Board and pipe welding machines
The trench machines of type series PT are robust and powerful and thus suited for the pipe trench as well as for workshop application.

The trench machines are suited for welding PE, PE100, PP, PVDF and other thermoplastic materials in pipe diameters ranging from 40 mm to a maximum of 1600 mm. On the right and left sides of the machine, there is a double clamping device with quick clamps which are guided by two hydraulic cylinders. An electrical hydraulic unit operates this double clamping device to ensure the precise joining of the pipes.

The heating element is equipped with a high-quality PTFE coating to prevent the parts from sticking to it. The temperature is electronically controlled and visualised by means of a digital display. Newly developed reduction clamping inserts allow to convert the machine for another pipe diameter in a matter of seconds without loosening any screws. The facing tool and the heating element are suspended from the guide shafts when used and then for storage they are placed in the provided transport box.

As an option, it is possible to supply a recording device. In addition to the control function, it guides the user step by step through the welding cycle. After completing the welding process, a welding record is printed for documentation purposes. Owing to the development of special modules and software, manually operated trench machines can be converted to trench machines with semi- and fully automatic control (CNC).
<table>
<thead>
<tr>
<th>Model</th>
<th>Welding range</th>
<th>Pressure stages</th>
<th>Voltage</th>
<th>Power</th>
<th>Basic equipment</th>
</tr>
</thead>
<tbody>
<tr>
<td>PT 125</td>
<td>40mm – 125mm</td>
<td>SDR 41 – SDR 6</td>
<td>230V; 50Hz</td>
<td>1.5kW; 6.5 A</td>
<td>-</td>
</tr>
<tr>
<td>PT 160</td>
<td>40mm – 160mm</td>
<td>SDR 41 – SDR 6</td>
<td>230V; 50Hz</td>
<td>2.1kW; 9.1 A</td>
<td>-</td>
</tr>
<tr>
<td>PT 200</td>
<td>63mm – 200mm</td>
<td>SDR 41 – SDR 6</td>
<td>230V; 50Hz</td>
<td>2.7kW; 11 A</td>
<td>-</td>
</tr>
<tr>
<td>PT 250</td>
<td>63mm – 250mm</td>
<td>SDR 41 – SDR 6</td>
<td>230V; 50Hz</td>
<td>3.3kW; 14 A</td>
<td>-</td>
</tr>
<tr>
<td>PT 315</td>
<td>90mm – 315mm</td>
<td>SDR 41 – SDR 6</td>
<td>230V; 50Hz</td>
<td>4.8kW; 22 A</td>
<td>-</td>
</tr>
<tr>
<td>PT 355</td>
<td>90mm – 355mm</td>
<td>SDR 41 – SDR 6</td>
<td>230V; 50Hz</td>
<td>4.8kW; 22 A</td>
<td>-</td>
</tr>
<tr>
<td>PT 500</td>
<td>200mm – 500mm</td>
<td>SDR 41 – SDR 6</td>
<td>400V; 50Hz</td>
<td>6.9kW; 33 A</td>
<td>-</td>
</tr>
<tr>
<td>PT 630</td>
<td>315mm – 630mm</td>
<td>SDR 41 – SDR 6</td>
<td>400V; 50Hz</td>
<td>11.5kW; 17 A</td>
<td>-</td>
</tr>
<tr>
<td>PT 600</td>
<td>450mm – 800mm</td>
<td>SDR 41 – SDR 6</td>
<td>400V; 50Hz</td>
<td>13.9kW; 22 A</td>
<td>-</td>
</tr>
<tr>
<td>PT 1000</td>
<td>630mm – 1000mm</td>
<td>SDR 41 – SDR 6</td>
<td>400V; 50Hz</td>
<td>17.4kW; 28 A</td>
<td>-</td>
</tr>
<tr>
<td>PT 1200</td>
<td>630mm – 1200mm</td>
<td>SDR 41 – SDR 6</td>
<td>400V; 50Hz</td>
<td>21.7kW; 34 A</td>
<td>-</td>
</tr>
<tr>
<td>PT 1600</td>
<td>1000mm – 1600mm</td>
<td>SDR 41 – SDR 6</td>
<td>400V; 50Hz</td>
<td>54kW; 80 A</td>
<td>-</td>
</tr>
<tr>
<td>PT 250CSE</td>
<td>63mm – 250mm</td>
<td>SDR 41 – SDR 6</td>
<td>230V; 50Hz</td>
<td>3.3kW; 14 A</td>
<td>X</td>
</tr>
<tr>
<td>PT 315CSE</td>
<td>90mm – 315mm</td>
<td>SDR 41 – SDR 6</td>
<td>230V; 50Hz</td>
<td>4.8kW; 22 A</td>
<td>X</td>
</tr>
<tr>
<td>PT 355CSE</td>
<td>90mm – 355mm</td>
<td>SDR 41 – SDR 6</td>
<td>230V; 50Hz</td>
<td>4.8kW; 22 A</td>
<td>X</td>
</tr>
<tr>
<td>PT 500CSE</td>
<td>200mm – 500mm</td>
<td>SDR 41 – SDR 6</td>
<td>230V; 50Hz</td>
<td>8.9kW; 37.5 A</td>
<td>X</td>
</tr>
</tbody>
</table>

