insights

INFORMATION FROM THE COMPANY

HERMLE
milling at its best

Edition I . April 2006

To all customers, persons interested, shareholders, employees and friends of company

Dates

METAV
Munich
April 4 - 7, 2006
hall B6 - stand B9

In-house exhibition
Gosheim
April 26 - 29, 2006

Die and Mold
Shanghai / China
May 08 - 12, 2006
hall E2 - stand B018

Metallobrabotka
Moscow / Russia
May 23 - 27, 2006
hall 2.3 - stand C10

METAV
Düsseldorf
June 20 - 24, 2006
hall 16 - stand C27

IMTS
Chicago / USA
September 06 - 13, 2006

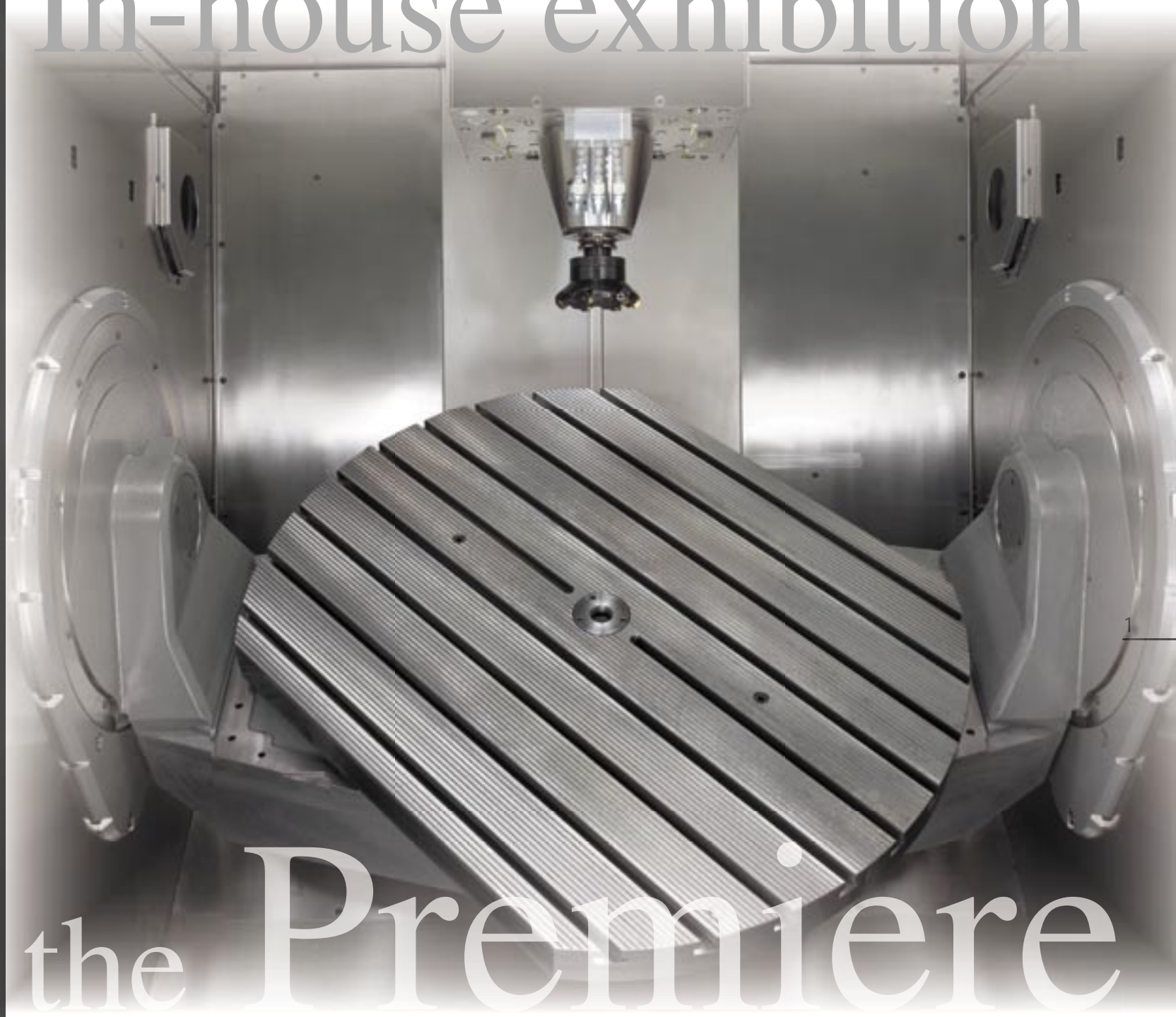
MSV
Brünn / Czech Republic
September 18 - 22, 2006

AMB
Stuttgart
September 19 - 23, 2006

For more participations in trade fairs by Hermle, please go to www.hermle.de

We look forward to seeing you!

In-house exhibition



the Premiere

C 50 U dynamic

C 20 U

RS 60

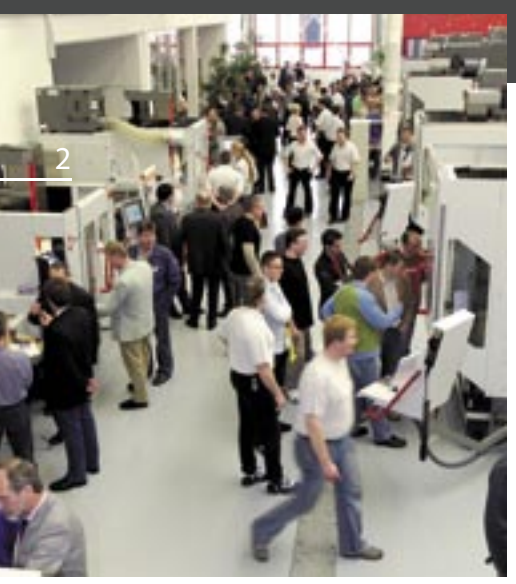
In-house *exhibition*

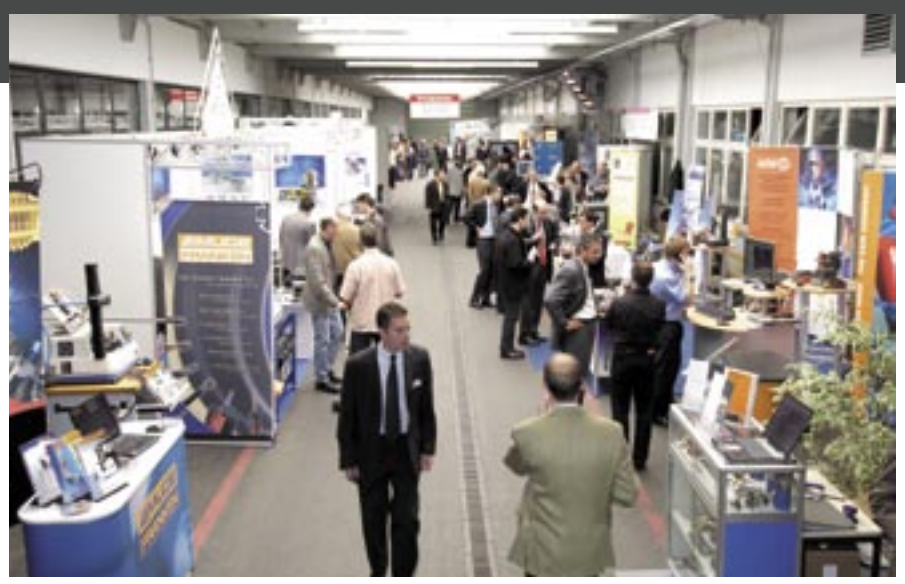
from April 26 to 29, 2006

in the Technology and Training Centre in Gosheim

Daily from 9.00 a.m. to 5.00 p.m.
Saturday from 9.00 a.m. to 3.00 p.m.

- Over 20 machines in full protection
- Technical presentations tool steels / product information
- Guided company tours
- Special show featuring many exhibitors from the area of tool technology





Exhibition 2006 -
with special tool technology show

The traditional spring exhibition at Hermle AG will be held this year from April 26 - 29 2006 in Gosheim.
Every day from 09.00 a.m. to 5.00 p.m and on Saturday from 09.00 a.m. to 5.00 p.m., the Hermle AG will allow their customers and interested persons to have a look at the assembly and production of Hermle products at the technology and training centre and on guided company tours.

