Liquid Cooling for inductive and resistive components
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REO liquid cooling

An Increase in Effectivity

Traditional methods of air cooling encounter their limits at the latest when limited space refuses to permit optimal air circulation from being realized or, due to high temperatures, cooling using the ambient air is not possible. The water cooling (liquid cooling) method is a very efficient option for drawing heat away from a heat source. The heat is transported with the high heat capacity and density of the coolant. This makes this type of cooling more efficient than traditional air cooling. Very high cooling power densities are possible.

As an example, we will consider a comparison between air cooling and liquid cooling:

- assumed power loss: 3200 W
- temperature difference to be reached: 5K

Calculation of the coolant volume required:

\[
\text{Air: } \dot{V} = \frac{Q}{\Delta T \cdot \rho \cdot c_p} = \frac{3200}{5K \cdot 1.007 \cdot 1007} = 0.6555 \frac{m^3}{s} = 655 \text{ l/s}
\]

\[
\text{Water: } \dot{V} = \frac{Q}{\Delta T \cdot \rho \cdot c_p} = \frac{3200}{5K \cdot 983 \cdot 4179} = 0.0001557 \frac{m^3}{s} = 0.1557 \text{ l/s}
\]

In order to achieve a cooling of 5K with power dissipation of 3200W, 655 l/s air is required or only 0.1557 l/s water. This illustrates the significant advantage.
Comparison of common cooling methods:

In the following example, the 4 common cooling methods will be compared. This will display which types of heat can be converted on a surface of 10 x 10 cm and a temperature difference of 30K.

Example: \( Q = h * A * (T2-T1); \) Surface = 10 cm * 10 cm ; temperature difference = 30K

<table>
<thead>
<tr>
<th></th>
<th>Forced air cooling</th>
<th>Water cooling (recirculating cooling)</th>
<th>Immersion cooling</th>
</tr>
</thead>
<tbody>
<tr>
<td>Heat transfer coefficient</td>
<td>h = 5 - 30 W/m²K</td>
<td>h = 100 - 1600 W/m²K</td>
<td>h = 800 - 10000 W/m²K</td>
</tr>
<tr>
<td>Q = 2 – 9 W</td>
<td>Q = 6 – 120 W</td>
<td>Q = 30 – 480 W</td>
<td>Q = 240 – 3000W</td>
</tr>
<tr>
<td>- Free convection</td>
<td>- Free + forced convection</td>
<td>- Forced convection</td>
<td>- Free convection</td>
</tr>
</tbody>
</table>

Using water-cooled systems, one can convert significantly higher capacities on the same surface - from which the increased cooling efficiency arises.

REO has long since recognized the trend towards water cooling and has operated developments in the water cooling area for inductive and resistive components. This has enabled REO to build up a comprehensive know-how and a wide spectrum of variously designed water-cooled products.

Water cooling is an excellent solution, especially for the use of inductive and resistive components, as temperature behavior plays a major role here. Water cooling enables the temperature of the components to be kept at an optimum level in a unique way, as high power losses are directly transported out of application via the cooling lines. This ensures a longer lifetime for the components as well as increased performance.

Water cooling is a technique that pays off

Constructing this kind of system may be initially connected with higher costs than with regular forced air cooling, however, these investments pay off in the end.

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Advantages of liquid cooling

- High efficiency and low noise levels
- Minimization of construction sizes up to 80% with resistors
- Effective cooling with high ambient temperatures
- Very low excess surface temperature
- Increase of lifetime with normal operation
- Constant, high performance, as temperature is directly dissipated
- Only cooling type during which the temperature may fall below the ambient temperature
- Very well suited for industrial applications in which components with low
- Surface temperatures are required (wood and textile industries or in explosion-protected environments, wind turbines)

The illustration shows a water-cooled REO braking resistor. The infrared recording allows the temperatures of the cables to be easily seen, while the resistor is kept at an optimal temperature with water cooling.
REO cooling variants

Cooling using a cooling plate
The cooling occurs using cooling plates, which mechanically separate the cooling circuit from the electrical power circuit. Thus the electrical, active components have no contact with the coolant.

