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July 2002

Liebherr-Werk Ehingen GmbH
The European market leader's road to success

Liebherr-Werk Ehingen GmbH was established on 22nd February 1969 as a subsidiary of the individual enterprise Hans Liebherr at that time. Still in the same year it was possible to start the production of truck cranes, mobile cranes and deck cranes. Almost a year later, the factory was awarded a larger export order from the former Soviet Union for the delivery of 55 telescopic cranes totalling 20 million DM. In 1972, the home market position was strengthened by the establishment of a dealer and agent organization. Continuous extension of the product range and steady improvement of the existing equipment contributed to get a bigger foot in the market.

Already in 1974 sales did total 61 million DM, 40 million DM of which were related to truck cranes and 21 million DM to deck cranes. Due to the extension of the deck crane range, also for the offshore industry, Liebherr succeeded in entering the top group of international deck crane manufacturers.

A major order for 150 deck cranes totalling 70 million DM and further follow-up orders even increased the turnover to more than 100 million DM in 1975. The factory had to be extended in a second development stage in order to cope with the increased production volume.

At this stage, the manufacturing program included a wide range of mobile and crawler cranes of 10 to 280 tons, competitive on the international market. While deck cranes were supplied world-wide to all leading shipbuilding nations, the chief markets for mobile and crawler cranes were the European countries and the Near and Middle East. The workforce increased to 1,100 in 1976 and the factory was extended again by an assembly shop of 13,000 m².

The outstanding period of growth from 1975 to 1977 was succeeded by a high standard phase of consolidation. The Middle East markets further gained in significance. In 1978, mobile dock cranes for cargo and bulk handling were included into the program and manufactured in series of various ratings.

Complete emphasis on mobile and crawler cranes since 1980

The increasing capacity requirement for the steadily growing crane range was the decisive factor to concentrate completely on the mobile and crawler cranes at Ehingen as from 1980 and to cede the production of deck cranes, offshore cranes and container cranes to Liebherr-Werk Nenzing GmbH. At that stage already, a turnover of 294 million DM was realized with mobile and crawler cranes.

A milestone, essential for the further development of Liebherr-Werk Ehingen GmbH was a major order awarded by the Soviet State Trading Company, Maschinoimport, Moscow, in October 1981, for the delivery of 333 telescopic cranes totalling 368 million DM. The production of those cranes, required to be operative at temperatures of minus 50°C, was a challenge Liebherr braved against international competition. This order too required the design and development of a 60-tonner all-terrain crane, the basic concept of which was the standard for the successful mobile crane range of today.

In order to ensure continuous success of the new crane business, a repair centre for used cranes was established at Ehingen and put into operation in 1983. There, more than 2,500 used cranes have been overhauled and resold till today.

The change-over from the product range to the new series of LTM cranes was finalized in 1986. This, from a technical point of view, entirely new crane generation for combined on-road and off-road application was noticed with great interest by customers at home and abroad.

During the following years, the LTM crane range was extended by new types of the 800, 400 and 200 ton class. The cranes within the capacity range of 40, 50 and 70 tons partly underwent essential modifications in order to meet the specific requirement of certain countries with respect to total weight and axle loads. For the crawler cranes of up to 650 t lifting capacity, a new technical concept was developed which enables easy transportation and multi-purpose application due to variable boom configurations. To date Liebherr crawler cranes of the type LR 1650 are in

operation on large-scale construction sites in India, Japan, in the former USSR and in the USA.

A particular success in 1990 was an important order received from the Bundeswehr for 459 mobile cranes of the types FKL and FKM with 10 t and 20 t lifting capacity. After years of preliminary studies and comprehensive field tests, the decision was made in favour of Liebherr at that time. The last mobile cranes of that order have been delivered to the Bundeswehr in 1994.