The extensive Hermle machine program will be completed by a special show on more than 700 m^2 of exhibition area including renowned manufacturers from the field of tool technology. Also exhibiting are the control unit manufacturers Heidenhain and Siemens and many manufacturers of CAD/CAM systems, tool management software and the like.
The topics balancing, shrinking and tool measurement will of course also be shown.

At the technology and training centre, more than 20 machines, more than 90% of which are in the 5-axis design, will be equipped with both automation technology and sector-specific machining options during the four days of exhibition.

The highlights are in particular:

- The new 5-axis large-scale C 50 U dynamic machining centre for processing 2000 kg with 5 axes
- The new 5-axis C 20 U machining centre - compact, modular, and automatable
- A 5-axis C 30 U machining centre with RS 60 robot system - the robot system for transport weights up to 60 kg
- Other machining centres with interesting processing features
- Special Tool Technology show with over 30 exhibitors

Exhibitors

Tool Technology
BOTEK PRÄZISIONSBOHRTECHNIK GMBH
EMUGE WERK-RICHARD GLIMPEL GMBH U. CO. KG
FRAISA SA
HITACHI TOOL ENG. EUROPE GMBH
INGERSOLL WERKZEUGE GMBH
ISCAR GERMANY GMBH
KELCH & LNKS GMBH
KENNAMETAL GMBH & CO. KG
KOMET GROUP GMBH
LMT DEUTSCHLAND GMBH
MMC HARTMETALL GMBH
OSG GMBH
PAUL HORN GMBH
POKOLM FRÄSTECHNIK GMBH & CO. KG
SANDVIK GMBH
SCHRENK GMBH / SECO TOOLS
SCHUNK GMBH & CO KG
WILLY TRAUB GMBH & CO. KG
WOHLHAUPTER GMBH

Software - CAD/CAM
ALPHACAM GMBH / UGS
CAMPLETE SOLUTIONS INC.
CAMTEK GMBH / PEPS CAD/CAM SYSTEME
CGTECH DEUTSCHLAND GMBH
CIMCO INTEGRATION
COSCOM COMPUTER GMBH
DELCAM GMBH
OPENMIND TECHNOLOGIES AG
SESCOI GMBH
SOLIDCAM GMBH
TEBIS AG
TRANSCAT PLM GMBH & CO KG / IBM
UNICAM SOFTWARE GMBH / MASTER CAM

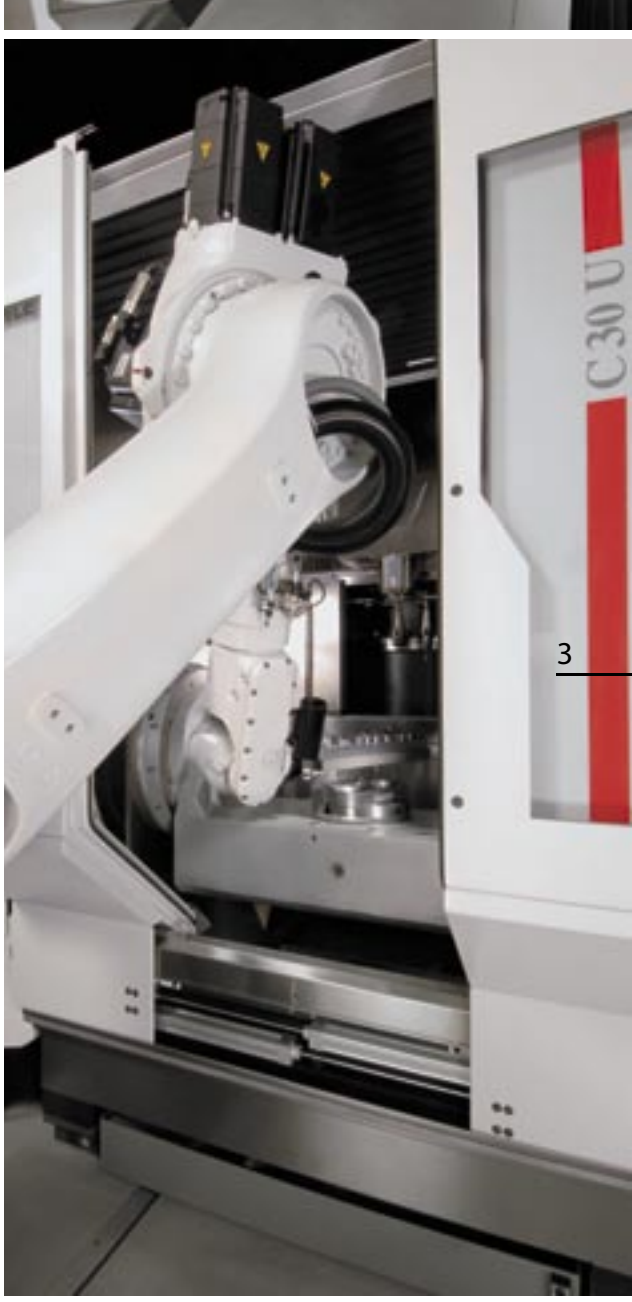
Control technology
DR. JOHANNES HEIDENHAIN GMBH
SIEMENS AG

C 30 U with RS 60

RS robot cell for fully automatic loading and unloading of pallets and components

The Hermle Automation Offensive of 2005 is followed early in 2006 by the large robot cell RS 60, adapted to our C-series. The RS 60 robot system is designed as a modular cell and is created specifically for each customer. Pallets and/or workpieces can be outfed or fed into from the unloading and loading station in the magazine. The pallets are "hooked" in place on a storage shelf in the cell shown here. The advantage of this is that there is room for numerous pallets and pallet size can be selected individually. The robot arm has been arranged so that the machine operator has direct access to the working area at all times through an access door on the side and is even able to intervene in the work process manually. This is part of Hermle's philosophy and is consistently implemented in all robots systems, handling systems, and pallet changers.

- Fully automatic pallet and/or workpiece loading, i.e. the system can also be configured for flexible pallet handling and direct workpiece handling
- Can be extended to form flexible manufacturing cell or system
- Inexpensive transport and simple installation by means of "hook-ready" designs of the machine, and also of the robot cell
- Can be used 7 days a week in multiple shifts
- Integrated software for flexible order management
- Further processing of the components on the 6th side and/or chamfering, grinding, washing, monitoring, inspecting, testing, etc.
- Customer-specific grippers and/or double gripper solutions
- Set up station for loading and unloading also during the manufacturing process (parallel to core time frame)
- Customer-specific workpiece / pallet storage
- Four transport weight classes - 6, 16, 30 or 60 kg
- High system competence through a single manufacturer



Large scale machining centre C 50 U

POWERFUL

Hermle is opening up new dimensions with the new large-scale machining centre C 50 U dynamic. For tool and mould construction, but also for part manufacturers processing workpieces with Ø 1000 mm at a height of 810 mm and a maximum workpiece weight of 2000 kg with highest precision in 5-axes simultaneously.