- Basic equipment: not available

**Subject to technical changes without notice.**
Workshop machines of type series PL

The pipe welding machines of type PL are sturdy and reliable welding machines. Due to the precise linear guides in the torsion-resistant basic frame, the machine allows the user to obtain a high degree of precision and stability under load.

The workshop machines operate hydraulically, they are computer controlled and suited and programmable for the welding of PE, PP and PVDF as well as other thermoplastic materials according to the latest DVS stipulations (DVS: German Welding Society).

For documentation and control purposes, a welding record is automatically printed at the end of the welding process.

The PTFE coated heating element as well as the electrical facing tool are connected with the basic frame of the machine. For clamping the individual pipe segments, several tools are available in various designs. For the production of T (45°, 60° and 90°), single-Y and double-V joints, special clamping tools were developed for the individual machine types.
### Technical Data of Type Series PL

#### PL 125 C
- **Welding range**: 25mm – 125mm
- **40mm – 160mm**
- **90mm – 315mm**
- **90mm – 400mm**
- **90mm – 500mm**
- **90mm – 400mm**
- **90mm – 500mm**

#### PL 160 C
- **Welding range**: 25mm – 125mm
- **40mm – 160mm**
- **90mm – 315mm**
- **90mm – 400mm**
- **90mm – 500mm**
- **90mm – 400mm**
- **90mm – 500mm**

#### PL 315 C /CNC
- **Welding range**: 25mm – 125mm
- **40mm – 160mm**
- **90mm – 315mm**
- **90mm – 400mm**
- **90mm – 500mm**
- **90mm – 400mm**
- **90mm – 500mm**

#### PL 400 CNC
- **Welding range**: 25mm – 125mm
- **40mm – 160mm**
- **90mm – 315mm**
- **90mm – 400mm**
- **90mm – 500mm**
- **90mm – 400mm**
- **90mm – 500mm**

#### PL 500 CNC
- **Welding range**: 25mm – 125mm
- **40mm – 160mm**
- **90mm – 315mm**
- **90mm – 400mm**
- **90mm – 500mm**
- **90mm – 400mm**
- **90mm – 500mm**

