

SmartPower 25 – 400 t

Servo-hydraulic efficiency

world of innovation



EFFICIENT – PRECISE – VERSATILE

The smart basis for your success

The advantages

- » Highly compact servo-hydraulic injection molding machine with outstanding stability
- » High-precision injection units with extensive equipment options
- » Top efficiency with „Drive-on-Demand“ drive system as standard
- » Additional energy saving through patented KERS energy recovery system
- » User-friendly thanks to Unilog B8 control system with integrated assistance systems
- » Short mold changing time through ergonomically optimized clamping system
- » Conversion into a full production cell possible with WITTMANN auxiliaries and the Wittmann 4.0 “Plug & Produce” integration package
- » Attractive price/performance ratio

The machine series

SmartPower standard: 18 machine sizes with clamping forces ranging from 25 to 400 t

SmartPower Medical: for clean-room applications with clamping forces ranging from 25 to 400 t

SmartPower Combimould: for multi-component injection molding with clamping forces ranging from 60 to 400 t





SmartPower

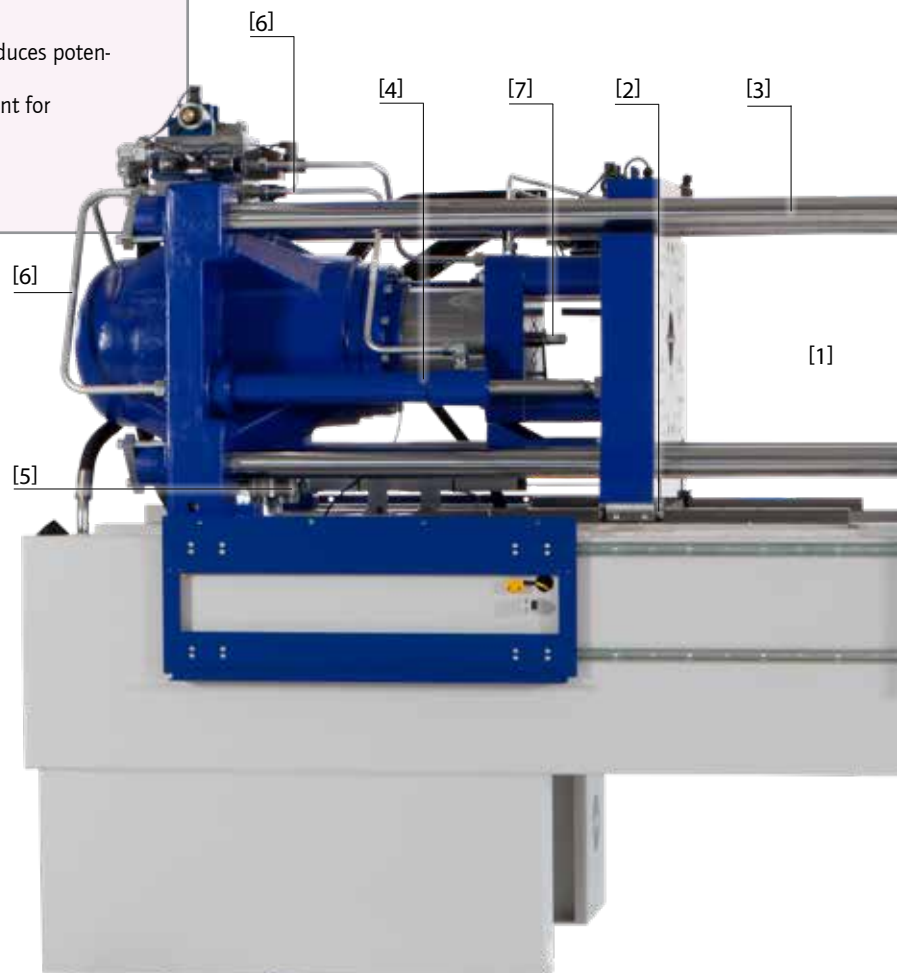
The system highlights

- » **Servo drive is standard for the hydraulic system ("Drive-on-Demand")**
All SmartPower machines are equipped with a combination of fast-responding servo motors with high-performance fixed displacement pumps as standard. The system benefits are extreme dynamism, high speed and precision of the machine movements and minimal energy consumption.
- » **Plasticizing unit – compact, maintenance-friendly**
All SmartPower plasticizing/injection units are pivotable and designed for easy access. This offers optimal conditions for quick access to the screw. Optionally a servo electric screwdrive is available.
- » **KERS – the optimal energy utilization system**
The patented KERS (Kinetic Energy Recovery System) for injection molding machines transforms the kinetic energy released by deceleration processes into electrical energy. The resulting electrical power is utilized within the machine, e. g. for barrel heating. KERS enables an additional energy consumption cut of up to 5%.
- » **Well-balanced clamping system protects the molds**
The 4-pillar clamping system, with force transmission via a central pressure pad and two diagonally positioned fast-stroke cylinders, ensures optimal force transmission into the mold and simultaneously a high level of mold protection.
- » **Sensitive mold protection**
Without coming into contact with the tie-bars, the moving platen is guided on linear guides and rotating roller bearings via a sturdy moving carriage with a high load capacity for heavy molds. The minimal rolling friction of the moving platen guide system offers ideal conditions for highly sensitive mold protection and cleanness.

CLAMPING UNIT

A perfectly balanced power pack

- » **Ample space for the mold and for symmetrical force distribution**