In the same year, two crawler cranes of 1200 capacity were delivered to Japan. With a hook-height of 224 m they are the highest lattice boom cranes in the world. In 1995, Liebherr presented an entirely new boom technology for telescopic cranes. An oviform boom profile of outstanding inherent stability was developed for the LTM mobile cranes of 90 t, 120 t and 160 t which, for the first time, enabled the application of 6-section telescopic booms of up to 60 m length. In conjunction with the new electronic controlled telescoping system „Telematik“, this new practice-oriented boom technology offers the user of mobile cranes a multitude of new application facilities and an improved price/performance ratio. In 1998, the newly developed boom technology experienced its interim highlight with the 7-section, 84 m long telescopic boom of the LTM 1500.

Outstanding engineering increases product advantage

Continuous innovations in the processing of special steels and in the development of hydraulic, electric and electronic drive and control systems are necessary in order to meet the high demands a mobile crane is exposed to during the alternating operations.

Part of the modern vehicle technology of a mobile crane are features such as weight-optimized and torsion-resistant frames, the hydropneumatic suspension „Niveaumatik“ of a crane and road preserving version, a proven and functional axle and steering concept, an efficient and economic travelling drive as well as an operator-friendly and safe supporting concept. Moreover, a modern and convenient driver's cabin is instrumental in safe driving.

In 1990 Liebherr developed its own system for the control and monitoring of a mobile crane. That LICCON system is the most modern programmable computer world-wide for the control and monitoring of mobile cranes.

With an entirely new developed boom technology in 1997, Liebherr demonstrates further top class engineering for increased benefit during crane operation. The new oviform, particularly torsion-resistant boom profile contributed in saving weight and in increasing the boom length. Furthermore, the automatic rapid-cycle telescoping system „Telematik“ permits to quickly select various boom lengths. The new telescopic boom technology features functionality and efficiency to the greatest extent.

The data bus transmission technique which revolutionized the crane technology and increased distinctively the functionality as well as the efficiency of the Liebherr mobile and crawler cranes has been additionally a further contribution to success by the end of the Nineties.

International success

The mobile and crawler cranes designed and manufactured at Ehingen did win recognition on the international markets and Liebherr is European market leader to date. In 2001, the essential export markets of the company were the USA, Spain, the Netherlands, Great Britain, France and Italy.

During the financial year 2001, Liebherr-Werk Ehingen GmbH realized a turnover of 1,646 million DM with 1,213 new cranes and 352 used cranes. The workforce comprised 2,100 persons by the end of year 2001.

Works extension and extensive capital expenditure

Liebherr-Werk Ehingen GmbH has experienced a growth above average during the past years. Its turnover of 1,646 million DM in 2001 had more than doubled compared to 1993.

In order to ensure a continuous growth and to further expand its international position as the leading manufacturer of mobile and crawler cranes, sites totalling 210,000 m² have been acquired in the north of the factory within the frame of a several years' scheme of expenditure for a works extension which actually increases the total area available to 535,000 m². In April 2001, a new factory hall of 372 m length for the final assembly of the LTM mobile cranes has been inaugurated. This hall enlarges the covered production area by 44,000 m² to more than 123,000 m² – sufficient to produce up to 1,400 mobile and crawler cranes per annum in future if required in the world's most modern crane factory.

This extension would equally result in a progress of productivity – an important aspect in safeguarding employment. The capital expenditure totals 200 million DM since the establishment of Liebherr-Werk Ehingen GmbH, more than 30 years ago.

The manufacturing program

I. Telescopic mobile cranes

All-terrain cranes

The all-terrain mobile cranes type LTM on the 2- to 8-axle carriers and with the hydropneumatic „Niveaumatik“ suspension feature combined on-road/off-road operation.

