

holzimpulse

PERSPECTIVES FOR YOUR COMPANY

2021

*New:
H.I.T. Finger Jointing
Technology
(Page 2)*

Innovations for your success

SAWING TECHNOLOGY | FINGER JOINTING TECHNOLOGY | PLANING TECHNOLOGY | GLULAM TECHNOLOGY



PAGE 4 Automated sorting and glulam production



PAGE 6 Highly flexible order picking system in the timber wholesale trade

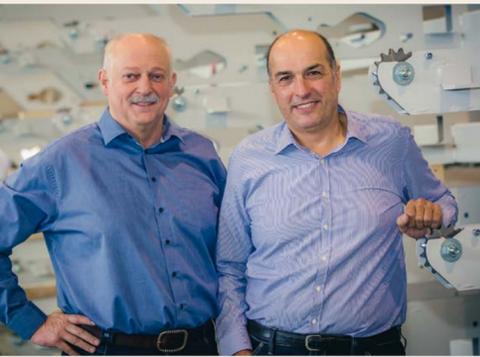


PAGE 12 Production line for solid beech wood products



PAGE 14 More flexibility – NSM Resawing Line and ASM Automatic Resawing Line

NEWS AT H.I.T



Franz Jeckle and Franz Anton
Managing Directors of H.I.T.

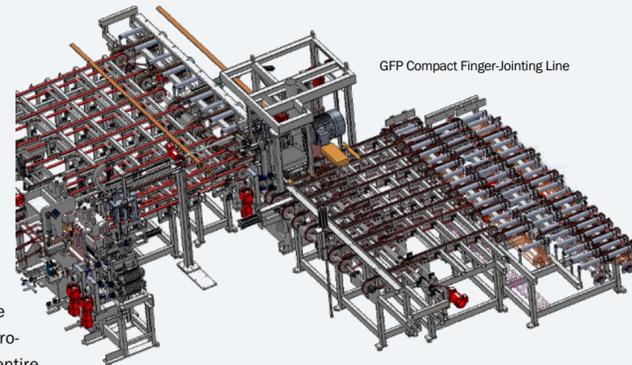


On the way to becoming a full-range supplier

Now it's official: H.I.T. has taken the next big step on the way to becoming a full-range supplier in the timber industry by hiring all former SMB employees and acquiring all design documents and rights for the former SMB machines.

With our newly founded subsidiary **H.I.T. Keilzinkentechnik GmbH & Co. KG**, we see ourselves in the great position to continue the production and further develop the entire range of machines of the former SMB. With a combined 80 years of experience in the timber industry and merging the competence of H.I.T. in plant engineering and the proven SMB machines for finger jointing lines, we will be able to offer you convincing complete end-to-end-solutions in the future.

For the quickest possible start of the newly founded company with its own location in Breitenenthal – approx. half an hour's drive away from our headquarters in Ettringen – Managing Director Werner Spieth receives support from Hans Lieble, who will continue to act in an advisory capacity, and Markus Graf as Operations and Design Manager, among others.

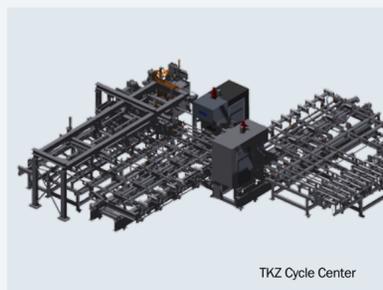


GFP Compact Finger-Jointing Line

Our focus will be to guarantee that you get the usual reliability in planning and execution together with all the other services you were used to.

The finger jointing lines that have been on the market for decades and are still competitive in all aspects thanks to continuous further developments and cover the whole range from **compact lines to cycle centers to packet lines**.

We are looking forward to working on the first joint projects with you and wish our new colleagues at H.I.T. Keilzinkentechnik a good start at their new location!



TKZ Cycle Center



Werner Spieth Hans Lieble Markus Graf

H.I.T. Keilzinkentechnik GmbH & Co. KG
86488 Breitenenthal | Steinbach 2
Telefon 08282/6034300
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New structures, new website

With the addition of finger-jointing technology, we have also addressed the concept of our online presence and will soon initiate the relaunch of our H.I.T. website.

Besides modernizing the design and updating our range of services, increasing the user-friendliness is another objective. The website will be optimized for mobile devices so that all content will also be accessible via smartphone or tablet.



Modernization: feeding and removal equipment for joinery plant

At their site in Reuthe, Austria the Mayr-Melnhof Group invested in a new joinery plant in response to the increased demand and the necessary higher flexibility.

The replacement of the joinery plant also made it necessary to expand the existing mechanization equipment. This means that timber can now be conveyed to the joinery machine directly after the planing machine, or packages

can be transported directly to the infeed after the stacking machine, where they are then placed on the infeed for joinery using a vacuum gripper. As the timber is already final planed at this point, special attention was paid to a transport that is gentle on the timber.

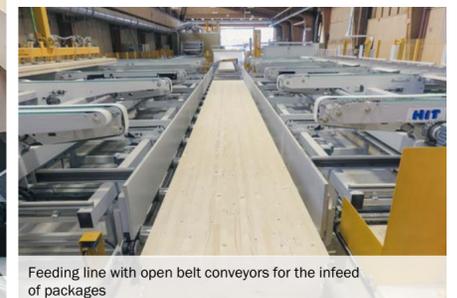
Another challenge was the consideration of the existing production processes and the available floor space, which required some special constructions.



