



Ultraclean®/Ultraconstant®

Clean Room³ – Intelligent Solutions for your Clean Room Requirements



Weiss Reinraumtechnik



Weiss Clean Room³



Clean room solution in accordance with, amongst others, EU and FDA-GMP/VDI 2083, ISO 14644 and Semi/Sematech



A complete range of wall-mounted, ceiling-mounted and floor systems

Clean room system solutions and clean room know-how

Weiss provides you with system solutions and components for all clean room applications. Weiss systems have proven their worth everywhere where clean and stable conditions are required. Even so, we still want to achieve more for our customers.

With the Clean Room³ concept we want to show how a symbiosis of well-proven clean room systems and top clean room know-how can be multiplied to clean room². For your benefit.

Industrial clean room systems for all clean room classes

We offer our customers integrated systems and components in the following fields:

- Food industry
- Beverage industry
- Medical technology
- Genetic and bio engineering
- Laboratories
- Pharmaceutics
- Pharmacies
- Optoelectronics
- Microelectronics
- Micromechanics
- Automotive engineering
- Nanotechnology

for all clean room classes and areas of application. The benefit is that Weiss is one of the few companies active worldwide that provide tailored systems, air-conditioning units and process technology from a single source.

Cooperation from the beginning

Working together, our customers particularly value the sound advice given in developing systems, support in design planning, close cooperation with installation and startup as well as the service and training.

In various projects we have been able to identify significant insights into the interaction and efficiency of individual components so that you as a Weiss partner can, in turn, benefit from this knowledge for your clean room solutions.

Weiss Reinraumtechnik – part of an international technology group

Weiss Klimatechnik and Weiss Umwelttechnik have been concerned with manufacturing equipment and systems for creating optimum air-conditioning environments for over 50 years now. Weiss Klimatechnik's core business includes clean room technology development and manufacturing, complete ceiling-mounted systems, air-conditioning for operating theatres and data room air-conditioning. Weiss Klimatechnik is a member of the Schunk Group – an international technology group with a broad range of products & services in materials and systems technology. The Schunk Group employs over 7,500 staff worldwide and is represented by 80 subsidiaries in 25 different countries.



Support in GMP consultation, qualification (DQ, IQ, OQ, PQ), acceptance inspection and training

The benefits of Weiss clean room solutions

- + Protection for product, personnel and environment = Clean Room³
- + Considerable experience with all clean room applications
- + Global presence

Competence in Pharmaceuticals



Insulators, process-compatible, ergonomic installation



Weiss clean room components – GMP Class A

GMP CLASS	MAX. NUMBER OF PARTICLES IF NOT IN OPERATION (1/m ³)		MAX. NUMBER OF PARTICLES IN OPERATION (1/m ³)	
	0,5 µm	5 µm	0,5 µm	5 µm
Particle size				
A	3,500	1	3,500	1
B	3,500	1	350,000	2,000
C	350,000	2,000	3,500,000	20,000
D	3,500,000	20,000	n.d.*	n.d.*

EU GMP, Annex 1, 2003

** not defined*

In-depth knowledge of the pharmaceutical technology – prerequisite for target-oriented clean room consulting

Experience has shown that the best solutions are found when application requirements are precisely formulated. We regard ourselves as the ultimate experts for clean room projects in the pharmaceuticals field, i.e. we evaluate problems and potential before the first customer meeting. Taking into consideration the relevant standards and regulations (GMP, FDA, Medical Product Law, Medicine Law), we then provide the individual solution for your requirements from the clean workbench to the turnkey clean room system.

Consulting, systems and components for all applications of pharmaceutical technology, biotechnology, gene technology and the manufacture of bulk pharmaceutical chemicals

In the pharma field we provide full consultation and all systems for realizing

- Clean room classes A-D
- Clean room air-conditioning equipment especially for the pharma industry
- Clean room wall, ceiling, floor and illumination systems in accordance with GMP regulations
- Heating, cooling, sanitary and electrical installations especially for the pharma industry
- Ultra-pure gases, ultra-pure water, and ultra-pure steam
- Protection concepts/high containment
- Hot-air sterilisation and hot-air tunnels
- Stability test cabinets and chambers
- DKD laboratories (German Calibration Service) for in-house and in-situ calibration for air and air-conditioning sensors

Weiss life science applications – in use throughout the world

For life science applications we provide turnkey equipment which, in particular, guarantee the elimination of contamination risks. Weiss equipment is successfully used throughout the world in the pharmaceutical industry, in medical technology and in numerous laboratories and research institutes.

Extensive qualification services

As a partner, Weiss Reinraumtechnik can offer you a wide range of qualification services. We do not only give you advice on current requirements, but also inform you of the present trends and developments in the various national, European and international standards so you are well prepared for future clean room requirements.



Protection from contamination and cross-contamination of product, environment and personnel.