The LTM crane range comprises 16 types:

LTM 1030/2-	35 t capacity
LTM 1045/1-	45 t capacity
LTC 1050	50 t capacity
LTM 1055/1-	55 t capacity
LTM 1060/2-	60 t capacity
LTM 1080/1-	80 t capacity
LTM 1090/2-	90 t capacity
LTM 1100/2-	100 t capacity
LTM 1150/1-	150 t capacity
LTM 1160/2-	160 t capacity
LTM 1200/1-	200 t capacity
LTM 1250/1-	250 t capacity
LTM 1400/1 -	400 t capacity
LTM 1300/1-	300 t capacity
LTM 1500 -	500 t capacity
LTM 1800 -	800 t capacity

II. Lorry-mounted telescopic cranes

The Liebherr telescopic cranes type LTF mounted on customer-selected chassis have been specifically designed for the erection of prefabricated houses and handling of prefabricated sections. The LTF 1030-3/4 with 30 t lifting capacity is manufactured optionally with 3- or 4-axle chassis.

III. Lattice boom cranes

Liebherr offers these cranes on mobile or crawler carriers with lifting capacities of 350 t to 1200 t. Various boom configurations enable these cranes to be adapted to the individual requirements for the construction of power stations and bridges as well as for offshore operation.

The program comprises six crane types:

1. Mobile crane

LG 1550 - 550 t capacity, on 8-axle carrier

2. Crawler cranes

LR 1350/1 - 350 t capacity

LR 1400/2 - 400 t capacity

LR 1600/1 - 600 t capacity

LR 1800 - 800 t capacity

LR 11200 - 1200 t capacity

Die Fahrzeugkrane.

Mobile and Crawler Cranes.

Grues mobiles et sur chenilles.

2002

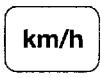


LIEBHERR

Die Mobil- und Autokrane.

Mobile and truck cranes.

Grues mobiles routière et tout terrain.



t
m
max.

75

kW/PS

km/h

max.

