

Dieffenbacher CPS lines in China



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Dieffenbacher CPS lines in China

The growing demand for CPS and the surge of new orders from China for HDF/THDF plants over recent years resulted in a substantial build-up of installation activity for panel plant supplier Dieffenbacher GmbH + Co. KG of Eppingen, Germany.

From January 2009 to December 2009 Dieffenbacher installed and started up a further 8 new THDF CPS Lines.

Back in early 2003 a major policy was formulated at Dieffenbacher to cater for the scope of installation work for this first wave of plant orders to be erected and commissioned, by assigning a dedicated team of site supervisory personnel under the management of a Dieffenbacher project coordinator in China.

This unusual circumstance of having such a large number of plant orders to attend to in one single country over a short period of time was a unique opportunity to make maximum use of the presence of specialised personnel, and to rotate them efficiently between sites in order to minimize travel and establishment times.

Optimization of communication together with efficient transfer of plant knowledge and start up experience gained at one site could be applied effectively to accelerate progress on each succeeding plant.

Major benefit was achieved in attending to the requests and needs of the panel customers' plant operations by having the shortest possible response times and by the immediate availability of specialists in each of the required technical categories in the same time zone.

Plantation Timber Products (Leshan) Limited

Plantation Timber Products (PTP) was set up in 1993 by businessmen Larry Moh and Daniel Spitzer providing a scheme to support local farmers with a forest plantation programme. The first MDF plant located in Leshan, Sichuan Province started production in 1997. Downstream processing was added with three short cycle laminating lines and doorskin production.



PTP Leshan



PTP Leshan, Former

| Project data sheet: | |
|--|--------------------------------------|
| Customer: | PTP Leshan |
| Project: | THDF |
| Plant location: | Leshan City, Sichuan Province, China |
| First Board date: | November 1996 |
| Design & Project Planning, Engineering, Site services: | Dieffenbacher Group |
| Glue mixing: | Dieffenbacher |
| Drying, sifting: | Schenkman & Piel |
| Mat forming: | Dieffenbacher |
| Forming line, continuous press: | Dieffenbacher, CPS 8 ft x 19 m |
| max. line speed: | 1.000 mm/sec |
| capacity: | 490 m ³ /day |
| Panel thickness: | 2,0 – 27 mm |
| Raw board handling: | Dieffenbacher Handling Systems |
| Sanding line: | Dieffenbacher Handling Systems |
| Cut to size line: | Dieffenbacher |

Plantation Timber Products (Shishou) Limited

A second MDF line with CPS technology of the same size came on stream in 1999 in Shishou, Hubei Province. In 2001 the Shishou plant started up another MDF line.

In 2007 the company CVC Asia Pacific bought the PTP Group from CHH.



PTP Shishou



PTP Shishou

| Project data sheet: | |
|---------------------------------|--------------------------------|
| Customer: | PTP Shishou |
| Project: | THDF |
| Plant location: | Shishou, Hubei Province, China |
| First Board date: | October 1998 |
| Mat forming: | Metso |
| Forming line, continuous press: | Dieffenbacher, CPS 8 ft x 19 m |
| max. line speed: | 1.000 mm/sec |
| capacity: | 490 m ³ /day |
| Panel thickness: | 2,0 – 40 mm |
| Raw board handling: | Dieffenbacher Handling Systems |

Guangxi Gaofeng Rong Zhou Wood Based Panel Ltd.

Gaofeng founded in the early 1990's, was originally a plantation company. In 1995, Dieffenbacher supplied the company with a multi opening press for their first MDF line.

This line has a capacity of 50,000 m³/a and is located in Nanning in the capital of Guangxi Province. After 4 years, they began extension of their MDF capacity with locally made machinery, whereby 3 lines were installed in the Gaofeng

Group. In 2003, in Guangxi Rong Xiang they invested in a state of the art MDF line, including a Dieffenbacher CPS continuous press. The design capacity is 130,000 m³/a.

Gaofeng Rong Xiang's major product is thin high-density fibreboard (THDF), thickness range 2 mm – 6 mm.

Mr. Yu Haoguang is the CEO of Gaofeng Group, and Mr. Qin is the GM of Gaofeng Rong Xian.



CPS Press



MDF Preparation area



Mr. Qin – General Manager

| Project data sheet: | |
|--|---|
| Customer: | Guangxi Gaofeng |
| Project: | THDF |
| Plant location: | Rongxiang City, Guangxi Province, China |
| Contract date | March 2002 |
| First Board date: | November 2003 |
| Design & Project Planning, Engineering, Site services: | Dieffenbacher Group |
| Glue mixing: | Dieffenbacher |
| Drying, sifting: | Schenkman-Piel-Engineering |
| Mat forming: | Dieffenbacher |
| Forming line, continuous press: | Dieffenbacher, CPS 8 ft x 23,2 m |
| max. line speed: | 1.200 mm/sec |
| capacity: | 500 m ³ /day |
| Panel thickness: | 2,0 – 40 mm |
| Raw board handling: | Dieffenbacher |
| Sanding line: | Dieffenbacher |

Liren Group Lishui OAK Co., Ltd.

Liren founded in the early 1990's, was originally involved in wet process fiberboard. The company modified the line to MDF in 1992, having a capacity of 30,000 m³/a and located in Lishui City in the province of Zhejiang. Mr. Xu, General Manager and a major shareholder, was responsible for the decision to proceed with this modification. Thereafter, Mr. Xu made several investments in MDF lines in South China.

All lines use locally made machinery and before 2002, eight such lines were installed in the Liren Group. In 2003, the Group invested in a state of the art medium density fibreboard (MDF) line at Lishui OAK in Lishui, which included a Dieffenbacher CPS press line. The press is designed for a capacity of 130,000 m³/a. The major product in Lishui OAK is THDF (2 mm - 6 mm). Today the Liren Group has a total installed MDF capacity of 700,000 m³/a.



CPS press



Mr. Xu Mengzhang, President of Liren Group



Plant area, Lishui

| Project data sheet: | |
|---|---------------------------------------|
| Customer: | Liren Group |
| Project: | Lishui OAK, THDF |
| Plant location: | Lishui City, Zhejiang Province, China |
| Contract date | April 2002 |
| First Board date: | August 2003 |
| Design & Project Planning, Engineering site services: | Dieffenbacher Group |
| Glue mixing: | Dieffenbacher |
| Drying, sifting: | Schenkman-Piel-Engineering |
| Mat forming: | Dieffenbacher |
| Forming line, continuous press: | Dieffenbacher, CPS 8 ft x 23,2 m |
| max. line speed: | 1.200 mm/sec |
| capacity: | 500 m ³ /day |
| Panel thickness: | 2,0 – 40 mm |
| Raw board handling: | Dieffenbacher |

Sunway Forest Products Co.,Ltd.

