Higher cut-quality, longer service life, more productivity: with VOLLMER’S technologies and services.

In 1909, Heinrich Vollmer developed the first saw setting and filing machines. His goal: maximum cutting tool and saw blade sharpness. At VOLLMER, we have been bringing this vision to life for more than 100 years. Successfully, and with sustained enthusiasm.

When it comes to handling sharp tools, nobody is more meticulous. Nobody knows more about circular saw blades, tooth shapes and tooth angles. Nobody is more consistent when it comes to developing new technologies that may soon make tool manufacturing and handling even more effective and economical. When it comes to circular saws, our developers, engineers and technicians have gained unique experience and a head start that is built on know-how over decades. What are you going to get out of it? Future-proof machines and solutions that have also been subjected to practical testing, which consistently set new benchmarks in reliability, precision and ease of use. Above all, services that are fine-tuned to your requirements, which lighten your load and enable you to concentrate fully on your core business.

When you are in business with VOLLMER, you are not just going to profit from high cutting rates, better cut-quality, longer service life and the resultant increase in productivity when your circular saws are deployed. You are also going to get the warm feeling that comes from knowing that you have a strong and futuristic partner by your side. A partner who helps you to sharpen your company’s profile.

MORE PRECISION
MORE EFFICIENCY
USE YOUR CIRCULAR SAWS SUCCESSFULLY WITH VOLLMER’S KNOW-HOW
CIRCULAR SAW

FOR THE CIRCULAR SAW IN TOOL PRODUCTION AND IN SHARPENING SERVICE
// VÖLLMER offers a comprehensive range of machines for the production and processing of carbide-tipped circular saw blades. This ranges from the manual sharpening machine right up to the VÖLLMER service centre with robot systems for complete automatic processing. The more variable the solution, the more uniform the efficiency and quality of your processing: the latest machine designs with CNC drives, multiprocessor technology and intelligent software ensure this.

FOR THE CIRCULAR SAW IN THE CHIPPER CIRCULAR SAWMILL
// Turn your sharpening room into a profit centre: with VÖLLMER’s processing machines, which are fully tailored to your requirements. From the particularly efficient CHC-eco series for standard tasks right up to the sophisticated handling system with automatic loading. Enhance your productivity and your success – thanks to extremely accurate tooth geometries and high cutting rates.

FOR MAXIMUM EASE OF USE IN EVERY DEPLOYMENT
// In the last 100 years, we have not just been working on machines. We have also been focussing on the people who operate them. The VÖLLMER operating concept is geared towards making their work as simple, safe and pleasant as possible. The concept is intuitive and logical, and every single VÖLLMER machine makes use of it. Copied frequently, but never matched.

CUTTING THROUGH TO MORE PRODUCTIVITY: EXPLOIT YOUR CIRCULAR SAWS POTENTIAL TO THE FULLEST!

PROFESSIONAL HANDLING AND CARE IS THE KEY TO THE EFFECTIVE AND PRODUCTIVE DEPLOYMENT OF YOUR CARBIDE OR HSS CIRCULAR SAWS.

VÖLLMER therefore has a uniquely diverse portfolio of advanced high-performance machines that can handle any task related to the maintenance, sharpening and tempering of your circular saws. Whether it is tool production, chipper sawmills or sharpening services, VÖLLMER has the right solution for your special requirements. A solution with a future! And since grinding isn’t the only thing that matters, we also have impressive solutions that deal with other important process steps that cover the entire spectrum of circular saw-related tasks: for instance, special sharpening and soldering machines for repairing circular saw blades.

These pages will give you an initial overview of the VÖLLMER machines that you can use to make handling of and working with circular saws a highly efficient process. For further information, please visit our website or contact your usual representative at VÖLLMER.

AREAS:
Band saw Frame saw Circular saw

APPLICATIONS:
Tooth face and tooth top in one single clamping operation. Automation can be integrated.
Whereas the perfect tooth face and tooth top grinding is important for the productivity of the carbide saw blade, the accurately ground tooth side is important for the surface quality. Good that VOLLMER has optimum solutions for both the handling processes.