Direct transport after the planer to the joinery with liftable and lowerable belt conveyor in the roller conveyor



Feeding line with closed belt conveyors



Feeding line with open belt conveyors for the infeed of packages

Automated sorting and glulam production

Founded as a sawmill and timber construction company back in 1905, the Aumann Group has developed into a full-range supplier of solid timber products. The sawmill operation was abandoned several years ago in order to concentrate increasingly on the production of glued laminated timber products.

At the company headquarters in Ziemetshausen, Aumann offers the complete range of services in timber construction, tailored to the customer's wishes. The services range from the production of the required timber products to the planning and construction of residential, factory and commercial buildings.

The Aumann Group employs 160 people, about half of whom are responsible for glulam production at ASTA Holzwerk. The other half is employed in timber construction.

The 200,000 m³ of dried raw material required for production is mainly procured within a radius of 250 km. A share of approx. 15 % is accounted for by Scandinavian sawn timber. All sawn timber is PEFC certified. The finished products are mainly sold in the D-A-CH countries.

To meet the increasing demand, company owner Theo Aumann decided to set up a completely new production line. The start of construction in 2018 was preceded by an intensive planning phase. H.I.T. was awarded the contract for the supply of the entire quality sorting system as well as for the complete equipment for glulam production downstream of the final planing machines.

Planing line and quality sorting

The line is primarily used for preplaning and sorting the raw material for glulam production into up to 7 assortments. However, it can also be used for the production of special assortments, such as planed timber for the company's own timber house construction.

The planer is followed by a longitudinal transport through a scanner for mechanical strength grading and a marking station for the application of the quality and cross-cut markings.

The sawn timber packages are loaded with a forklift truck. The packages are unstacked layer by layer by pushing off the top layer in longitudinal direction. The stacking strips are collected in a box. After destacking, the separation is completed before the timber passes the moisture measuring station and the curvature and board position detection. Timber lying on the wrong side is turned to the right side using a board turner; boards that are too crooked or boards with the wrong moisture content are ejected via an ejection flap in front of the planer and collected in a trolley. The exact cutting to length is also carried out upstream of the planer, and the timber can also be cut symmetrically with a center cut. With the subsequent accelerator, the timber is accelerated longitudinally to be fed into the planer without gaps.

The main assortment is stacked into packages with a separate stacking machine. The other assortments are sorted into 6 levels. From these levels, the timber is taken in layers on a lift and stacked into packages by means of a vacuum gripper.

All packages are taken over by a shuttle and prepared for removal by forklift.

The original requirement to operate the entire line with only one employee at the plant was even exceeded. The aim was to operate the line unattended, so that only the forklift drivers would be needed for loading and unloading the line.



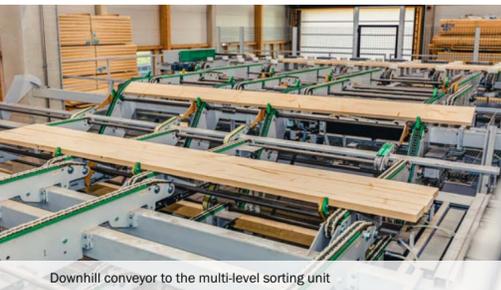
Package infeed with push-off destacker



Feeder and accelerator to the planer



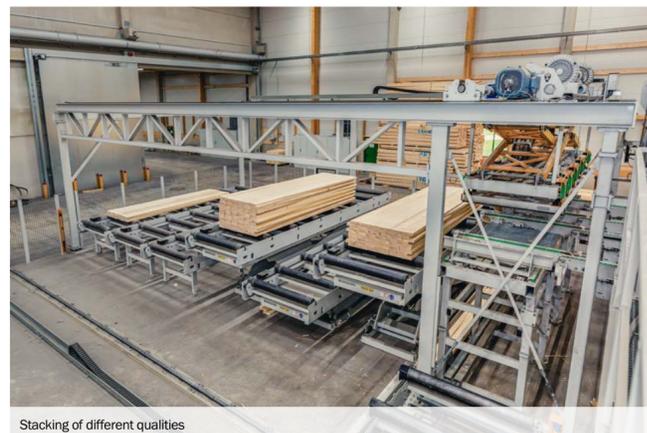
Stacking line with automatic strip positioning unit



Downhill conveyor to the multi-level sorting unit



Longitudinal transport through the marking station after the scanner, feeding to the stacking machine or to the multi-level sorting system



Stacking of different qualities



Shuttle for the removal of the packages from the picking area



Length cutting and stacking on the second level

Glulam production plus

The part of the line installed by H.I.T. starts with the takeover of the final planed products after the planing machines. Depending on the product width (either up to max. 400 mm or up to max. 1,000 mm) the planers are loaded. Based on the pre-selected mode (visible or non-visible goods), the timber is either distributed to the patching/repair stations located on an upper floor or directly to one of the two cross-cut saws for cutting to length.

is either stacked with another stacking machine or prepared for removal with the picking gripper.

In the floor storage area up to 2 packages can be formed in longitudinal direction one behind the other. The storage assignment is optional and is managed by a superordinate master computer system. Based on the stored package planning, the system provides the picking gripper with the storage position, which it approaches accurate to the millimeter and assembles the packages. On an upper level, timber can be stored for being added to the package at a later stage.