Guangxi Sunway Group was founded in the early 1950's and was originally a pencil factory based in Guangxi Wuzhou. In 1988, the company imported the first particleboard line from Sunds with a capacity of 30,000 m³/a. In 1996 the first MDF line from Sunds/Kusters was imported, with a capacity of 100,000 m³/a and a further investment in 2002

with two locally made lines in Guangxi Chengxi. 2003 marks the biggest investment, with the largest MDF line in Asia, 250,000 m³/a, when Sunway ordered a Dieffenbacher CPS line, with Metso supplying other plant items.



Mr. Fang Feng Chao – Project Manager



MDF Preparation area



CPS press

| Project data sheet: | |
|----------------------------|---|
| Customer: | Sunway Forest Products Co. Ltd. |
| Project: | MDF / HDF |
| Plant location: | Wuzhou, Guangxi Province, China |
| Contract date | June 2002 |
| First Board date: | December 2003 |
| Design & Project Planning: | Metso |
| Forming line: | Metso |
| Continuous press: | Dieffenbacher, CPS 9 ft x 42 m (ext. to 48 m) |
| max. line speed: | 1,200 mm sec |
| capacity: | 900 m ³ /day |
| Panel thickness: | 2,5 – 38 mm |

Shandong Zhenghe Wood Industry

Zhenghe Group had their origin in the petroleum industry. In 2003, the company invested in an MDF line when management decided that MDF was a very promising product and held a bright future.

They invested in a state of the art MDF line in the Guangrao Economic Technical Developing Zone in the province of Shangdong. Dieffenbacher's scope of supply was from the gluing station to raw board storage.

The major product is THDF (2 mm – 9 mm). Raw material is fast growing poplar. Mr. Jiang is President of Zhenghe Group. Mr.Liu Baowei is GM of Zhenghe Wood Industry Co.,Ltd.



Mr. Zhang, Mr. Husmann, Mr. Liu Baowei, Mrs. Shirley Li, Mrs. Li Jie, Chief Engineer



Forming line



CPS press

| Project data sheet: | |
|---|----------------------------------|
| Customer: | Shandong Zhenghe Wood Industry |
| Project: | THDF |
| Plant location: | Gao Rao County, Shandong, China |
| Contract date | September 2002 |
| First Board date: | February 2004 |
| Design & Project Planning, Engineering site services: | Dieffenbacher Group |
| Glue mixing: | Dieffenbacher |
| Drying, sifting: | Schenkman-Piel-Engineering |
| Mat forming: | Dieffenbacher |
| Forming line, continuous press: | Dieffenbacher, CPS 9 ft x 28,5 m |
| max. line speed: | 1.200 mm/sec |
| capacity: | 650 m ³ /day |
| Panel thickness: | 2,0 – 40 mm |
| Raw board handling: | Dieffenbacher Handling Systems |
| Raw board storage syste: | Dieffenbacher Handling Systems |
| Sanding line: | Dieffenbacher Handling Systems |
| Cut to size plant: | Dieffenbacher |

Asia Dekor (Heyuan) Co.,Ltd.

Asia Dekor was founded in the mid 90's and initially started as a producer of laminate flooring using HDF. Today Asia Dekor is one of the most well known companies within China's forestry industry.

A high capacity short cycle press line was ordered from Dieffenbacher in 2000 to produce HDF flooring. The plant location is in Shenzhen industrial zone.

Early 2003 the decision was made to invest in an MDF production plant to be located in Heyuan City of Guangdong Province.

Dieffenbacher was chosen as the main plant supplier for this greenfield installation with an annual design output of 200.000 m³ MDF.



MDF Preparation area



CPS press



Liu GongTing – President,
Wolf-Gerd Dieffenbacher – President

| Project data sheet: | |
|---|------------------------------------|
| Customer: | Asia Dekor (Heyuan) Co.Ltd. |
| Project: | HDF / THDF |
| Plant location: | Heyuan, Guangdong Prov., China |
| Contract date | January 2003 |
| First Board date: | June 2004 |
| Design & Project Planning, Engineering site services: | Dieffenbacher Group |
| Glue mixing: | Dieffenbacher |
| Drying, sifting: | Schenkman-Piel-Engineering |
| Mat forming: | Dieffenbacher |
| Forming line, continuous press: | Dieffenbacher, CPS 8,5 ft x 31,3 m |
| max. line speed: | 1.300 mm/ sec. |
| capacity: | 780 m ³ /day |
| Panel thickness: | 2,0 – 35 mm |
| Raw board handling: | Dieffenbacher Handling Systems |
| Raw board storage system: | Dieffenbacher Handling Systems |

Weihua Group Co.,Ltd.

Weihua Group founded in 1992 was originally in the construction business. The company was established by Mr. Li Jianghua and his wife, Mrs. Liu Xian. In the beginning their business was involved in hydro power generation, water supply and construction. The company installed its first locally made MDF line in 1997. This line capacity is 30,000 m³/a and is located in Meizhou in the province of Guangdong. Two years later they invested in one locally made line with 50,000 m³/a in Zhengchen City in the province of Guangdong, and in 2003 built contemporary MDF line in Qingyuan city of Guangdong.

The majority of plant items were supplied by Dieffenbacher, including from gluing to raw board storage. The major product is THDF (2 mm – 9 mm). The first board was produced only 13 months after signing of the contract. In 2004 Weihua Group employed 3500 people and had a turnover of approximately 150 million USD.