Je nach Fa
Depending on truck chassis / I



LTF 1030-3/4

30 2,5

205
278

80

LTM 1030/2

35 3

270
367

80

LTM 1045/1

45 3

270
367

80

LTM 1055/1

55 2,5

270
367

80

LTM 1060/2

60 2,5

270
367

80

LTM 1080/1

80 2,5

320
435

80

LTM 1090/2

90 3

300
408

76

LTM 1100/2

100 2,7

400
544

80

LTM 1150/1

150 3

400
544

76

LTM 1160/2

160 3

400
544

76

LTM 1200/1

200 3

400
544

80

LTM 1250/1

250 3

440
598

76

LTM 1300/1

300 3

440
598

76

LTM 1500

500 3

440
598

77

LTM 1800

800 3

420
570

78

LG 1550

550 4,5

420
570

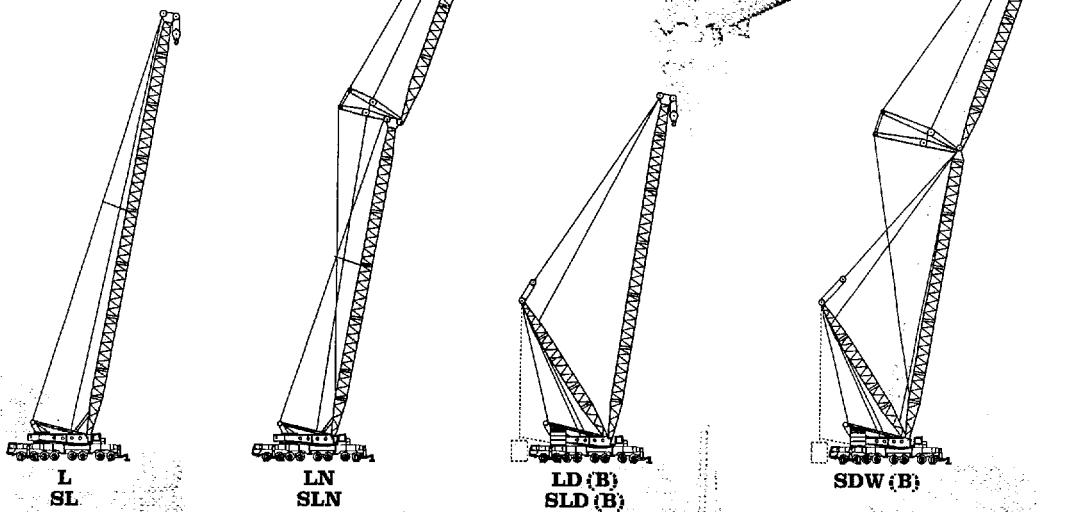
78

			kW/PS	min./max.	min./max.	max. m	max. t	max. m	max. t	Ausleger Boom/Jib Flèche/ Fléchette
max.	Stand/Option									
hrgestell épendant du châssis porteur			100 136	8,4 - 26	8,2 - 14,4	42 (27)	2 (9)	36 (24)	0,8 (2,2)	T, TK
60	4 x 4 x 4	-	9,2 - 30	8,6 - 15	45 (30)	2,8 (8,3)	40 (26)	0,5 (1,4)		T, TK
60	6 x 4 x 6 6 x 6 x 6	-	10,3 - 34	9,2 - 16	50 (34)	2,6 (9,9)	42 (30)	0,6 (1,6)		T, TK
60	6 x 4 x 6 6 x 6 x 6	-	10,2 - 40	9,5 - 16	56 (41)	3,1 (10,1)	48 (36)	0,6 (1,5)		T, TK
60	8 x 4 x 8 8 x 6 x 8	-	10,9 - 42	9,5 - 17	60 (42)	3,5 (10,1)	48 (38)	0,7 (1,5)		T, TK
60	8 x 6 x 8 8 x 8 x 8	-	10,8 - 48	10,5 - 19	66 (48)	2,4 (8,7)	56 (44)	0,6 (1,2)		T, TK
60	8 x 6 x 8 8 x 8 x 8	120 163	11,7 - 52	10,8 - 19	72 (52)	2,6 (10,2)	56 (46)	0,9 (1,2)		T, TK
60	10 x 6 x 8 10 x 8 x 8	149 202	11,5 - 52 66*	10,8 - 19	84 (52)	1,8 (11,4)	66 (48)	0,9 (2,2)		T, TK, TVK
50	10 x 6 x 10 10 x 8 x 10	120 163	12,6 - 56 63*	11,2 - 28	92 (56)	2,2 (13,5)	74 (54)	0,9 (1,6)		T, TK, TVK
50	10 x 6 x 10 10 x 8 x 10	149 203	13,2 - 60	12,2 - 36	96 (60)	2,2 (15)	74 (54)	1,2 (2,9)		T, TK
60	10 x 6 x 8 10 x 8 x 8	180 245	13,3 - 60 67*	12,2 - 36	103 (60)	1,8 (17)	86 (56)	1 (4,6)		T, TK, TVK
43	12 x 6 x 10 12 x 8 x 10	180 245	15,5 - 72	12,2 - 70	108 (72)	2 (14)	92 (66)	1,1 (3,1)		T, TK, TF, TN,
43	12 x 6 x 10 12 x 8 x 10	180 245	15 - 60	10,5 - 70	116 (80)	1,7 (30,5)	92 (58)	1,1 (5,4)		T, TK, TF, TN, TA, TAK, TAE, TAN
31	16 x 8 x 12	240 326	16,1 - 84	14 - 91	145 (84)	4,2 (20,9)	108 (74)	1,9 (2,0)		T, TF, TVF, TN, TVN, TY, TYF, TVYF, TYN, TVYN
31	16 x 8 x 12	300 408	19,3 - 60	14 - 91	146 (80)	8 (107)	126 (54)	4,4 (43)		T, TF, TN, TAN, TD, TDB, TDN, TDNB
31	16 x 8 x 12	300 408	[21 - 105]	21 - 91	180 [105]	28 [55]	124 [92]	2,3 [4,4]		L, LD, LDB, LN, SL, SLD, SLDB, SLN, SD, SDB

Auslegersysteme.