A package alignment system integrated before the package wrapping unit ensures precisely aligned packages without any significant gaps between individual pieces of timber.

The packages prepared for dispatch in this way are now either stored in a warehouse with a crane or loaded directly onto a truck.

Due to the high quality demands of the Aumann company concerning the final product, all conveyor systems were designed with special consideration of the gentlest possible timber transport, so that, for example, the cross conveyors are equipped with belts.

Timber with a width greater than 650 mm is always manipulated via the upper deck, where it is cut to length and stacked into packages.

Narrower timbers are also cut to length individually or in batches and then transported in the direction of the package formation unit. This line also has an integrated foil wrapping unit, which can also be used to wrap individual pieces of timber with stretch film. Afterwards, the timber

The completed packages are moved lengthwise out of the floor storage area by a carriage moving under the packages and transferred onto a shuttle, which also takes over the packages coming from the second level and transfers them to the package packing line.



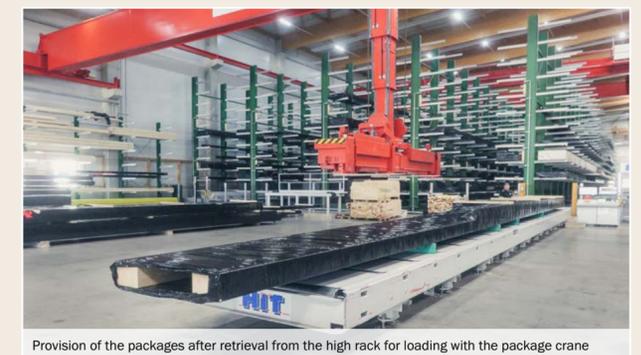
Picking cross-cut saw with pliers for cutting narrower boards on the lower level



Picking gripper with split load pick-up, additional rack for intermediate storage of timber