Forming Line



CPS press



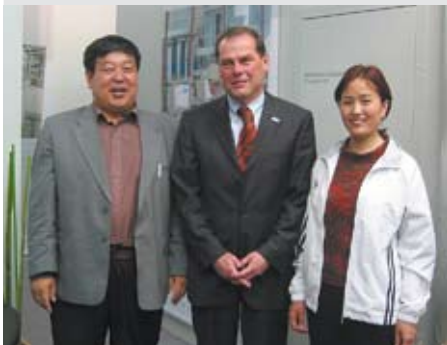
Mr. Li Jianghua – Chairman, Mr. Oho Guang Yuan – Governor, Mr. Yao Wen Zhang – Plant Manager

| Project data sheet: | |
|---|----------------------------------|
| Customer: | Weihua Group Co.,Ltd. |
| Project: | HDF/THDF |
| Plant location: | Qingyuan, Guangdong Prov., China |
| Contract date | March 2003 |
| First Board date: | June 2004 |
| Design & Project Planning, Engineering site services: | Dieffenbacher Group |
| Glue mixing: | Dieffenbacher |
| Drying, sifting: | Schenkman-Piel-Engineering |
| Mat forming: | Dieffenbacher |
| Forming line, continuous press: | Dieffenbacher, CPS 9ft x 28,5 m |
| max. line speed: | 1.200 mm/sec |
| capacity: | 650 m ³ /day |
| Panel thickness: | 2,0 – 40 mm |
| Raw board handling: | Dieffenbacher Handling Systems |
| Raw board storage system: | Dieffenbacher Handling Systems |
| Sanding line: | Dieffenbacher Handling Systems |
| Cut to size plant: | Dieffenbacher |

Hebei Yingang Wood Ind. Co.,Ltd.

Hebei Yingang Group was founded in 1993 as a joint venture between Mr. Fang and the Hebei Salt Bureau. In the beginning they had a small PB line with 15,000m³/a capacity. The company first installed a locally made MDF line in 1993. This line capacity is 30,000m³/a and is located in Zhengding City in the province of Hebei. In 1996, they erected another locally made MDF line with 50,000m³/a to increase their market share.

In 2003, a modern continuous computer controlled MDF line was ordered, the majority of the equipment being supplied by Dieffenbacher, from gluing to raw board storage. The major product is THDF (2 mm – 9 mm).



Mr. Fang Hua Zhi – CEO, Mr. Wolf-Gerd Dieffenbacher – President, Mrs. Fang



THDF-production line



Plant area

| Project data sheet: | |
|---|----------------------------------|
| Customer: | Hebei Yingang Wood Ind. Co.,Ltd. |
| Project: | THDF |
| Plant location: | Hebei Province, China |
| Contract date | March 2003 |
| First board: | August 2004 |
| Design & Project Planning, Engineering site services: | Dieffenbacher Group |
| Glue mixing: | Dieffenbacher |
| Drying, sifting: | Schenkman-Piel-Engineering |
| Mat forming: | Dieffenbacher |
| Forming line, continuous press: | Dieffenbacher, CPS 8 ft x 23,2 m |
| max. line speed: | 1.200 mm/sec |
| capacity: | 500 m ³ /day |
| Panel thickness: | 2,0 – 40 mm |
| Raw board handling: | Dieffenbacher Handling Systems |

Sichuan Guodong Co.,Ltd.

Guodong Group was originally in the glass coating and construction business. Mr. Wang Chunming has been the CEO and Chairman for Guodong Group since its inception. Guodong became involved in the panel industry in 1998. The company purchased a straw board line in 1998 from Metso with a capacity of 50,000 m³/a is using a single opening press and located in Shuangliu City in the province of Sichuan.

Since that time they have also imported two Dieffenbacher short cycle press lines for the production of laminate flooring. At the end of 2003 a sophisticated MDF line was ordered, with the majority of the equipment supplied by Dieffenbacher, from gluing to raw board storage. Design capacity is 220,000 m³/a.



Guadong Project Team



Guadong Short cycle line



CPS press

| Project data sheet: | |
|---|------------------------------------|
| Customer: | Sichuan Guodong Co.,Ltd. |
| Project: | HDF/THDF |
| Plant location: | Chengdu, Sichuan Prov., China |
| Contract start: | January 2004 |
| First Board date: | May 2005 |
| Design & Project Planning, Engineering site services: | Dieffenbacher Group |
| Refiner: | Pallmann |
| Glue mixing: | Dieffenbacher |
| Drying, sifting: | Schenkman-Piel-Engineering |
| Mat forming: | Dieffenbacher |
| Forming line, continuous press: | Dieffenbacher, CPS 8,5 ft x 40,6 m |
| max. line speed: | 1.200 mm/sec |
| capacity: | 850 m ³ /day |
| Panel thickness: | 2,0 – 40 mm |
| Raw board handling: | Dieffenbacher Handling Systems |
| Sanding line: | Dieffenbacher Handling Systems |
| Cut to size plant: | Dieffenbacher |

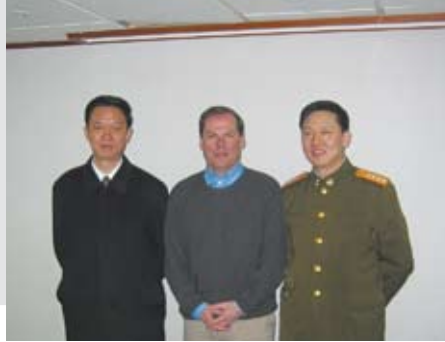
Shanxi Zhong Xing Timber Co.,Ltd.

Shanxi Zhongxing Wood Industry Co.Ltd., when originally established in 1990 supplied products to the panel industry. They installed their first locally manufactured MDF line in 1995. This line capacity is 30,000m³/a and is located in Hangzhong in the province of Shangxi. Thereafter, in the same city they installed a second MDF line of 50,000m³/a. In 2003, a new MDF plant was erected with the now-standard continuous configuration in Xian City in the province of Shangxi.

The major scope of supply by Dieffenbacher included from the gluing station up to raw board storage, with design capacity of 130,000m³/a.



Forming line



Mr. Liu Zhong Xin – President, Mr. Wolf-Gerd Dieffenbacher – President, Mr. Liu Zhang Xiang – Director



| Project data sheet: | |
|---|-----------------------------------|
| Customer: | Shanxi Zhong Xing Timber Co.,Ltd. |
| Project: | THDF |
| Plant location: | Xian, Shaanxi Province, China |
| Contract date | March 2004 |
| First board expected: | End 2005 |
| Design & Project Planning, Engineering site services: | Dieffenbacher Group |
| Glue mixing: | Dieffenbacher |
| Drying, sifting: | Schenkman-Piel-Engineering |
| Mat forming: | Dieffenbacher |
| Forming line, continuous press: | Dieffenbacher, CPS 8ft x 23,2 m |
| max. line speed: | 1.200 mm/sec |
| capacity: | 500 m ³ /day |
| Panel thickness: | 2,0 – 40 mm |
| Raw board handling: | Dieffenbacher Handling Systems |

Hubei Baoyuan Co.,Ltd.

The Baoyuan Group when formed in the early 1990's was originally based in the coal and gypsum mining industries. The company acquired its first locally supplied MDF line in 1998. This line with output of 50,000 m³/a is located in Jingmen City in the province of Hubei. Mr. Cai, CEO of the Baoyuan Group, developed as a major aim the increasing diversity of the business and identified the opportunity to grow with the latest panel production technology available in the market.

