FFG Werke GmbH offers a broad range of turning, milling, and gear manufacturing technology, based on the knowhow of the renowned machine tool brands VDF Boehringer, Hüller Hille, Hessapp, Honsberg, Modul and Witzig & Frank. These brands are well known as reliable and innovative equipment suppliers for the automotive and truck, machine building, general machining, railway, aerospace, energy and heavy engineering industries. The company has a global footprint, which is enhanced by a network of strong sales & service partners. While being an independent group member, FFG Werke GmbH benefits from the strengths and opportunities of the global Fair Friend Group. The brand FFG Europe stands for premium technology within FFG. Apart from the German brands, it comprises the Italian manufacturers Jobs, Sachman, Rambaudi and Sigma.







FFG Werke GmbH

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Brands Excellence for your Production

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HESSAPP

Honsberg



WITZIG & FRANK



FFG Europe's Renowned German Machine Tool Brands

VDF BOEHRINGER

Longstanding tradition in horizontal turning technology, leading in longterm performance and quality



- Universal lathes
- ► Horizontal turning centers
- ► Horizontal turn/mill centers

HESSAPP

Pioneer in vertical turning technology



- Vertical turning centers
- Pick-up type vertical turning centers
- Pick-up type vertical turning centers with transfer technology

HÜLLER HILLE DIEDESHEIM

Machining centers for demanding production tasks



- 4- and 5-axis horizontal machining centers
- ► Flexible manufacturing systems

Honsberg

Service solutions for manufacturing systems



- Transfer lines
- Special machines
- Systems retrofit

MODUL

Over 110 years of gear manufacturing technology from Chemnitz



- Hobbing machines
- Gear manufacturing centers
- Chamfering/deburring machines

WITZIG & FRANK

Modular machine concepts for metal cutting and forming applications



- ▶ Multi-way rotary transfer machines
- Multi-spindle, multi-station machining centers
- Special machines

Contents

Turning technology

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FFG Werke GmbH – company profile 22/23

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VDF BOEHRINGER **Horizontal Turning**

DUS-Series -Cycle Controlled Universal Turning Machines

VDF DUS turning machines for single workpieces or small batch sizes

The VDF DUS series universal turning machines was optimized technically and economically to suit your manufacturing requirements, covering a wide range of applications. Many machine types and a large number of options accommodate a wide range of solutions to fulfill your requirements and allow for highly-economical use even in special applications.

Due to the cycle control and the possibility of manual operations, machines of the DUS series are mainly used for single workpiece or small batch size production. An automatically-indexing turret in combination with a second chip protection door allow full CNC machining and therefore the enhancement of efficient use in medium batch sizes as an alternative to a CNC lathe.

Achieve high performance and precision -VDF DUS series from S to XXL

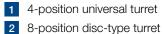
- ► Turning lengths from 1000 mm up to 20 000 mm
- ► Swing over bed from 420 mm up to 1600 mm
- ► Drive power 11 kW up to 65 kW
- ► Workpiece weight up to 16 tons (VDF 1600 DUS)
- ► Manual turning for single workpieces
- ► Step-by-step operations (cycles) for small batch sizes
- ► CNC mode for larger batch sizes
- ► State-of-the-art control Siemens Sinumerik 840D sl or Heidenhain Manualplus 620











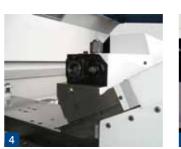
3 Turning, drilling and

milling unit

4 Y-axis

- 5 Boring rest with additional support rest for long boring bars
- 6 With the stationary steady rest, all quills can be adjusted from the front reducing the risk of accidents through optimal accessibility
- 7 Travelling steady rest
- 8 Stationary, self-centering and hydraulically-operated steady rest
- 9 Traveling, self-centering and hydraulically-operated steady rest
- 10 C-axis
- 11 Grinding devices
- 12 Big Bore rear end chuck with spindle size 20 and bore diameter 365 mm













