

HIGH LIGHT

GRUNWALD® 
Dosing · Filling · Packing



GRUNWALD's customer magazine no 29 / September 2014



Editorial	2
GRUNWALD service department under new management	3
GRUNWALD assembly hall expanded again	3
Multi-functional dessert line supplied to Edmund Merl	4-5
GRUNWALD-UF-WHITE CHEESE cup filling line	6-7
Spontaneous relief operation for flood victims in Bosnia	8



EDITORIAL



"Come - see - be amazed". This was how our visitors expressed their emotions when they visited the GRUNWALD pasture at the "interpack" fair this year. Already in the first few days of the fair the amount of visitors was so huge that the capacity of our fair stand was fully exhausted. High flexibility in filling the most diverse products and a significant reduction in costs were in the center of the GRUNWALD trade fair appearance.

Expert visitors from at home and abroad informed themselves on the announced technical refinements and innovative concepts "made by GRUNWALD".

In many talks and discussions our new developments were highly praised. Detailed projects were approached, concepts were discussed and ways for solutions debated.

One more time the interpack provided an exciting environment for leading interesting expert discussions and establishing numerous

new contacts. This fair is THE highlight which we concluded with numerous orders and new customers.

Apart from all the bustling activity, the personal dialogue and the hospitality on the GRUNWALD pasture was never neglected. Our guests liked to sit in our traditional and cozy beer garden. They enjoyed the atmosphere and had themselves spoiled with the typical specialties from the Allgäu. The "Fidelis Leberkäse (kind of meatloaf popular in the region) freshly baked by our country butcher from Wangen was the number-one hit of the dishes offered.

Thank you for coming! We were glad that you found the time for a visit at the GRUNWALD pasture. Already now we are looking forward to meeting you again at the next "interpack" fair in spring 2017.

Yours
Ralf Müller
and the GRUNWALD team

COVER

"Our Allgäu" - with its young cattle on the pastures and the numerous cows grazing on the meadows softly embedded in the downs of the Allgäu.

Photo: Marlies Hodrius

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NEWS

GRUNWALD service department under new management

Bernd Bernhart, who has been the responsible head of the service department for nearly 10 years is taking over one of the two newly created jobs as a project leader at GRUNWALD as from August 2014.

In the future the project leaders will be responsible for the successful realisation of huge projects and for the complete filling lines upon contraction of the machine orders. They will accompany the process from start of operation to acceptance of the machine. They will also keep close contact to customers and employees during the project and will provide information for a smooth settlement of the project. An interesting and responsible job - in the interest of our customers.

On this occasion we would like to say thank you Bernd for your long-lasting, excellent commitment in customer service and in the organisation of service assignments of our fitters. Your empathy and high professionalism enabled you to master the most difficult tasks.

Our special thanks and respect for this. Good luck and much success for your new tasks.

Marcel Sgonc is the "new one" in the service department and the successor of Bernd Bernhart.

Marcel Sgonc previously was head of customer service and spare part sales at an Austrian engineering company. He possesses the necessary knowhow in order to act customer-oriented, self-responsible and flexible in international customer service. He started working in our company in March 2014 and will become head of our service department as from August 1.

He will be supported by Bernd Rothenaicher as his deputy. Bernd is an "old hand" at Grunwald and has managed this position successfully for many years.

We are glad that we could gain Marcel Sgonc for us and for our clients and wish him a successful start and good luck!



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GRUNWALD assembly hall expanded again

Once in a while you could gain the impression that GRUNWALD was a constant construction site. Hardly has one building activity been completed when the next expansion is already on the way.

In 2007 the new production hall was built with more than 1000 square meters. One year later we expanded the assembly hall by 500 square meters to a total of 1000 square meters. At

the same time 5 new offices with a total of 125 square meters were added, the company access drive was transferred and the parking lot was enhanced. In 2012 our construction site was started.

In June 2013 the buildings were inaugurated with a wonderful party.

In order to meet the orders for inline machines which had increased tremendously, we

urgently had to create the necessary space for mounting the machines. Thus, the ground was broken for another expansion of our assembly hall - this time by 600 square meters - at the location of the former parking lot in April. Completion of the building is expected to be in September.

After the eighth building expansion we now possess 6100 square meters roofed area - on a land area of 13,400 square meters.

Start of construction middle of April 2014



Construction site middle of May



Construction site June 2014





Precise filling technique for manufacturing fresh products

Multi-functional dessert line supplied to Edmund MERL

INFO

MERL - the name stands for exclusive recipes, portioned on demand, always fresh with an appetising appeal and free of preservatives.

MERL offers a variety of choices for every taste:

- Delicacies for the counters in delicatessen stores and department stores
- Mixed salads for meat-lovers such as sausage salad or chicken salad
- Fresh salads made of potatoes, noodles, eggs or cheese
- Fresh salads made of vegetable and fruits and uncooked vegetables
- Varieties of fish and seafood
- Dressings
- Desserts
- Antipasti / tapas / spreads

The major factor for all products produced by MERL is the use of exquisite, fresh raw materials.