Weiss customer benefits for the pharma industry

- + Excellent knowledge of pharmaceutical production
- + Systems successfully in use throughout the world
- + Excellent advice on specifications and standards

Weiss Clean Room Solutions for Microelectronics



Highest classes of cleanliness for optimum production conditions

In microelectronics and related fields Weiss ensures that the defined classes of cleanliness for particles and airborne molecular contamination (AMC) as per ISO/Semi/Sematech standards are adhered to for optimum conditions of production e.g. in

- PCB production
- Multimedia and optical industry
- Microelectronics
- Micromechanics
- Aerospace industry

Semi-conductor technology, CD-R, DVD-R, diffusion and etching techniques

For the manufacture of micro-systems and applications in silicon semi-conductor technology, DVD, DVD-R, oxidation and diffusion technology, wet chemicals and deep etching techniques, we plan and develop solutions with the relevant specifications.



These apply to clean working areas of ISO Class 5 and higher, product protection from environment contamination and air conditioning to achieve stable temperature and humidity conditions in production and process technology.

Clean room-compatible designs

We align clean room installations to the particular requirements of your production. Weiss provides wall and ceiling-mounted systems for ISO Class 1 to 9 clean room installations, flexible modular designs, absolutely impermeable to particles and, if necessary, gas-sealed, flush-fitted designs and guaranteed resistant to disinfection and cleaning agents.

Clean room core competence – hand-in-hand with strong partners

The core competence of Weiss clean room technology is in:

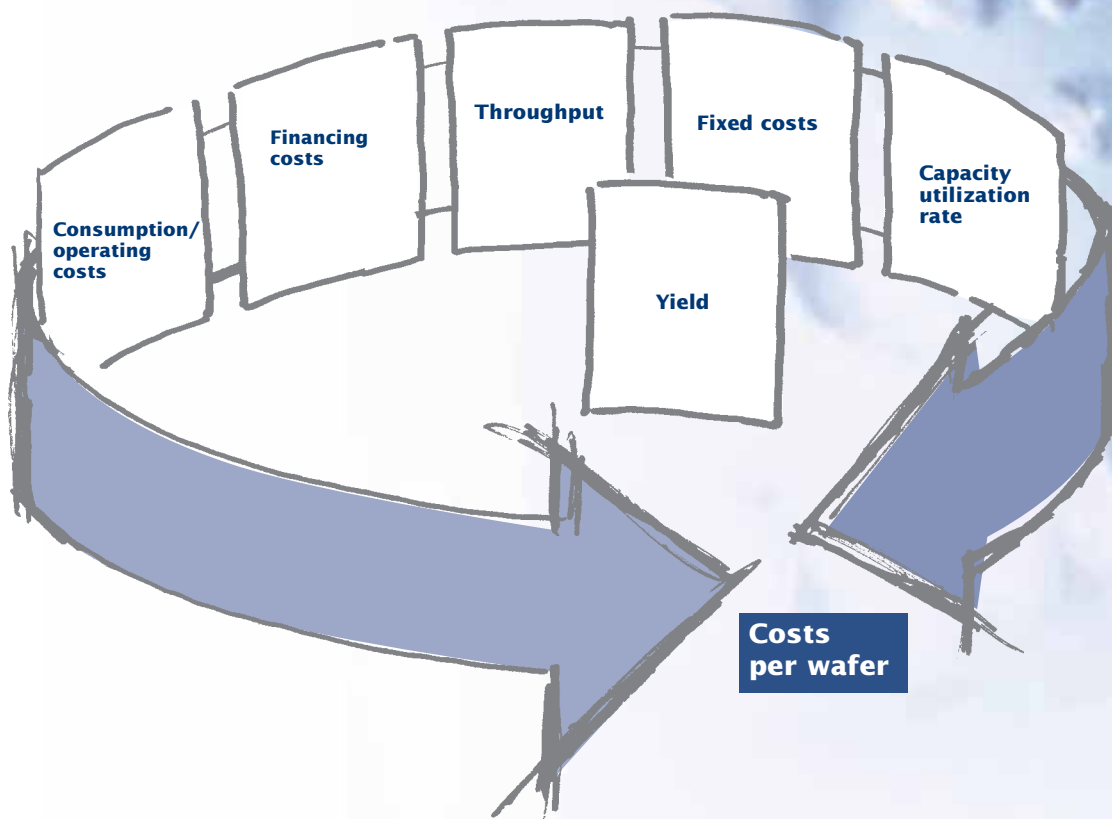
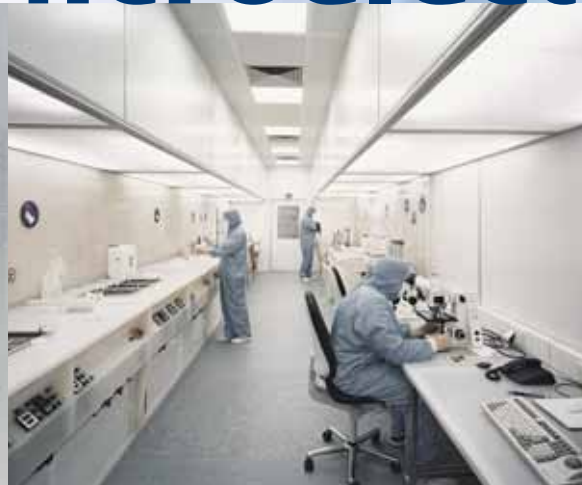
- HVAC, clean room
- Utilities/Facilities
- Power & Electrical & Control
- Health & Safety & Environment

And we have strong partners at our side. Our sister companies of the semi-conductor division manufacture highly clean components for the semi-conductor industry. Our sister companies of the manufacturing technology division specialise in the most up-to-date automation technologies. Thus our core competence in clean room technology does not exist on its own. It is, in fact, incorporated into a network of specialists. This is something you can benefit from enormously.