Technical data





VDF 400 DUS

VDF 560/630 DUS

Technical data







Universal turning machines		VDF 400 DUS	VDF 560 DUS	VDF 630 DUS	VDF 800 DUS	VDF 1000 DUS	VDF 1110 DUS	VDF 1600 DUS
Turning length	mm	1000	1000-8000	1000-8000	1000-20 000	1000-20 000	1000-20 000	2000-12 000
Swing over bed/cross slide	mm	420/235	570/365	640/435	820/500	1000/700	1110/810	1600/1150
Stroke of cross slide/compound slide	mm	250	345	345	540	540	540	900
Cutting tool cross-section, per DIN 770 h x b	mm	25 x 25	32 x 25	32 x 25	40 x 25	40 x 25	40 x 25	50 x 50

VDF BOFHRINGER

VDF T Series -**Horizontal Turning Centers**

Distinctively VDF

The robust construction of every VDF T / VDF TM machine is designed to meet the highest demands for stability, allowing for complex and simultaneous machining operations. The beds are made of polymer concrete to provide maximum rigidity and damping. High-quality linear roller guides ensure precision and a long service life which is the only way to guarantee constant high precision over many years - part after part. Drives and guideways are state-of-the-art, providing long-term high performance and precision.

Your advantage

- ► Machine concept tailored towards optimized part costs
- ► Configure the VDF T machine in-line with your specific
- ► Robust machine design ensures reliable, long-lasting precision in production
- ► Excellent accessibility to all modules provides easy setup and operation
- ► High technology competence
- ► Easy operation and service
- ► Easy integration of automation features

Application range of the VDF T series

- ► High volume production short cycle times
- ► Large variety of parts sizes (depending on machine type)
- ► Fully-automated production, including process monitoring
- Heavy machining
- ► Hard and soft turning (replacing grinding operations)

Technologies on board

- Hard turning
- Superfinishing
- ▶ Lead-free turning
- ▶ High pressure coolant
- ► Turning with minimal quantity lubrication (MQL) Dry machining
- Drilling, milling
- Complete machining
- Cutting to length and centering
- Hobbing





Work area with upper and lower tool turret Work area with two upper tool turrets

VDF TM Series – Horizontal Turn/Mill Center

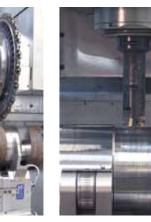
VDF 450 TM - Turn/mill center for complete machining of medium-sized workpieces

- ► Large working range for highest demands (X-stroke up to 725 mm / Y-stroke up to 300 mm)
- ► High-torque geared spindle (max. 5340 Nm)
- ► 4-axis machining with additional lower tool turret
- ► Upper tool turret with B-axis and powerful milling spindle (max. 380 Nm)
- ► Tool shuttle for quick tool change









Shaft machining with milling cutter

Technical data

Turning centers Turning length

Turning diameter

Swing over bed

Spindle nose

Main spindle

Turret



mm

mm

mm

size

type









Turn/mill center VDF 450 TM for single setup machining



Technical data



VDF 450 TM		Turn/mill center	VDF 450 T	VDF 400 T	VDF 300 T	VDF 250 T	VDF 180 T
1300/2200/3400/4500	mm	Turning length	1300/2200/3400/4500	1300/2200	850/1850	850/1850	900
650	mm	Machining diameter	650	650	350	290	290
700	mm	Swing over bed	700	700	620	620	620
A11	size	Spindle nose	A11	A11	A11	A6	A8
geared spindle	type	Main spindle	geared spindle	geared spindle	geared spindle	motor spindle	single-stage drive
-175/+210	mm	Y-axis	VDI 50 radial	VDI 50 radial	VDI 40 radial	VDI 40 radial	VDI 40 radial

Vertical Turning

DVH Series – Single Spindle Pick-Up Type Vertical Turning Machines

The DVH series pick-up type vertical turning machines provide maximum productivity and quality in modern production. More than 20 years of experience in the development and production of pick-up style vertical turning machines combined with continuous further development help you to master the process requirements of today. The consistent focus on technological solutions has given rise to an enormous pool of knowledge and experience – from which you too can benefit.