Boom/jib system. Types de flèche.

Telzkopausleger Telescopio boom Flèche télescopique	T
Verlängerter Teleskopausleger Boom extension Télescopie rallongé	V
Klappspitze Folding jib Flèchette pliante	K
Feste Gitterspitze Lattice fly jib Flèchette treillis fixe	F
Wippbare Gitterspitze Luffing lattice jib Flèchette treillis relevable	N
Teleskopausleger abgespannt Guyed telescopic boom Flèche télescopique haubanée	A
Hauptausleger Main boom Flèche principale	L
leicht small légère	S
schwer heavy lourde	
Wipphare Gitterspitze Luffing jib Flèchette relevable	N
schwer heavy lourde	W
Derrickausleger Derrick boom Derrick	D
Schwebeballast Suspended counterweight Lest suspendu	B



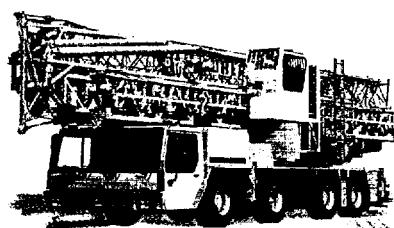
Anmerkungen:
LTF = Liebherr-Teleskop-Fertighauskran
LTM = Liebherr-Teleskop-Mobilkran in Straßen-/Geländeausführung
• Auslegerverlängerung mit Gitterwischerschlössern
LG = Liebherr-Gittermast-Mobilkran
• Traglasten entsprechen DIN/ISO
• LTM-Krane mit 45/60 t auch als Feuerwehrkrane
• Angaben in () gelten für den Teleskopausleger
• Angaben in [] gelten für den

Remarks:
LTF = Liebherr telescopic crane for the erection of prefabricated houses
LTM = Liebherr all terrain crane
• Telescopic boom extension with lattice sections
LG = Liebherr mobile crane with lattice boom
• Lifting capacities acc. to DIN/ISO
• LTM-cranes with 45/60 t also as fire service cranes
• Values given in brackets () are valid for telescopic boom
• Values given in brackets [] are valid for

Remarques:
LTF = Liebherr grue télescopique pour montage de maisons préfabriquées
LTM = Liebherr grue mobile routière et tout terrain
• Rallonge flèche télescopique avec des éléments en treillis
LG = Liebherr grue mobile avec flèche en treillis
• Forces de levage selon DIN/ISO
• Grues mobiles de type LTM avec 45/60 t aussi comme grues pour sapeurs-pompiers
• Les valeurs entre parenthèses () sont valables pour flèches télescopiques
• Les valeurs entre parenthèses [] sont valables

Der Mobilbaukran.

**Mobile construction crane.
Grue mobile de construction.**

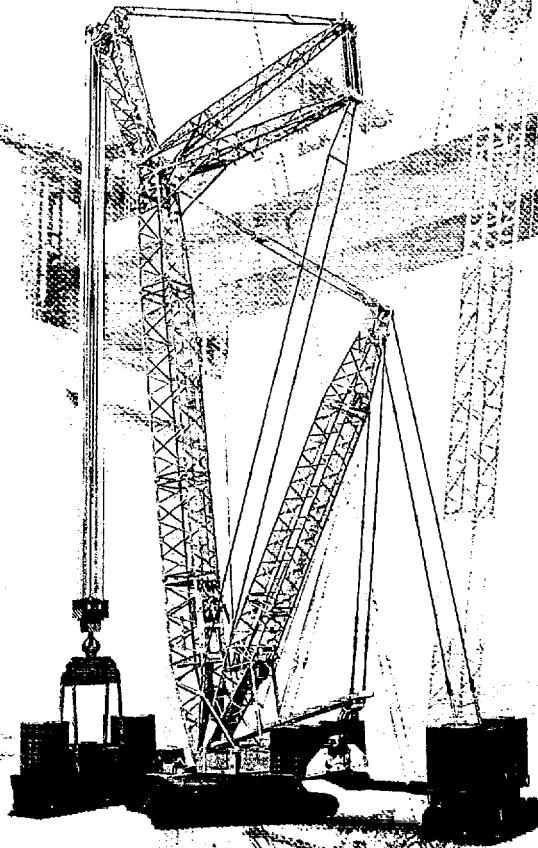


MK 80

	max	t	m	mu
	8	10	98	

Die Raupenkrane.