Intelligent machine concepts, the highest precision and comfortable handling are just as synonymous with VOLLMER as the stable construction as well as a high degree of robustness and long service life.

AN OVERVIEW OF THE MOST IMPORTANT ADVANTAGES:

- Compact construction
- Machines with a stable construction for precise sharpening results
- Maintenance-friendly, thanks to the separation between the machine compartment/working area
- Simple operation
- Outstanding grinding results
- High capacity and economic efficiency
- Rare maintenance visits
- Advanced technology
- Optimally tuned to operation area and requirements

PROCESSING OF TOOTH FACES AND TOOTH TOPS

CP 650
CNC-controlled machine for sharpening tooth faces and tooth tops on carbide-tipped circular saw blades.

<table>
<thead>
<tr>
<th>Circular saw diameter</th>
<th>80 to 650 mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>Blade thickness</td>
<td>up to 5 mm</td>
</tr>
<tr>
<td>Tooth pitch</td>
<td>up to 100 mm</td>
</tr>
</tbody>
</table>

CHC 840 and CHC 1300
Flexible sharpening machine for carbide-tipped circular saw blades up to diameter 840 or 1300 mm.

<table>
<thead>
<tr>
<th>Circular saw diameter</th>
<th>CHC 840</th>
<th>CHC 1300</th>
</tr>
</thead>
<tbody>
<tr>
<td>Blade thickness</td>
<td>up to 8</td>
<td>up to 8</td>
</tr>
<tr>
<td>Tooth pitch</td>
<td>up to 100</td>
<td>optional up to 180</td>
</tr>
</tbody>
</table>

CHP 840 and CHP 1300
Universal sharpening machine for carbide-tipped circular saw blades up to diameter 840 or 1300 mm.

<table>
<thead>
<tr>
<th>Circular saw diameter</th>
<th>CHP 840</th>
<th>CHP 1300</th>
</tr>
</thead>
<tbody>
<tr>
<td>Blade thickness</td>
<td>up to 8</td>
<td>up to 8</td>
</tr>
<tr>
<td>Tooth pitch</td>
<td>up to 100</td>
<td>optional up to 180</td>
</tr>
</tbody>
</table>
CIRCULAR SAW // TOOTH FACES AND TOOTH TOPS

### CHX
Flexible sharpening machine for machining the tooth face and tooth top of carbide-tipped circular saw blades in one set-up up to a diameter of 840 or 1300 mm.

<table>
<thead>
<tr>
<th>CHX 840</th>
<th>CHX 1300</th>
</tr>
</thead>
<tbody>
<tr>
<td>Circular saw diameter</td>
<td>80 to 840</td>
</tr>
<tr>
<td>Blade thickness</td>
<td>up to 8</td>
</tr>
<tr>
<td>Tooth pitch</td>
<td>up to 100</td>
</tr>
</tbody>
</table>

### CHX 840 with HS
Automatic machine loading of circular saw blades with a diameter of 140 to 530 mm in addition to the sharpening machine CHX 840.

<table>
<thead>
<tr>
<th>CHD 270</th>
</tr>
</thead>
<tbody>
<tr>
<td>Circular saw diameter</td>
</tr>
<tr>
<td>Blade thickness</td>
</tr>
<tr>
<td>Tooth pitch</td>
</tr>
</tbody>
</table>

### CM 200
Sharpening machine for processing the tooth faces and tooth tops on carbide-tipped circular saw blades.

<table>
<thead>
<tr>
<th>CM 300</th>
</tr>
</thead>
<tbody>
<tr>
<td>Circular saw diameter</td>
</tr>
<tr>
<td>Blade thickness</td>
</tr>
<tr>
<td>Tooth pitch</td>
</tr>
</tbody>
</table>

### QR 270
Eroding machines for processing the tooth tops of PCD-tipped circular saw blades.

<table>
<thead>
<tr>
<th>QR 270</th>
</tr>
</thead>
<tbody>
<tr>
<td>Circular saw diameter</td>
</tr>
<tr>
<td>Blade thickness</td>
</tr>
<tr>
<td>Tooth pitch</td>
</tr>
</tbody>
</table>
CIRCULAR SAW // TOOTH SIDES

/// PROCESSING TOOTH SIDES

/// CHF 21 H
Machines for repairing carbide-tipped circular saw blades.