Weiss clean room technology benefits

- + Clean room core competence
- + Know-how of the Weiss sister companies
- + Consulting incorporated into the process chain

Systems Microelectronics



Food, Optics, Medicine, Laboratory



Supply and exhaust air system on an aseptic filling machine in the beverage industry

CLASSES OF CLEANLINESS AS PER DIN EN ISO 14644-1	5	6	7	8
EU C-GMP CLASSES	A	B	C	D
Typical applications	Aseptic filling of beverages			
	Aseptic food processing			
		Food packaging		
	CD, DVD, optical components			
				Precision measuring
				Fine measuring
	Medicine			
	Production of cytostatic agents			
Weiss solutions	S2 – S4 laboratory			
	Weiss insulators			
	Weiss-LF, low-turbulence work benches			
	Weiss filter fan units			
	Weiss minienvironments			
	Weiss barrier systems, local clean rooms, housings			
Weiss clean room systems				

What counts is experience and the transfer of knowledge

We have acquired substantial knowledge during long years of cooperation in the conception, planning and realization of clean room solutions and the recommendation of components for the

- Food industry
- Optical industry
- Laboratories
- Institutes
- Universities
- Hospitals
- Pathologies

from which you can greatly benefit.

The food industry is an example of tighter requirements being placed on clean rooms.

The industry is increasingly replacing chemical preserving agents by natural durability measures.

To this end particle and germ-free zones are created around filling and sealing machines, for instance.

Producers of dairy products, baby foods and ready-to-serve meals as well as OEM manufacturers of filling equipment have been customers of ours for many years now.

For precise results – Weiss experimental chamber technology

Weiss provides turnkey systems (quality classes 1 to 4 according to VDI/VDE 2627) to minimize negative climatic and environmental influences that affect precision when performing measuring tasks so that the final results are error-free.

Application fields are:

Linear measurement technology, paper testing, textile examinations and environmental analysis.

Safety of products, environment and personnel

GMP/FDA-compatible working places both with and without filter technology are part of our range of services. The various kinds of clean room zones created by air separating curtains for detecting and aspirating pollutants ensure optimum protection for products, personnel and environment. We as your Weiss clean room technology partner can offer all the necessary and appropriate application training and professional service for safety and non-assigned working places.

Working places - ergonomics and economic efficiency

Weiss advises you on customer-specific clean room table or non-assigned working place configuration and on ergonomic, economic working place solutions for weighing, filling, cleaning and sampling. We do not only support you with complete installation and startup monitoring but also with all validations and qualification/DQ, IQ and OQ documentation.



Hot air sterilization, low-maintenance outlay and no risk from cross-contamination

Benefits of what Weiss has to offer

- + Transfer of knowledge from related fields
- + Protection of product, personnel and environment
- + Economical working place solutions

Clean Room Fundamentals and Concepts

Turbulent and low-turbulence supply air systems

VDI 2083, sheets 1 and 3
 ISO 14644, sheets 1, 2, 3, 4, 5
 DIN EN 779
 DIN EN 1822