**Crawler track cranes.
Grues sur chenilles.**



LR 1350/1

LR 1400/2

LR 1600/1

LR 1800

LR 11200

m		km/h						Ausleger Boom/Jib Flèche/ Fléchette		
max.	kW/PS	max.	Stand./Option	min./max.	min./max.	max. m	max. t	max. m	max. t	
3,24	270 367	80	8 x 6 x 8	6 - 42	6 - 36,6	28	8	48	1,7	TA

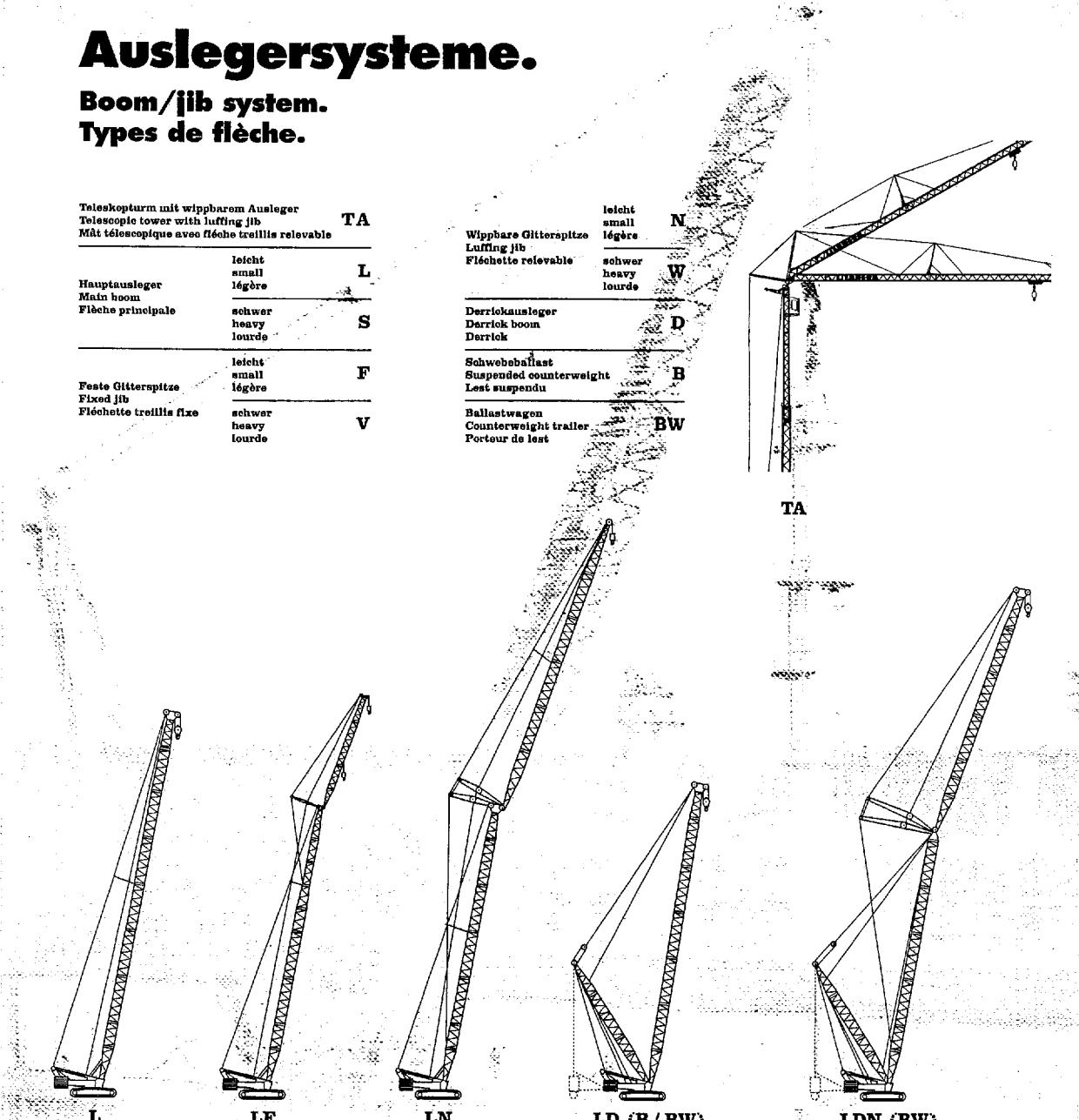
		 tm								Ausleger Boom/Jib Fläche/ Flèchette
t	m	max.	kW/PS	min./max.	min./max.	max. m	max. t	max. m	max. t	
350	6	4048	270 367	18 - 120	24 - 78	150 (118)	17,5 (50)	- (104)	- (10)	L, S, W, F, D, B, BW
400	4,5	5248	300 408	21 - 119	21 - 91	162,5 (116)	18,2 (68)	120 (104)	12,8 (21,5)	L, S, N, W, F, D, B, BW
600	12	9548	400 544	21 - 140	28 - 105	191 (137,5)	20 (105)	136 (124)	7,7 (16,6)	S, W, F, V, D, B, BW
800	12	13772	498 677	21 - 126	21 - 91	180 (123)	90 (259)	124 (104)	27 (50)	S, W, D, B, BW
1200	12	20904	746 1014	42 - 126	42 - 112	226 (120)	50 (400)	164 (112)	20 (60)	S, N, D, BW