- Circular saw diameter: 80 to 700 mm
- Blade thickness: up to 6 mm
- Tooth pitch: from 8 onwards mm

/// CPF 650
CNC-controlled machine for sharpening side angles on carbide-tipped circular saw blades.

- Circular saw diameter: 80 to 650 mm
- Blade thickness: up to 5 mm
- Tooth pitch: up to 100 mm

/// CHF 840 and CHF 1300
CNC-controlled machine for grinding tooth sides on carbide-tipped circular saw blades with a diameter of up to 840 or 1300 mm.

- CHF 840
  - Circular saw diameter: 80 to 840 mm
  - Blade thickness: up to 6 mm
  - Tooth pitch: from 8 onwards mm
- CHF 1300
  - Circular saw diameter: 80 to 1300 mm
  - Blade thickness: up to 6 mm
  - Tooth pitch: from 8 onwards mm

/// CHF 270
Sharpening machine for processing the tooth sides of carbide-tipped circular saw blades.

- Circular saw diameter: 80 to 840 mm
- Blade thickness: up to 14 mm
- Tooth pitch: up to 180 mm

/// CMF 200
Machine for processing the tooth sides on carbide-tipped circular saw blades.

- Circular saw diameter: 200 to 840 mm
- Blade thickness: up to 15 mm
- Tooth pitch: up to 180 mm

/// CMF 300
Machine for processing the tooth sides on carbide-tipped circular saw blades.

- Circular saw diameter: 200 to 1440 mm
- Blade thickness: up to 18 mm
- Tooth pitch: up to 180 mm

Automation solutions on pages 14/15

/// Automation solutions on pages 14/15

10
11
Machine for processing the tooth sides of PCD-tipped circular saw blades according to the wheel-electro-erosion process.

<table>
<thead>
<tr>
<th>Circular saw diameter</th>
<th>80 to 840 mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>Blade thickness</td>
<td>up to 14 mm</td>
</tr>
<tr>
<td>Tooth pitch</td>
<td>up to 180 mm</td>
</tr>
</tbody>
</table>

Brazing equipment for debrazing and brazing carbide teeth.

<table>
<thead>
<tr>
<th>Circular saw diameter</th>
<th>100 to 830 mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>Carbide tooth width</td>
<td>up to 6 mm</td>
</tr>
</tbody>
</table>

VOLLMER also has suitable automation solutions for all companies who wish to machine circular saw blades with high efficiency and productivity with minimum labour utilisation – without compromising on the quality of the result. For automatic machining on tooth faces and tooth tops as well as tooth sides during production and in service. Round-the-clock.

Thanks to the tried and tested ND handling system in combination with easy data entry, you are going to profit from maximum flexibility.

ESPESCALLY INTERESTING FOR SHARPENING SERVICES:

You can decide the sequence in which the individual processing steps should be executed, which coil cars are processed and when and where the processed saw blades are stored. The diameter, number of teeth and tooth geometries can be changed when processing several batches. Your VOllMER representative will gladly advise you in detail on the most optimum automation solution for you.
### MACHINE COMPATIBILITY / AUTOMATION

<table>
<thead>
<tr>
<th>MACHINE</th>
<th>ND 230</th>
<th>ND 250</th>
<th>ND 270</th>
<th>ND 320</th>
<th>ND 340</th>
<th>ND 360</th>
</tr>
</thead>
<tbody>
<tr>
<td>CHD 270</td>
<td>✔</td>
<td>✔</td>
<td>✔</td>
<td>✔</td>
<td>✔</td>
<td>✔</td>
</tr>
<tr>
<td>CHF 270</td>
<td>✔</td>
<td>✔</td>
<td>✔</td>
<td>✔</td>
<td>✔</td>
<td>✔</td>
</tr>
<tr>
<td>CM 200</td>
<td>✔</td>
<td>✔</td>
<td>✔</td>
<td>✔</td>
<td>✔</td>
<td>✔</td>
</tr>
<tr>
<td>CMF 200</td>
<td>✔</td>
<td>✔</td>
<td>✔</td>
<td>✔</td>
<td>✔</td>
<td>✔</td>
</tr>
<tr>
<td>CM 300</td>
<td>✔</td>
<td>✔</td>
<td>✔</td>
<td>✔</td>
<td>✔</td>
<td>✔</td>
</tr>
<tr>
<td>CMF 300</td>
<td>✔</td>
<td>✔</td>
<td>✔</td>
<td>✔</td>
<td>✔</td>
<td>✔</td>
</tr>
<tr>
<td>QR 270</td>
<td>✔</td>
<td>✔</td>
<td>✔</td>
<td>✔</td>
<td>✔</td>
<td>✔</td>
</tr>
<tr>
<td>QF 270</td>
<td>✔</td>
<td>✔</td>
<td>✔</td>
<td>✔</td>
<td>✔</td>
<td>✔</td>
</tr>
</tbody>
</table>