Advantages

- ► The pick-up principle
- Integrated automatic loading/unloading
- Low cost per piece through high productivity
- Multiple machine operation as the machine is decoupled from the operator
- ► Optional upgrades to the standard model
- X- and Y-axes for drilling operations
- Additional 4-axis cross slide (improves efficiency by up to 45%)
- ► Excellent ergonomics
- Easily accessible, generous work area
- Ideal setup conditions, ensuring extremely short unproductive downtimes
- Large window for monitoring the manufacturing process



Two drilling turrets and additional Y-axis



Ergonomic work area



Hard turning/grinding as option

DVT Series – Pick-Up Type Vertical Turning Machines with Transfer Technology

Unique machine design

DVT is the original Hessapp design for complete machining without compromise, combined with maximum precision. When it comes to high precision in sequential chuckings, in particular, the advantages are significant, as the workpiece is transferred to the next chuck still clamped, without losing its position. Ever more restricted production floor space requires a compact machine design. Compared to the footprint of two individual interlinked machines with a turnover station, the advantages of the DVT are especially obvious.

Ergonomic machine design with large doors and windows provide for maximum user friendliness, easy setup and fixturing. Without the turnover station between chuckings, automation setup times are also minimized.

Advantages

- ► Innovative transfer technology
- Automatic loading/unloading of the machine
- Workpiece transfer with maximum positioning accuracy

HESSAPP

- No conveyors or turnover stations between the first and second chucking operations
- Low cycle times and minimal setup times
- Complete machining (2 clampings) in one machine
- ► Flexible automation solutions
- Self-loading/unloading
- No loaders required
- Easy changeover to different workpiece diameters
- Problem-free linking to other equipment



Work area



Workpiece transfer



Machining on stationary spindle

Technical data



DVH 200



DVH 300



DVH 630

	B.	

Work area		DVH 200	DVH 300	DVH 400	DVH 500	DVH 630	DVH 750
Turning diameter max.	mm	220	260	450	500	570	630
Swing diameter max.	mm	260	320	510	510	630	750
Part height with chuck	mm	320	320	470	470	450	500

Technical data









DVT 200

DVT 300

DVT 400

DVT 500

Work area		DVT 200	DVT 300	DVT 400	DVT 500	DVT 630	DVT 750
Turning diameter max.	mm	220	260	450	500	570	630
Swing diameter max.	mm	260	320	510	510	630	750
Part height with chuck	mm	320	320	470 US/360 LS*	470 US/360 LS*	470	500

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Vertical Turning

VDM Series -**Vertical Turning Centers**

You provide us with a complex workpiece or process, we develop the appropriate system solution (including clamping devices, tools and control system) that meet your individual demands.

- ► Precise and secure workpiece clamping utilizing workpiece weight
- ► Highest accuracy through the thermally-symmetric design of the spindle housing with closed circuit oil lubrication
- ► Extremely rigid machine base
- ► High flexibility for an optimal solution of complex turning tasks
- ► Ergonomically convenient for operating and easy access to the work zone
- ► Optimal chip management through 45° angle of the machine base

Fields of applications

- ► Small to large part sizes (depending on machine type)
- ► Fully automated production including process monitoring (optional)
- Heavy machining
- Hard turning and super finishing

Technologies

- Turning
- Drilling
- Milling
- Grinding
- Hard turning
- Hobbing

Examples from our range of workpieces







Hard turning





Cross slide

- ► Heavily ribbed cast iron construction for high rigidity
- ► Optimal guidance, guideways made of hardened and ground profile bars
- ► High positioning accuracy, consistent precision and
- ▶ Linear measuring system with pneumatic overpressure

Technical data



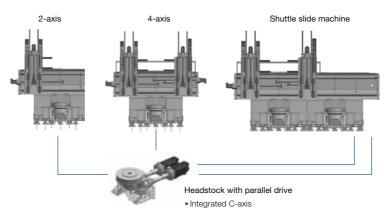






Work area	VDM	250	550	800	1000	1600	2000
Turning Ø max.	mm	250	600	800	1150	1600	1800
Swing Ø max.	mm	350	680	950	1450	1800	2000
Workpiese height							
with chuck	mm	300-900	600	800	1000	1000 (Opt. 1600)	1000 (Opt. 2000)