Here, REO can offer you 2 variants:

1. Variant C:
   In this variant, a heat sink will be attached to the component from the outside to cool it. This variant is especially interesting for low power levels and small components.
   Example: Reactor CNW MC 903 or braking resistor BW C 152

2. Variant D:
   In variant D, the heat sinks are integrated into the components and directly affixed to the heat sources in order to enable a higher degree of efficiency. This design is very interesting at high power levels. Example: Reactor CNW MD 903 or braking resistor BW C 158

Direct liquid cooling
Here, the electrical, active components have direct contact with the coolant. The coolant flows around the electrically active part or directly flows through it - this is the most efficient method of cooling; at the same time, however, a number of conditions must be observed.

When developing and constructing water-cooled components, REO places increased value on the seamless integration into existing systems. However, the construction of its own cooling solutions, from which the customer application can benefit, has also been realized. Therefore, REO offers individual components or complete solutions as a switch cabinet version, specially for water-cooled drive systems in the larger power spectrum.
Design of liquid-cooled components

To develop liquid-cooled components, simulation plays a decisive role - with the help of various simulation techniques, cooling and coolant flow can be tested and optimized early during development and construction. This prevents later problems during construction or with the client.

Possibilities of simulation with REO:
- Simulation of gas and fluid flows
- Calculation of pressure, radiation, solid state temperature, fluid temperature, velocity, and density
- Thermal effect on the environment

Agreement on the cooling channel materials
Generally, connections made of brass-plated nickel or stainless steel are used. What is important here is an agreement concerning the materials for the cooling channels. All hoses, seals, and components have a sufficient temperature resistance of > 100 °C.

The performance data in the data sheets are valid under the following conditions:
- Maximum ambient temperature: 40°C
- Max. inlet coolant temperature: 25°C
- Max. coolant discharge temperature: 45°C
- Operating pressure: 4 bar
- Test pressure: 6 bar

Attention!!! In case of insufficient cooling or incorrect installation, the components may become overheated or damaged. Other temperatures, levels of power, and pressures are available upon requests. Solutions with higher coolant temperatures are also available.
Resistors
Liquid-cooled REOHM resistors

are available with power levels from 1 to 100 kW. Cooling channels introduced into the heat sink enable efficient cooling and the spatial separation of the electricity- and liquid-carrying lines - enabling safe application. In addition to the general advantages of the REOHM braking resistors, such as a more modular building to attain higher power levels or the compact design, the braking resistors have an optimal structure and power consumption, enabling them to also withstand vibration and shock tests. REOHM braking resistors are an optimized combination of proven and innovative techniques, so that nothing stands in the way of its use with high power classes under conditions of limited space when using water cooling.

Series REOHM BW D158 / 160

- Braking and load resistance for the drive technology, industrial applications.
- Test fields and rail technology with integrated water cooling
- Power: 5 – 100 kW
- Cooling channels series BW D 158: Aluminum (AlMgSi 0.5) Di = 10.5mm
- Cooling channels series BW D 160: Copper or stainless steel Di = 10 mm

Comparison of an air-cooled braking resistor with a liquid-cooled braking resistor

<table>
<thead>
<tr>
<th>Mechanical dimensions (LxWxH):</th>
<th>762 mm x 175 mm x 75 mm</th>
<th>320 mm x 150 mm x 68 mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>Space required during installation:</td>
<td>0.134 m²</td>
<td>0.05 m² (60 % space saved)</td>
</tr>
<tr>
<td>Surface temperature with a full load:</td>
<td>387 °C</td>
<td>35 °C (90 % lower surface temperature)</td>
</tr>
</tbody>
</table>
Advantages of liquid-cooled resistors

The diagram illustrates the efficiency of water cooling using a measurement carried out on an air-cooled and a water-cooled REOHM braking resistor. If the air-cooled resistor with a power level of 3000 W has a surface temperature of 387°C, the surface temperature for a water-cooled resistor is 35°C at the same power level.

Series REOHM BW D330

New resistor series for higher power levels for automotive and testing field applications in addition to industrial applications.

Very compact dimensions and effective cooling.

The goal here is not to cool the component but also to use the dissipated heat and make it available to the user.

<table>
<thead>
<tr>
<th>Series BWD 330</th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>Type</td>
<td>BW D 330</td>
</tr>
<tr>
<td>Power</td>
<td>up to 60 kW</td>
</tr>
<tr>
<td>Protection type</td>
<td>IP 20 ...IP 66</td>
</tr>
<tr>
<td>Resistance values</td>
<td>1-100 Ohm</td>
</tr>
</tbody>
</table>

The BW D330 is also available in very compact construction with an integrated braking chopper. Here, the resistor and chopper create a compact unit with a cooling system.
Liquid-cooled REO reactors

are available in protective types IP00 to IP65. REO- can realize various types of water cooling for these components. This means the targeted discharge of losses via the cooling circuit - the losses are not discharged into the environment. By using water cooling, the temperatures in the components can be greatly reduced - this means less stress on the insulation materials and a longer lifetime.