Auslegersysteme.

Boom/jib system. Types de flèche.

Teleskopurm mit wippbarem Ausleger Telescopic tower with luffing jib Mât télescopique avec flèche treillis relevable		TA
Hauptausleger Main boom Flèche principale	leicht small légère	L
	schwer heavy lourde	S
		N
Feste Gitterspitze Fixed jib Flèchette treillis fixe	leicht small légère	F
	schwer heavy lourde	V
Derricksleiter Derrick boom Porteuse de lest	schwer heavy lourde	W
		D
Schwebekauslast Suspended counterweight Lest suspendu		B
Ballastwagen Counterweight trailer Porteur de lest		BW

Wippbare Gitterspitze Luffing jib Flèchette relevable	leicht small légère	N
	schwer heavy lourde	W
Derricksleiter Derrick boom Porteuse de lest		D
Schwebekauslast Suspended counterweight Lest suspendu	B	
Ballastwagen Counterweight trailer Porteur de lest		BW



Anmerkungen:

- MK = Mobilbaukran
- LR = Liebherr-Raupekran
- Traglasten entsprechen DIN/ISO
- Angaben in () gelten für den L/S-Ausleger mit Derrickleinrichtung

Remarks:

- MK = Mobile construction crane
- LR = Liebherr crawler crane
- Lifting capacities acc. to DIN/ISO
- Values given in brackets are valid for L/B-boom with derrick equipment

Remarques:

- MK = Grue mobile de construction
- LR = Liebherr grue sur chenilles
- Forces de levage selon DIN/ISO
- Les valeurs entre parenthèses sont valables pour flèche L/S-principale avec derrick

Die Vertriebs- und Servicestellen für Lie

The sales and service locations for mobile and crawler cranes.
Les établissements pour vente et service de grues automotrices.

