



LIEBHERR INDUSTRIAS METÁLICAS S.A.

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Liebherr Industrias Metálicas S.A.



LIEBHERR

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Liebherr Industrias Metálicas S.A. has been a member of the Liebherr Group since 1990. It is dedicated to the production and sales of a large programme of tower cranes, both bottom-slewing and top-slewing. Furthermore, the company markets the whole range of Liebherr tower cranes.

Having moved to a newly-built production site in 1997, Liebherr now has considerable scope for future development.

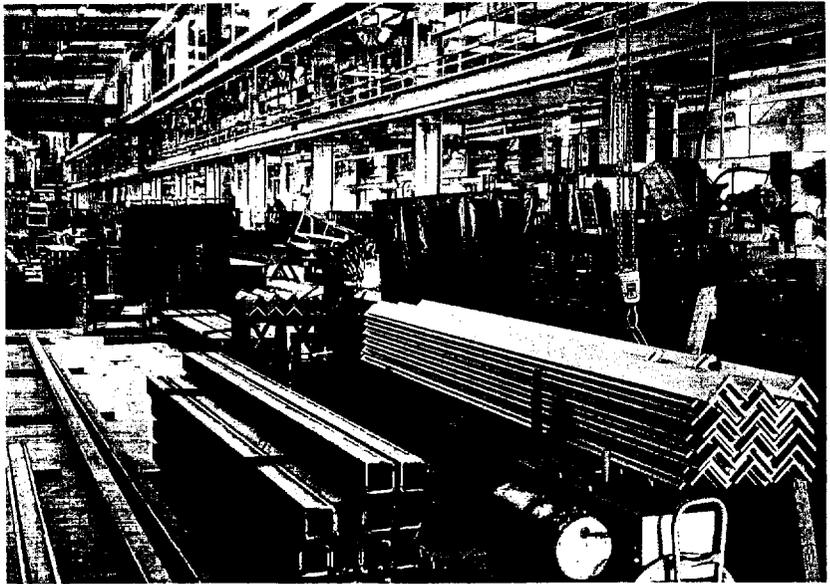
The new factory, built on a 175.000m² site, enables Liebherr to manufacture cranes using



the latest technologies. All necessary equipment and supply is available, for example CNC-regulated machines as well as automatic welding installations, modern and environmentally acceptable paint shops and ample space for final assembly.



Liebherr tower cranes use sealed-welded corner posts and diagonal struts. This ensures great accuracy and interchangeability of the structural elements.



The stability of a tower section is determined by the layout of diagonal struts. Welding is performed in specially designed modular fixtures. Those interchangeable components enable Liebherr to offer a varied range of accurately produced tower sections.



Safety at work is also one of the key factors at the Liebherr production site in Pamplona. For example in welding: personnel not directly involved is protected by filter walls in order to prevent exposures to UV rays.



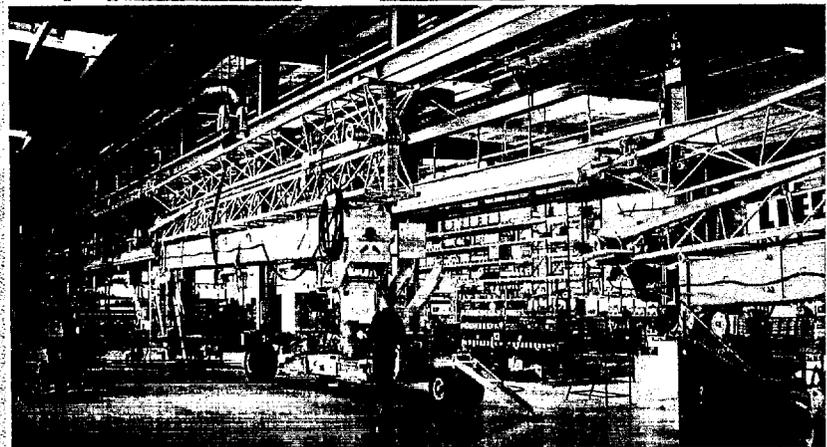
Safety is also of great importance in the modern paint shops. This picture shows the paint shop for large elements of max. 3x3 m² section and 15 m length, where primer coating, painting and drying are combined in one process. All installations are integrated into an automatic disposal system, designed according to efficient environmental protection criteria.