Advantages of liquid-cooled reactors

Max. temperature CNW 953/180 air-cooled: 205°C
Max. temperature CNW D 953/180 water-cooled: 120°C
Max. temperature CNW MD 953/180 water-cooled and poured: 68°C

The advantages of the water cooling method can be clearly seen based on the measurements. All 3 variants were tested with the same load; when doing so, the open water-cooled reactor had a temperature advantage of 52 K.
In the CNW MD version, the temperature in the reactor could even be lowered by 137 K. This advantage was achieved due to special encapsulation techniques and a special REO construction.
In addition, the behavior at different inlet temperatures was researched to test the behavior at different operating conditions.

Temperature advantage up to 137 K
Series CNW MC - for smaller components

- Reactor cast on a metal plate, with integrated cooling channels.
  This component enables targeted and optimized cooling for smaller power levels and is characterized by its simple integration into existing cooling systems.

<table>
<thead>
<tr>
<th>Series CNW MC - for smaller components</th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>available in 4 different versions. (IP00, IP 20, IP 20+EMV and IP64)</td>
<td></td>
</tr>
<tr>
<td>Type</td>
<td>CNW MC</td>
</tr>
<tr>
<td>Current</td>
<td>6-70A</td>
</tr>
<tr>
<td>Protection type</td>
<td>IP 00 …IP 64</td>
</tr>
<tr>
<td>Inductance:</td>
<td>0.4-10 mH</td>
</tr>
</tbody>
</table>

**Coldplate-Choke CNW MC**

- Targeted and optimized cooling
- Suitable for industrial water and standard cooling liquids
- Easy connection for liquid cooling
- Working pressure up to 4 bar (10bar test)
- Protection up to IP64
- Various connections: wires, terminals, terminal box
- Quiet
- Lower surface temperature
Series CNW MD - for medium to larger power levels

- For currents from 100 A - 400 A (Series CNW MD):
  Chokes of the series CNW MD 400 are fully encapsulated or alternatively partially encapsulated. An encapsulation allows in interaction with the liquid cooling a better heat transfer than the same component not encapsulated. The encapsulation allows a protection class up to IP 65.

- For currents of 400 A - 2000A (CNW MD):
  CNW MD chokes up to 2000 A are partially encapsulated. The partial encapsulation enables an optimum heat transfer while reducing weight. The number of cooling profiles are customized.

<table>
<thead>
<tr>
<th>Liquid-cooled choke CNW MD</th>
</tr>
</thead>
<tbody>
<tr>
<td>• Targeted and optimized cooling</td>
</tr>
<tr>
<td>• Suitable for industrial water and standard cooling liquids</td>
</tr>
<tr>
<td>• Easy connection for liquid cooling</td>
</tr>
<tr>
<td>• Pressure drops to ≤ 0.6 bar</td>
</tr>
<tr>
<td>• Degree of protection up to IP 65</td>
</tr>
<tr>
<td>• Various connections: wires, terminals, terminal box</td>
</tr>
<tr>
<td>• Quiet</td>
</tr>
<tr>
<td>• Lower surface temperature</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Series CNW MD with cooling profiles</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Type</strong></td>
</tr>
<tr>
<td>Type</td>
</tr>
<tr>
<td>Current</td>
</tr>
<tr>
<td>Protection type</td>
</tr>
<tr>
<td>Inductance</td>
</tr>
</tbody>
</table>
REO-ColdPlate

is a sub-structure component especially developed for Coldplate Inverter. The REO-ColdPlate has cooling loops running through it that can be connected to a water cooling system. The customer can, for example, mount a Coldplate Inverter, IGBTs, rectifier switches, and other power electronic components onto the components, which can also be cooled via the REO-ColdPlate. This does not require an additional cooling plate and it will save installation space, volume, and material.

REOHM series BW D 158 CP

Substructure of braking and load resistors for the Cold Plate Inverter in drive technology, industrial applications, testing facilities, and rail technology with water cooling. Components, such as converters, can be directly attached to the resistor and will be cooled with its water cooling.