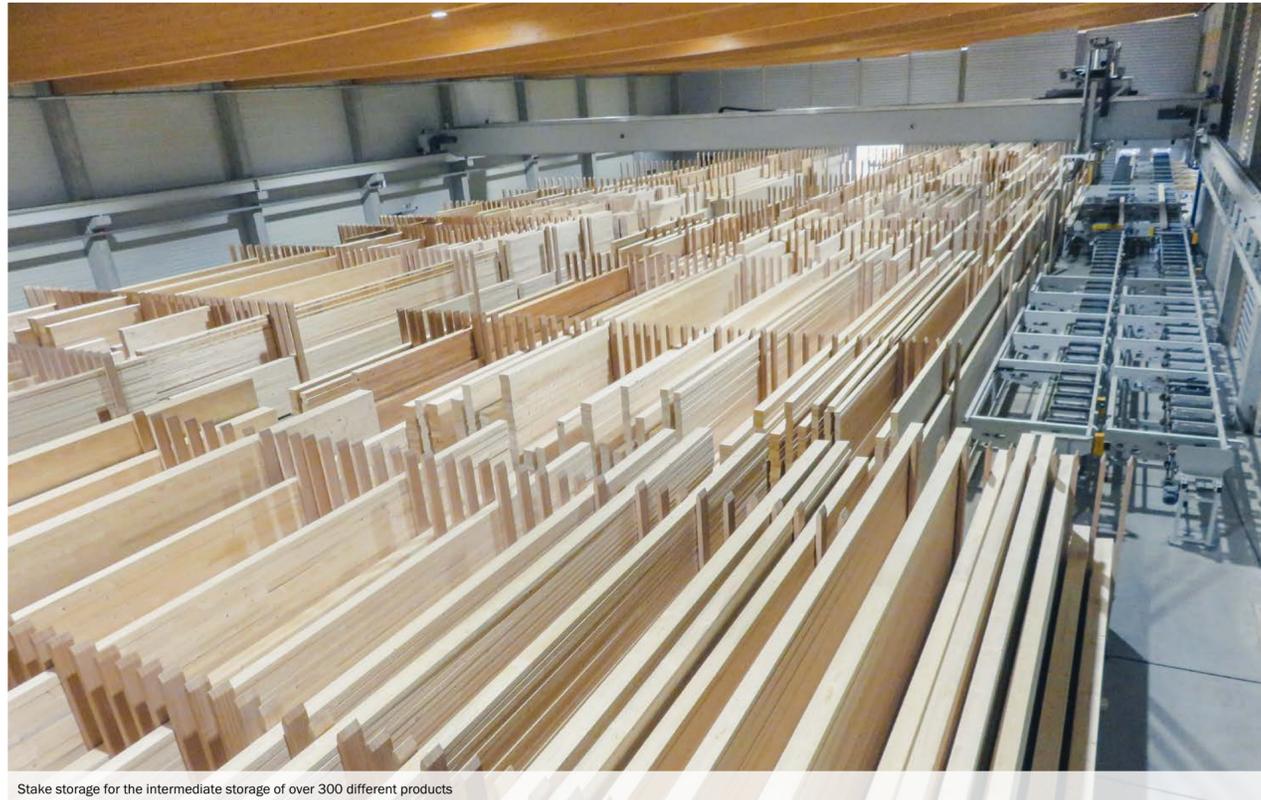


Selective turner between patching stations 1 and 2

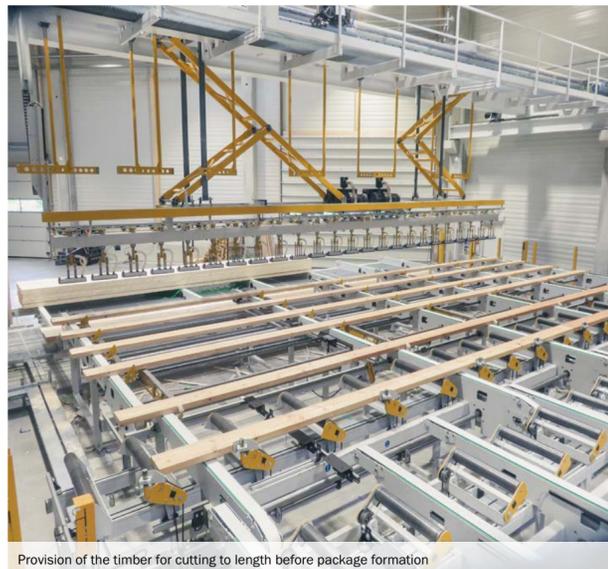


Provision of the packages after retrieval from the high rack for loading with the package crane

Mastering the chaos – highly flexible order picking system in the timber wholesale trade



Stake storage for the intermediate storage of over 300 different products



Provision of the timber for cutting to length before package formation

HOLZ BALK GmbH & Co.KG, with 3 locations in Bavaria and over 330 years of experience in the timber industry, is focusing on the wholesale of timber products after they discontinued their sawmill operations in 2018.

With a total of 70 employees, the company handles approx. 30,000 m³ of SST, glulam, wood-based panels and planed goods each year. The goods are purchased from industrial producers in Germany, Austria and the Czech Republic and sold to customers within a radius of approx. 150 km.

The family business, founded as early as 1829, is now run by Josef Balk in the sixth generation. In each generation, the company grew continuously and responded to changing requirements. Thus, also with regard to speed and flexibility in order processing, the company could not avoid modernizing the existing process and decided to invest in a fully automatic system for the formation of shipping packages of glulam.

As a wholesaler, the most important thing is to keep a large number of different products in sufficient quantities in stock to be able to fulfil customer orders directly with the goods on stock in the shortest possible time. At Balk alone, the number of different products (various cross-sections, lengths and qualities) amounts to over 500. Accordingly, the storage capacity is also large – just under 3,000 m³. H.I.T. was able to convince Balk with our concept of a fully automatic stake storage system and executed the order at the end of 2019.



The purchased packages of timber goods are transferred to the H.I.T. mechanization system and are destacked individually or in layers by means of a vacuum gripper and are buffered before being loaded into the stake storage. The same crane that unstacks the packages for storage also takes over the timber removed from the warehouse and assembles it into new packages as ordered by customers.

The timber to be stored is distributed lengthwise to two unloading stations, from where it is picked up by a single piece gripper and stored in the corresponding stake compartments.

Based on incoming orders, the timbers are individually taken from the stake compartments in

the correct order and handed over to the dispatch area. If the timber still has to be cut to length, this is done with a picking & packing crosscut saw also supplied by H.I.T. Any remaining pieces are stored again in the stake store according to their remaining standard length.

The removed timber is labeled on the front side before it is assembled into packages. Larger batches with the same cross-sections can be stacked with a stacking machine to relieve the vacuum gripper.

With a positioning unit the timbers can be set up on their narrow side in order to optimize the package formation. The finished packages can be optionally wrapped with foil before being provided for removal and loading.



Assembling order packages either by stacking machine or vacuum gripper



The process is largely fully automatic. The employees have been relieved of the previously strenuous physical work and now only take on monitoring tasks to control the processes. The entire warehouse is managed by a higher-level control system, which is also responsible for package planning and order processing.

With the steadily growing share of timber construction in the construction trade as a whole, Josef Balk is positively looking to the future and feels well equipped with this investment in the picking & packing system.



Provision of the timber for cutting to length before package formation



Feeding with selective turner after destacking (bottom) to the multi-level storage with 2 levels

“Open heart surgery” – conversion of the existing glulam-production

At their Gaggenau site, the founded in 1985 family-owned company currently processes approx. 120,000 m³ of raw material into glue-laminated timber, DUOLAM and TRIOLAM. The business of the company with its 70 employees is overseen by founder Gerhard Strobel and his son Dominik. Renowned customers, especially in the prefabricated house construction sector, source their goods from Gaggenau. The majority of the goods are delivered within Germany, but customers from neighboring countries and Spain are also supplied.

The increasing demand for high-quality glulam encouraged the two managing directors to rebuild the existing production facilities around the glulam presses and to make the largest investment in the company's history.