VDM modular kit





Grinding unit



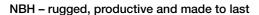
Drilling- and milling unit

Tool holder

HESSAPP

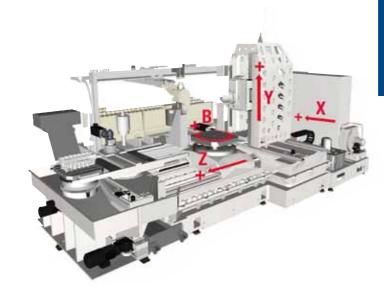
Horizontal Milling

NBH Series – Horizontal Machining Centers



With decades of success, the NBH series has now been updated according to modular design principles, available in pallet sizes from 500 x 500 mm up to 1000 x 1250 mm. The new series adds state of the art design, technology and control features, adding a new chapter to more than 40 years of machining center expertise.

Traditionally, the letters NBH stood for quality and performance in production, which were now even enhanced regarding ruggedness, productivity and endurance. The new models were designed for increased output and lower cost per part, best-in-class availability, excellent maintainability and maximum application and manufacturing flexibility. They are ideally suited for high volume automotive and tier supplier applications as well as mid-range, small and single part industrial production.



Distinctively NBH -

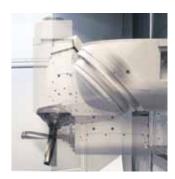
advantages of the NBH machining centers

- Modular design with a variety of table, spindle and tool magazine options allows you to configure the machine according to your needs
- Reduced positioning and idle times due to high rapid traverse rates up to 70 m/min and rotary table positioning up to 80 1/min
- Robust guideway system with large ball screws, bearings and guideways, and backlash-free, preloaded guiding units, as well as a heavy machine bed for long-term precise heavy duty machining
- Digital drives with maintenance-free, brushless, digitally controlled three-phase servo motors in completely closed design
- ► High-performance geared spindle up to 2600 Nm torque
- ► Easy upgrading for flexible production cells and systems
- Multi-pallet storage system
- Linear and multi-level pallet storage system
- Robot and gantry loader automation

NBH 630 5X

Swivel head motor spindle

Spindle speed	1/min	10 000
Power 100%/40% ED	kW	30/38
Torque 100%/40% ED	Nm	286/378
Swivel range, horizontal = 0°	deg	0 to -225



HÜLLER HILLE

□ DIEDESHEIM □

NBH 800 5X

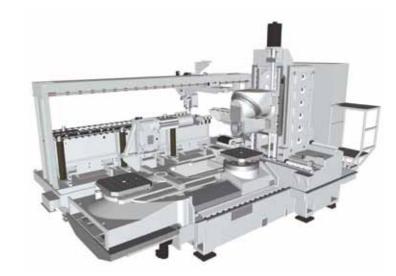
NC tilting/rotary table

Pallet clamping surface	mm	800 x 800
Interference	Ø mm	1200
Pallet load	kg	1500
Swiveling range A-axis	deg	-30 to +120
Swiveling range B-axis	deg	360



For large part machining on NBH 1000 models, a 5-axis swivel geared spindle is available, which is suitable for 5-sided machining and angular drilling.





Technical data







Technical data









Horizontal machining centers	type	NBH 5	NBH 500	NBH 6	NBH 6+	NBH 630	NBH 800	NBH 1000	NBH 1200
X-/Y-/Z-axis	mm	700/630/700	900/800/900	800/800/800	1050/800 [1000]/1000	1025/800 [1000]/1000	1400/1100 [1400]/1400	1800/1400/1800	1800 [2600]/1250 [1600]/1400 [1780]
Pallet clamping surface	mm	500 x 500	500 x 500	630 x 630	630 x 630	630 x 630 [800 x 800]	800 x 800 [1000 x 1000]	1000 x 1000 [1000 x 1250]	1000 x 1250
Interference	Ø mm	700	900	900	1150	1150	1600	2000	2100 [2400] [2800]
Chuck height	mm	1000	1000	950	1300	1300	1500	1800	1350 [1700]
Pallet load	kg	500	800	1000	1500	1500	2000	3000	3500 [7000]
									[] = option

Multi-way Milling Technology WITZIG & FRANK

Witzig & Frank offers a broad range of equipment and technologies for volume production – from proven, highly productive transfer systems to flexible multi-station, multi-spindle machining centers. Applications include automotive powertrain components, faucet, fittings, construction equipment, electrical engines, as well as household equipment and hand tools.