<table>
<thead>
<tr>
<th>Series BW D 158 CP</th>
</tr>
</thead>
<tbody>
<tr>
<td>Type</td>
</tr>
<tr>
<td>Power</td>
</tr>
<tr>
<td>Protection type</td>
</tr>
<tr>
<td>Resistance values</td>
</tr>
</tbody>
</table>
REO liquid-cooled combinations

It is also possible to build multiple components into one component and therefore obtain a compact unit. The cooling can be directly integrated, the cooling performance is increased and the component dimensions decreased. Therefore, for multiple components, the customer only has 2 water connections, thus saving on the piping in the switch cabinet.

Directly liquid-cooled components

These special components are designed to the customer’s specifications. Non-conductive liquids can be used as coolant liquids here (e.g. deionized water), although water can also be used. Here, specific framework conditions must be clarified with the customer.

In general, one could say the directly water-cooled components display the highest degree of efficiency in cooling.

Examples of directly water-cooled components:

Electrical conductor, directly cooled with deionized water.

REO Three-Phase Transformer
- NTT-3UI 210sp-DT6990
- Input voltage: 3 x 400 V, 50 Hz
- Output voltage: 3 x 38 V
- Input current: 3 x 100 A
- Output current: 3 x 1053 A
- Nominal power: 69 kVA
- Test voltage: 2500 V
- Protection type: IP00

Directly water-cooled resistor BW D 130
- Direct water cooling with connection to electrically active components
- Cooling medium: deionized water; water
- Nominal voltage: 600V DC
- Nominal power: 5kW – 25kW

This resistor can also be used to effectively heat water and service water. The heat can therefore be used in other processes.

Example:
Combination of EMV filter and motor reactor with water cooling
Nominal voltage: 3x 480V
Nominal current: 100 A
Liquid-cooled complete systems

REO not only offers individual components but also complete systems. Here, REO offers you its complete expertise from one source. Completely pre-wired solutions are offered.

Here, we can offer you solutions such as water-cooled load banks for test facility use, as well as complete EMV solutions for water-cooled inverters with increased power for wind, solar, and industrial applications.

### Switch cabinet system 280A
Liquid cooling for converter 135 kW

- Complete switch cabinet for applications
  3x 480V / 280A
- Construction:
  - EMC filter CNW 107.3/280
  - Line reactor CNW MD 903/280
  - Motor reactor CNW MD 854/280
  - Brake resistor BW D 158  50 kW at ED 100%
  - Cooling circuit, laid out for water-glycol mixture
  - Water distributor with regulated cycles
  - Electrical connection: copper rails

Systems for water-cooled drives in a larger performance spectrum than a complete solution in a switch cabinet.

### Resistor load for test equipment

- The module design is suitable for any load unit in the laboratory and is designed for laboratory and development institutes as a variable unit.
  - According to: EN 50178
  - Test voltage: 8.6 kV for type 301/207
  - Protective type: IP 20
  - Ambient temperature: 40°C
  - Nominal voltage: 230/400V
  - Nominal power: DC 1 82.5 kVA
    - AC 1 3x 23 kVA
    - AC 2 3x 70 kVA
  - Modular compact design
  - Various circuit configurations
  - Can be used as a single or three-phase load unit
  - Higher power levels and other voltages upon request
  - Cooling: Water cooling for water – glycol mixture
Coolant liquids

Typical coolants and material suitability

1. **Water**
   - Percentages of calcium, magnesium, hardness, chloride, and sulfate can lead to deposits and corrosions.

2. **Deionized water**
   - Also called demineralized water
   - All ions, calcium, sodium, iron, copper, chloride, bromide, salt, and impurities have been removed
   - The higher the insulation effect, the higher the corrosiveness

3. **Glycol and aqueous solutions**
   - Ethyl glycol water has very good physical properties but is toxic
   - Propylene glycol water has slightly inferior properties but is better suitable for use in the food industry.

4. **Salt water**
   - Deposits and severe corrosion
   - Contamination must be taken into consideration

5. **Deionized water**
   - Distilled water
   - Very suitable for microchannels
   - No electrical charge or mineral deposits
   - Very aggressive and unusually corrosive

6. **Non-conductive liquids** - Dielectric liquids have properties similar to deionized water and are not very corrosive

To safely operate the equipment, the VGB cooling water guidelines must be strictly adhered to (VGB-R 455 P).

The most frequent contaminations in industrial cooling systems are:

- mechanical contaminations
- Excessive hardness
- Chemical contaminations
- Biological contaminations, e.g. algae, bacteria

In the standard design, the maximum inlet temperature is + 25°C and the maximum discharge temperature is + 45°C. Higher or lower temperatures are available upon request.