Personnel

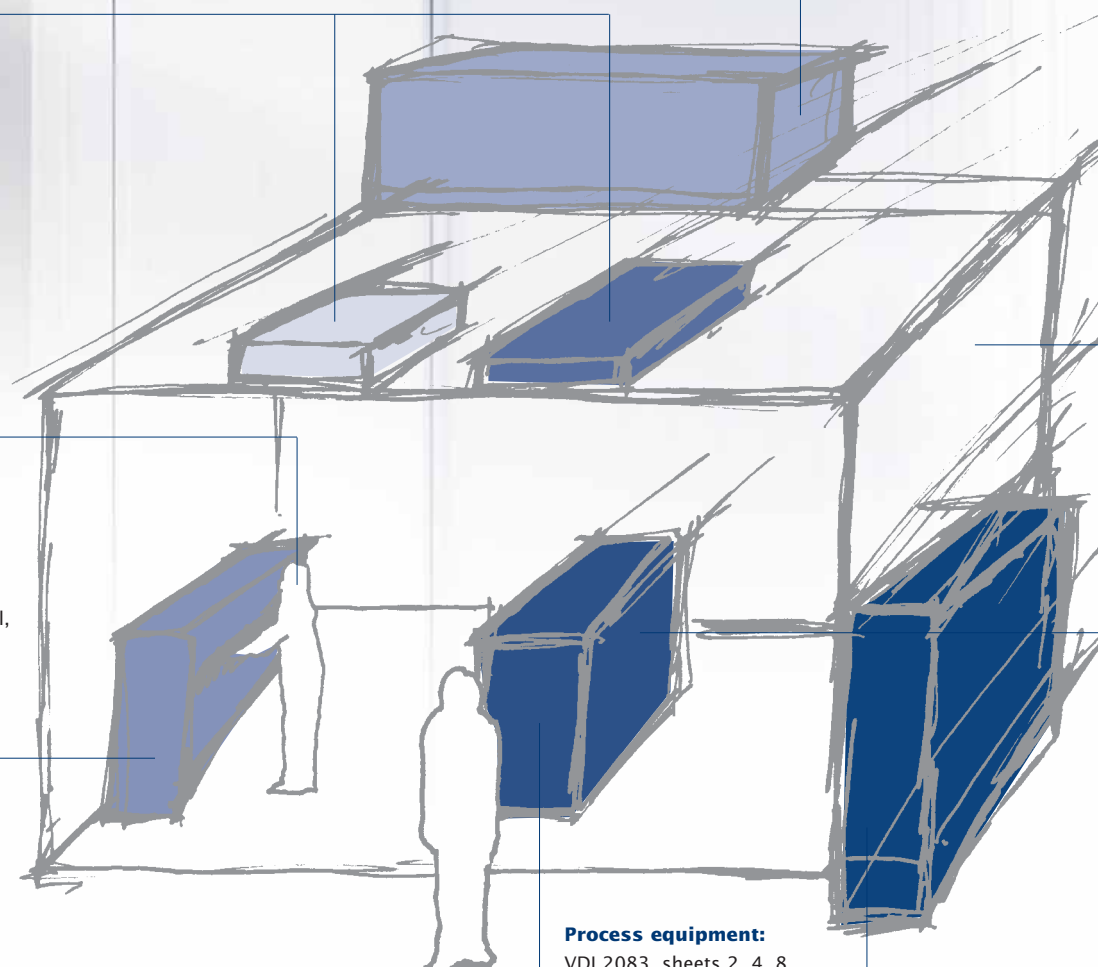
VDI 2083, sheets 5 and 6
 DIN EN ISO 14644-1, sheets 4 and 5

Clean working places Microbiological workbenches/ clean workbenches

Laminar flow, protection of personnel,
 product and environment
 Process media:
 VDI 2083, sheets 7, 9 and 10
 ISO 14644, sheet 7

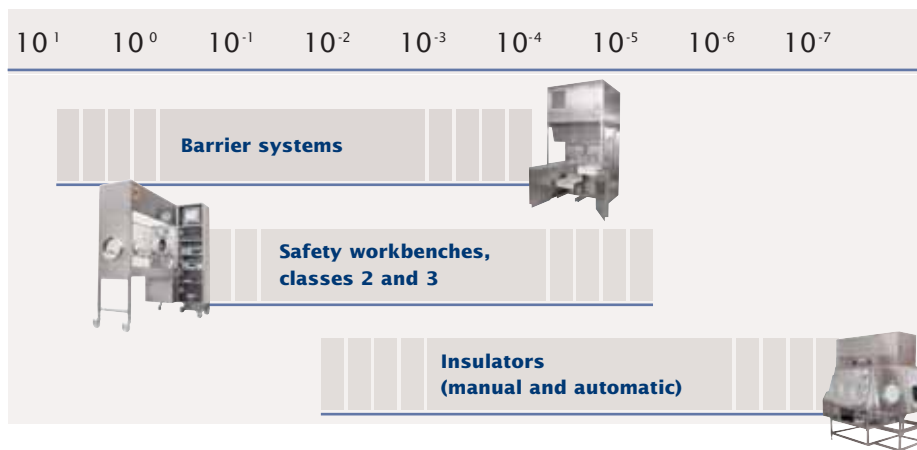
Process equipment:

VDI 2083, sheets 2, 4, 8
 ISO 14644, sheets 2, 4, 5, 8,
 Semi/Sematech



High Containment

Maximum exposure limit values in mg/m³



Weiss standard air-conditioning unit

for constant interior
air conditions and humidity
VDI 2083
ISO 14644

Air measuring technology

VDI 2083, sheet 3
ISO 14644, sheets 2 and 3

Surface measuring technology

VDI 2083, sheet 4
ISO 14644, sheets 4 and 5

Components and Systems

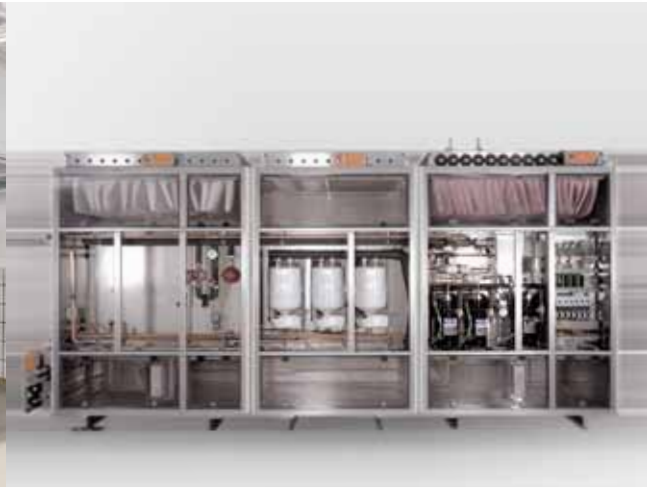
PHARMACEUTICAL CLEAN ROOM CLASSIFICATIONS	A	B	C	D
Clean room class as per VDI 2083	3	3	5	6
Clean room class as per Fed. Std. 209e (withdrawn)	100	100	10.000	100.000
Clean room class as per DIN EN ISO 14644-1	5	5	7	8
Kind of air stream	TAV	Turb.	Turb.	Turb.
Maximum number of particles/m ³ > 0,5 µm	3,500	3,500	350,000	3.5 E6
Maximum no. of colony-forming units in the air volume (in operation) CFU/m ³	< 1	10	100	200
Maximum no. of colony-forming units on sedimentation plates (in operation) CFU/m ²	< 1	5	50	100
Maximum no. of colony-forming units on sedimentation plates (in operation) CFU/m ²	< 1	5	25	50

Weiss Products

*The better alternative.
Weiss standard wall-
and ceiling-mounted
systems in flush-fitted
design*

*Hot air sterilizers
and tunnels. As a
total system from a
single source incl. all
qualification services*

*Over 10,000 units in
use throughout the
world. Top quality
air-conditioning units
for clean rooms,
constant air conditioning
and special uses*



Filter fan units



Barrier systems



Safety workbenches



Compact air-conditioning units

The Weiss clean room technology range consists of a large number of components and systems that have proved their worth worldwide with innumerable customers for many years now.

- Compact air-conditioning units
- Precision air-conditioning units
- Air-conditioning chamber systems
- Wall and ceiling-mounted systems
- Hot air sterilizers and tunnels
- Mobile clean room containers, cells, cabins and tents
- Clean workbenches and microbiological safety workbenches
- „Laminar“ flow clean room cabins
- Barrier systems
- Filter fan units
- Minienvironments
- Air showers
- Personnel and material barrier systems

More efficient than many other solutions. Minienvironment for highly clean production

Various kinds of filling tables, also for the microbiological sector



Insulators



*Flexible housing
ISO classes 5-9*

Weiss benefits

- + One of the most extensive clean room product ranges in the world
- + Solutions for all clean room requirements
- + Innovative, approved, economical applications

Weiss – Complete Clean Room Services

1. Weiss clean room technology companies

Weiss Klimatechnik: Systems, equipment and service for creating industrial process air conditioning

Weiss Umwelttechnik: Testing equipment and systems for environment simulation

Vötsch Industrietechnik: Testing equipment and systems for heat treatment and drying

Weiss GWE: Systems and working places for pollutant detection and aspiration

BDK: Laminar flow equipment and systems, insulators, safety workbenches and barrier systems

2. Cooperation in brain trusts

University of Duisburg, ISPE, IPA Fraunhofer Institute, VDI, ISO, IEST, GAMP Forum

Weiss Clean Room³

The Weiss Clean Room³ concept means that we consider every project from an integrated, customer-oriented perspective and give you extensive advice.

3. Global representation

- Weiss Reinraumtechnik is a member of the Schunk Group with subsidiaries worldwide
- Global exchange and transfer of knowledge in materials technology
- Weiss Reinraumtechnik: 16 representative offices worldwide

4. Transfer of knowledge

Weiss benefits from the Schunk partner companies, the Schunk Semiconductor Unit and Schunk Fördertechnik, among others.

System Consulting / Project Planning / Designing

- Feasibility studies
- Concept planning
- Profitability analyses
- Financing management
- Implementation planning
- Cooperation in approval processes
- General contractor, cooperations, partnerships

Production

- Equipment manufacturing
- Plant construction
- Clean room components
- Monitoring systems
- Special designs
- Special equipment
- System solutions

Installation / Commissioning

- Worldwide supervising and commissioning network
- Extensive network of bases
- Acceptance inspection measurements/clean room measurements
- Documentation
- Qualification/requalification (DQ, IQ, OQ, PQ)

Training

- Clean room technology
- Air-conditioning technology
- Systems / products
- Clean room behaviour

After-Sales Service

- Spare parts management / consignment stock
- Maintenance / service worldwide
- Dial-up data transfer
- Technical facility management for small and medium-sized systems
- Qualification and requalification
- ISO 9001: 2000 certified
- Hygiene test as per VDI 6022



Austria
Belgium
Brazil
China
Czech Republic
Denmark
Dubai
Egypt
France
Great Britain
Hungary
India
Italy
Japan
Mexico
Netherlands
Poland
Portugal
Romania
Russia
Saudi Arabia
Slovenia
Sweden
Switzerland
Taiwan
Tunisia
Turkey
Ukraine
USA