A tradition which started in 1933 with the production of fresh herring and sausage salads as well as pickled herrings in the south part of the city of Cologne.

Since 1965 premium delicatessen salads have been offered free of preservatives.

Fresh delicatessen salads from the self-service shelf have always been popular. MERL supplies its products within Germany but also to the neighbours abroad. For filling and manufacturing the latest dessert creation in round cups of different sizes GRUNWALD supplied the rotary-type filling unit (see photo).

A delicious dessert is the highlight of every meal. Besides the well-known delicatessen products MERL has also produced a variety of different desserts for many years in order to successfully crown the meal at home with a delicious dessert.

In the refrigerated cabinets of the supermarkets the consumer can find a big choice of fresh patisserie and mixed desserts promising a unique taste experience. Apart from a huge variety and a high quality the visual aspects are very important because exclusive products demand eye-catching packaging which wake a desire in the customer and induce him to buy.

Highest demands for highest quality

In order to be able to present these high-grade dessert creations in a high-grade manner the filling and packaging machines are also required to be of high standard.

When producing desserts with many layers the products must be filled on top of each other in several steps without flowing into each other. For some desserts an additional baked pastry case is put in between, for others toppings are used.

The continually changing recipes and the many requirements due to the different consistence of the creams, sauces and fruits present a real challenge for the fully-automated filling. The number of layers as well as the position of the intermediate layers and products can vary. Flexibility is therefore of utmost importance - but simultaneously high requirements are placed to the performance and availability of the filling machine.

New ways for "pure pleasure"

Because of the existence of a long-standing reliable cooperation between GRUNWALD and MERL the responsible managers referred to GRUNWALD with these complex demands. In order to be able to fulfill all the complex requirements new ground had to be broken.

The solution was found on the basis of a standard rotary-type machine. For this purpose the GRUNWALD ROTARY 20.000 was equipped with a large free space for manual filling or topping. It also allows a flexible arrangement of up to four automatic filling stations.

Different layers of fruit jelly and creams can be filled via up to three simultaneously working piston fillers. The rotary-type machine offers enough free space for filling cake bases manually. Moreover, chocolate sprinkles or other pourable products can be garnished as topping through a vibration dosing machine. High flexibility is achieved as the dosage is filled by a movable arm and the filling positions can be changed variably. Another factor are the manual filling positions.

The big advantage of these interactions is that the number and the location of the individual product layers can be changed flexibly and can be adapted to the individual customer requirements.

Further applications

The rotary-type filling machine we supplied is used as a multi-function dessert line. As an additional extra it can also be used for standard products with only one filling station with

a maximum capacity of up to 100 cups per minute. In this case the manual filling line is covered in order to increase product safety and hygiene.

The multi-functional dessert line can thus be changed into a high-performance rotary-type machine.

The close cooperation with the customer plays an important role in developing and introducing new products. On this occasion we would like to say thank you to family MERL for their trust and the successful mutual cooperation. The relationship of both our family enterprises was further

strengthened thereby and this is the basis for both companies for further successful growth.

Photo below:

2-lane multi-functional dessert line GRUNWALD ROTARY 20.000 with free space for manual filling or topping

Photo right, from above to below:

- GRUNWALD-ROTARY 20.000 used as a high-precision rotary-type machine with covered manual filling section
- vibratory filler for garnishing chocolates strifes or other pouring products
- piston filler for fruit jelly and creams

CONTACT

Please do not hesitate to contact us if you are interested in this rotary-type machine and in receiving further information or if you are looking for a solution for your filling application please contact us.

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Photo left:
Enjoying German cakes in a different way: MERL cake desserts in different cup sizes - for the daily pleasure





UF WHITE CHEESE Filling, Coagulation and Closing Line

... makes your vision a reality

NEWS



The GRUNWALD-UF WHITE CHEESE cup filling line is designed for various kinds of cast cheeses such as

- FETA type
- Domiaty
- Queso Fresco
- all types which are based on UF concentrate.

Description of the plant:
The plant is build-up in three blocks:

1) Filling section

In the filling section the plastic cups are placed in the cup magazines and by cup destacking dispensed onto the filling conveyor, which will transport the cups stepwise under

- cup sterilisation UV(C)
- spraying station for anti-stick
- filling station
- spraying station for anti-foam and
- onto the pushover station at the inlet to the coagulation conveyor.

2) Coagulation section

As soon as 16 filled cups have been accumulated on the chain and peg drive of the filling machine, they are discharged on the coagulation conveyor.

In the coagulation section the filled cups will be transported gently from one end of the tunnel to the other for a period of 20 - 25 minutes (depending on type of cheese to be produced). A slowly moving transport conveyor is used to guarantee the coagulation of the products in the cups. The temperature of the tunnel will be continuously monitored.

At the end of the coagulation conveyor the cups will be pulled out row by row to the

transfer conveyor leading to the inlet of the GRUNWALD-HITTPAC AKH-019SE closing machine or alternatively back to the filling section for filling second layer.