#### Pressure Range
- **SDR 41 – SDR 7.4**
- **SDR 41 – SDR 6**
- **SDR 41 – SDR 6**
- **SDR 41 – SDR 6**

#### Voltage
- **230V; 50Hz**
- **230V; 50Hz**
- **230V; 50Hz**
- **400V; 50Hz**

#### Power
- **1.6 kW**
- **2.2 kW**
- **5.6 kW; 24.5 A**
- **6.2 kW; 9 A**
- **9.95 kW; 14.4 A**

#### Heating element removable, PTFE coating and thermostat
- **X**
- **X**
- **X**
- **X**

#### Electrical facing tool
- **X**
- **X**
- **X**
- **X**

#### Four-jaw clamping plate
- **25 – 125mm**
- **40 – 160mm**
- **90 – 315mm**
- **90 – 400mm**

#### Rotating clamping jaws
- **125mm**
- **160mm**
- **315mm**
- **400mm**

#### Transport box
- **X**
- **X**

---

### Technical Data of Type Series PL

#### PL 630 CNC
- **Welding range**: 315mm – 630mm
- **315mm – 800mm**
- **630mm – 1200mm**
- **900mm – 1600mm**

#### Weldable bends
- **90° T joint connection**: 315mm – 630mm
- **90° T joint connection**: 315mm – 630mm
- **90° T joint connection**: 630mm – 900mm
- **90° T joint connection**: 900mm – 1200mm

#### Pressure range
- **SDR 41 – SDR 6**
- **SDR 41 – SDR 6**
- **SDR 41 – SDR 6**
- **SDR 41 – SDR 6**

#### Voltage
- **400V; 50Hz**
- **400V; 50Hz**
- **400V; 50Hz**
- **400V; 50Hz**

#### Power
- **23kW; 34 A**
- **23 kW; 34 A**
- **39 kW; 56 A**
- **55 kW; 85 A**

#### Basic machine including rotating clamping jaws
- **630mm**
- **800mm**
- **1200mm**
- **1600mm**

#### Heating element removable, PTFE coating and thermostat
- **X**
- **X**
- **X**
- **X**

#### Electrical facing tool
- **X**
- **X**
- **X**
- **X**

#### Four-jaw clamping plate
- **315 – 630mm**
- **315 – 800mm**
- **630mm – 1200mm**
- **900mm – 1600mm**

#### Reduction clamping inserts for rotating clamping jaws
- **315,355,400,450,500,560mm**
- **315,355,400,450,500,560mm**
- **315,355,400,450,500,560mm**
- **315,355,400,450,500,560mm**

#### Clamping jaws for fittings
- **25,32,40,50,63,75,90,110mm**
- **315,355,400,450,500,560mm**
- **315,355,400,450,500,560mm**
- **315,355,400,450,500,560mm**

#### Clamping element for 90° T joint connection
- **25 – 125mm**
- **40 – 160mm**
- **90 – 315mm**
- **90 – 400mm**

#### Reduction clamping inserts for 90° T joint connections
- **315,355,400,450,500,560mm**
- **315,355,400,450,500,560mm**
- **315,355,400,450,500,560mm**
- **315,355,400,450,500,560mm**

#### Transport box
- **X**
- **X**

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Subject to technical changes without notice.
The manual pipe welding machines of the series EURO and WORLD are light-weight, highly versatile machines. They allow the user the possibility to process PE and PP pipes as well as fittings in dimensions up to SDR 11.

A sturdy frame guarantees a safe transport as well as the easy handling during processing. Via the installation of several storage facilities, it is possible to store the clamping tools quickly and easily.
## Technical data of type series EURO & WORLD

### EURO 160
- **Welding range**: 40mm – 160mm
- **Pressure stages**: SDR 41 – SDR 17,6 alle Ø; SDR 11 Ø 40 – 125mm
- **Voltage**: 230V; 50Hz
- **Power**: 1,3 kW
- **Reduction clamping inserts**: 40,50,63,75,90,125,140mm
- **Clamping jaws, rotating up to**: 7,5°
- **Heating element with PTFE coating and thermostat**: X
- **Electrical facing tool**: X
- **Protection for heating element**: X
- **Welding pressure scale for PE pipes**: X

### WORLD 160
- **Welding range**: 40mm – 160mm
- **Pressure stages**: SDR 41 – SDR 17,6 alle Ø; SDR 11 Ø 40 – 125mm
- **Voltage**: 230V; 50Hz
- **Power**: 1,3 kW
- **Reduction clamping inserts**: 40,50,63,75,90,125,140mm
- **Clamping jaws, rotating up to**: 7,5°
- **Heating element with PTFE coating and thermostat**: X
- **Electrical facing tool**: X
- **Protection for heating element**: X
- **Welding pressure scale for PE pipes**: X