He decided to build a sophisticated MDF line in Jingmen City in order to increase the capacity and efficiency of his MDF production.

The major components were supplied by Dieffenbacher and extend from gluing to the raw board storage. The raw material being 100% poplar is readily available in the surrounding areas as many farmers plant poplars near their homes.



Project Engineering meeting



MDF plant

| Project data sheet: | |
|---|--------------------------------|
| Customer: | Hubei Baoyuan Group Co.,Ltd. |
| Project: | THDF |
| Plant location: | Jinmen, Hubei Province, China |
| Contract date | March 2004 |
| First board expected: | September 2005 |
| Design & Project Planning, Engineering site services: | Dieffenbacher Group |
| Glue mixing: | Dieffenbacher |
| Drying, sifting: | Schenkman-Piel-Engineering |
| Mat forming: | Dieffenbacher |
| Forming line, continuous press: | Dieffenbacher, CPS 9ft x 20,4m |
| max. line speed: | 1.200 mm/sec |
| capacity: | 520 m ³ /day |
| Panel thickness: | 2,0 – 40 mm |
| Raw board handling: | Dieffenbacher Handling Systems |

Asia Dekor (Huizhou) Woods Co.,Ltd.

During 2004 the decision was made to build a world-standard particle board production line to be located in Huizhou City/Guangdong Province in close proximity to the main furniture manufacturing centres of the region. Name plate capacity of the plant is 220.000m³ PB/a. Dieffenbacher was again chosen as the supplier of the main process plant sections, and were also given full responsibility for overall plant planning and engineering. In 2007 the company CVC Asia Pacific took over the Asia Dekor Group.



Ground breaking ceremony, Mr. Liu GongTing – President, Asia Wood



Robot handling



Contract signing

| Project data sheet: | |
|---|------------------------------------|
| Customer: | Asia Dekor (Huizhou) Woods Co.,Ltd |
| Project: | Particle Board |
| Plant location: | Huizhou, Guangdong Prov., China |
| Contract date | September 2004 |
| First Board expected: | December 2005 |
| Design & Project Planning, Engineering site services: | Dieffenbacher Group |
| Glue mixing: | Dieffenbacher |
| Mat forming: | Dieffenbacher |
| Forming line, continuous press: | Dieffenbacher, CPS 8,5 ft x 20,1 m |
| max. line speed: | 900 mm/sec. |
| capacity: | 800 m ³ /day |
| PB Panel thickness: | 6,0 – 30 mm |
| Raw board handling: | Dieffenbacher Handling Systems |
| Raw board storage system: | Dieffenbacher Handling Systems |

Taishan Weilibang Co.,Ltd.

Weihua Group placed the second order with Dieffenbacher for the construction of another new THDF plant. The new company Guangdong Taishan City Weilibang Wood Industry Co. Ltd. is located in Taishan City, Guangdong Province, China.

Dieffenbacher was selected by this customer as a result of their excellent experience with the project Weihua I in Qingyuan. The superior technical solutions – in particular the nominated and achieved high plant speed of 1,200 mm/second – proved convincing.

Another decisive argument was the smooth start-up and excellent after sales service.

Therefore it is not surprising that in September 2004 Dieffenbacher was awarded this contract for plant engineering and supply of the main HDF process equipment. The Dieffenbacher scope of supply comprises a total machinery package including gluing, drying, air grading, forming & press line, diagonal saw, board cooling, cut to size and board stacking in the finished size of 4 x 8 ft.



Conti panel system



Ground breaking ceremony



Site works

| Project data sheet: | |
|---|------------------------------------|
| Customer: | Taishan Weilibang Co.,Ltd. |
| Project: | THDF |
| Plant location: | Taishan, Guangdong Province, China |
| Contract date | September 2004 |
| First board expected: | December 2005 |
| Design & Project Planning, Engineering site services: | Dieffenbacher Group |
| Glue mixing: | Dieffenbacher |
| Drying, sifting: | Schenkman-Piel-Engineering |
| Mat forming: | Dieffenbacher |
| Forming line, continuous press: | Dieffenbacher, CPS 8 ft x 18,2 m |
| max. line speed: | 1.000 mm/sec |
| capacity: | 380 m ³ /day |
| Panel thickness: | 2,0 – 12 mm |
| Raw board handling: | Dieffenbacher Handling Systems |

Hebei Yingang Wood Industry Co. Ltd.

In early March 2006 Hebei Yingang Wood Industry Co. Ltd., located in Zhengding City, Hebei Province placed the order for the main equipment for its new particle board project. This came only 2 years after the successful start up of Yingang's first continuous THDF Line using a Dieffenbacher CPS Forming & Press system. The new plant project will replace an existing multi-opening press line and will expand particle board capacity of the Company fivefold in order to satisfy the rapidly growing demand of the Chinese furniture industry for high quality particle board. The PB project site is in close vicinity to the existing continuous

Dieffenbacher MDF plant and is ideally suited to make use of the common factory site infrastructure. Raw material supply will be round wood as well as residue materials supplied from a large number of wood working plants surrounding the Yingang factory. In addition the plant has the possibility to accept input of a high percentage of recycled wood. The new particle board line will feature the latest design Dieffenbacher CONFORM 3 head forming station for the production of super fine surface particle board in the thickness range from 4 to 40 mm with a nominal daily output of 750m³ of standard particle board.



Mr. Fan Huazhi, General Manager, Yingang Wood Based Panel Co.Ltd.



Single stage drum dryer



Project team

| Project data sheet: | |
|--|---------------------------------------|
| Customer: | Yingang Wood Based Panel Co.,Ltd. |
| Project: | Yingang PB |
| Plant location: | Zhengding City, Hebei Province, China |
| Contract date: | March 2006 |
| First board date: | 2007 |
| Design & project planning, engineering, site services: | Dieffenbacher Group |
| Glue mixing: | Dieffenbacher |
| Drying, sifting: | Dieffenbacher |
| Mat forming: | Dieffenbacher |
| Forming line, continuous press: | Dieffenbacher, CPS 8 ft x 20 m |
| Max. line speed: | 1.200 mm/s |
| Capacity: | 750 m ³ /day |
| Panel thickness: | 4,0 – 40 mm |
| Raw board handling: | Dieffenbacher |

Anhui DongDun Wood Based Co., Ltd.