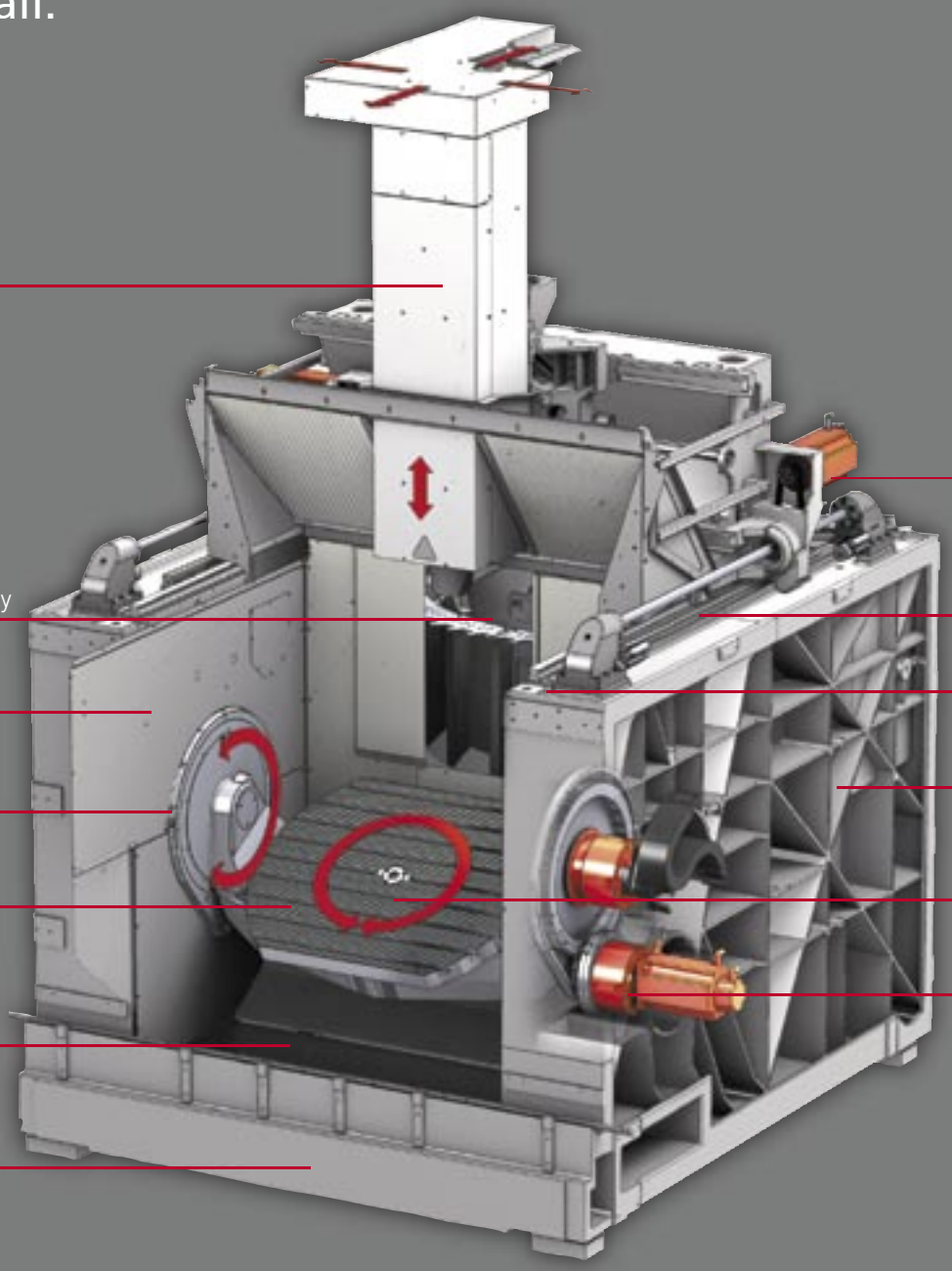
Basic machine structure in reliable modified gantry design with optimal main axis support. Tandem drive in the Y-axis for high machine dynamics. Forces are ideally absorbed by three guideways, each with one guide shoe.

Two NC swivelling rotary tables with integrated torque motor (C-axis) and tandem drive (A-axis). Swivel ranges from +30° / -115° for flexible use in the 5-axis sector. High machine dynamics for fast tool changing times and dynamic milling processes, and all that with precision in the single-digit µ range. Proven control unit technology combined with the most modern bus technology for reliable milling strategies.

Useful details such as access platforms in front of and beside the machine, automatic top, chip conveyor, cassette lining with integrated central cable routing, service doors in front of all fluid units, stainless steel covered working area plus options such as internal coolant supply, oil mist extraction, and much more make for ideal use in the manufacturing area.

Technical data:	
Traverse X–Y–Z:	1000-1100-700 mm
Speed:	18.000 rpm
Rapid traverse linear X-Y-Z:	60-60-50 m/min
Control:	iTNC 530 / S 840 D
NC swivelling rotary tables:	
Clamping surface:	Ø 700 mm
Swiveling range:	+30° / -115°
Speed - swivelling axis A:	20 rpm
Speed - rotary axis C:	30 rpm
Maximum table load:	2.000 kg
Clamping surface:	Ø 1150 mm
flattened to:	900 mm
Swiveling range:	+30° / -115°
Speed - swivelling axis A:	20 rpm
Speed - rotary axis C:	30 rpm
Maximum table load:	2.000 kg

The advantages in detail:



3 axes in the tool
component-independent dynamics

Pick-up magazine
integrated in the base unit in a space-saving way

Stainless steel design
of the entire working area

Ideal swarf clearance
dry machining

Swivel range
of NC swivel rotary tables +30° to -115°

Largest working area
relative to installation surface

Accessibility
excellent ergonomics

Tandem drive
for high machine dynamics in the Y-axis

Force characteristics
3 guideways with one guideshoe for ideal force balance

Linear axes
above the working area

Modified gantry design
with ideal main axis support

Torque motor (C-axis)
for high dynamics

Tandem drive (A-axis)
prevents torsion with high accuracy

Large tool dimensions
max. tool diameter Ø1000 mm / max. tool height 810 mm

Coolant tank
with large coolant volume

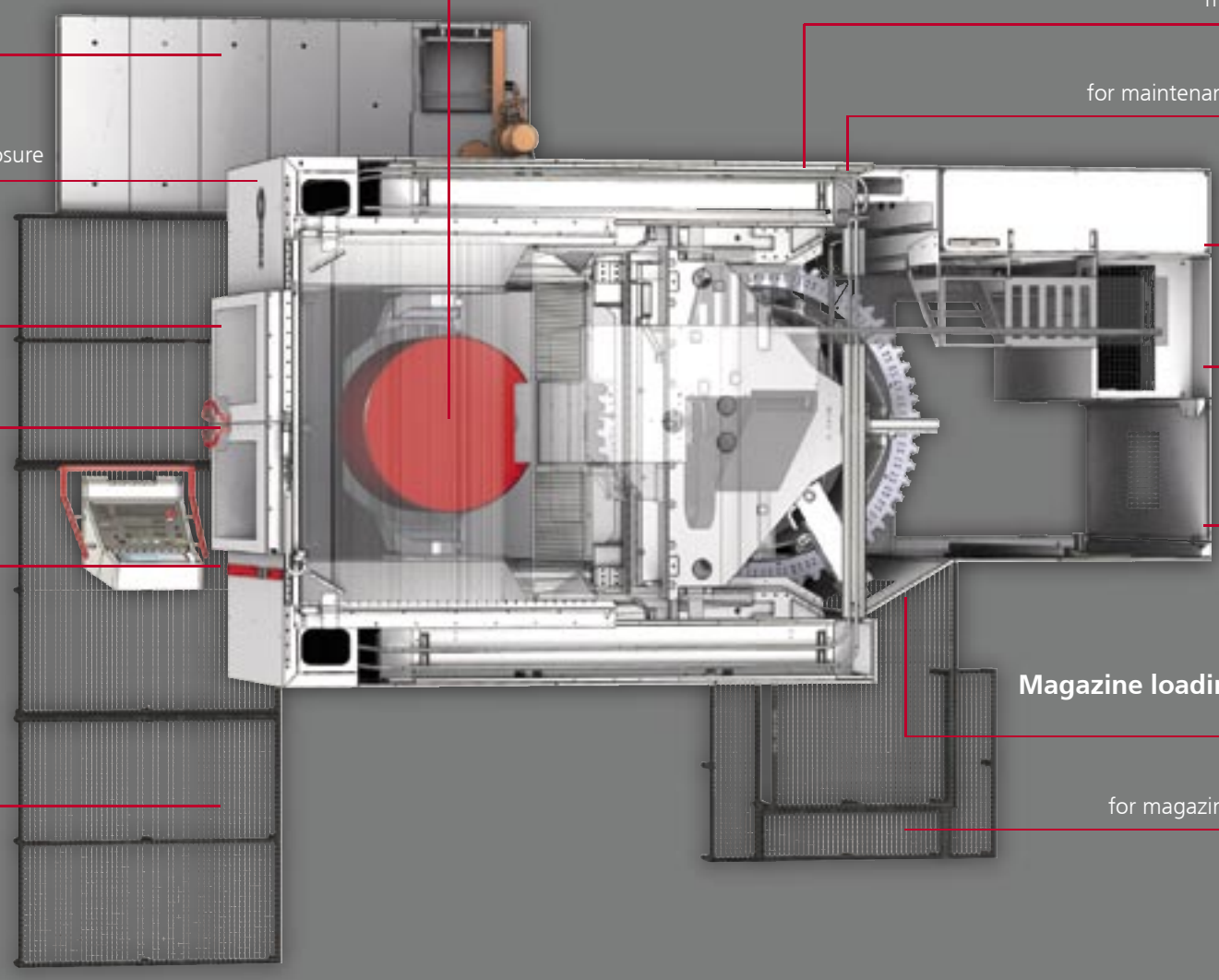
Central cable routing
integrated into the machine enclosure

