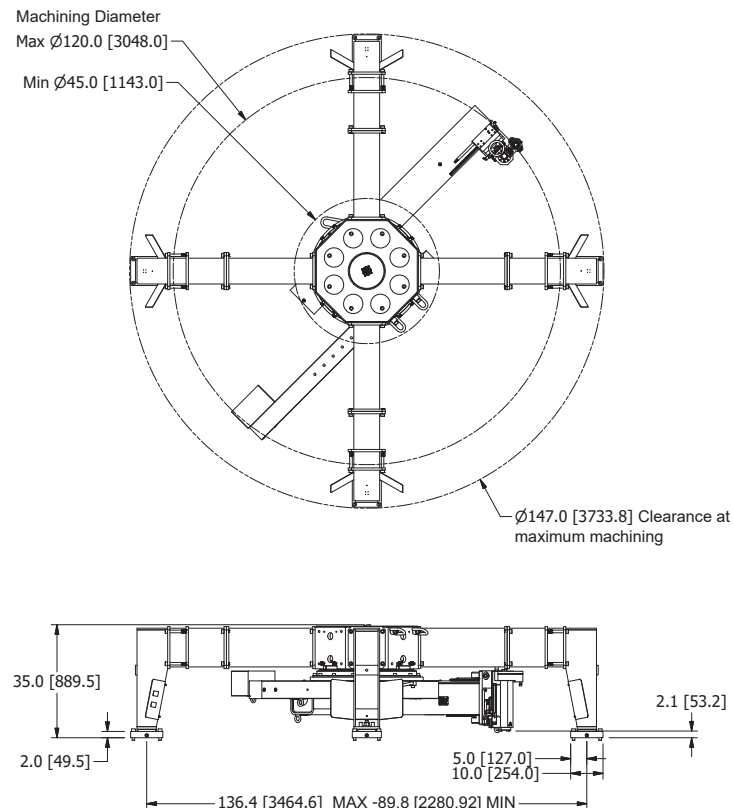
OPERATIONAL DIMENSIONS

Dimensions in Inch (mm)

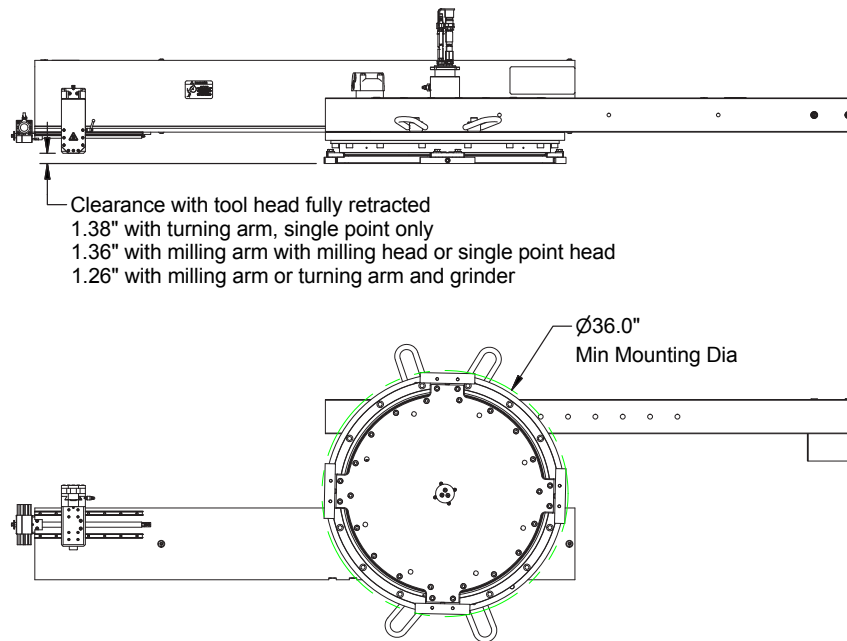
OD Chuck Assembly, OD-Mount Configuration, Single-Point Machining



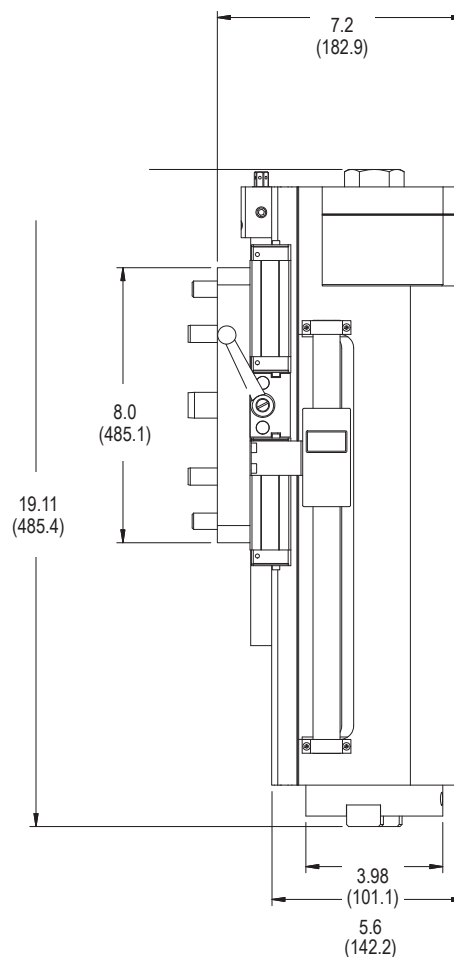
OD Chuck Assembly, OD-Mount Configuration, Milling



Surface Mount Configuration, Milling



Milling Head Assembly



OEM OPERATIONAL TRAINING

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CLIMAX pioneered the concept of portable machine tools in 1964. Since that time, CLIMAX has grown to become the world's largest provider of innovative on-site machining solutions.

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All training programs are taught by experienced OEM CLIMAX trainers. Your instructor will provide valuable information on operator safety, tool set-up, mounting, and operation that will help you complete your on-site machining tasks quickly and to the highest quality standards.

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OEM TRAINING

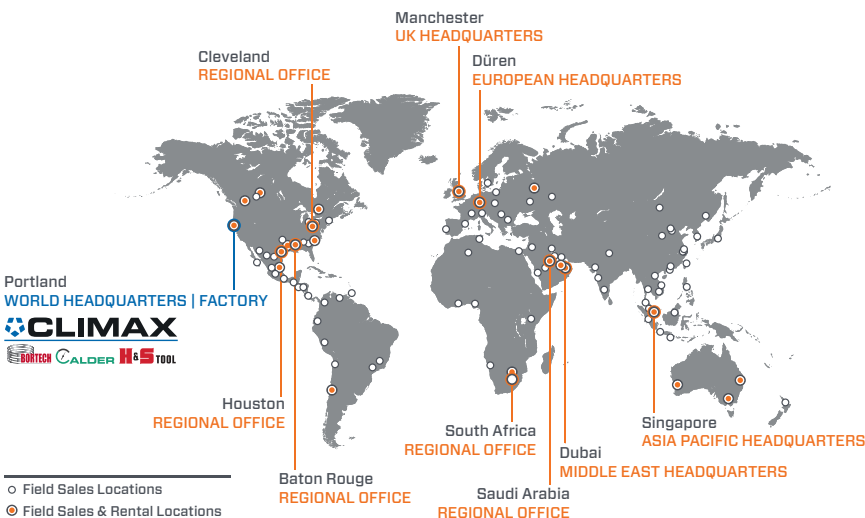
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