### EURO 200
- **Welding range**: 40mm – 200mm
- **Pressure stages**: SDR 41 – SDR 26 alle Ø; SDR 17,6 Ø 40 – 160mm; SDR 11 Ø 40 – 125mm
- **Voltage**: 230V; 50Hz
- **Power**: 1,9 kW
- **Reduction clamping inserts**: 40,50,63,75,90,125,140,160mm
- **Clamping jaws, rotating up to**: 7,5°
- **Heating element with PTFE coating and thermostat**: X
- **Electrical facing tool**: X
- **Protection for heating element**: X
- **Welding pressure scale for PE pipes**: X

### WORLD 250
- **Welding range**: 63mm – 250mm
- **Pressure stages**: SDR 41 – SDR 33 alle Ø; SDR 22 Ø 40 – 225mm; SDR 17,6 Ø 40 – 160mm; SDR 11 Ø 40 – 140mm
- **Voltage**: 230V; 50Hz
- **Power**: 3 kW
- **Reduction clamping inserts**: 63,75,90,110,125,140,160,180,200,225,280mm
- **Clamping jaws, rotating up to**: 7,5°
- **Heating element with PTFE coating and thermostat**: X
- **Electrical facing tool**: X
- **Protection for heating element**: X
- **Welding pressure scale for PE pipes**: X

### EURO 315 C
- **Welding range**: 90mm – 315 mm
- **Pressure stages**: SDR 41 – SDR 26 alle Ø; SDR 22 Ø 225 – 250mm; SDR 11 Ø 90 – 200mm
- **Voltage**: 230V; 50Hz
- **Power**: 4,5 kW
- **Reduction clamping inserts**: 90,110,125,140,160,180,200,225,280mm
- **Clamping jaws, rotating up to**: 22,5°
- **Heating element with PTFE coating and thermostat**: X
- **Electrical facing tool**: X
- **Protection for heating element**: X
- **Welding pressure scale for PE pipes**: X

*Subject to technical changes without notice.*

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- not available: X
- basic equipment: basic equipment
The heating element socket welding machine of type series POLY is suited for PE, PP and PVDF pipes and fittings of diameters from 16 to 110 mm.

The machines are highly versatile and light-weight, but nevertheless mounted on a sturdy frame. Due to the infinitely variable prism clamping jaws, all external diameters can be easily clamped.

The motion of the carriage can be effected depending on the construction design either manually via gear wheel and gear rack or hydraulically. Heating pins and sockets are provided with a high-quality coating each and comply with the stipulations of DVS 2208.

**Technical data:**

<table>
<thead>
<tr>
<th></th>
<th>POLY 75</th>
<th>POLY 110 M</th>
<th>POLY 110 P</th>
</tr>
</thead>
<tbody>
<tr>
<td>Welding range</td>
<td>16mm – 75mm</td>
<td>16mm – 110mm</td>
<td>16mm – 110mm</td>
</tr>
<tr>
<td>Voltage</td>
<td>230V; 50Hz</td>
<td>230V; 50Hz</td>
<td>230V, 50Hz</td>
</tr>
<tr>
<td>Power</td>
<td>0,8 kW</td>
<td>1,6 kW</td>
<td>1,6 kW</td>
</tr>
<tr>
<td>Drive</td>
<td>manual</td>
<td>manual</td>
<td>hydraulic</td>
</tr>
<tr>
<td>Heating pins and</td>
<td>16,20,25,32,40,50,63,75 mm</td>
<td>16,20,25,32,40,50,63,75,110mm</td>
<td>16,20,25,32,40,50,63,75,110mm</td>
</tr>
<tr>
<td>sockets with PTFE</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>coating for DA</td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>
The manual socket welding devices are suited for complex facility parts and parts which are difficult to access on the construction site and in the workshop.

Depending on the design, the user can either apply an electronic and/or thermostatic temperature control.

Heating pins and sockets which are provided with a high-quality coating enable the processing of diameters ranging from 20 mm to 110 mm.

Useful accessories, as e.g. a table clamp holder, can be stored together with the manual socket welding device in a sturdy transport box.

