

2|2013

INNOVATIV



The new Plant 3 in Ennigerloh



Dear reader,

In the 21st century, mechanical engineers will require the highest levels of innovation and speed when putting their expertise into practice in the pharmaceutical technology sector.

In addition to the Achema in Frankfurt am Main, the most important trade fair for this technology is the Interpack in Dusseldorf, being held in May 2014. The exhibitors at these events include

a growing number of machinery manufacturers from Asia.

On closer examination, an expert can easily recognize the origin of many of the machines being presented. Increasingly, European developments are being shamelessly copied.

Anyone buying this machinery and equipment should expressly insist on exemption from any possible claims by third parties. The reason is that unfortunately, German and other European patent rights are ignored, and therefore claims by German manufacturers are possible provided a patent exists in Europe or at least in Germany. It is doubtful in any case whether such copies will actually be able to withstand the high quality demands of the pharmaceutical industry.

Now, the successful work of the Bohle team has given rise to a procedural masterpiece:

The Bohle Uni Cone BUC®- Process.

Many customers are already lavishing praise upon this development.

What can this process do?

A conical fluid-bed base with a displacement cone in the middle transports granules or pellets radially outwards. This means that the circulation in the fluid bed also extends from the inside to the outside.

The advantage: All the products are moved to an outer region. Thus, the spray effect in this outer section can be effectively and evenly applied to all products.

This way, we achieve a very precise uniformity of more than 99%.

In addition to the quality of the coating, the secure control must also be mentioned. The operator can follow the working process visually through windows. The sizes and the distribution achieved can be measured and the process controlled by means of particle measurement.

You can test the Bohle Uni Cone BUC®- Process in our Service Center at any time. You will be astonished.

Dr. Toller



Process machine production starts 2013

New Plant 3 in the Haltenberg-Ost industrial area has been opened



More than 450 employees, customers and partners of L.B. Bohle from politics and industry took part in the opening ceremony of Plant 3 in Ennigerloh on 21 September 2013. During a "Bavarian Evening", entrepreneur Lorenz Bohle thanked all those concerned for the fact that the new building in the Haltenberg-Ost industrial area could be handed over on time after only eleven months – despite complex licensing issues and a severe winter. Currently, the 550 m² of office space and workshop, as well as the 2,600 m² of production premises are being fitted out. The start of production is planned for November 2013. The company is investing a total of five million euros.

District administrator Dr. Olaf Gericke congratulated Lorenz Bohle and all the employees on the expansion of the L.B. Bohle Maschinen + Verfahren GmbH headquarters. Sixty new jobs will be created at the Ennigerloh loca-

tion by these investments. Dr. Gericke added that he would be pleased if there were many more entrepreneurs like Lorenz Bohle in the Warendorf district who invested so fearlessly.

Lean production as the key

The new building on the 20,000 m² on Nordring is marked by a long production hall, from which an office building with a glass gallery extends sideways. From there, future visitors will be able to experience the production of the coaters and other process machinery as it happens.

"With this investment, we are laying the foundation for further sales growth," said Mr Bohle. Following the principle of lean production, the company would produce far more efficiently in the new plant and would be able to deliver faster than the competition. Annual

growth rates of 20% were the target. Coating machines, soon to be produced at Plant 3, would play a key role.

However, L.B. Bohle is not only backing innovation and sustainability in relation to machinery: "With an energy efficiency 20% higher than that demanded by current regulations, we are sending a signal", Lorenz Bohle added. So that the company can continue to grow in the future, Bohle and the city of Ennigerloh already agreed an option in 2011 to buy an adjacent plot of land, also with an area of 20,000 m².

From the circle of national and international clientele, Dr. Hans-Georg Feldmeier, Chief Production and Development Dermapharm AG, used the opening ceremony for a few spontaneous congratulations to Lorenz Bohle and his team. He praised the innovative power and quality of the machines.

Impressions of the opening ceremony

The facility was transformed into a ceremonial venue with much love and care. The guests were very impressed.



During the ceremony, Dr. Olaf Gericke (the District Administrator of Warendorf), and the Deputy Mayor of Ennigerloh Ingrid Halene expressed their greetings to the company.



Handing over the key: The architect Richard Pawlowski (right) symbolically hands over the key for Plant 3 to Managing Director Lorenz Bohle.

The musicians of the Musikverein Rösenbeck under the direction of Gerhard Eberbach provided musical accompaniment during the evening, entertaining with both formal and folksy music.





The famous singer Günther Wewel (third from left) and his wife accepted the invitation from Marianne and Lorenz Bohle. Prof. Patrick Sensburg, member of the German parliament, is pictured on the left.



Great art at the main entrance: The artist Elmar Klute from Germany's Sauerland region designed the illuminated mobile.



Four-hundred and fifty people celebrated the opening of the new production facility. Employees, customers and friends of the company were very impressed by the atmosphere.

A cake for the opening ceremony. Much effort went in to specially decorating the cake with a miniature coater and a model of the building itself.



Bright colours decorate the gallery. From here, customers can look into the daylight-flooded production hall.

Brand and utility models are now protected

Bohle Uni Cone BUC® coats even small particles more precisely and evenly

With the Bohle Uni Cone BUC® process, the special machine builder L.B. Bohle Maschinen + Verfahren GmbH can protect a new development method for precise coating of particles as a utility model right now. "We have shown that our new method works much more accurately and evenly than the conventional Wurster process, says the managing director Lorenz Bohle.