Generously dimensioned mold platens and a clamping system with perfect symmetrical force distribution provide an optimal environment for all kinds of injection molding tools, including all types of media connections. [1]
- » **Sensitive and precise**
Within the SmartPower clamping system, the exclusive task of the tie bars is force transmission between the external platens. Without tie bar contact, the moving platen travels on the linear bearings virtually free of friction [2]. In very few steps, the tie bars can be optionally retracted and reset. [3]
- » **Fast movements**
 - The moving platen is driven by two diagonally positioned travel cylinders. [4]
 - Combination of the travel cylinders with a hydraulic differential gear system enables quick movements.
 - The travel cylinders are dimensioned for high opening forces. [4]
- » **Compact design for minimal footprint**
The suction valve placed at the bottom of the pressure cylinder reduces the length of the clamping unit to a minimum. [5]
- » **Maintenance-friendly and easy to clean**
 - Ample use of rigid hydraulic tubes in lieu of hoses reduces potential maintenance requirements. [6]
 - Easy access to the ejector area and platen environment for machine setting [7]



INJECTION UNIT

Versatile precision

Wittmann

- » **Everything designed for series stability**
 - All screws > 25 mm come with a 22:1 L/D ratio.
 - Ultimate repeatability with an optional controlled servo valve
 - Momentum-free nozzle system thanks to axial positioning of the travel cylinders [8]
 - Plasticizing barrels can be fitted to different injection units with identical screw diameter
 - WITTMANN BATTENFELD HiQ software modules (optional) offer sensitive control strategies to compensate external factors such as temperature, moisture, regrind or masterbatch content variations.
- » **Optimal operability and flexibility**
 - Free access to the injection unit for easy material feeding, machine setting and servicing
 - All injection units up to size 3400 are pivotable (for quick screw replacement)



Anti-wear options

In addition to the premium-quality standard equipment, an extensive range of options is available to provide extra anti-wear and/or anti-corrosion protection. Predefined option packages and a selection matrix facilitate the selection of the right plasticizing unit.

DRIVE TECHNOLOGY

Energy efficiency with "Drive-on-Demand"



Fast-responding, precise, thrifty

"Drive-on-Demand" is the innovative combination of a fast-responding, speed-controlled, air-cooled servo motor with a fixed displacement pump. This drive unit is only activated when required by movements and pressure build-up. During cooling times or cycle pauses for parts handling, the servo drive remains switched off and thus consumes no energy. In operation, "Drive-on-Demand" is the basis for highly dynamic, controlled machine movements and short cycle times.

The "Drive-on-Demand" system is standard in the SmartPower machine series.