DongDun Company headquarters are situated at Changshu near Shanghai. The Company is well known as one of the biggest MDF producers in the country, with a total of 9 production lines already in operation, all using multi opening presses. The existing plants are predominantly located in the neighboring provinces of Shanghai. In July 2006 the subsidiary company Anhui DongDun Wood Based Co., Ltd confirmed their decision for a new green field THDF project at a site adjacent to the banks of the mighty Yangtse River near the city of Chizhou in Anhui Province with design capacity of 200.000 m³/a.

At the DongDun THDF project the latest CPS press design improvements were implemented, with the emphasis placed on optimising high speed production of thin board. The new Dieffenbacher CPS design ensures improved compression profile control and protection of steel belts at design speeds of 1,500 mm/sec and above. The forming line has additional new features in the continuous belt prepress for optimum pre compression of thin HDF mats.



Mr. Rolf Kasper, Project Manager; Mr. Li You Yu, President DongDun Wood Industry Group; Mr. J. Rozynek, Project Planing Manager; Mrs. Li; Mr. Georg Rahm, Sales Director Asia/Pacific



CPS DongDun



Contract signing of DongDun THDF Plant Chizhou City, Anhui

| Project data sheet: | |
|--|-----------------------------------|
| Customer: | Anhui DongDun Wood Based Co.,Ltd. |
| Project: | DongDun THDF |
| Plant location: | Chizhou, Anhui Province, China |
| Contract date: | July 2006 |
| First board date: | 2007 |
| Design & project planning, engineering, site services: | Dieffenbacher Group |
| Glue mixing: | Dieffenbacher |
| Drying, sifting: | Dieffenbacher |
| Mat forming: | Dieffenbacher |
| Forming line, continuous press: | Dieffenbacher, CPS 8 ft x 26 m |
| Max. line speed: | 1.500 mm/s |
| Capacity: | 680 m ³ /day |
| Panel thickness: | 2,0 – 40 mm |
| Raw board handling: | Dieffenbacher |

Sichuan Shengda Forestry Industry Group Co.,Ltd.

Sichuan Shengda Forestry Industry Group Co.,Ltd. is a leading manufacturer of flooring and wooden decorative materials and ranks amongst the largest wooden products companies in China. The Company already operates several MDF laminate flooring plants and over the past few years has maintained its place as the second largest producer of laminate flooring in China. It currently has four flooring factories located in Chengdu and one in Shanghai.

Shengda has developed well known brand names in domestic and international markets, with substantial export volumes to major overseas markets including USA, Japan, Russia, Malaysia, Hong Kong, Vietnam and several European countries. The new plant with continuous press system will be located in Chengdu and is designed to produce MDF/HDF down to a minimum thickness of 2 mm.



(From left to right) Mr. Dong Jingtao, President; Mr. Jiang Changzheng, Chairman; Mr. Georg Rahm, Sales Manager



Group of contract signing



CPS during installation

| Project data sheet: | |
|--|----------------------------------|
| Customer: | Shengda Wooden Products Co.,Ltd. |
| Project: | Shengda THDF |
| Plant location: | Chengdu, Sichuan, China |
| Contract date: | October 2006 |
| First board date: | 2007 |
| Design & project planning, engineering, site services: | Dieffenbacher Group |
| Sifting: | Dieffenbacher |
| Mat forming: | Dieffenbacher |
| Forming line, continuous press: | Dieffenbacher, CPS 8 ft x 18,2 m |
| Max. line speed: | 1.200 mm/s |
| Capacity: | 380 m ³ /day |
| Panel thickness: | 2,0 – 16 mm |
| Raw board handling: | Dieffenbacher |

Dare Global of China enters Thin HDF Production with Dieffenbacher

The panel division of the Dare Global Group of companies has grown within only 3 years to make Dare Global one of the major producers of this country. Five different production sites are currently operated in the south eastern provinces of P.R. China. The company produces MDF/HDF on three continuous press lines of 250.000 m³ p.a. output each, two multi opening systems with a MDF capacity of 100.000 m³ p.a. each and particle board on a modern continuous plant system with a name plate capacity of 500.000 m³ p.a. Large volumes of the panel output is consumed by Dare's subsidiary companies of laminate flooring and integrated furniture production plants in

Fuzhou and Jiangsu Provinces. The raw material supplies are secured by approximately 70.000 hectares of forestry plantation which come under direct management control of Dare Global. Very soon after the successful completion of project phase 1 the company now announced Dare Global project phase 2 to be launched. This encounters primarily project installations with main focus on Thin High Density panel production in the range of 2 to 8 mm. Panel of unsanded surface suitable for direct printing as well as panel of sanded surface quality are produced at maximum design line speed of 1.500 mm/sec.



(From right to left) Mrs. Liyou, General Manager Panel Division; Mr. Cheng Xing Kang, President Dare Global; Mr. H. J. Schreiber, Vice President Dieffenbacher; Mr. Liu Shouhua, Sales Director Dieffenbacher China



Press installation



Contract signing ceremony

| Project data sheet: | |
|--|--------------------------------|
| Customer: | Dare Global Group |
| Project: | Dare THDF |
| Plant location: | Zhaoqing, Guangdong, China |
| Contract date: | January 2007 |
| First board date: | 2008 |
| Design & project planning, engineering, site services: | Dieffenbacher Group |
| Glue mixing: | Dieffenbacher |
| Drying, sifting: | Dieffenbacher |
| Mat forming: | Dieffenbacher |
| Forming line, continuous press: | Dieffenbacher, CPS 8 ft x 24 m |
| Max. line speed: | 1.500 mm/s |
| Capacity: | 680 m ³ /day |
| Panel thickness: | 2,0 – 8 mm |
| Raw board handling: | Dieffenbacher |
| Raw board storage system: | Dieffenbacher |

Hubei Weilibang Wood Industry Co.,Ltd. Hebei Weilibang Wood Industry Co.,Ltd.

China's emerging MDF/THDF panel market has seen the Weihua Group grow within only 3 years to become one of the biggest players in panel production in this country. The Company was amongst the first in China to pioneer THDF production using proven CPS production system when it started its operation at Qingyuan and Taishan. Whilst both these existing lines and another three multi opening lines are located in Guangdong Province, the new projects at Hubei and Hebei are aimed to expand the Company's business activities into the middle and northern part of China. With the latest addition of two

new CPS lines and another continuous THDF line to follow these in Yaoling Province, the Weihua Group will have a combined capacity of more than 1,000,000cu/m MDF/THDF per annum, making it one of the major panel producing companies in this giant exciting panel market. The Company has been very successful in operating its existing CPS lines from start-up, and within a short period of time has been able to strongly expand its market share in the huge Guangdong area, with the sheer endless number of furniture producing industries absorbing virtually the entire THDF output at the door step.