Encapsulated working area
with top

Crane loading
max. door opening 1250 mm

Control panel
ergonomic rotating

Platform
extending along the entire front of the machine



Cube 67
most modern Profibus technology

Service door
for maintenance work - pneumatic/lubrication

Switch cabinet
central with cooling unit

Cooling
central for the entire machine

Service door
for maintenance work-hydraulic

Magazine loading and unloading station
for ergonomic tool loading

Platform
for magazine loading and unloading station

C 20 U - compact

COMPACT

The C 20 U represents a smaller model in the Hermle AG C-series. Modular layout with different types of tables ideal for a range of parts up to 300 kg (5-axes) and 1000 kg (3-axes). Small space requirement with comparatively large traverses in the X/Y/Z-axes. Tool magazine integrated into the basic machine body i with 30 tool pockets.

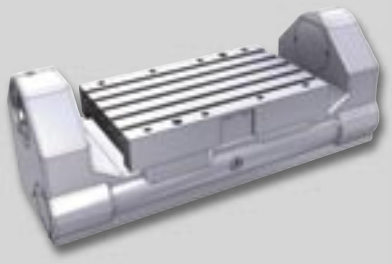
Basic machine structure in reliable modified gantry design. Centre drive in the Y-axis for high machine dynamics. Forces are ideally absorbed by three guideways, each with one guide shoe.

The NC swivel rotating table with swivel ranges of +/- 115°, ideal for 5-axis simultaneous processing. The rigid clamping table with its clamping surface of 800 x 465 mm can receive heavy, bulky workpieces

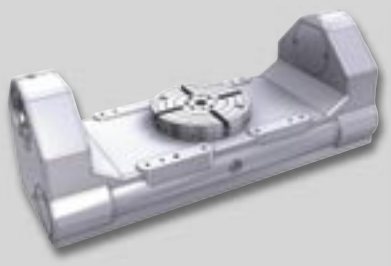
The C 20 U can be expanded with a pallet changer and pallet storage, combined with a chip conveyor, internal coolant supply and an additional tool magazine to form a smart production machine.

Additional automation features are possible for the C 20 with the HS 30 handling system or RS 6 to RS 60 robot system. Of course extensive options are available for a wide range of applications such as graphite processing, carbide machining, etc..

Table variants:

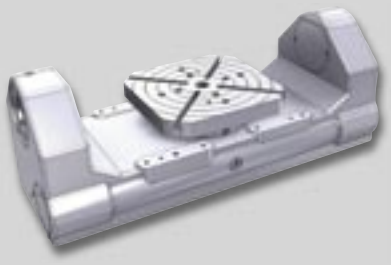


NC swivel rotary table Ø 280 mm
with upper clamping plate (option)



NC swivel rotary table Ø 280 mm

NC swivel rotary table Ø 280 mm
with adjacent clamping plate (option)



NC swivel rotary table Ø 280 mm
with clamping plate (option)

Rigid clamping table 800 x 465 mm

Technical data:	
Traverse X–Y–Z:	600-450-450 mm
Rapid traverses linear X-Y-Z	45 m/min
Speed:	10.000, 16.000, 40.000 rpm
Torque:	up to 200 Nm
Main power:	up to 32 kW
Magazine pockets:	30 pieces
Control:	iTNC 530 / S 840 D
NC clamping rotary table	
Clamping surface:	Ø 280 mm
Swivel range:	+/- 115°
Speed - swivelling axis A:	25 rpm
Speed - rotary axis C:	25 rpm
Maximum table load.:	300 kg
Adjacent table plate (option):	650 x 370 mm
Upper clamping plate (option):	600 x 370 mm
Clamping plate (option):	Ø 450, 370 x 370 mm
Rigid clamping table	
Clamping surface:	800 x 465 mm
T-grooves parellel	7 / 14 H7
Maximum table load:	1.000 kg

The advantages in detail:

3 axes in the tool
component-independent dynamics

Collision protection
with collision inquiry

Easy to service
ideal accessibility to the auxiliary units

Central drive
centrally arranged Y axis main drive

Force characteristics
3 guideways with one guideshoe
for ideal force balance

Linear axes
above the working area

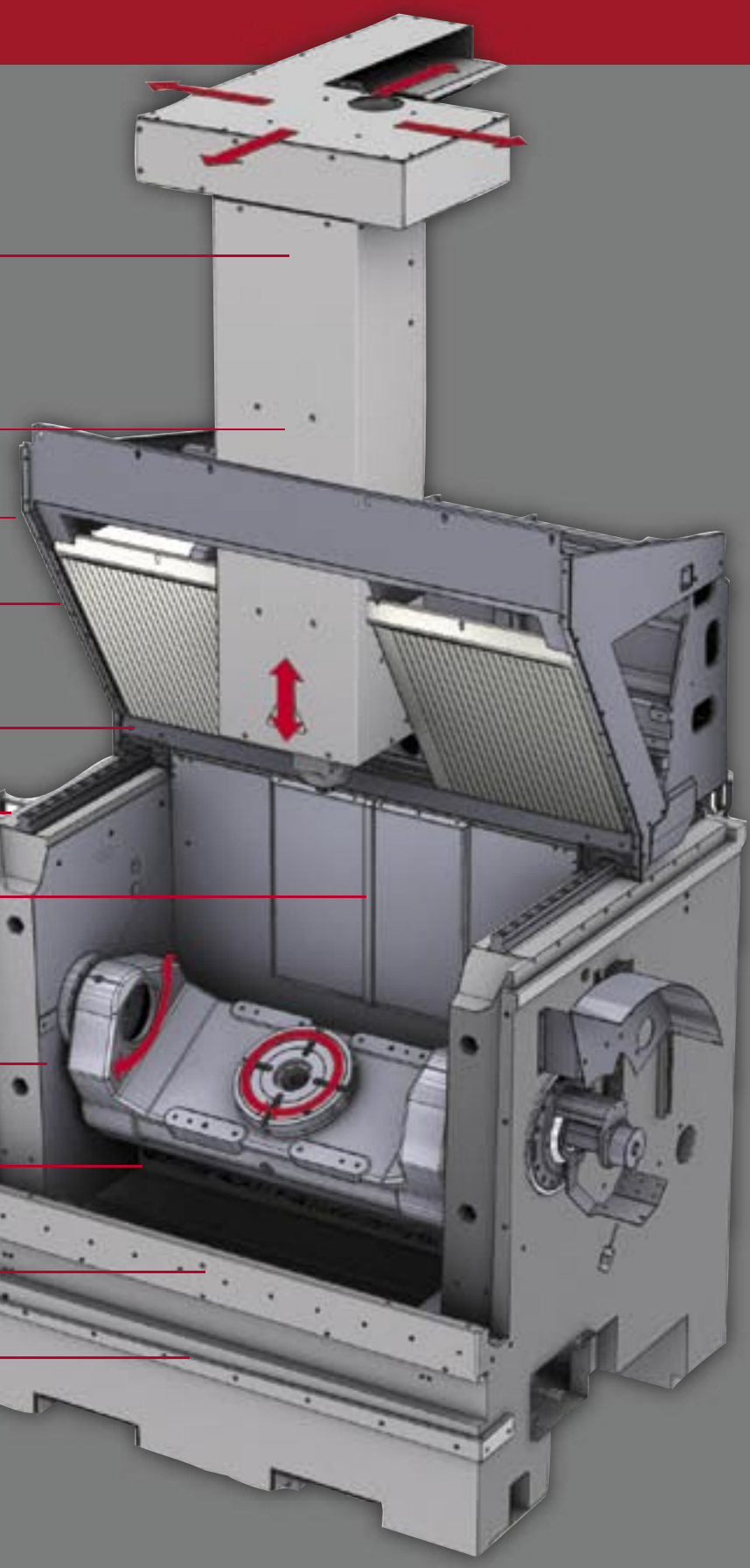
Pick-up magazine
integrated in the base unit in a space-saving way