2) Multi-step filling

When filling volumes above 500 ml the cups are filled in more than one step. The filling operation takes place as follows.

- After filling one part of the total volume, the partly filled cups are discharged to the coagulation tunnel. From the coagulation conveyor the cups are discharged to the return conveyor of the filling machine. Then the cups are indexed on the chain and peg drive of the filling station and are filled with another amount of the final volume.
- Step 1 is repeated as often as necessary to reach the final volume.

When the cups are filled with the total amount at the end of the coagulation conveyor the still open cups will be automatically discharged onto the infeed conveyor of the fully automatic packing machine GRUNWALD-HITTPAC AKH-019SE.

Photos on this page:

Photo top left shows the filling section with UV sterilisation of cups, anti-stick spraying filling nozzle and anti-foam spraying.

Photo below shows the buffer tank for the UF retentate, rennet mixing/buffering tank as well as the two mixing/buffering tanks for anti-foam/anti-stick.



3) Closing machine

The still open cups with the now coagulated cheese will be automatically transported to the following stations:

• infeed station

In the infeed station the cups are discharged to an indexing tappet and are placed in the rotary table

• Cheese cutting station

The cheese will be divided into 4 or 6 blocks by a vertical moving cutting knife

• Parchment paper station

where a pre-cut parchment paper lid is placed on top of the coagulated cheese

• Dry salting unit

dosing an adjustable quantity of fine salt on the parchment paper

• Lid dispenser

placing a UV sterilised pre-cut seal lids exactly on the cup and point welding it in order to keep it in position during the move to the heat sealing station

• Heat sealing station

for complete sealing of the lid-material.

• Space for Date coder on the foil lid

• **Cover lid dispenser** (optional) for applying a snap-on lid on top of the plastic-foil lid

• Cup lift and discharge conveyor

of the closed cups

Photos on this page:

Photo top left shows the dry-salting unit inclusive the buffer tank.

Photo below shows the cheese cutting section, for dividing the cheese into 4 or 6 blocks.

GRUNWALD offers various options for the UF-WHITE CHEESE cup filling line:

- Cup Buffer magazine
- GDL mixing tank prior to buffer tank
- Extended line for higher capacity
- Extended coagulation tunnel for up to 30 min. holding time
- 2 or 3 layered filling
- Cheese cutting
- Gas flushing to reduce residual oxygen
- Foil from reel sealing/cutting

Capacity / speed: 1.000 - 4.800 cups/hour depending on volume, product consistency, product characteristics, remaining headspace in the cup and packing material.

CONTACT

If you are interested in this UF-WHITE CHEESE cup filling line and in receiving further information or if you are looking for a solution for your filling application please contact us.

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NEWS

Spontaneous relief operation for flood victims in Bosnia

Our employee Arnan Zukic launched an impromptu relief operation at the end of June. Arnan Zukic was working in Italy when he heard about the flood disaster in Bosnia and Herzegovina through Facebook and the internet.

After seeing his homeland flooded and his people suffering and in crisis, he immediately launched a relief operation, with the help of everyone he knew.



He roused everyone he knew into action via phone and via Facebook, using the snowball principle. One of the first people to receive a call requesting help and support was our Managing Director Ralf Müller.

Ralf Müller didn't think twice before offering his immediate support. He provided one of the large vans from the corporate fleet for the relief operation. As well as covering all transport costs, he also gave EUR 1200 for aid supplies.

Within a short time, Arnan Zukic had people of all nationalities between the towns of Wangen and Sonthofen working to help him transport relief aid to the flood victims.

In just five days, enough money and supplies had been donated to send a total of 2.5 tons of aid supplies. Arnan Zukic's wife worked together with family and friends to organise the shopping, write lists and



find empty garages to store the goods until they were ready to be sent.

The shops that they visited offered them special discounts and donated countless items for the flood victims. Over 100 boxes were filled with staple foods, toiletries, clothes and toys.

Once the last space in the van was filled, our employee Sarah Gürsching had been dealing with the customs formalities for transporting the aid supplies and the



Sarajevo-based aid organisation Merhamet had agreed to store the supplies, Arnan Zukic and his brother Sanin set off on Friday afternoon.

They only planned to take the supplies to the Merhamet central warehouse close to Kaonik Buscova, near Sarajevo.

When they arrived, the brothers discovered that the aid organisation had lost many vehicles in the flood and that they



desperately needed vehicles to distribute the goods that were arriving from all over. Therefore the brothers decided to stay and to deliver large quantities of the goods to faraway locations with the van.

Until late into the night on Saturday, and even on Sunday, they made one journey after another.

On Sunday night, Arnan and Sanin, tired but safe and happy, began the journey home after travelling nearly 3000 km.



Arnan Zukic would like to thank all who helped. He estimates that the donations of money and goods totalled about EUR 5000.

"I will remember the smiles on people's faces for the rest of my life.

My brother and I are very happy to have provided aid to the people suffering in our country, together with our friends and family."