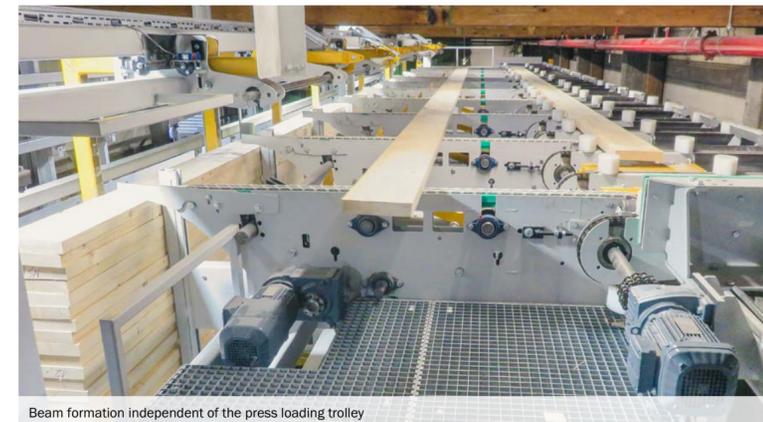
The final decision to implement this plant expansion together with H.I.T. was preceded by an intensive planning phase, where the focus was particularly on the existing spatial conditions and the shortest possible reconstruction period.



Unstacking of the finger-jointed raw lamellas in layers



Proven combination for glue application: a robust H.I.T. feed unit and an Oest glue application head for feed speeds up to 350 m/min



Beam formation independent of the press loading trolley



Press loading trolley, transversely movable to one of the 4 press chambers

Due to the high amount of ongoing production at Hördener the work was carried out in two steps. First, a completely new line for the handling and packing of the timber, including a new final planer, was built downstream of the existing presses. In the second step, all units required for the entire area of lamella destacking, gluing and press feeding were installed.

Lamella gluing and press feeding units

Previously, the press batches were formed manually, the packages with the finger-jointed lamellas were unstacked by hand and the lamellas were stacked again on the press loading trolley in accordance with the beam structure after gluing.

Besides the high manual effort, there was no possibility to mix different qualities in the beam structure.

The entire area was automated in the course of the expansion project. The packages are fed to a destacking unit via a roller conveyor. Here, the packages are destacked layer by layer by means of a vacuum destacker. Then the timber is separated and transported lengthwise. A lamella planer and a primer application unit can be installed further downstream in this longitudinal transport system. In the subsequent cross transport unit, the lamellas can be turned automatically (if required), before they are conveyed upwards by an elevator and distributed over 2 levels.

In accordance with the beam structure, the lamellas are removed from one of the two

levels, accelerated lengthwise and transferred to the surface gluing unit. The glued lamellas are stacked into press batches with a maximum height of 2 meters. The press loading trolley, which has also been newly installed, takes over the press batch fully automatically from the beam formation unit and transfers it lengthwise into one of the 4 press chambers.

Takeover after press, finish planing line

After the pressing time has elapsed, the press is emptied in the longitudinal direction. The press content is again taken over by an unloading trolley, which transports it in the transverse direction and then transfers it longitudinally to the turning and separation station. The press batch is separated, the timber is automatically turned to the wide side and buffered before the final planer.

The finished planed timber is taken over after the planer and transferred to the picking crosscut saw, either individually or in batches. The positioning clamp of the saw grips the timber and moves to the required crosscut length – with an accuracy down to the millimeter. The timber is then stacked into packages and can be wrapped with foil before being conveyed lengthwise and made available for removal by forklift. In order to meet the high quality demands on Hördener products, all transport equipment downstream of the final planer was designed for particularly gentle transport.



Press unloading trolley, transversely movable, followed by turning and separating stations



Turning of the DUO timber on the wide side in front of the planer



Takeover of the timber after planer and crosscut saw with positioning clamp



Stacking of the timber into packages



Wrapping of the packages before forwarding

Sawmill reconstruction after fire

The sawmill of the company Holzbau Gunkel in Waldkappel, which has existed since 1930, was destroyed by fire. The decision was quickly made to rebuild the sawmill at the same location and thus preserve the 15 jobs.

With a combination of head saw and edger, they cut 12,000 solid cubic meters of logs annually – two thirds are pine, one third is made up of larch and Douglas fir; also small quantities of oak are included. The logs required for cutting is sourced within a radius of 50 km. A part of the manufactured products is used by their own timber construction subsidiary and the affiliated planing mill, the majority is sold to timber traders or to construction companies.

The reconstruction was partly carried out with used equipment, such as a used automatic edger of H.I.T. The new grader with mechanization was also delivered by H.I.T. Possibilities for expansion were already taken into account during the planning stage.

H.I.T. installed a new continuous cross-cutting line between the used board separator and the edger. The edger is followed by new H.I.T. mechanization technology. The timber is taken over separately after a cross conveyor and fed to the grading line. Here, either two additional special drop-off stations or the box sorting can be selected via a swiveling conveyor belt.

In the sorting system consisting of 13 drop boxes, the timber is sorted according to the preselection made at the edger. The emptying, as well as the package formation, is done manually.



Continuous cross-cutting and measuring lines upstream of the edger



Splint separator after the edger with subsequent separation and transport to grading



Grading line with drop boxes



General view of edger and grading lines



Presse à stratifié puissante, 41 m de long, 5,5 m de haut et 2 m de profondeur; divisé en 6 segments



JOHANN HUTER & SÖHNE KG | AT-INNSBRUCK 

Flexible 40.5 m press

The Innsbruck-based family business Huter & Söhne looks back on a tradition of over 150 years and, as a general contractor in the building trade, combines craftsmanship with the efficiency of a modern industrial company.

Now in its sixth generation, the company employs 260 people and offers almost all construction services, including all carpentry and joinery services.

The glued laminated timber required for timber construction, approx. 6,000 m³ per year, is produced on a project-specific basis using their own production line. The production of glued laminated timber is practically exclusively for the company's own needs.