Ideal swarf clearance
dry machining

Accessibility
excellent ergonomics

Modified gantry design
with ideal main axis support

Mineral casting
excellent vibration damping properties



Palett changer PW 160

NC swivelling rotary table:	Ø 280 mm
Swivel range:	+ / - 115°
Pallet dimensions:	320 x 320 / Ø 400 mm
	400 x 400 / Ø 500 mm
Number of pallets without storage:	3 pallets
Number of pallets with 4-fold storage:	7 pallets
Transport weight per side including pallet:	max. 160 kg

Repeating accuracy < 0,01 mm

5-axis machining centres area at toolcraft

Toolcraft company president Bernd Krebs in front of a C 30 U

toolcraft

In Dimensionen denken!

Central Activation Field:

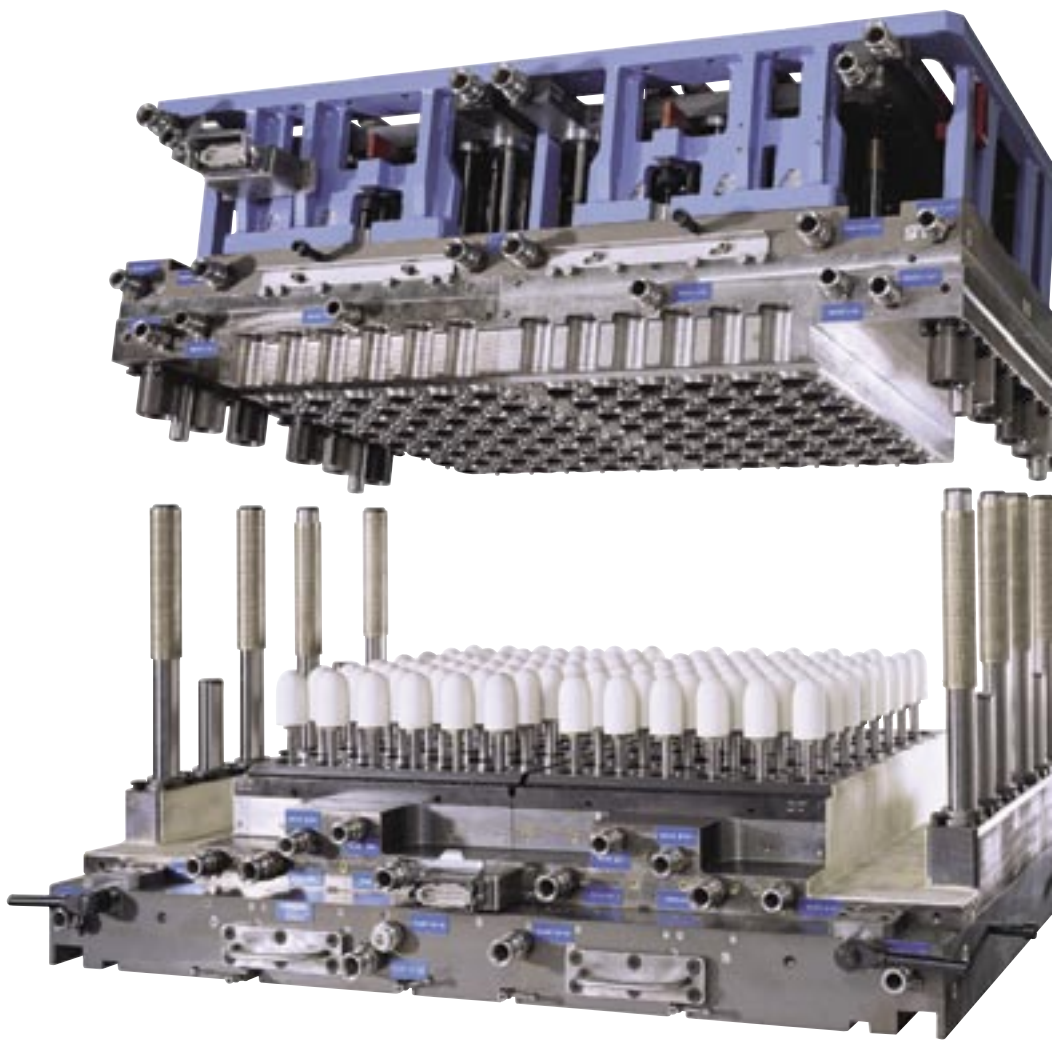
5-Axis Milling

Sample case with a representative range of tools related to 5-axis simultaneous/complete machining

Highly complex geometries, ultra-exotic materials, highest precision and shortest action and reaction times – these form the common denominator of company philosophy at MBFZ-toolcraft GmbH, Georgensgmünd, Germany. The slogan "think in dimensions" certainly applies when seen in this way, as the four companies currently belonging to the group combine enormous know-how, creative problem solving competence and much experience in reference to CAD-/CAM technology, digitising technology, 3D programming, precision part manufacturing, 5-axis simultaneous / complete processing and laser labelling. Since the mid 90s, MBFZ-toolcraft has been rethinking its philosophy in the direction of "technology as a competitive factor", which is why they became involved in 5-axis machining in 1996. After some initial experiences, company president Bernd Krebs and his employees took a look at the market, which was then still relatively sparsely occupied in terms of powerful 5-axis machining centres and learned to know during a trade show the machining centres of Hermle. As the first manufacturer of CNC universal milling machines and CNC machining centres, Hermle had developed a complete new generation of machines especially for multi-axis/ 5-axis complete machining, which promptly created a sensation in markets. Instead of competitors' machines equipped for 4- and 5-axis machining, the concept of multi-axis/ 5-axis complete machining took over with all C-series machines and is still the basis of today's concept. Naturally this greatly improved work speed and accuracy as well as increasing free space for positioning of tools and workpieces. They tried out the system, tested it extensively, found it excellent and decided it was the way of the future. In 1998, MBFZ-toolcraft acquired the first 5-axis machining centre with a C 600 U. It was followed in 2001 by a larger C 800 U machining centre and an additional C 600 U. The great success with 5-axis simultaneous / complete machining caused great enthusiasm and was much discussed by customers. In 2003 the company invested in a CNC C 30 U high-performance machining centre, the following year in another C 30 U and in a larger C 40 U sister-unit, and again in 2005 in a CNC C 40 high-performance machining centre. The seven Hermle machining centres still do not represent the end of the run, since corporate group members Formenbau Spalt and YPTI in Indonesia now rely on the machining centres from Gosheim as well. Thus the three locations together are currently using 10 Hermle machines in multi-shift operation. There's a reason for that, as Bernd Krebs explains: "We don't see ourselves as suppliers or even as just an extended workbench. We understand that we are technology service providers, actively solving customers' problems from the development phase through to the preseries or small series phase. Generally we work in the range between 1 and 100 with our part numbers, with prototypes and development parts representing our main business. Thanks to the high-performance machine park with the most modern 5-axis machining centres, we are capable and always prepared to respond quickly to the most demanding requirements and extreme schedules of customers. We have to be able to rely especially on the 5-axis machining centres, which are indispensable for quick conversion. That's why we work in the area of Hermle machines, because of the extreme demands of us and our customers".

www.toolcraft.de

MARBACH®
Werkzeugbau



Thermoformwerkzeug für Becher - kombiniert oder getrennt formend und stanzend

Leap Forward

with 5-Axis Complete Machining

The technology-based company Marbach Werkzeugbau GmbH, Heilbronn, was founded in 1923 as a tool manufacturing business that produced band steel segments for the shoe industry. Over a good 80 years it developed into a tool manufacturing group active worldwide in the areas of band steel and die cutting systems for folding cartons used for packaging as well as thermoform tools for buckets and containers similar to buckets for filling and packaging a wide variety of products.