<table>
<thead>
<tr>
<th>Copper</th>
<th>Aluminium</th>
<th>Stainless steel</th>
<th>Liquid</th>
</tr>
</thead>
<tbody>
<tr>
<td>x</td>
<td>x</td>
<td>x</td>
<td>Water</td>
</tr>
<tr>
<td>x</td>
<td>x</td>
<td>x</td>
<td>Glycol</td>
</tr>
<tr>
<td>x</td>
<td>x</td>
<td>x</td>
<td>oils</td>
</tr>
<tr>
<td>x</td>
<td></td>
<td>x</td>
<td>Salt water</td>
</tr>
<tr>
<td>x</td>
<td></td>
<td>x</td>
<td>Deionized water</td>
</tr>
<tr>
<td>x</td>
<td>x</td>
<td>x</td>
<td>Non-conductive liquids</td>
</tr>
</tbody>
</table>
Pressure loss

Every component has a pressure loss that is very important for the design of the cooling system and the coolant pump. The coolant loss is a pressure difference created by wall friction and internal fluid friction in pipelines, fittings, valves, etc. The resistor number $z$ for components can be taken from table works. The resistor number itself can be dependent on volume flow, geometry, Reynolds number, etc.

Calculation of the total pressure drop when connecting multiple cooling components

- Determination of the individual pressure drops
- Calculation of the total pressure drop according to the following formulas:
- Determination of the pressure drop of the entire system

Temperature monitoring

Because of the small and compact component, the cooled components would overheat and be destroyed without the water cooling system. Therefore, for the water-cooled series, the temperature of the components can be monitored by means of a temperature switch. If a nominal temperature is exceeded, the temperature switch opens and triggers an alarm contact. The temperature switch is equipped with 2 wires that are ready to be connected. Therefore, if the water cooling fails, the system will be turned off.

The pressure losses can be determined in advance using simulation procedures and calculation programs.
**Important information about the design**

### Connections

<table>
<thead>
<tr>
<th>1. Standard thread AG or IG</th>
<th>Customer has the option to screw in his connections himself (very cost-efficient)</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>Size: G1/8” – 1”</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>2. Threaded sleeve</th>
<th>Material: Nickel-plated brass / stainless steel</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>Inner hose diameter: 2 – 32mm</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th></th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>Hose diameter: 6 – 12mm</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>4. Hose screw connection</th>
<th>Material: Nickel-plated brass / stainless steel</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>Hose diameter: 4 – 17.6mm</td>
</tr>
</tbody>
</table>

| 5. Separable hose connector low drip / non-drip | |

---

1. **Coolant**  
Which coolant is used? - Important for material selection and the design of the cooling system.

2. **Cooling channels material**  
Which other material is used in the system?? Important for durability and design!!  
E.G. Copper and aluminum may not be used in a circuit, otherwise a chemical reaction may occur between both materials, which could lead to destruction of the pipes.

3. **Flow volume**  
Important for the design of the cooling system and the components!!  
REO gives standard values in the data sheet. Deviations from this data must be inspected.

4. **Pressure drop**  
Important for the design of the cooling system and the interconnection of the cooling channels.

5. **Max. temperatures of the coolant during supply and return**  
Very important for the component design and the fulfillment of the customer’s requirements.

6. **Connections**  
A threaded connection is standard. REO also offers a wide spectrum of water connections.

**Connection variants**  
Generally, connections made of brass-plated nickel or stainless steel are used. What is important here is an agreement concerning the materials for the cooling channels. All hoses, seals, and components have a sufficient temperature resistance of > 100 °C. The most common connection variants are displayed in the following table. We will be happy to offer you other connection variants upon request.
Applications

**NTT RD 158**
Water-cooled resistor for rail technology
Nominal voltage: 4.2 kV / DC

**BW D 330/40000**
For use in vehicles.

**NTT BW 158**
Braking resistor 10 kW for the Project Coaster

**Choke CNW MD 953/180**
Nominal voltage: 480V
Nominal current: 180A

**Choke CNW MC 933/340**
Nominal current: 340A
Test voltage: 2.5 kV

**Combination EMV filter + PFC resistor**
Nominal voltage: 480V
Nominal current: 50A / 100A
Divisions - Germany

**REO INDUCTIVE COMPONENTS AG**

**Train Technologies Division**
Centre of Competence Berlin
Erasmusstraße 14 · D-10553 Berlin
Tel.: +49 (0)30 3670236 0 · Fax: +49 (0)30 3670236 10
E-Mail: zentrale.berlin@reo.de · Internet: www.reo.de