Witzig & Frank's technology, turnkey and systems knowhow comprises various machining technologies, clamping and fixturing variants, automation and workpiece handling as well as control and drive options.

Machine models

- ► TURMAT Multi-way rotary transfer machine
- ► LSA Multi-way manufacturing cell
- ➤ TRIFLEX Modular multi-station machining center for single setup 5-sided machining
- ► TWINFLEX / TWINFLEX MD multi-spindle two-station machining center



TRIFLEX machine with Uniflex turret head

Industrial Applications







Technology examples

Witzig & Frank machines are ideally suited for integrated machining solutions.

Milling



Drilling



Broaching



Inside turning



Threading



Draw bar tools



In-process bush pressing



Integrated drill hole control



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Hobbing, Chamfering and Deburring

of Gears, Ring Gears and Shafts

The small and medium sized Modul hobbing machines were designed for efficient gear manufacturing, including hobbing, chamfering and deburring of medium-sized gears, ring gears and shafts with single or multiple gearings up to 400 mm in diameter and module 8.0. Typical applications include hobbing, chamfering and deburring of wheels, rims and shafts with single or multiple gearings. Auxiliary equipment is available to match the machine to your tasks. Our machines are suitable for all hobbing and gear milling processes, including skiving of hardened gears.

All models are suitable for dry and wet processing. High speed, carbide or milling cutters are applied according to the application, together with various configurations of hob heads and table drives. Our portfolio covers spurs, helical, spheric and tapered gearings, as well as software options for shafts with multiple gearings, worm gears, chain wheels and special profiles. Our patented CDT technology allows for integrating various auxiliary technologies directly into the hobbing machine, such as chamfering, deburring and radial drilling. The CD machine series for chamfering and deburring completes the range of solutions for integrated gear manufacturing, in gear manufacturing centers, single technology machines, manufacturing cells or lines.

single setup hobbing, chamfering and deburring

SynchroCut for burr-free flanks -

The SynchroCut concept is based on the CDT technology. The synchronised chamfering spindles are interfaced with the ongoing hobbing process and work time-parallel to the gear cutting process. The special 2-cut-chamfer/deburr-strategy guarantees almost burr-free flanks without secondary burrs. With this fully CNC-controlled process, gears and shifts can be deburred with very little effort for setup, changeovers and corrections. Apart from enhanced qualities, cycle times are being reduced despite auxiliary processes.





Hobbing of gears and ring gears Hobbing of shafts



CDX - solutions for integrated or separate chamfering/deburring

Gear Manufacturing



Powerhouse for gears, shafts and screw-type workpieces

The large hobbing machine series from Modul are very stable and rigid machines for the most demanding cutting tasks. The machine employs all hobbing techniques of spur and helical gearings using one or multiple cut technology with climb or conventional feed exploiting the different tool solutions available on the market, like hobs and milling cutters. For very large modules like rotors, or for machining tough materials, the machines are equipped with exceptionally strong, high torque PowerCutting tool spindle drives.

The H 600/800 series can be automated with a standard ring loader. For heavy workpieces, gantry loaders and pallet storage systems can be applied. The H 900 - 2300 series is equipped with a backlash-free double wormgear drive providing highest accuracy even at low speeds. Internal gearings can be machined with optional internal milling heads and corresponding adapters.