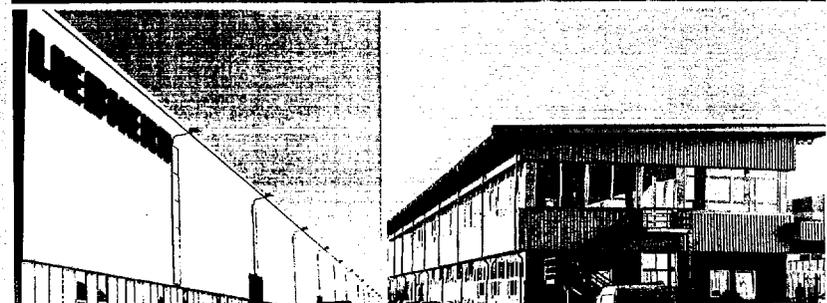
The component stock includes space for 600 pallets. The computer managed logistic system ensures that all parts such as motors and electrical equipment arrive in position just in time for the assembly of the tower crane.

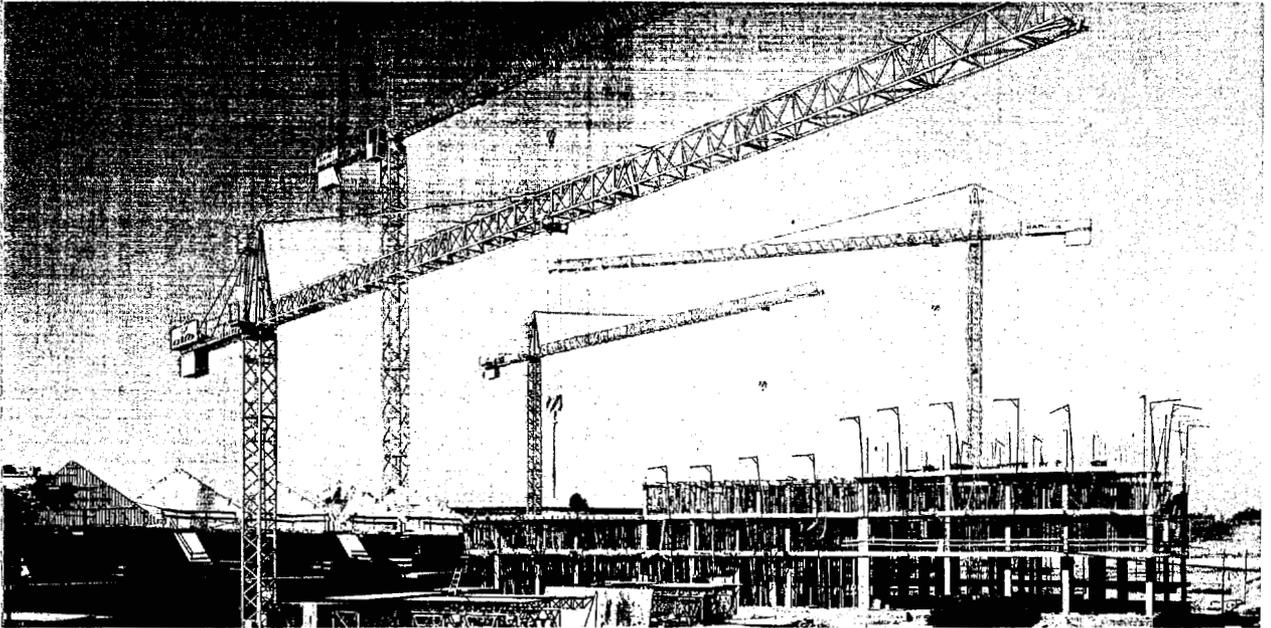


The final step is the assembly of the painted parts and corresponding components. Modern equipment such as gantry cranes facilitate this process. The quality control of all functions is performed by a team of specialists.



The Liebherr factory in Pamplona is one of the most modern tower crane plants in the world.





Liebherr supplies a range of tower cranes which covers all the needs and demands of a modern construction site. Liebherr creates progress by applying advanced technology. Its corporate aims have always been quality and a

wide product range to satisfy customers' needs. Modern production technology guarantees precision and therefore the exceptional reliability of Liebherr tower cranes.