Due to the increased demand and in order to increase flexibility, Huter & Söhne decided to replace one of the existing presses. H.I.T. Maschinenbau was able to convince this customer with its concept and received the order for the installation of the 40.5 m long glulam beam press.

The press delivered by H.I.T. was built in place of the existing press after the lamella planer. The new press has 6 individually controllable segments, which can work separately or be switched together depending on the length of the timber to be processed. The lamellas for the up to 2 m high and up to 330 mm wide glulam beams are glued on the roller conveyor after the lamella planer and transported towards the press via individually movable conveyor lines.

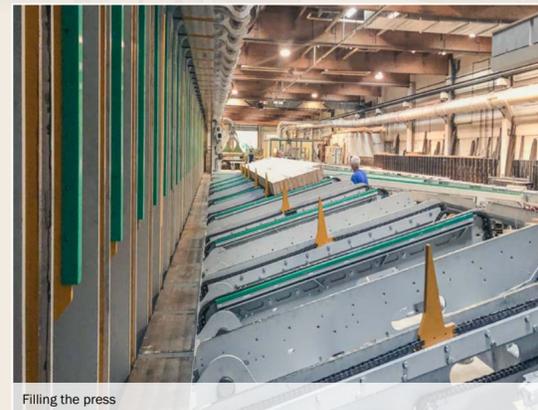
The press itself is fed laterally. To assist with manual filling, the swiveling lateral section of the press has a positioning unit which helps to turn the horizontally positioned slats to the narrow side before they are put together for press

filling. The gripper included in the lateral section cycles downward with each slat until the desired number of slats is reached. The lateral section then swings upwards and is mechanically locked in the press frame before the top and side pressures are applied. The upper pressure cylinders are positioned centrally according to the width of the lamellas in order to optimally introduce the pressing force; anti-tilt units prevent the lamellas from tilting when the press is set up.

After the pressing time has expired, the upper and side pressure cylinders are retracted and the lateral part is opened until it is in an horizontal position. The gripper chain pushes the finished glulam onto roller rails, or the glulam beams can also be removed directly from the open press with the hall crane.

Of course, the press can also be used to produce stepped beam lengths. Compensation fields additionally allow for an optimized length offset, so that timber/beam lengths can be produced largely independently of the press grid.

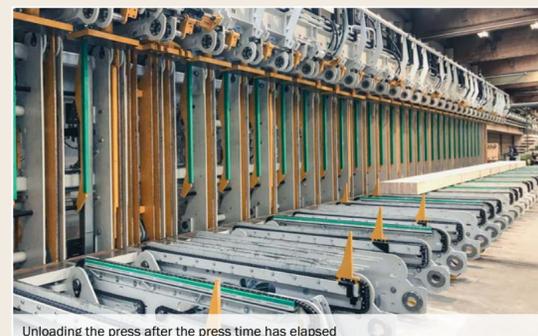
With its parameters, such as the high pressure, the press is also suitable for processing hardwoods, as Huter & Söhne also produces a small proportion of oak beams.



Filling the press



Positioning unit for the lamellas to support the filling of the press



Unloading the press after the press time has elapsed



Buffering of the lamellas before recalibration and subsequent surface pressing

FAGUS
SUISSE

FAGUS SUISSE SA | CH-LES BREULEUX 

New Production line for solid beech wood products



Package loading and unloading before vacuum destacking



Feeding the raw material into the finger-jointing line

In 2014, the company Fagus Jura was formed as a result of several forest owners and sawmills joining forces. With the aim of using beech as a raw material for load-bearing building products, the company – which was originally founded as a project company – primarily performed basic research into process and product development in the first few years. The successful pioneering work culminated in 2017 in the founding of Fagus Suisse, the only company in Switzerland that automatically produces structural laminated timber from beech and other hardwoods.

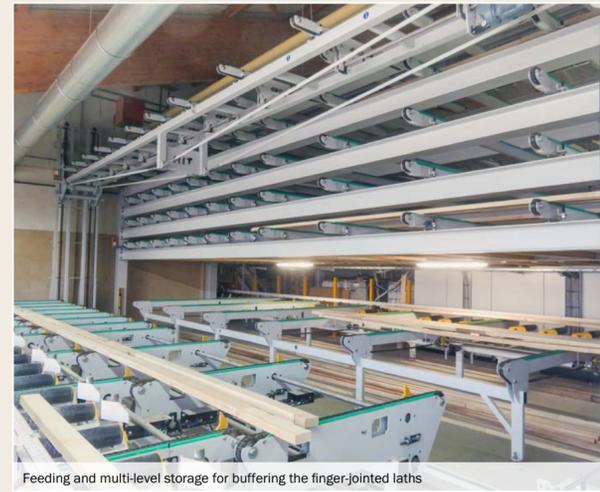
H.I.T. was involved in the product development process at an early stage and was subsequently able to convince the customer with a mechanization solution adapted to their special application and the available space.

The raw material – pre-sorted in 4 qualities and calibrated beech laths with a cross-section of 50 x 50 or 50 x 100 – is fed to the finger-jointing line in packages. A vacuum destacker lifts the timber in layers before individual timber pieces are separated from the layer and transported towards the optimizing cross-cut saw. For quick changes of assortment, destacking can also be carried out from a second package station.