Today the entire Marbach Group has 1000 employees, of which 350 work in cutting die technology. The relatively simple cutting dies are manufactured at 15 different locations in Germany, Europe and Asia for their respective regions. On the other hand, tool manufacturing for thermoform tools involves complex tool systems with up to 140 cavities. These tools are only manufactured in Germany. There are also service locations in Poland and the USA. Marbach sees itself as the largest producer of die cutting tools for the packaging industry in the world, and they claim technology leadership in the area of thermoform tools. These top positions are the result of both creative engineering and know how. They are also the result of the highest toolmaker quality and adequate workshop equipment.

Hans Masche, Director of Operations for Tool Manufacturing in Heilbronn comments: "We invest continuously in the most modern technology, which allows us to offer our customers advantages in both technology and service. Whereas we focussed earlier on manufacturing band steel segment and rotation roller tools, customers are now asking for complete systems for thermoform tools delivered ready to use. Earlier, we were able to concentrate on manufacturing rotation parts because manufacturing of cubic parts played hardly any role at all and was also outsourced in some cases. Today, everything has changed. Demand for complete manufacturing means we have made a complete turnaround and acquired more competence in cubic processing, and especially in multi-axis complete machining". That led Masche and his colleagues to search for high-performance machining centres for complete multi-axis machining.

Initial milling tests led to the decision to acquire series C 40 U machining centres from Hermle and accordingly two were ordered in 2003. Starting with the strategy, "away from simple turning and on to moulding milling technology" the C 40 U series proved entirely convincing, since it is designed from the ground up for integrated 5-axis complete machining in one clamping operation. With close team work, the company very quickly established a 5-axis milling technology so that more and more orders came in for the two C 40 U machining centres, specifically carbide machining of inserts for cylinder rollers as well as manufacturing of complex shaped aluminium parts for thermoform tools. It works so well and successfully that Marbach made additional investments in 5-axis complete machining and universal milling processing in 2005. They purchased another C 40 U machining centre with a 420 mm diameter NC swivel rotary table as well as a C 600 U machining centre with a 200 mm diameter rotating clamping device for flexible machining of small workpieces in small to medium-size series. The two machines have the same Heidenhain iTCN 530 control units as their predecessors, which means there is a single control unit standard at Marbach. The current Hermle machine park allows for very flexible usage, according to Hans Masche: "Thanks to 5-axis complete machining, we are capable of meeting our customers needs both technologically and economically. Naturally this represents a competitive advantage for us".

www.marbach.com

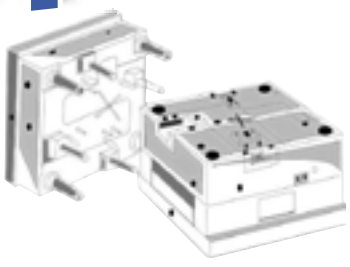
Selection of thermoform buckets made of PP, for which Marbach Werkzeugbau GmbH manufactures a wide range of complete thermoform tool systems

Multi-part thermoform tool system with bucket outer contour and flanges to reinforce the base of the bucket

Two-part thermoform tool system

Schnurr

Präzisions-Formenbau
Precision moulds
Kunststoff-Spritzguß
Plastic injection moulding

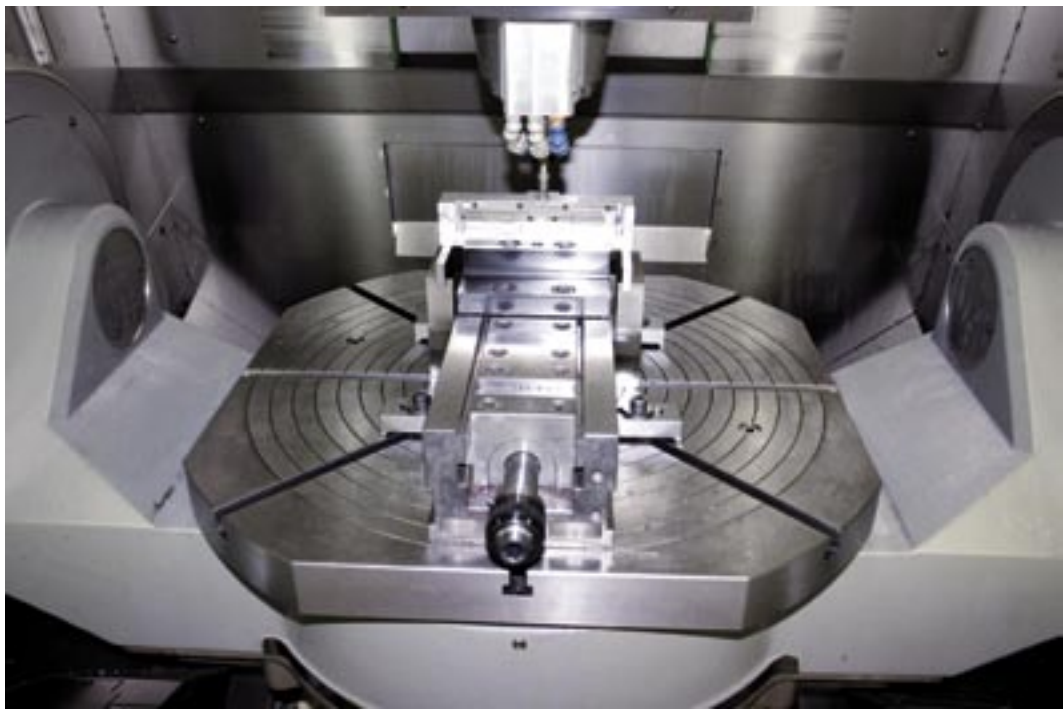


From left to right, Hermann Luckmaier - Director of AV, Helmut Schnurr - Founder and owner of Helmut Schnurr GmbH, Thomas Witt - machining centre operators and Stefan Schmid - Company President of Helmut Schnurr GmbH

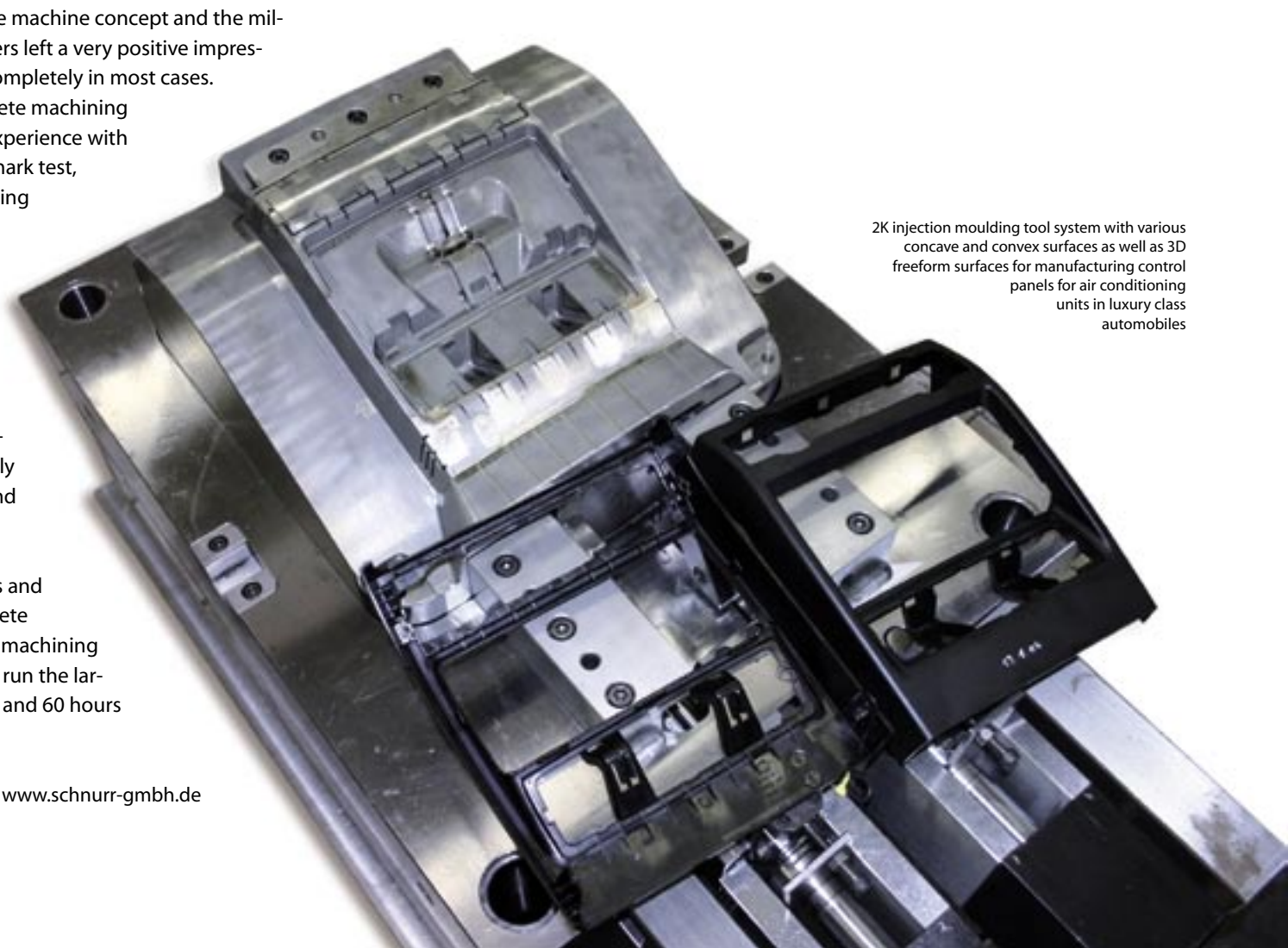
Giving shape to customers‘ wishes...