Leadership of Weihua Group



Construction work



Ground braking ceremony

Hubei Weilibang Wood Industry Co.,Ltd. Hebei Weilibang Wood Industry Co.,Ltd.

During 2007 Weihua Group was public listed on the stock exchange and according to its Chairman Mr. Li Jianhua the basic plan is to further expand

the Company's core business, concentrating on forest plantations and panel production.

| Project data sheet: | |
|--|--|
| Customer: | Hubei Weilibang Wood Industry Co.,Ltd. |
| Project: | Hubei THDF |
| Plant location: | Xingfan City, Hubei, China |
| Contract date: | March 2007 |
| First board date: | 2008 |
| Design & project planning, engineering, site services: | Dieffenbacher Group |
| Glue mixing: | Dieffenbacher |
| Drying, sifting: | Dieffenbacher |
| Mat forming: | Dieffenbacher |
| Forming line, continuous press: | Dieffenbacher, CPS 8 ft x 24 m |
| Max. line speed: | 1.500 mm/s |
| Capacity: | 680 m ³ /day |
| Panel thickness: | 2,0 – 8 mm |
| Raw board handling: | Dieffenbacher |
| Raw board storage system: | Dieffenbacher |

| Project data sheet: | |
|--|--|
| Customer: | Hebei Weilibang Wood Industry Co.,Ltd. |
| Project: | Hebei THDF |
| Plant location: | Qiu County, Hebei, China |
| Contract date: | March 2007 |
| First board date: | 2008 |
| Design & project planning, engineering, site services: | Dieffenbacher Group |
| Glue mixing: | Dieffenbacher |
| Drying, sifting: | Dieffenbacher |
| Mat forming: | Dieffenbacher |
| Forming line, continuous press: | Dieffenbacher, CPS 8 ft x 24 m |
| Max. line speed: | 1.500 mm/s |
| Capacity: | 680 m ³ /day |
| Panel thickness: | 2,0 – 8 mm |
| Raw board handling: | Dieffenbacher |
| Raw board storage system: | Dieffenbacher |

SHANXI ZHONG XING TIMBER CO.,LTD.

Shanxi Zhong Xing Timber was the first company in the Western Province of Shaanxi to establish a THDF plant using modern CPS technology to produce THDF.

The company was very successful to quickly establish a strong market presence in the area and only 2,5 years after start up of their first continuous panel plant a second CPS plant was ordered in September 2007.

Liu Zhong Xin is the President of the Group. He and his team are well known throughout the country for their skilled use of fruit tree residues extracted from the huge fruit plantations surrounding the world famous City of Xian best known for its Terracotta Warrior Army.



Mr. Liu Zhongxin (right) director of Xian



Terracota soldiers



Kick off meeting

| Project data sheet: | |
|--|-----------------------------------|
| Customer: | Shanxi Zhong Xing Timber Co.,Ltd. |
| Project: | Xian 2 THDF |
| Plant location: | Hangzhong City, Shaanxi, China |
| Contract date: | September 2007 |
| First board date: | 2008 |
| Design & project planning, engineering, site services: | Dieffenbacher Group |
| Glue mixing: | Dieffenbacher |
| Drying, sifting: | Dieffenbacher |
| Mat forming: | Dieffenbacher |
| Forming line, continuous press: | Dieffenbacher, CPS 8 ft x 23,6 m |
| Max. line speed: | 1.500 mm/s |
| Capacity: | 680 m ³ /day |
| Panel thickness: | 2,0 – 25 mm |
| Raw board handling: | Dieffenbacher |
| Raw board storage system: | Dieffenbacher |

HUNAN XIANGLIN NEW ENVIRONMENTAL PROTECT WOOD CO.,LTD.

The Company has been pioneering the introduction of thin high density panel and the Province of Hunan with a total population of more than 30 million people will see its first continuous THDF production system with CPS technology installed at the Capital City of Changsha. The

nearby plantation area has a managed forestry resource of soft wood and hard wood species. The Greenfield plant location is close to the City boundaries within a newly developed industrial park and adjacent to furniture producing industries.

| Project data sheet: | |
|--|---|
| Customer: | Hunan XiangLin New Env.Prot.Wood Co.,Ltd. |
| Project: | XiangLin THDF |
| Plant location: | Changsha City, Hunan, China |
| Contract date: | November 2007 |
| First board date: | 2009 |
| Design & project planning, engineering, site services: | Dieffenbacher Group |
| Glue mixing: | Dieffenbacher |
| Drying, sifting: | Dieffenbacher |
| Mat forming: | Dieffenbacher |
| Forming line, continuous press: | Dieffenbacher, CPS 8 ft x 18,2 m |
| Max. line speed: | 1.000 mm/s |
| Capacity: | 380 m ³ /day |
| Panel thickness: | 2,0 – 12 mm |
| Raw board handling: | Dieffenbacher |
| Raw board storage system: | Dieffenbacher |

Baoshan Corporation (Group) Co., LTD.

Pengzhou City, approximately 100 km west of Chengdu City/Sichuan Province, is to be the location for a green field THDF plant. During late 2007 the company Sichuan Province Pengzhou City Baoshan Corporation (Group) Co., Ltd. made their project decision for a CPS production system including CPS press size 8 ftx23 m. Panel plant supplier Dieffenbacher GmbH + Co. KG of Eppingen, Germany will supply the core process plant units including gluing, drying, forming, continuous pressing and board outfeed system.

Pengzhou area was heavily effected by the earthquake on May 12.2008.



After the earthquake on May 12.2008.

| Project data sheet: | |
|--|---------------------------------------|
| Customer: | Baoshan Corporation (Group) Co., LTD. |
| Project: | Baoshan THDF |
| Plant location: | Pengzhou City, Sichuan, China |
| Contract date: | February 2008 |
| First Board date: | 2009 |
| Design & Project Planning, Engineering, Site services: | Dieffenbacher Group |
| Glue mixing: | Dieffenbacher |
| Drying, sifting: | Dieffenbacher |
| Mat forming: | Dieffenbacher |
| Forming line, continuous press: | Dieffenbacher, CPS 8 ftx23,6 m |
| Max. line speed: | 1.500 mm/s |
| Capacity: | 680 m ³ /day |
| Panel thickness: | 2,0 – 25 mm |
| Raw board handling: | Dieffenbacher |

PTP Leshan Ltd.