Each lath has a fixed position in the end product right from the start, and

a defined finger offset must be maintained in the subsequent process in order to achieve the desired strength. The challenge of material tracking in the master computer was solved by the customer themselves: the position of every single lath in the end product can be subsequently tracked.

The laths produced after finger-jointing are temporarily stored in a curing store with 5 levels and removed from storage as required and fed to the four-sided planing line. The planed laths are buffered before they are transferred to the gluing station and the subsequent high-frequency press. In the first pass, the press produces lamellas from several individual laths glued together. These are stored in an intermediate store by means of a vacuum lifter.



Feeding and multi-level storage for buffering the finger-jointed laths



Buffering of finger-jointed laths after finger-jointing before calibration and gluing

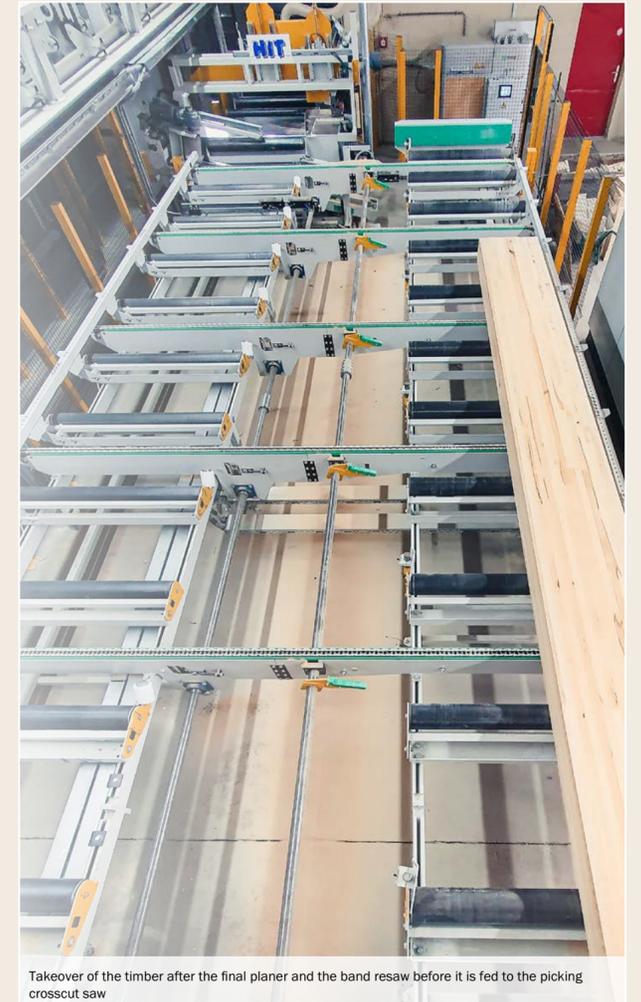
For the production of the glulam beam as a final product, the lamellas are removed by vacuum lifters. The removed lamellas pass the lamella planer on the same path as before and then the glue application station and the high-frequency press where the lamellas are pressed over their whole surface during this pass. The resulting glulam beams are finally planed and, if necessary, cut open horizontally with a band resaw. The glulam beams are cut to length

exactly to customer requirements using a subsequently located cross-cut saw.

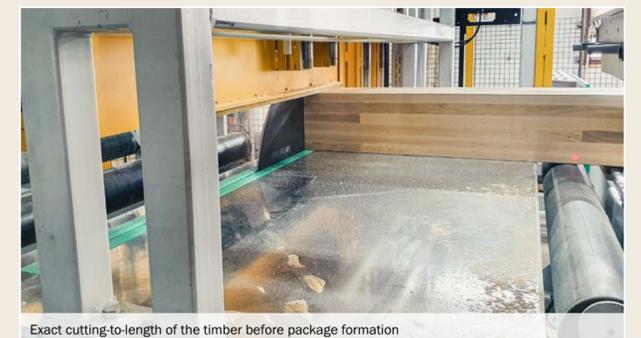
The plant enables the production of laminated timber in the highest strength classes and the production of solid wood panels and can process both hardwood and softwood.



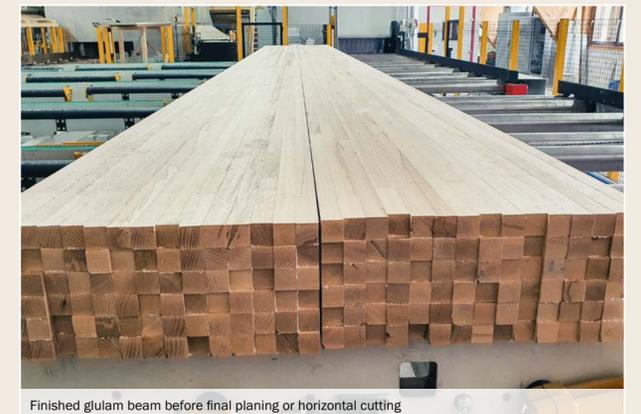
Intermediate storage of the lamellas as a semi-finished product before pressing



Takeover of the timber after the final planer and the band resaw before it is fed to the picking crosscut saw



Exact cutting-to-length of the timber before package formation



Finished glulam beam before final planing or horizontal cutting



With the resawing line, construction timber with a length of up to approx. 11 m can be produced



Feeding from head saw to the resawing line - main products is taken off to the right



SÄGEWERK BÄRENWALDE GMBH | D-CRINITZBERG 

More flexibility with the NSM resawing line and the ASM automatic edging

Founded in 1885, this sawmill looks back on a long tradition in wood processing. Friedrich and Sebastian Troeger have been managing the company as owners since 2016.