The Wurster process is used in the pharmaceutical industry, when small particle, so called pellets, must be coated. Most coating systems, which were used today, were based on this method which was developed by the American Pharmacists Dale E. Wurster in 1959. Biggest weaknesses are hardly calculable setting parameters and the spray nozzles in the bottom", explains Lorenz Bohle, CEO of the L.B. Bohle Maschinen + Verfahren GmbH.

The adjustment parameters must be re-tested in long tests for each product. This approach runs more on the basis of experience rather than on verifiable data, Bohle describes the scientific dilemma. Losses in production and to large fluctuations in the coating uniformity are the results. "We have developed two major changes that solve both problems of the Wurster process", says Lorenz Bohle. A sloping floor and a conical tip in the center provide a uniform turbulence of the product. Simultaneously, the coating substance is spray to lateral nozzles. "We thus reach a hitherto possible coating uniformity. By this process the customers can apply their products with active substance with the highest precision", said the



The L.B. Bohle product range of fluid bed systems contains machines from the BFS 3 in a laboratory scale up to the biggest type BFS 480. The Bohle Uni Cone BUC® optimizes the process.

CEO. "The losses are under one percent in a very complex process."

The tangential nozzles have also enhanced quality advantages in handling. If a nozzle is blocked, it can be cleaned with aqueous operation during the current process. "Because of the tremendous benefits we can secure a utility

patent protection for the process and have protected the Uni Cone BUC® as European brand."

(Utility model: 2012 102 157,9 – Fluid Bed System with a conical fluid bottom; Brand: 011 659 067)



Bohle Uni Cone BUC® distributor plate with tangentially mounted spray nozzles.



Further information:
www.lbbohle.com



Construction progresses in October in bright sunshine.

Technology Center

The next opening follows the last

On 21 September 2013, L.B. Bohle celebrated the opening of Plant 3 in Ennigerloh with a big party. The next opening ceremony is already firmly planned for the summer of 2014 – that of the Technology Center at its headquarters on Industriestrasse.

The construction work for the new development, test and presentation center “is running absolutely according to plan and the building will be comple-

ted this December”, Managing Director Lorenz Bohle said. This will be followed by the interior work and fittings.

Around 2 million euros is being invested in the sophisticated Technology Center, a building which is high-tech in terms of architecture, too. Here, L.B. Bohle offers scientists and students from the Universities of Dusseldorf and Graz, as well as the measurement, control and process experts

from Siemens a platform to develop complete production lines for processes optimized for wet and dry granulation. The focus will be on permanent and cross-process measuring, monitoring, and control of production.



A large window front will decorate the Technology Center after the completion.

Recognized as a member of BlueCompetence

With immediate effect, L.B. Bohle Maschinen + Verfahren GmbH is now a recognized "Alliance Member" of the VDMA's "BlueCompetence" sustainability initiative.

This initiative takes a stance on the issues of energy efficiency, electric mobility, society, energy policy and industry. Sustainability is particularly important in all areas, even for the medium-sized engineering company L.B. Bohle. The continuous development and optimi-

zation of technical processes are issues that the employees deal with on a daily basis. Energy efficiency, environmental compatibility and sustainability are taken into account during every stage of production and development.

Bohle is a conscious partner of the VDMA initiative – for the benefit of the future, customers, employees, and of course the environment.



"Known consignor"

Certification process for Plant 2 completed safely



The design building at the Sassenberg site.

In late July 2013, L.B. Bohle Maschinen + Verfahren GmbH was told the news officially: the globally active company had been approved by the Federal Aviation Office (LBA) as a "known consignor". The procedure, which was requested and supervised internally by the quality management and safety officer Martin Schembecker lasted more than a year. The LBA has examined the procedures and processes and now the engineering company has an official license

as a "known consignor" for Plant 2 in Sassenberg. This means that L.B. Bohle is part of a secure supply chain for freight to its customers, a chain that is fully documented.

A whole series of conditions and safety measures had to be met before official approval was granted. Thus, the establishment of an air cargo security programme for the Sassenberg location formed part of the certification process. The security officer and his deputy, Andreas Rutsch, were trained to this end.

Furthermore, all other employees who are dealing with secure air cargo, such as the project managers, had to take a written examination.

On the one hand, the whole process took a great deal of time and money. However, this investment will pay off in day-to-day business, because L.B. Bohle is continuously recommended as a secure, flexible and reliable partner for its customers.



The production building of Plant 2 in Sassenberg.

Employee anniversaries

Eight staff members celebrate 25 years of service



Lorenz B. Bohle (left) and the anniversaries of the year 2013.

Mechanical engineering company L.B. Bohle of Ennigerloh, Germany honoured its long-time employees during a small ceremony and dinner.

Besides nine colleagues who have been working for 10 years at the firm, Ralf Brandt, Ralf Höner, Reinhard Nelling, Hermann Bücken, Peter Pelz, Rüdiger Waldmann, Thorsten Wesselmann and Joachim Reckendrees can now look back on 25 years at the company. For Managing Director Lorenz B. Bohle, it

is of particular importance, "to always be able to rely on this bundled experience and expertise." Yet, besides the expertise, team consciousness was also a criterion of success. "This long period of service speaks for stability and for a harmonious working atmosphere."

Owner Lorenz Bohle thanked all the loyal employees and is looking forward to another successful collaboration, so that "the Bohle growth story can also continue successfully in the future."

These employees have spent ten years with company:

Thorsten Kießhauer, Marina Kirsch, Jörg Mühlenbein, Martin Schembecker, Armin Bohle, Winfried Schindler, Peter Sawadski, Raphael Block and Michael Jasper

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