In addition to their THDF capacity at Leshan City, Sichuan Province, a second Dieffenbacher CPS line was ordered by Plantation Timber Group during August 2007. The CPS press line of 8 ft x 23 m will be located adjacent to the existing CPS line and to the existing two Dieffenbacher short cycle press lines. Together with its second plant location at Sishou, Hubei Province, the PTP Group will then be operating a total of three Dieffenbacher CPS lines.



Group photo signing ceremony



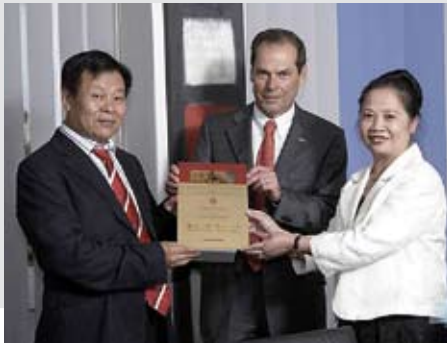
Big Buddha in Leshan

| | |
|--|----------------------------------|
| Project data sheet: | |
| Customer: | PTP Leshan Ltd. |
| Project: | Golden Pig |
| Plant location: | Leshan City, Sichuan, China |
| Contract date: | February 2008 |
| First Board date: | 2009 |
| Design & Project Planning, Engineering, Site services: | Dieffenbacher Group |
| Glue mixing: | Dieffenbacher |
| Drying, sifting: | Dieffenbacher |
| Mat forming: | Dieffenbacher |
| Forming line, continuous press: | Dieffenbacher, CPS 8 ft x 23,6 m |
| Max. line speed: | 1.500 mm/s |
| Capacity: | 680 m ³ /day |
| Panel thickness: | 2,0 – 25 mm |
| Raw board handling: | Dieffenbacher |

Fengkai Weilibang Wood Industry Corporation Ltd.

Celebration of 100th CPS press

It is with great pride that Dieffenbacher is celebrating the sale of its 100th CPS press, the first having been built in 1990. This 100th press has been sold to Weihua Fengkai, a member of the Chinese Weihua Group, which is already operating eight MDF lines in a number of Chinese provinces, including five Dieffenbacher CPS lines. The latest MDF line in Fengkai City in the province of Guangdong includes a CPS press with a width of 9 feet and a length of 38 metres and a designed board capacity of 250.000 m³ per year. This plant will increase the yearly production capacity of the Weihua Group to a total of 1,220,000 m³. The Weihua and Dieffenbacher companies jointly celebrated this historical event at the Dieffenbacher headquarters in Eppingen. Present at the ceremony were Mrs Liu Xian, General Manager and Mr Li Jianhua, Chairman of the Weihua Group. Mr. Wolf-Gerd Dieffenbacher emphasized the friendly cooperation which has developed over the years between the two companies, and presented the golden name plate for the 100th CPS press to our distinguished guests.



Mr. Li Jianhua, Mr. W.-G. Dieffenbacher, Mrs. Liu Xian being handed over the congratulation certificate (f.l.t.r.)



In the front (f.l.t.r.): Mrs. Liu Xian, Mr. Wolf-Gerd Dieffenbacher, Mr. Li Jianhua **In the background:** Dr. Werner Hoffmann, Georg Rahm, Sabine Lobrec, Shouhua Liu, Maren Jakob and Gerhard Melzer

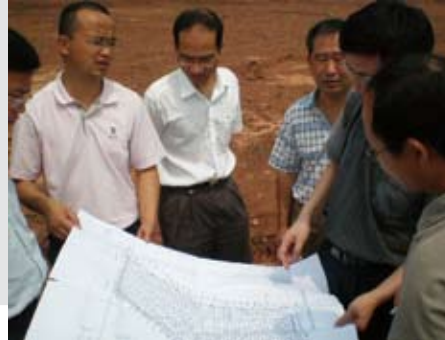
| Project data sheet: | |
|--|--------------------------------|
| Customer: | Guangdong Weihua Corporation |
| Project: | Weihua Fengkai MDF |
| Plant location: | Fengkai, Guangdong, China |
| Contract date: | November 2007 |
| First Board date: | 2009 |
| Design & Project Planning, Engineering, Site services: | Dieffenbacher Group |
| Glue mixing: | Dieffenbacher |
| Drying, sifting: | Dieffenbacher |
| Mat forming: | Dieffenbacher |
| Forming line, continuous press: | Dieffenbacher, CPS 9 ft x 38 m |
| Max. line speed: | 1.500 mm/s |
| Capacity: | 900 m ³ /day |
| Panel thickness: | 2,0 – 40 mm |
| Raw board handling: | Dieffenbacher |
| Raw board storage system: | Dieffenbacher |

Sichuan Nanchong Guodong Forestry Technology Co., Ltd

The Western China Sichuan Province has already established a strong base of modern THDF, HDF plants using CPS systems. Sichuan Guodong Construction Company of Chengdu decided to order again from Dieffenbacher a plant package with CPS line 8 ft x 26 m. Guodong selected a green field site at Nanchong City some 200 km north of Chengdu. At their existing plant sites in the Chengdu suburb of Shuangliu the Guodong Group already operates one huge CPS line for HDF and two Dieffenbacher short cycle press lines used mainly to produce melamine laminate flooring.



Site levelling works mid 2008

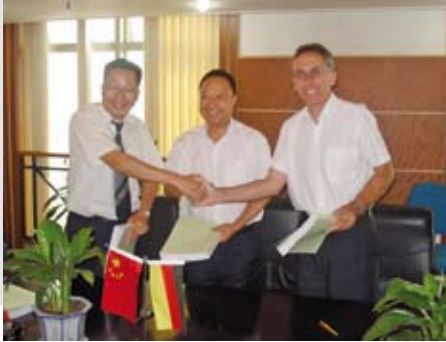


Project meeting on plant site mid 2008

| Project data sheet: | |
|--|---|
| Customer: | Sichuan Nanchong Guodong Forestry Technology Co., Ltd |
| Project: | Guodong Nanchong THDF |
| Plant location: | Nanchong, Sichuan Province, China |
| Contract date: | 2008 |
| First Board date: | 2009 |
| Design & Project Planning, Engineering, Site services: | Dieffenbacher Group |
| Chip cleaning: | Dieffenbacher |
| Refining: | Andritz by Dieffenbacher |
| Glue mixing: | Dieffenbacher |
| Drying, sifting: | Dieffenbacher |
| Mat forming: | Dieffenbacher |
| Forming line, continuous press: | Dieffenbacher, CPS 8 ft x 26 m |
| Max. line speed: | 1.500 mm/s |
| Capacity: | 750 m ³ /day |
| Panel thickness: | 2,0 – 32 mm |
| Raw board handling: | Dieffenbacher |
| Raw board storage system: | Dieffenbacher |
| Sanding: | Imeas by Dieffenbacher |
| Cut to Size: | Holzma by Dieffenbacher |

Guangyuan Shengda Forestry Industry Co., Ltd

Shortly after the successful production start-up and acceptance of the companies first Dieffenbacher THDF plant in Chengdu, Shengda Group decided to order again from Dieffenbacher a THDF plant package with CPS line 8 ft x 23 m. The company Guangyuan Shengda Forestry Industry Co., Ltd. will operate the new plant in Guangyuan City, Sichuan Province some 300 km north of Chengdu.