- Very stable and rigid structure
- ▶ Direct drive worktable up to model H 800
- ► Extended counter column for longer workpieces
- Workpiece support solutions for longer parts
- Automation option via ring loader
- Dedicated worktable design option for rotor cutting
- ► Compact layout with integrated auxiliary units









Hobbing of worm gears



Form milling of gears



Internal form milling

Technical data





Technical data









		H 80/100/130/160/200 (CDT)	H 250/300/400 (CDT)	H 250 CDM	CD/CDA/CDX 250	H 600/800	H 900/1500/2300
Workpiece diameter max.	mm	80/100/130/160/200	250/300/400	250	250	600/800	900/1500/2300
Module max.	mm	4.0	8.0	5.0	5.0	18.0/22.0	24.0/28.0
Radial travel max.	mm	10-100/25-115/45-135/60-150	25-205/40-255/60-285	25-205	_	70-495/595	65-695/80-1000/460-1480
Axial travel max.	mm	100-300/450	200-600/800	200-800	_	310-1110	310-1330/310-1710

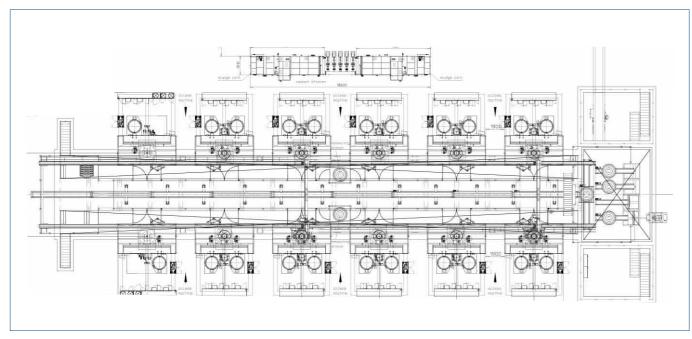
Automation Solutions

Automation Solutions

Flexible automation concepts

We help you to design a process tailored to your workpiece, manufacturing requirements, quality standards and production environment. The result of this joint engineering process is a solution that includes an integrated, efficient automation concept.





Manufacturing system for train wheels with Hessapp VDM vertical turning machines

All Hüller Hille machining centers can be equipped with

- ► Multi-pallet storage system (MPS)
- Linear pallet container (LPC)
- ► Multi-level pallet storage system
- ► Multi-pallet handling system (MPH)
- ▶ Robot and gantry loader automation

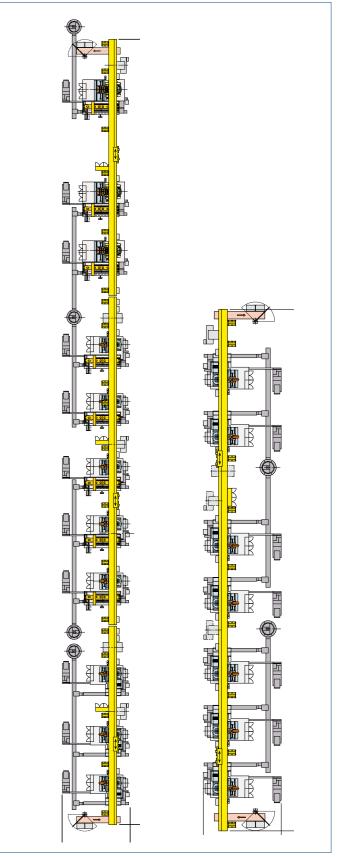
These optimized modules for flexible production cells and systems can be used in combination with various machine types and technologies.



Direct loading of an NBH 800 5X via robot



Multi-level pallet storage system with 34 pallets on two levels



Manufacturing line for heavy duty cast transmission housings on 18 Hüller Hille machining centers NBH 630 and NBH 800 5X with NC tilting/rotary table for precise 5-axis machining

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Service for all Brands and Legacy Brands of FFG Werke GmbH



FFG 24/7 Service and Support: www.ffg-werke.com/24x7

VDF BOEHRINGER



Horizontal turning machines

Service Center Goeppingen Stuttgarter Strasse 50, 73033 Goeppingen Tel: +49 800 000 5639

HESSAPP



Vertical turning machines

Service Center Taunusstein Aarstrasse 57, 65232 Taunusstein Tel: +49 612 824 3260

HÜLLER HILLE DIEDESHEIM



Horizontal machining centers

Service Center Mosbach Steige 61, 74821 Mosbach Tel: +49 626 166 123

Honsberg



Transfer lines, special machines

Service Center Witten Stockumer Strasse 28, 58453 Witten Tel: +49 230 217 90-0





Gear manufacturing

Service Center Chemnitz Marienberger Strasse 17, 09125 Chemnitz Tel: +49 371 576 386