**Technical data:**

<table>
<thead>
<tr>
<th>Model</th>
<th>Welding range (mm)</th>
<th>Power (W)</th>
<th>Temperature control</th>
<th>Weight (kg)</th>
<th>PTFE-coated heating pins and sockets for DA (mm)</th>
</tr>
</thead>
<tbody>
<tr>
<td>PF 032F KIT</td>
<td>20 – 32</td>
<td>800</td>
<td>Thermostat</td>
<td>6.0</td>
<td>20,25,32</td>
</tr>
<tr>
<td>PF 063R KIT</td>
<td>20 – 63</td>
<td>800</td>
<td>Thermostat</td>
<td>9.0</td>
<td>20,25,32,40,50,63</td>
</tr>
<tr>
<td>PF 110R KIT</td>
<td>20 – 110</td>
<td>1600</td>
<td>Thermostat</td>
<td>20.0</td>
<td>20,25,32,40,50,63,75, 90, 110</td>
</tr>
</tbody>
</table>
Heating elements for socket welding

Portable heating elements with high-quality PTFE coating for socket welding of PE and PP pipes and fittings. The temperature of the heating element is infinitely variable and equipped with a thermostatic temperature control. At request, the heating element can also be supplied in a handy transport box.

<table>
<thead>
<tr>
<th>Technical data:</th>
<th>Diameter (mm)</th>
<th>Power (W)</th>
<th>Weight (kg)</th>
</tr>
</thead>
<tbody>
<tr>
<td>TE 140 / 30°</td>
<td>140</td>
<td>600</td>
<td>2.4</td>
</tr>
<tr>
<td>TE 140</td>
<td>140</td>
<td>600</td>
<td>2.4</td>
</tr>
<tr>
<td>TE 180</td>
<td>180</td>
<td>800</td>
<td>2.6</td>
</tr>
<tr>
<td>TE 230</td>
<td>230</td>
<td>1300</td>
<td>3.9</td>
</tr>
<tr>
<td>TE 300</td>
<td>300</td>
<td>1500</td>
<td>4.8</td>
</tr>
</tbody>
</table>

Band saws of type series ST

The band saws of type series ST are hydraulically operated and CNC controlled band saws. They were designed for the accurate sawing of PE, PP and other thermoplastic pipes, profiles and fittings. Due to the swivelling saw arm, it is possible to saw various pipe diameters and mitre cuts (up to 67.5°). The saw arm is lowered and the pipes are clamped via an accurate hydraulic system.

<table>
<thead>
<tr>
<th>Technical data:</th>
<th>ST 630</th>
<th>ST 800</th>
<th>ST 1200</th>
</tr>
</thead>
<tbody>
<tr>
<td>Sawing range</td>
<td>mm</td>
<td>200 – 630</td>
<td>200 – 800</td>
</tr>
<tr>
<td>Max. sawing speed</td>
<td>m/min</td>
<td>400</td>
<td>400</td>
</tr>
<tr>
<td>Sawing angle</td>
<td>°</td>
<td>27.5° – 67.5°</td>
<td>27.5° – 67.5°</td>
</tr>
<tr>
<td>Voltage</td>
<td>V</td>
<td>400V; 50Hz</td>
<td>400V, 50Hz</td>
</tr>
<tr>
<td>Power</td>
<td>kW</td>
<td>2.6</td>
<td>2.6</td>
</tr>
<tr>
<td>Dimensions</td>
<td>cm</td>
<td>380x330x300</td>
<td>380x330x300</td>
</tr>
<tr>
<td>Weight</td>
<td>kg</td>
<td>1015</td>
<td>1015</td>
</tr>
</tbody>
</table>
Type series SL 1000M

- The smallest of the construction series of the board welding machines
- SL 1000M is a purely manual machine with hydraulic control
- It is suited for PE-HD, PP, PVC, PVDF

Technical data:

- Working width: 1000mm
- Max. material thickness: 20mm – PVC 5mm
- Dimensions: 1860 x 900 x 1250mm
- Weight: 611Kg
Type series SL ... CNC

The design of the butt welding machines of the types SL....CNC, SL....M and SLV....CNC is characterised by the optimum relationship between acquisition costs and the rationalisation effect to be achieved for each company owner.