With a total of 15 employees, approx. 15,000 solid cubic meters of regional logs are processed at the Crinitzberg site. All common sawn timber products are produced, from construction timber to packaging timber.

In order to increase flexibility and to be able to guarantee deadlines, they decided to replace the ageing resawing line and the manual edger, which was no longer up to date.

The decision was made in favor of an automatic resawing line and an automatic edger from H.I.T. - again, as a new H.I.T. box sorting system had already been installed in 2014.



Measuring and continuous cross-cutting upstream of the automatic edger

After the existing head saw the sawn timber is taken over. The main products are transported to the right to the alignment table of the resawing line; the side products are buffered on a cross conveyor in front of the board separator upstream of the edger.

The alignment of the timber in front of the NSM250 variable resawing line for up to 5 products is monitored by the operator of the head saw. The operator sees the camera image with a representation of the cutting lines on a monitor and can take corrective action if necessary. If required, the cant can also be turned with the turning unit integrated in the feeder.

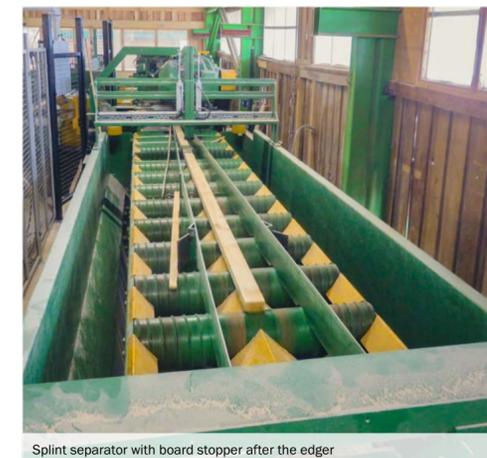
The products inside the splitting wedge after the resawing line is transferred lengthwise to an existing discharge conveyor. Side products, on the other hand, are dropped onto the buffer in front of the edger.

The products thus brought together after the head saw and the resaw are separated with the help of the board separator in front of the edger. An operator also sorts out rejects and determines which timbers are to be cut on the face side

or also in the middle. The board contour is determined with the subsequent laser measurement when passing transversely. Based on the resulting data and taking into account the assortments stored in the control program, the optimization program calculates the optimum cutting pattern. This is displayed graphically to the operator at the edger so that they can still adjust the cutting pattern if necessary. For an optimal utilization of the timber, the edger can variably cut up to three products. In the splint separation conveyor that follows after the edger, certain widths can be held back by means of a board stopper, so that the entire batch is not conveyed at once to the grading line. With a conveyor belt the timber is transported in longitudinal direction to the existing transverse high grader with 9 boxes, or to the existing special drop zone.



Transfer of the products after the edger to the already installed H.I.T. transverse high grader



Splint separator with board stopper after the edger

SÄGEWERK
GREIFENSTEINER

SÄGEWERK DIETMAR GREIFENSTEINER | A-MARIAZELL 

Moving to the new sawmill with new combined KSM200 resawing line



Measuring and continuous cross-cutting downstream of the board separator



Centering and alignment table in front of the KSM

The company, which was founded by the father of the owner Dietmar Greifensteiner in 1983 in Mariazell, Austria is a classic gang sawmill. Five employees process approx. 12,000 solid cubic meters of softwood logs. 50% of the logs is sourced from the surrounding area and a further 50% is purchased in the neighboring Czech Republic.

To be able to continuously offer the benefits of a highly flexible production, but also to increase the cutting capacity, it was decided to build a new plant right next to the existing sawmill. As in the old mill, a gang saw was installed in the new one. Parts of the existing mechanization from the old plant were reused. For resawing and edging, the decision was made to use the KSM combined resawing line from H.I.T.

The plant section supplied by H.I.T. begins with the transfer of the timber after the customer's board separator and ends with the transfer of the timber

after the splint separator in longitudinal direction to the customer's mechanization.

The timber, inspected by the operator, passes through laser measurement and continuous cross-cutting before being placed on the centering table in front of the saw. The cut is carried out with a maximum of 5 variable products, the material lying outside the splitting wedge is transported back to the edging unit via a rotary conveyor, and any splints are transferred to the waste disposal system.



Splint separator and return to edging

Company anniversary

We would like to thank you for your long-term loyalty this year with our employees for 10, 20, 25 and 30 years of service thank you very much.

We say thank you

10 YEARS

- HERIBERT GOBER | MANUFACTURING
- CHRISTIAN SCHREIEGG | MANUFACTURING AND ASSEMBLING
- MARCUS GÖDRICH | CONSTRUCTION
- DETER RÖSLER | VARNISHING
- MANUEL PAULI | HEAD OF MACHINING
- RALF TEPPER | STOCK

20 YEARS

- REGINA SCHWAB | STOCK
- MICHAELA WÖSS | MANAGEMENT ASSISTANT

25 YEARS

- ANDREAS BAUR | PURCHASING
- THOMAS TRUNZER | SUPPORT / SERVICE ELECTRICAL

30 YEARS

- STEFAN FILSER | PLANNING / SALES

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Local Notice

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