Weiss Compact Air-Conditioning Units

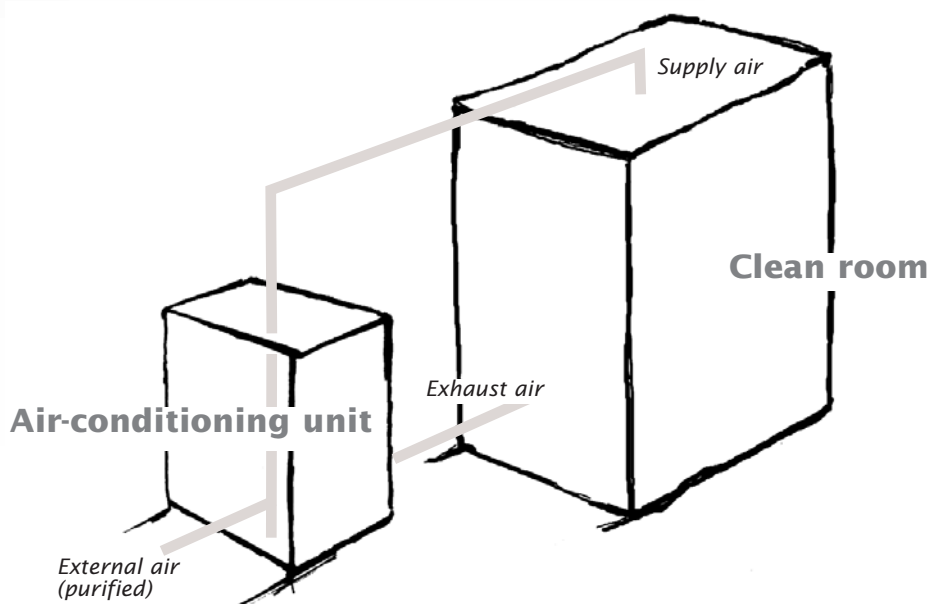
Compact air-conditioning units

The new generation of compact air-conditioning units has been specially developed for universal use for differing air-conditioning and clean room requirements. Compact design combined with innovative technology ensure significant operating cost benefits.

- Nominal volume flow from 2,000 to 22,000 m³/h
- Up and downflow designs
- Full air-conditioning function with heating, cooling, humidifying and dehumidifying
- Complies with VDI 6022
- Filter class: F7 standard, F9 possible as second stage
- Pumped cold water or active cooling
- Integrated switch cabinet
- Temperature constancy: ± 0.5 K
- Humidity constancy: $\pm 2\%$ r.h.



Compact Solution



Design variant (upflow) as circulating air appliance with external air proportion

Benefits at a glance

- Set-up possible near the clean room
- Minimum floor space needed
- Short duct and supply stretches
- Easy, rapid installation
- Service-friendly
- Good cleanability as per VDI 6022

Weiss Compact Air-Conditioning Units

SIZE COMPACT AIR-CONDITIONING UNIT	35.3	55.3	75.3	90.3	120.3	160.3	220.3
NOMINAL VOLUME FLOW							
Volume flow with max. ext. pressure loss m ³ /h	3,500	5,500	7,500	9,000	12,000	16,000	22,000
Max. external pressure loss Pa	600	900	620	580	900	700	750
COOLING – COOLING CIRCUIT, AIR-COOLED, EXTERNAL							
Cooling capacity (tc=50 °C) as per EUROVENT							
Suction temp. +27 °C/46% r.h. - total/sens. kW	13.4/11.5	18.4/17.9	29.2/26.2	34.9/31.4	45.4/41.7	54.4/52.3	73.1/71.0
Partial type code (DX=direct evaporator)	DX	DX	DX	DX	DX	DX	DX
COOLING – COLD WATER 7/12.5 °C							
Cooling capacity as per EUROVENT							
Suction temp. +27 °C/46% r.h. - total/sens. kW	11.6/9.8	26.1/20.4	36.6/28.5	42.9/33.5	60.6/46.8	75/58.9	106/82.7
Partial type code (CW=cold water)	CW	CW	CW	CW	CW	CW	CW
*other temperatures on request							
FAN MOTOR UNIT *							
Product type							
Nominal motor power kW	2.9	7.4	7.4	7.4	2 x 7.4	2 x 7.4	3 x 7.4
Current consumption, max. A	4.6	12.7	12.7	12.7	2 x 12.7	2 x 12.7	3 x 12.7
Electrical connected load kVA	3.2	8.8	8.8	8.8	17.6	17.6	26.4
Partial type code (D=Downflow/U=Upflow)	D	D	D	D	D	D	D
FREQUENCY CONVERTER							
Product type static frequency converter							
FILTER F7 SUCTION SIDE							
Product type cassette filter, pocket filter (only downflow), as per DIN EN 779							
FILTER F9 SUCTION SIDE (OPTION)							
Product type cassette filter, pocket filter (only downflow), as per DIN EN 779; also available as second filter stage							
HOUSING DIMENSIONS							
Width mm	1,090	1,090	1,355	1,610	2,140	2,405	2,405
Depth mm	650	850	850	850	850	1,100	1,100
Height mm	1,950	1,950	1,950	1,950	1,950	1,950	1,950
Partial type code (width, depth)	10.6	10.8	13.8	16.8	21.8	24.11	24.11
STANDARD UNIT, COMPLETE							
Complete weight DX/CW kg	325/286	384/312	534/471	628/523	890/778	1153/1038	1284/1086
Sound power level at nominal volume flow and ext. pressure loss Pa	50	50	50	50	50	50	50
Sound pressure level in free field (1 m distance) db (A)	64	54	59	66	59	66	68
Supply voltage V/Ph/Hz	V/Ph/Hz			400/3/50			
Electrical connected load* kVA	9.9	12.1	20.7	21.1	32.6	33.2	45.3
* without condenser							
OPTIONS							
HUMIDIFYING – STEAM GENERATOR							
Product type electrode steam humidifier, internal; accuracy +/- 6%							
Current consumption A	4.7	7.4	10	11.9	15.9	21.1	29.1
Rated input kW	3.2	5	6.8	8.1	10.8	14.4	19.8
Electrical connected load kVA	3.2	5	6.8	8.1	10.8	14.4	19.8
Max. steam output kg/h	4.2	6.6	9	10.8	14.4	19.2	26.4
Water supply bar	1 - 10	1 - 10	1 - 10	1 - 10	1 - 10	1 - 10	1 - 10
Water conductivity µS/cm	125-900	125-900	125-900	125-900	125-900	125-900	125-900
On request	external humidifier type MK5 P (resistance heating principle); accuracy +/- 2%; also for fully desalinated water						
HEATING – ELECTRIC HEATING							
Product type plain tubular heaters, continuously controlled							
Max. heating capacity kW	7.5	15	15	21	21	21	30
Current consumption A	10.8	21.7	21.7	30.3	30.3	30.3	43.4
Electrical connected load kVA	7.5	15	15	21	21	21	30
HEATING – HOT WATER 70/50							
Heating capacity at suction temp. 15 °C kW	15.9	23.9	32.4	36.2	49.2	66.5	79.2
Hot water volume m ³ /h	0.7	1	1.4	1.6	2.2	2.9	3.5
HEATING – HOT WATER 70/50 (PREHEATER)*							
Heating capacity at suction temp. -15 °C kW	22	34.7	47.2	57.6	79	114.6	138.5
Hot water volume m ³ /h	1	1.5	2.1	2.5	3.5	5	6.1
*Preheater in top-mounted box (only downflow)							