Owing to the solid and extremely sturdy frame construction and the hydraulic drive of the machine (no compressed air required), it is possible to weld thermoplastic materials such as PE-HD, PP-H, PP-B, PP-R, PVDF and also PP-S in a board thickness ranging from 3-50 mm depending on the welding factor, as well as HDPE-500 (up to a board thickness of 20 mm) and PVC-U, PVC-RI (up to a plate thickness of 30 mm). It is also possible to weld cylinders from an internal diameter of 350 mm onward.

By means of the automatic opening of the holding bolts, these parts can be removed laterally from the machine after the welding process has been completed. All machines are fitted with a cold aligning device and a parallel guide of the clamping tables.
All operating elements are clearly arranged in an operating panel. In connection with mobile foot switches, the operator is always capable of positioning the boards to be clamped with both hands and of tensioning the clamping bar simultaneously.

The butt welding machines can optionally be equipped with a manual or a CNC control. With the CNC control, the material type, board thickness and length must only be entered. After the plate has been aligned, the welding process will proceed fully automatically pursuant to the latest DVS guidelines. The operator can certainly also enter other welding parameters. The integrated printer prints a welding record with all data of the welding parameters if desired.

Basic equipment:

Hydraulic drive for exact clamping and welding pressures.

PTFE-coated heating element of a special cast alloy for high temperature precision.

The twisting of the individual clamping plates is prevented due to the overall motion of the clamping bar.

Folding lateral support arms help to save space when the machine is not in use.
The butt welding machines of type series SLV are an extension of type series SL...PLUS.

With this machine, thermoplastic materials can not only be welded horizontally but also at right angles. Thus it is often possible to avoid costly hot gas or extrusion welds and folds. The horizontal board is welded to the vertical board (board thickness, vertical welding max. 30 mm and horizontal welding max. 50 mm).

Thus it is possible to produce right-angled profiles and closed channels with an internal leg pipe dimension from 300 mm onward.

Owing to the vacuum holder which can be mounted or dismounted in no time, the solid fixation of the vertically positioned boards is ensured. With this version it is also possible to produce pipes from a minimum diameter of 400mm without the vacuum holder.

The lateral support arms can be folded up so that no unnecessary space is occupied when the machine is not used.
Heating bending machines

Heating bending machines of a working width of up to 3 m and a material thickness up to 20 mm.

For further interesting information ask for our brochure for heating bending machines.

Manual welding devices & accessories


For further interesting information ask for our brochure for roof welding systems.

Extrusion welding & accessories

The manual extrusion welding device with internal and external air supply are used in workshop and construction site application.

For further interesting information ask for our brochure for extrusion welding systems.

LDU Data Logging Unit

Suitable for our own PT models, and most other, electro-hydraulic field welding machines.

Measures and reports on every butt weld performed

- The printing data-logger is designed and constructed for the measurement of butt welding parameters of PE, PP and PVDF pipes and fittings.
- In addition to the control function, the printing data machine helps the operator during all working phases showing on the display and advising with an acoustic signal the pressure and the time to be achieved during all welding cycle phases.
- The heating mirror temperature (once the operator has set up the material, diameter and wall thickness of the pipe) is controlled by computer according to the material and wall thickness involved.
- The possibility to print in advance all welding parameters helps the operator avoiding the use of welding tables.
- At the end of welding, a final print allows the operator or supervisor to check if the welding cycle has been correctly performed.

<table>
<thead>
<tr>
<th>Maximum Working Pressure</th>
<th>0 - 160 Bar</th>
</tr>
</thead>
<tbody>
<tr>
<td>PN Weldable</td>
<td>PN 2.5 - PN 40</td>
</tr>
<tr>
<td>Voltage</td>
<td>230V 50Hz (standard, other on specific request)</td>
</tr>
<tr>
<td>Power</td>
<td>100 watt - IP 20</td>
</tr>
</tbody>
</table>

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