### STACK OCCUPANCY / SAW BLADE DIAMETER

<table>
<thead>
<tr>
<th>Single stack</th>
<th>100 to 630 mm</th>
<th>100 to 630 mm</th>
<th>100 to 630 mm</th>
<th>200 to 840 mm</th>
<th>200 to 840 mm</th>
<th>200 to 840 mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>Double stack</td>
<td>100 to 305 mm</td>
<td>100 to 305 mm</td>
<td>100 to 305 mm</td>
<td>200 to 410 mm</td>
<td>200 to 410 mm</td>
<td>200 to 410 mm</td>
</tr>
</tbody>
</table>

### GRIPPER / BLADE WEIGHT

<table>
<thead>
<tr>
<th>STANDARD GRIPPER</th>
<th>Single-sided use</th>
<th>9 kg</th>
<th>9 kg</th>
<th>9 kg</th>
<th>20 kg</th>
<th>20 kg</th>
<th>20 kg</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>Two-sided use</td>
<td>6 kg</td>
<td>6 kg</td>
<td>6 kg</td>
<td>11 kg</td>
<td>11 kg</td>
<td>11 kg</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>SAWMILL GRIPPER</th>
<th>Single-sided use</th>
<th>10 kg</th>
<th>10 kg</th>
<th>10 kg</th>
<th>10 kg</th>
<th>10 kg</th>
<th>10 kg</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>Two-sided use</td>
<td>6 kg</td>
<td>6 kg</td>
<td>6 kg</td>
<td>6 kg</td>
<td>6 kg</td>
<td>6 kg</td>
</tr>
</tbody>
</table>
A part of the VOLLMER group of companies since 2006, Loroch is expanding the comprehensive product range of the group with additional, tried and tested and high-performance sharpening machines for circular saw and bandsaw blades. Loroch continues to pave the way, particularly when it comes to machining high-speed steel circular saw blades, and enjoys an excellent reputation at international level. Loroch’s product range includes simple and manual machines as well as fully automatic service centres. As a member of the VOLLMER family, it goes without saying that Loroch is also synonymous with maximum precision, innovative technology and maximum productivity.

### FULLY AUTOMATIC

#### K8C 710-T
Innovative service centre for automatic sharpening, re-tooth, chamfering and grinding of chip breaker grooves in metal circular saw blades. Ideal for saw blade manufacturers. High grinding volume. Complete machining of thin kerf saw blades possible. Complete machining of carbide-tipped table saws is possible.

| Blade diameter – manual | 40 (130) to 710 | mm |
| Blade diameter – with loader | 75 (130) to 560 | mm |
| Blade diameter Chamfering | 145 (105) to 710 | mm |
| Blade thickness | up to 8 | mm |
| Tooth pitch | 1 to 55 | mm |
| Number of teeth | 2 to 998 | |

#### EVOLUTION K850-M
Compact service centre for economical grinding of metal cutting saw blades. Ideal solution for small to medium-sized companies. Complete machining of carbide-tipped table saws is possible.

| Blade diameter – manual | 40 (130) to 850 | mm |
| Blade diameter – with loader | 75 (130) to 520 | mm |
| Blade diameter Chamfering | 145 bis 850 (105) | mm |
| Blade thickness | up to 8 | mm |
| Tooth pitch | 1 to 40 | mm |
| Number of teeth | 2 to 998 | |