Weiss Precision Air-Conditioning Units

For high demands – compact solution

Weiss precision air-conditioning units guarantee ultra-clean and constant air-conditioning and are suitable for all clean rooms and experimental chambers. The units are successfully in use throughout the world. Application is focussed on process air-conditioning.

- Nominal volume flow from 1,000 to 6,000 m³/h
- Upflow design
- Full air-conditioning function with heating, cooling, humidifying and dehumidifying (process humidification)
- VDI 6022
- Filter class F7, second stage externally possible
- Optional supply air filter
- Temperature constancy: ± 0.2 K
- Humidity constancy: ± 2 % r.h.



Fields of use

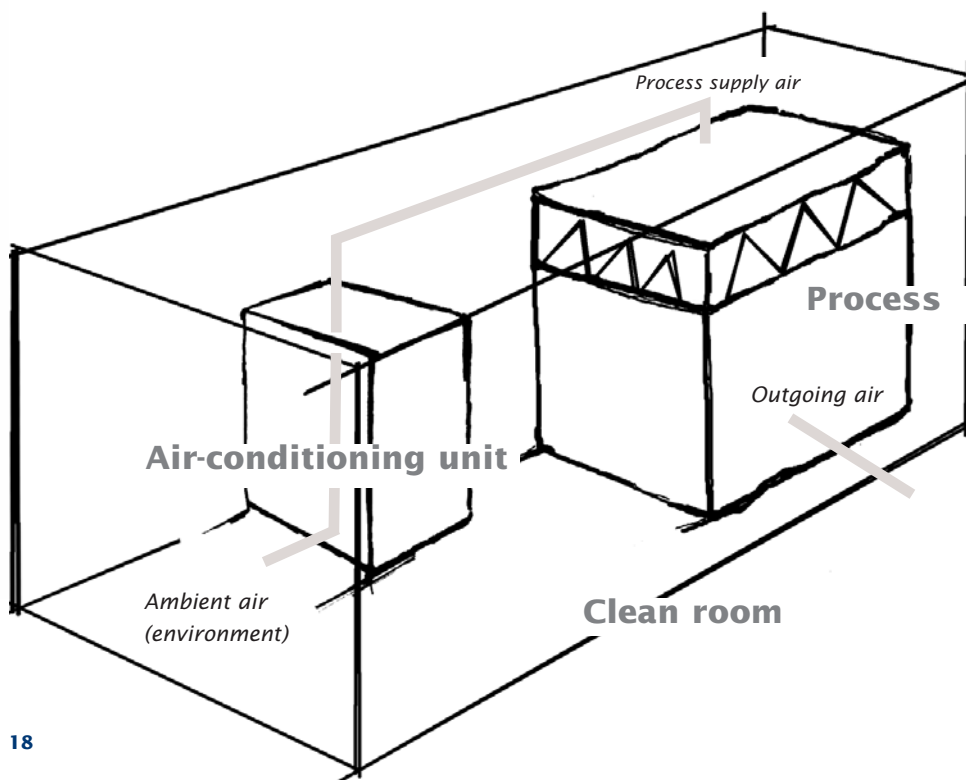
The main fields of use are in manufacturing processes where constant air-conditioning of a high consistency is needed within a process. An outstanding feature of the units is their high precision temperature and humidity control.