When Helmut Schnurr founded a mould and toolmaking business in 1980 in Bischofswiesen in the Southern German State of Bavaria, he may hardly have imagined the company would grow into a mid-sized business with 60 employees. In the beginning, he concentrated especially on mould and tool manufacturing and produced die cutting tools as well as injection moulding tools. Schnurr soon recognised that by specialising in injection moulding and plastic tools, he could find more opportunities for business development and began concentrating entirely on that area of business as early as 1981. This specialisation led to establishing a second entity involved in the production of parts from a wide range of plastics. Thus Helmut Schnurr GmbH, Bischofswiesen became a precision mould building and plastic injection moulding company. The in-house plastic injection moulding facility at Schnurr is not only important for producing precision moulds, it is also the ideal development partner for testing ideas, technologies and detailed/system solutions. Today Helmut Schnurr GmbH also sees itself as a specialist for 2K and multi-component tools, for demanding metal injection moulding and ceramic injection moulding tools and for special tools used to produce silicon mould parts. As a complete supplier, and also for reasons of quality, the company relies on the maximum amount of in-house manufacturing, and has thus developed all its own technologies for milling, turning, grinding, eroding and laser processing, as well as measurement technology, of course. Special attention is paid to milling, since customers are always demanding ever more complex tool systems for function-integrated injection moulding parts, which have also become larger. As a result, we h ad to acquire larger and more powerful milling machines or machining centres. Company President Stefan Schmid describes the process: “To meet our customers’ needs for more complex injection moulding parts and correspondingly larger precision forms, we required ever larger milling machines. We performed extensive tests and were very disappointed with this result or that. Finally we decided in favour of the C 1200 V Universal Machining Centre of Hermle. We found the machine concept and the milling trials fully convincing and the visits to reference customers left a very positive impression. On the C 1200 V we can manufacture parts of all sizes completely in most cases. This has enabled us to significantly increase extensive complete machining as well as toolmaking productivity”. Based on this excellent experience with the C 1200 V, Hermle AG was then invited to the next benchmark test, which involved investing in a high-performance CNC machining centre for 5-axis simultaneous/complete machining. Having learned much from this experience, Hermann Luckmaier, Director of Work Preparation at Helmut Schnurr GmbH and his colleagues developed a sophisticated workpiece that was found to be a hard nut to crack by potential machine suppliers. Ultimately the C 40 U, a high-performance CNC machining centre from Hermle AG performed all the required tasks with flying colours. The company ordered it. Luckmaier explained: “The C 40 U was the only machining centre that met our needs in terms of precision and high table loads. With its large working area of X = 850, Y = 700 and Z = 500 mm, the NC swivel rotary table with a diameter of 800 mm, the spindle with a speed of 18,000 rpms and the tool magazine containing 38 pockets, it is ideal for complete machining of our tool and moulding parts. We work with the machining centre in two shifts plus night shift. In practical terms, we can run the largest and most involved tool parts, which require between 12 and 60 hours of machining time, automatically, i.e. without supervision”.

www.schnurr-gmbh.de



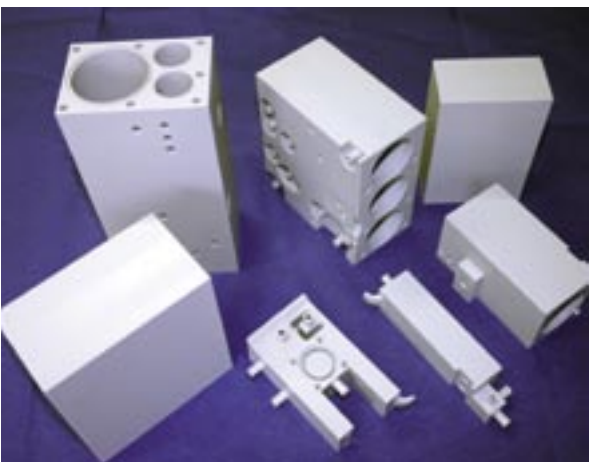
Working area of the C 40 U machining centre with an NC swivel rotary table with a diameter of 800 mm for flexible 5-axis complete machining of tool manufacturing parts in a single clamping operation



2K injection moulding tool system with various concave and convex surfaces as well as 3D freeform surfaces for manufacturing control panels for air conditioning units in luxury class automobiles

Fresenius Medical Care

Computer generated dialysis system from Fresenius Medical Care



Pictures from left to right:

Heater and multifunction blocks made of PP

Ralf Cimander - Director of production for machining and Dietmar Döhner - machine operator

C 600 U with handling system HS 30

Economical production of medical parts

From the Hirsch Apothecary founded in Frankfurt in 1462 to today's largest provider worldwide of products and services for dialysis – Fresenius Medical Care stands for the development of medicine and the progress of medical technology like hardly any other company.

The centre of this work is, as it has always been, people and their health. Key areas of emphasis today are dialysis devices, dialysis clinics and accompanying therapies. The most important target group is people with chronic or acute kidney failure. Dialysis systems of Fresenius Medical Care replace the lost functions of the body's own kidneys, thereby saving the patient's life. About 1.4 million people receive regular dialysis treatment today worldwide. The figure grows by about 6% annually. Most of them are connected to a dialysis device 3 to 4 times a week for 4 to 5 hours. It follows that sufficient capacity must be available to meet this demand.

As an internationally leader in dialysis, Fresenius Medical Care produces especially dialysis devices, dialysers (artificial kidneys) and products for dialysis. At two locations in Germany and the USA, 22,000 dialysis machines are manufactured annually. Half of all machines come from the plant in Schweinfurt, while the other half are produced in Walnut Creek California based on assembly kits delivered from Germany. All functions, user convenience and especially component/device quality are subject to demanding standards. Of course this is an especially important consideration in mechanical manufacturing. As Ralf Cimander, Director of Production for Machining Manufacturing in the Schweinfurt plant notes: "We have a modern CNC machine park with 18 units for turning, boring, and milling. Due to the high number of units processed, we place 30% to 40% of our order volume externally, but we keep the core components of the dialysis device in our own manufacturing. We want to have the expertise available in our own house for processing of critical PP full material." To ensure the required quality and economical manufacturing, the majority of CNC machines are equipped with fully automatic workpiece feeding mechanisms. For drilling/milling processing of heater and multifunction blocks, Ralf Cimander relies on machining centres of Hermle, "because they are able to meet our high demands in terms of performance capability, functionality, flexibility in application and usage, precision and user friendliness".