#### SOLUTION K850-T
Automatic saw sharpening machine for automatic complete processing of metal circular saw blades, ideal for multiple-machine operation. Grinding of chip breaker grooves with additional equipment. Complete machining of carbide-tipped table saws is possible.

| Blade diameter | 40 (130) to 850 (920) | mm |
| Blade diameter Chamfering | 145 bis 850 (920) | mm |
| Blade thickness | up to 8 | mm |
| Tooth pitch | 1 to 40 | mm |
| Number of teeth | 2 to 998 | |
### POWERSTAR 850
CNC-controlled high-tech grinding machine for manufacturing of metal cutting circular saws from (40) 130 to 850 (920) mm Ø.
Grinding of chip breaker grooves with additional equipment. Manual insertion of the grinding wheel, semi-automatic chamfering.
Grinding of chip breaker grooves with additional equipment.

<table>
<thead>
<tr>
<th>Parameter</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Blade diameter</td>
<td>(40) 130 to 850 (920) mm</td>
</tr>
<tr>
<td>Blade diameter Chamfering</td>
<td>(105) 145 to 850 (920) mm</td>
</tr>
<tr>
<td>Blade thickness</td>
<td>up to 8 mm</td>
</tr>
<tr>
<td>Tooth pitch</td>
<td>up to 40 mm</td>
</tr>
<tr>
<td>Number of teeth</td>
<td>2 to 998</td>
</tr>
</tbody>
</table>

### ELECTRICAL-MECHANICAL-CONTROLLED

#### SW 450
A versatile machine for complete processing of HSS, segmental and friction saws with ceramic grinding wheels.

<table>
<thead>
<tr>
<th>Parameter</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Blade diameter:</td>
<td></td>
</tr>
<tr>
<td>metal cutting saws</td>
<td>22 to 450 (550) mm</td>
</tr>
<tr>
<td>Wood/plastic cutting</td>
<td>22 to 450 (550) mm</td>
</tr>
<tr>
<td>Blade diameter friction</td>
<td>up to 950 (850) mm</td>
</tr>
<tr>
<td>Blade thickness</td>
<td>up to 8 mm</td>
</tr>
<tr>
<td>Tooth pitch</td>
<td>up to 20 mm</td>
</tr>
<tr>
<td>Tooth height</td>
<td>up to 8 (12) mm</td>
</tr>
</tbody>
</table>

#### SW 630-ST
For grinding of chip breaker grooves in metal circular saws with automatic displacement of the grinding wheel.

<table>
<thead>
<tr>
<th>Parameter</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Blade diameter</td>
<td>165 to 630 (650) mm</td>
</tr>
<tr>
<td>alternatively possible after 140</td>
<td>mm</td>
</tr>
<tr>
<td>Blade thickness</td>
<td>6 mm</td>
</tr>
<tr>
<td>Tooth pitch</td>
<td>3 to 50, vario toothing as well</td>
</tr>
<tr>
<td>Working speed</td>
<td>approx. 7 to 50 t/min</td>
</tr>
</tbody>
</table>
MEASUREMENT

TC 700

Checking the most significant data regarding HSS and carbide-tipped circular saw blades. The measurement data can be saved and printed with an image or directly sent via email.

| Blade diameter | 40 to 700 mm |
At VOLLMER, you will not only get sharpening and eroding machines perfectly tailored to your requirements, but also all the important auxiliary, maintenance and consumable materials, optimally tuned for smooth and efficient deployment. Improve the efficiency and service life of your original VOLLMER machine with the original VOLLMER quality.

### CONSUMABLES CIRCULAR SAWS
- Circular saw guides
- CBN grinding wheels
- Diamond grinding wheels
- Test and measuring tools
- Other consumables: filter fleece, feeder bolts, Volmaton, semi-fluid grease, grinding oil

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- info@loroch.de
CUSTOMISED SERVICE

In this competitive environment, VOLLMER is on your side, with highly efficient high-performance machines. A complete portfolio of services that are perfectly matched to your requirements. Our services help you ensure that your VOLLMER machines reach and sustain their full potential and enable you to concentrate fully on that which is most important: Your success.