The units are fitted with a compact refrigeration system with water-cooled condensers (air-cooled condenser optional). Humidification is provided by process humidifying systems.

Benefits at a glance

- Plug and play
- Very high availability rates (up to 99.99%)
- Compact design
- Minimum floor space needed
- Insensitive to the power frequency
- Optionally also with reheat system
- Set-up possible in the clean room

Ideal for Precision Air-Conditioning



Design variant as process air-conditioning unit with unimpeded intake from the environment and unimpeded outflow from the process area

Weiss Precision Air-Conditioning Units

SIZE PRECISION AIR-CONDITIONING UNIT		10.3	20.3	40.3	60.3 X1	60.3 X2
NOMINAL VOLUME FLOW						
Volume flow with max. ext. pressure loss	m ³ /h	1,000	2,000	4,000	6,000	6,000
Max. external pressure loss*	Pa	700	540	500	400	400
* enhanced motor unit on request						
HOUSING DIMENSIONS						
Width	mm	1,090	1,355	1,355	1,605	1,605
Depth	mm	850	850	1,100	1,100	1,100
Height	mm	1,950	1,950	1,950	1,950	1,950
COOLING – COOLING CIRCUIT						
Cooling capacity (tc=50 °C) as per EUROVENT						
Suction temp. +24 °C/60% r.h. - total/sens. kW		10.2	21.8	40.3	44.5	60
HUMIDIFYING – STEAM GENERATOR						
Product type		resistance steam humidifier, accuracy +/- 2%				
Current consumption	A	8.7	11	26.2	32.3	32.3
Rated input	kW	6	7.5	18.1	22.3	22.3
Electrical connected load	kVA	6	7.6	18	22.3	22.3
Max. steam output	kg/h	8	10	24	30	30
HEATING – ELECTRIC HEATING						
Product type		plain tubular heaters, continuously controlled				
Max. heating capacity	kW	10.5	14	28	28	28
Current consumption	A	15.2	23	48	48	48
Electrical connected load	kVA	10.5	15.9	28	28	28
FAN MOTOR UNIT						
Product type		directly driven, free running, IP 54, Iso class F				
Nominal motor power	kW	1.15	1.15	3.2	3.2	3.2
Current consumption, max.	A	2.82	2.82	5	5	5
Electrical connected load	kVA	1.95	1.95	3.46	3.46	3.46
FILTER SUCTION SIDE						
Product type		cassette filter, class F7 as per DIN EN 779				
PLATE CONDENSER, WATER COOLED, INTERNAL*						
Water volume flow at T=27/32 °C	m ³ /h	3	5.8	6.4	6.4	6.4
Capacity	kW	17.5	30.7	58	58	58
Pressure loss on water side	kPa	10	13	35	35	35
* design with air-cooled condenser on request						
REHEAT AS HEAT EXCHANGER						
Max. heating capacity	kW	-	-	-	-	26
Control		-	-	-	-	on/off
STANDARD UNIT, COMPLETE						
Complete weight	kg	500	620	710	900	1,000
Supply voltage	V/Ph/Hz	400/3/50-60				
Electrical connected load	kVA	25.0	43.0	79.0	85.0	90.0

Competent, immediate information

We would be glad to advise you on:

- Air-conditioning units and components for clean room applications and experimental chambers
- Complete clean room systems
- Complete experimental chambers as per VDI/VDE 2627
- Clean room wall, ceiling, floor and illumination systems
- Protective systems/high containment/barrier systems
- Mobile clean room containers, cells, cabins and tents
- Clean workbenches and microbiological safety workbenches
- Barrier systems
- Filter fan modules
- Minienvironments
- Hot air sterilizers and tunnels
- Air showers
- Personnel and material barrier systems
- Qualification/validation
- Training

References

- 3D-MICROMAC
- ABB CALOR EMAG
- ACIBADEM
- ANTIBIOTICE
- APOSAN
- ASML
- ASTA MEDICA
- ASTRA ZENECA
- SANOFI-AVENTIS
- BASF
- BAYER
- BOSCH
- BRITA MANUFACTURING
- CARL ZEISS
- CELANESE CHEMICALS
- CONTI TEMIC
- CONVAC
- CURASAN
- DAIMLER CHRYSLER
- DEGUSSA
- DEMAG ERGOTECH
- DEUTSCHE THOMSON
- DR. KADE
- DR. THEISS
- DRK BLUTSPENDEDIENST
- E.ON RUHRGAS
- EPPENDORF POLYMERE
- EADS
- GRUENENTHAL
- HASSIA MINERALQUELLEN
- HEMOTEQ
- I.G. BAUERHIN
- KRAUSS MAFFEI
- MARUBENI
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