Currently the plant in Schweinfurt is using a CNC C 800 U machining centre series acquired in 2003, a CNC C 600 U machining centre with automatic workpiece magazine/handling system HS 30 dating from 2001/2002 and a CNC C 30 U high performance machining centre ordered in 2005. The C 800 U machining centre is equipped with an NC swiveling rotary table with a diameter of 280 mm and an ICS high-pressure coolant system. Workpieces are fed or removed here automatically by industrial robots. The new CNC C 30 U high-performance machining centre also has an NC swiveling rotary table with diameter of 280 mm plus an ICS device and is prepared for fitting with workpiece handling by robot. The C 600 U machining centre occupies a special place with HS 30. It processes orders with high part numbers fully automatically. Ralf Cimander: "We manufacture a good 70 different milled parts from a wide variety of materials involving varying degrees of difficulty. The intensity of the machining also varies. Runtimes range from a few minutes to a maximum of 13 minutes. A maximum of 25 minutes is still required with the conventional machine park, which means we save about 50 % on time by using the Hermle C 600 U and the HS 30 automatic workpiece magazine and handling systems.

This figure vividly illustrates how CNC precision machining centres plus automatic part handling can drastically reduce non-productive times and increase performance. The HS 30 and the robot system also help to protect our jobs, since they allow us to design series manufacturing economically and thus keep it at this location".

www.fresenius.de

Fresenius Medical Care's new generation of dialysis system

Hermle corporate sales rise 10 % in 2005 to 156.1 million Euro

Dear customers, interested persons,
shareholders, employees and friends of the company,

I hope very much the positive trend in the German economy continues instead of being whittled away again by negative marginal phenomena. Germany would be well advised not to grow just abroad and thereby run the risk of producing only where there are markets. After all, we have become what we are today in Germany, but that also includes the corresponding general conditions - something that is easily forgotten.

Maschinenfabrik Berthold Hermle AG was able to finish the last fiscal year with a better than expected result and, according to preliminary calculations, further improve orders received, sales volume and bottom line. Orders received company wide for the reporting period climbed around 11.5 % to 160.7 million Euro (previous year 144.1). After an especially difficult start in Germany, demand quickened significantly towards the end of the year, contrary to expectations. Despite the late upswing, orders received in Germany for the entire year were still slightly below the previous year at 81.1 million Euro (previous year 82.4), while new orders outside Germany rose by 29 % to 79.6 million Euro (previous year 61.7). Orders received as of 31.12.2005 came to 30.8 million Euro (previous year 26.1).

Hermle sales volume rose 10 % company-wide to 156.1 million Euro (previous year 142.3). Since the higher volume of orders received first makes itself felt with a delay in sales, sales volume in Germany was 7.5% below the previous year at 76.9 million Euro (previous year 83.1). On the other hand, sales outside of Germany rose 34 % to 79.2 million Euro (previous year 59.2), thus contributing almost 51 % of total volume (previous year 42 %). The additional sales volume in addition to the extremely efficient and flexible company structure of Hermle ensured that the group's annual surplus after IFRS increased 12.3 million Euro to over 16 million Euro. As previously announced, Hermle is also planning on paying a special bonus in addition to the fixed dividend of 0.85 Euro per preferred share and 0.80 Euro per regular share. The supervisory board and management board will advise in May as to the amount of this bonus.

As of the end of the period, 31.12.2005, Hermle employed 647 company-wide, 33 more than one year ago. New positions were created especially in the areas of sales and customer service. The total number included 74 apprentices. The figure was the same last year and represents a high trainee quota of over 11 %.

Capital investment of the Hermle Group increased 23 % in 2005 to 8.0 million Euro (previous year 6.5). Investment centred around construction of a new production hall and the expansion of the shipping centre at the Gosheim location.

We will be presenting our traditional in-house exhibition again this year, and I'm pleased to extend a warm invitation to you today to attend.
New products such as the large-scale machining centre C 50, the compact C 20, and other automation solutions will be presented. You can take a guided tour and see for yourself the results of our investments in 2005. We hope Hermle will convince you and we can establish a long-term partnership to ensure productive cooperation in the future.

Sincerely

Dietmar Hermle

Hermle + Partner Vertriebs GmbH
Oymühlenstraße 29a - D-87466 Oy-Mittelberg
Phone +49 (0)8366 988007 Fax +49 (0)8366 987129
e-mail vertrieb.hpv@t-online.de
Internet www.hermle-partner-vertrieb.de

Hermle-Leibinger Systemtechnik GmbH
Daimlerstraße 14 - D-78532 Tuttlingen
Phone +49 (0)7461 96628-0 Fax +49 (0)7461 96628-398
e-mail info.hls@hermle.de

Hermle (Schweiz) AG
Rheingoldstraße 50 - CH-8212 Neuhausen
Phone +41 (0)52 67400-40 Fax +41 (0)52 67400-41
e-mail info@hermle-schweiz.ch
Internet www.hermle-schweiz.ch

Hermle Nederland B.V.
Molièrelaan 176 - NL-5924 AN Venlo-Blerick
Phone +31 (0)77 3961761 Fax +31 (0)77 4641070
e-mail info@hermle-nederland.nl
Internet www.hermle-nederland.nl

Verkaufsbüro Belgien
Martin Coun
Meldertsestraat 55 - B-3545 Halen
Phone +32 (0)13 5563-83 Fax +32 (0)13 5563-84
e-mail hermle.be@yucom.be

Hermle Machine Co. LLC
5100 West Franklin Drive - Franklin, WI 53132, USA
Phone +1 414 421-9770 Fax +1 414 421-9771
e-mail info@hermlemachine.com
Internet www.hermlemachine.com

Hermle Italia
Via Papa Giovanni XXIII 9-b - I-20090 Rodano (MI)
Phone +39 02 95327-241 Fax +39 02 95327-243
e-mail info@alwa.it
Internet www.alwa.it

Hermle Österreich

Rudolf Fluch
Sportplatzstrasse 31/2 - A-8712 Proleb
Phone +43 (0)3842 83377 Fax +43 (0)3842 82410
e-mail rudolf.fluch.hpv@utanet.at

Alexander Schiestl
Föhrenwald 35 - A-6105 Leutasch
Phone +43 (0)5214 20272 Fax +43 (0)5214 20377
e-mail alex.schiestl.hpv@aon.at

Hermle Česká Republika

Jaroslav Novácek
Svermova 349 - CZ-39102 Sezimovo Ùstí
Phone +420 (0)381 276278 Fax +420 (0)381 276221
e-mail jaroslav.novacek.hpv@volny.cz

Martin Skukálek
Podhájom 1365/164-73
SK-01841 Dubnica nad Váhom
Phone +421 (0)424 441888 Fax +421 (0)424 441886
e-mail martin.skukalek.hpv@stonline.sk

Hermle China

Shanghai Representative Office
#21E, No. 18 Cao Xi North Rd.
Xu Jia Hui,
200030 Shanghai, P.R.China
Phone +86 21 2281 9188 Fax +86 21 6427 1887
e-mail hermlesha@126.com

Beijing Representative Office
28# Beisan Huan Dong Road
ChaoYanDistric
100013 Beijing, P.R.China
Phone +86 10 64405196 Fax +86 10 64405216
e-mail hermlebeijing@vip.163.com

Hermle WWE AG
Zuger Strasse 72
CH-6340 Baar/ZG
Phone +41 (0)41 768 51-51 Fax +41 (0)41 768 51-50
e-mail info@hermle-wwe.com

OOO Hermle Vostok
ul. Polkovaya 1
RU-127018 Moskau
Phone +7 495 221 83 68 Fax +7 495 221 83 93
e-mail info@hermle-vostok.ru

IMPRINT

Published by:
Maschinenfabrik Berthold Hermle AG
Industriestraße 8-12 - D-78559 Gosheim
Editorial work, concept and layout: Udo Hipp / Südpol OHG
Phone +49 (0)7426 95-0
Fax +49 (0)7426 95-6110
e-mail info@hermle.de
Internet www.hermle.de
Photos Inspirations Ganter, Hermle AG
Printed Druckerei Fecker - Albstadt-Ebingen