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RUSSLAND

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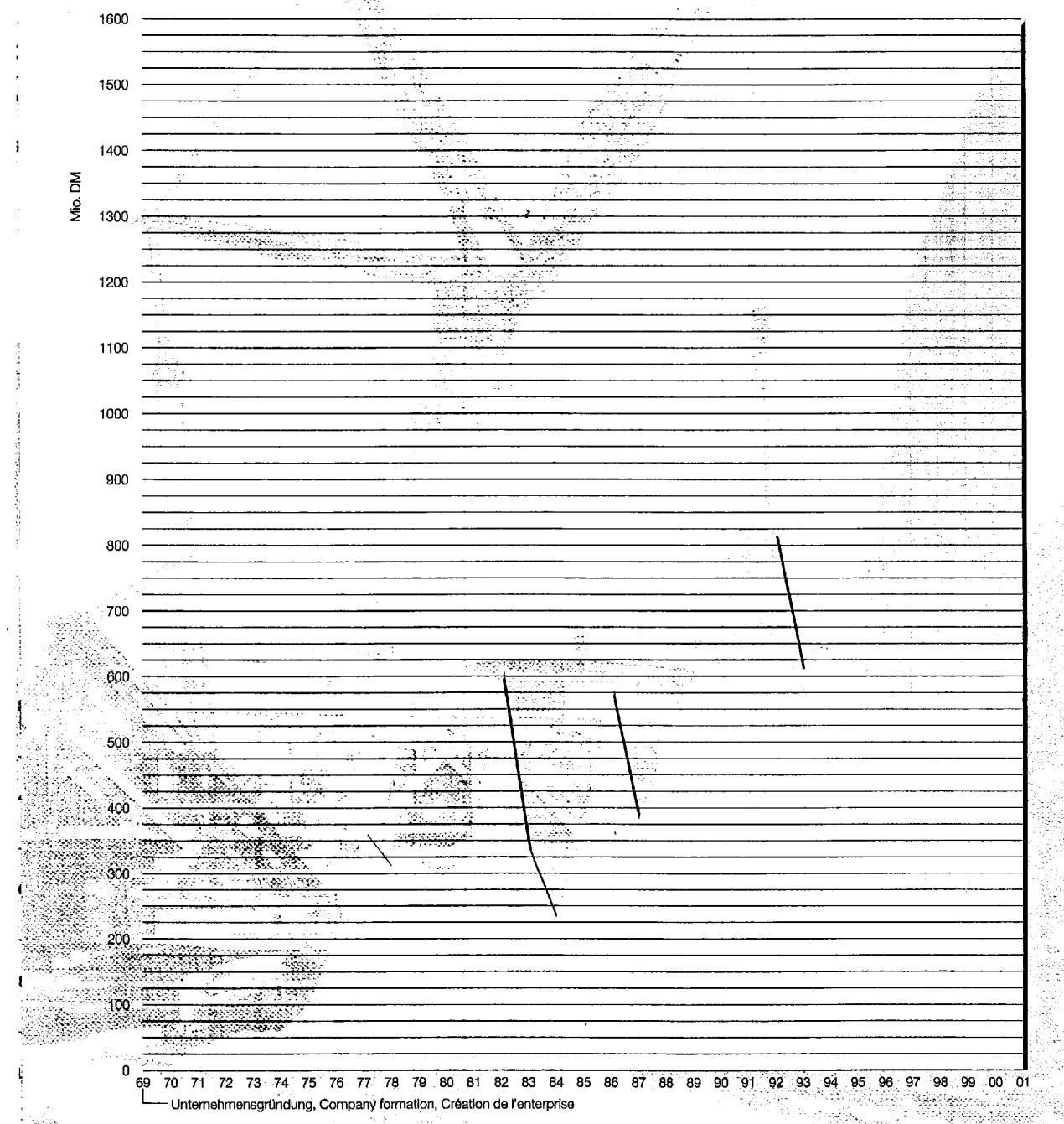
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Evolution du chiffre d'affaires.



Änderungen vorbehalten. / Subject to modification. / Sous réserve de modifications.

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