Contract signing for THDF plant Shengda line 2 (f.l.t.r.): Mr. Zhu Hongyao, Director of Shengda Group; Mr. Jiang Changzheng, President of Shengda Group; Mr. Georg. Rahm, Sales Director of Dieffenbacher

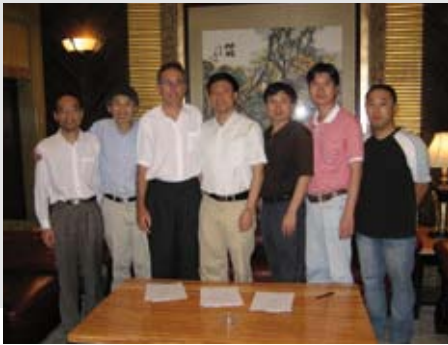
(F.l.t.r.) Mr. Zhu Hongyao, General manager of Shengda import and export company; Mr. Xiang Zhonghua, Chief Engineer of Shengda; Mr. Georg Rahm, Sales Director Dieffenbacher; Mr. Jiang Changzheng, President of Shengda Group; Mr. Wang Xiaoning, Project manager of Shengda 2

| Project data sheet: | |
|--|--|
| Customer: | Guangyuan Shengda Forestry Ind. Co., Ltd |
| Project: | Shengda THDF |
| Plant location: | Guangyuan city, Sichuan Province, China |
| Contract date: | August 2008 |
| First Board date: | 2009 |
| Design & Project Planning, Engineering, Site services: | Dieffenbacher Group |
| Chip cleaning: | Dieffenbacher |
| Glue mixing: | Dieffenbacher |
| Drying, sifting: | Dieffenbacher |
| Mat forming: | Dieffenbacher |
| Forming line, continuous press: | Dieffenbacher, CPS 8 ft x 23,6 m |
| Max. line speed: | 1.500 mm/s |
| Capacity: | 680 m ³ /day |
| Panel thickness: | 2,0 – 32 mm |
| Raw board handling: | Dieffenbacher |
| Raw board storage system: | Dieffenbacher |

Fujian Yongan Forestry (Group) Joint Stock Co., LTD

Fujian Yongan Forestry Group Joint established in 1994. The Group's principal activities are gathering, transporting, processing and selling wood; and manufacturing and selling forestry chemical products. Other activities include manufacturing and selling home furniture.

Since 1994 the company is operating a continuous MDF plant with a capacity of 110.000 m³/year. This line was supplied by Schenck Panel Production System which was acquired by Dieffenbacher in 1998. The new Dieffenbacher THDF plant package with CPS line 9 ft x 33 m. and a capacity of more than 250.000 m³/year will be located nearby the existing plant in Yongan City, Fujian Province some 300 km west of Fuzhou.



Contract signing



Plant view

| Project data sheet: | |
|--|---|
| Customer: | Fujian Yongan Forestry Joint Stock Co., LTD |
| Project: | Yongan THDF |
| Plant location: | Yongan City, Fujian Province P.R. China |
| Contract date: | June 2008 |
| First Board date: | 2009 |
| Design & Project Planning, Engineering, Site services: | Dieffenbacher Group |
| Glue mixing: | Dieffenbacher |
| Drying, sifting: | Dieffenbacher |
| Mat forming: | Dieffenbacher |
| Forming line, continuous press: | Dieffenbacher, CPS 9 ft x 33 m |
| Max. line speed: | 1.500 mm/s |
| Capacity: | 900 m ³ /day |
| Panel thickness: | 2,0 – 32 mm |
| Raw board handling: | Dieffenbacher |
| Raw board storage system: | Dieffenbacher |

Dieffenbacher Machinery Changzhou:

The Production at the new plant Dieffenbacher Machinery Changzhou (DMC) started in February 2007.

Changzhou in the province Jiangsu has nearly 3.5 Million inhabitants. It is located in the North-Western of Shanghai and can be reached within 2 hours by car from there. Changzhou is also very close to Nanjing, the capital of the province. It is located in the South-East and can be reached within 1.5 hours.

20 employees are already mounting and producing in the 2,500m² production hall.

12 further colleagues are working in the offices. Dryer regulation flaps, sifter housings, fiber bins and forming lines can be produced on smaller production machines. In the case of production shortages in other Dieffenbacher production plants, DMC is also able to produce press frames. It is planned to enlarge the assembly hall in 2008. That means, that the welding area will be expanded and a sand blasting cabin will be installed. After completion, the final production can be realized as planned in Changzhou.



Dieffenbacher Machinery Changzhou



Team Dieffenbacher Beijing Office



Dieffenbacher Beijing Building

Dieffenbacher Beijing Office Dieffenbacher Machinery Service Beijing Co.,Ltd.

Dieffenbacher Beijing Office, was established in 1999 followed by Dieffenbacher Machinery Service Beijing Co.,Ltd., which was founded in 2004. Mr. Liu Shouhua is the CEO of Dieffenbacher Beijing Office and general manager of Dieffenbacher Machinery Service Beijing. The both offices count nine employees and another two engineers will join the team soon.

Approx 70% of the whole production of THDF in China comes from Dieffenbacher CPS system. Since 2002, Dieffenbacher has supplied more than 20 CPS lines to china and occupied absolute quota of Chinese market. Based on strong responsibility and good reputation, Beijing office and

Machinery Service Beijing gained amazing success in China, but this does not tempt them to sit back and relax – All staffs are fully busy to support their customers.

Most services for equipments have been managed by Dieffenbacher engineers. This is a benefit for customers who are always satisfied by Dieffenbachers outstanding services.

It is planned to set up a further spare parts warehouse by March 2008. By this Dieffenbacher Beijing Office and Dieffenbacher Machinery Service Beijing will continue to offer excellent service to their customers.