WITZIG & FRANK



Multi-way rotary transfer machines, multispindle, multi-station machining centers

Service Center Offenburg Am Holderstock 2, 77652 Offenburg Tel: +49 781 289 1121

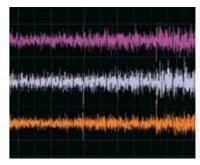
Service and support

- Commissioning
- ► Maintenance and inspections
- Repair service
- ▶ Spindle service
- Overhaul and retrofit
- Used machines
- ▶ Service contracts
- Machine relocation

Process and production optimization

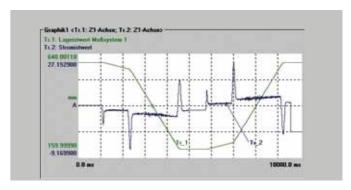
- Process optimization
- Programming
- Software: machine data acquisition, diagnosis, condition monitoring, energy management, virtual machine











Machine condition monitoring "Finger print" via vibration analysis, ballbar test and trace measurement.

Spare parts

- ▶ 24/7 delivery
- ► Central warehouse
- ► Individual service concepts



Training

- Operator training
- ► Maintenance training (mechanical, electrical)
- ▶ Programming training

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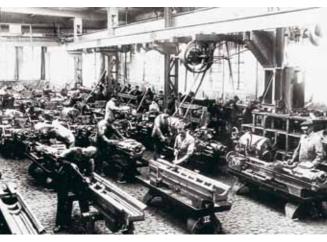
FFG Werke GmbH - Renowned German Machine Tool Manufacturers

Machine tool knowhow since 1789

The history of FFG Werke GmbH's brands starts with the foundation of the Honsberg company in 1789. VDF Boehringer, Hüller Hille, Hessapp, Honsberg, Modul, and Witzig & Frank have, since then, continually been drivers of innovation in the German machine tool industry. The first large international order was granted to VDF Boehringer as early as 1893, when Russian National Railways ordered 115 lathes in Göppingen. The success story of standardization was triggered by the VDF

standard lathe already in 1928. Modul can claim more than 110 years of development in gear manufacturing technology from Chemnitz. Among further milestones in production technology are the first rotary transfer machine by Witzig & Frank in 1932, the first Hessapp vertical turning machine in 1947 and the Hüller Hille machining center tradition of over 40 years.





Sites in Germany

Goeppingen

The company's headquarters in Goeppingen, which is linked to VDF Boehringer, combines application, sales and service capacities and is a full scope show room close to the customer base in the South-West of Germany.



Mosback

Home of the brands Hüller Hille and Diedesheim, the manufacturing site has becomes synonymous with the NBH series horizontal machining centers.



Offenburg

At the Offenburg plant, the advanced Witzig & Frank volume production solutions are being developed and built.

Witten

As a service location, Witten is close to the customer base in Western and Northern Germany, with special capabilities for Honsberg installations.



Taunusstein

As a pioneer of vertical turning technology, Hessapp brings together experience and innovation. The CNC turning centers form Taunusstein cover a wide range of applications.



Chemnitz

The Chemnitz site has a direct link to the first origins of hobbing technology. Today, the Modul experts offer complete gear manufacturing solutions.

Our Knowhow for Your Competitive Edge



"Reliable maintenance, comprehensive support and flawless spare parts management are the decisive factors in daily operations. With more than 200 highly qualified service engineers around the globe, we secure your productivity and apply our knowhow for your competitive edge."

Dirk Budde - Service



"When you're facing complex manufacturing tasks and dynamic market requirements, you need an experienced partner and tailored solutions. Our dedicated team of sales engineers and global representatives is at your service to configure and design the eugipment that fits your requirements."

Martin Winterstein - Sales & Marketing



"High quality products made in Germany - that has been our focus for many decades. We apply the same strict quality standards in our German manufacturing plants as during commissioning at our customers' sites. Regular external audits and continuous improvement processes ensure that we're always up to date for maximum productivity"

Giuseppe Iossa – Operations

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