**IBK Drives Division**
Holzhausener Straße 52 · D-16866 Kyritz
Tel.: +49 (0)33971 485 0 · Fax: +49 (0)33971 485 50
E-Mail: ibk@reo.de · Internet: www.reo.de

**Setzermann Medical Division**
Schuldhofzanner Weg 7 · D-84347 Pfaffenhofen
Tel.: +49 (0)1861 9886 40 · Fax: +49 (0)1861 9886 40
E-Mail: setzermann@reo.de · Internet: www.reo.de

**Test and PowerQuality Division**
Brühlertstraße 100 · D-42657 Solingen
Tel.: +49 (0)212 8804 0 · Fax: +49 (0)212 8804 188
E-Mail: main@reo.de · Internet: www.reo.de

---

**China**
REO Shanghai Inductive Components Co., Ltd
No. 536 ShangFeng Road · Pudong · 201201 Shanghai · China
Tel.: +86 (0)21 5858 0686 · Fax: +86 (0)21 5858 0289
E-Mail: info@reo.cn · Internet: www.reo.cn

**France**
REO VARIAC S.A.R.L.
ZAC Du Clos aux Pas · 686 rue de la Close-LUSSE · F-91048 Evry Cedex
Tel.: +33 (0)1 69 11 1898 · Fax: +33 (0)1 69 11 0918
E-Mail: reovaric@reo.fr · Internet: www.reo.fr

**Great Britain**
REO (UK) Ltd.
Units 2-4 Callow Mill Road · Craven Arms · Shropshire SY7 8NT · UK
Tel.: +44 (0)1588 672 411 · Fax: +44 (0)1588 672 718
E-Mail: main@reo.co.uk · Internet: www.reo.co.uk

**India**
REO GPD INDUCTIVE COMPONENTS PVT. LTD
2/202 Luna Road · Village Luna · Taluka Padra · Vadodara · 391440 · India
Tel.: +91 (2652) 221723, +91 (265) 2396971 · Fax: +91 (265) 2396971
E-Mail: info@reoag.in · Internet: www.reo-ag.in

**Italy**
REO ITALIA S.r.l.
Via Treponi · 25 · I-25086 Rezzato · BS
Tel.: +39 030 278 3883 · Fax: +39 030 279 0600
E-Mail: info@reoitalia.it · Internet: www.reoitalia.it

**Poland**
REO CROMA Sp.z.o.o
ul. Pozarnskiego 28, bud20 · PL-04-703 Warszawa
Tel.: +48 (0)22 812 3066 · Fax: +48 (0)22 815 6906
E-Mail: croma@croma.com.pl · Internet: www.croma.com.pl

**Russia**
REO RUSSIA Ltd.
17/2, Dorozhnyaya st., Voronezh 394062 · RUSSIA
Tel.: +7 (0473) 202 453 · Fax: +7 (0473) 207 011
E-Mail: info@reo-russia.ru · Internet: www.reo-russia.ru

**Spain**
REO ESPAÑA 2002 S.A.
C/Manuel Ventura i Campany 218 · Local 9 · E-08339 Vilassar de Dalt · Barcelona
Tel.: +34 937 509 994 · Fax: +34 937 509 995
E-Mail: info@reospain.com · Internet: www.reo-spain.com

**Switzerland**
REO ELEKTRONIK AG
Im Halbucker Sa · CH-8352 Elsau
Tel.: +41 (0)52 363 2820 · Fax: +41 (0)52 363 1241
E-Mail: info@reo.ch · Internet: www.reo.ch

**Turkey**
REOTURKEY ELEKTRONIK San. ve Tic. Ltd. Şti.
Halil Rıfatpasa Mah · Darülçeze CD Perpa Tic Merkezi B Blok Kat 8 No:1095 · TR-34384 Sisli · Istanbul
Tel.: +90 (0)212 2215 118 · Fax: +90 (0)212 2215 119
E-Mail: info@reo-turkey.com · Internet: www.reo-turkey.com

**USA**
REO-USA, Inc.
8450 E. 47th St · USA-Indianapolis, IN 46226
Tel.: +1 (317) 899 1395 · Fax: +1 (317) 899 1396
E-Mail: info@reo-usa.com · Internet: www.reo-usa.com