A brake on operating costs

- » The "Drive-on-Demand" system is standard equipment.
- » "Drive-on-Demand" lowers energy consumption by up to 35 per cent compared to modern variable displacement pump systems.
- » Additional energy cost cuts through reduction of idle power
- » Lower total expense for cooling, since oil cooling is normally not required
- » Lower maintenance expense through longer preservation of the oil quality due to less thermal load
- » Lower sound emission levels, consequently less investment in sound protection required
- » Easy retrofit of a second servo drive package for parallel movements [1]



INSIDER CONCEPT

"ex works" production cell

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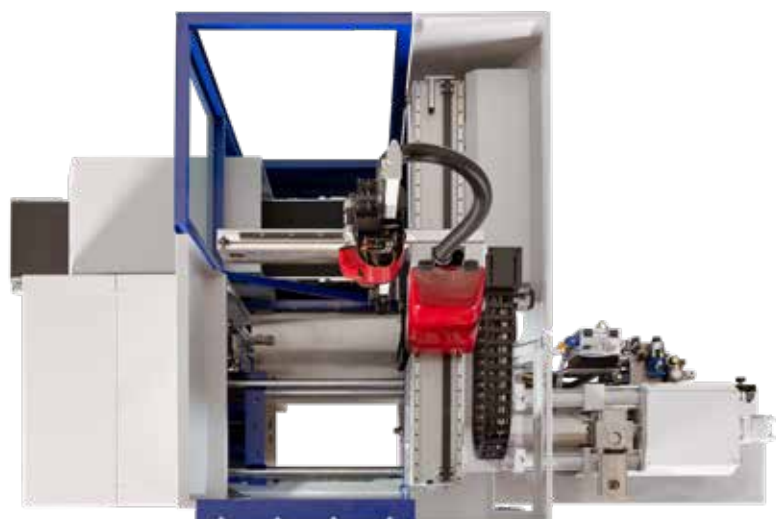
The insider concept is an ex-works solution to transform a SmartPower injection molding machine into a fully fledged production cell. In its basic version, the equipment cell integrates a parts handling system, a conveyor belt for parts transport and a protective housing firmly connected with the machine. Additional equipment modules for further processing, quality documentation and packaging are available as options. For the design and configuration of such higher automation levels, WITTMANN BATTENFELD places the combined expert knowledge of the entire group at its customers' disposal.

The advantages of insider automation

- » **Material flow systematization**
thanks to a uniform logistics interface for finished parts transfer at the end of the clamping unit, a prerequisite for positioning of several machines in rows
- » **Reduction of production space**
by up to 50 % compared to conventional automation solutions
- » **Minimization of robot cycle times**
through shorter travel paths and immediate parts depositing on conveyor belt
- » **Easy access in spite of integration**
to the mold and the robot thanks to mobility of the conveyor belt integrated in the protective housing
- » **Cost benefits,**
since safety features for all danger areas are already in place and certified ex works.
- » **CE mark included**
for every machine with an insider solution. No more costs for individual approval.



CE certified by type examination



UNILOG B8

Complex matters simplified

The Unilog B8 machine control system is the WITTMANN BATTENFELD solution to facilitate the operation of complex processes for human operators. For this purpose, the integrated industrial PC has been equipped with an enlarged intuitive touch screen operator terminal. The visualization screen is the interface to the new Windows® 10 IoT operating system, which offers extensive process control functions. Next to the pivotable monitor screen, a connected panel/handset is mounted on the machine's central console.



Unilog B8 Highlights

- » **Operating logic**
with a high degree of self-explanation, similar to modern communication devices
- » **2 major operating principles**
 - Operating/movement functions via tactile keys
 - Process functions on touch screen (access via RFID, key card or key ring)
- » **Process visualization**
via 21.5" touch screen display (full HD), pivoting laterally
- » **New screen functions**
 - Uniform layout for all WITTMANN appliances
 - Recognition of gestures (wiping and zooming by finger movements)
 - Container function – split screen for sub-functions and programs
- » **Status visualization**
uniform signaling system across the entire WITTMANN Group
 - Headline on the screen with colored status bars and pop-up menus
 - AmbiLED display on machine
- » **Operator assistance**
 - QuickSetup: process parameter setting assistant using an integrated material database and a simple query system to retrieve molded part data with machine settings pre-selection
 - Extensive help library integrated

The process in constant view

Wittmann

» SmartEdit

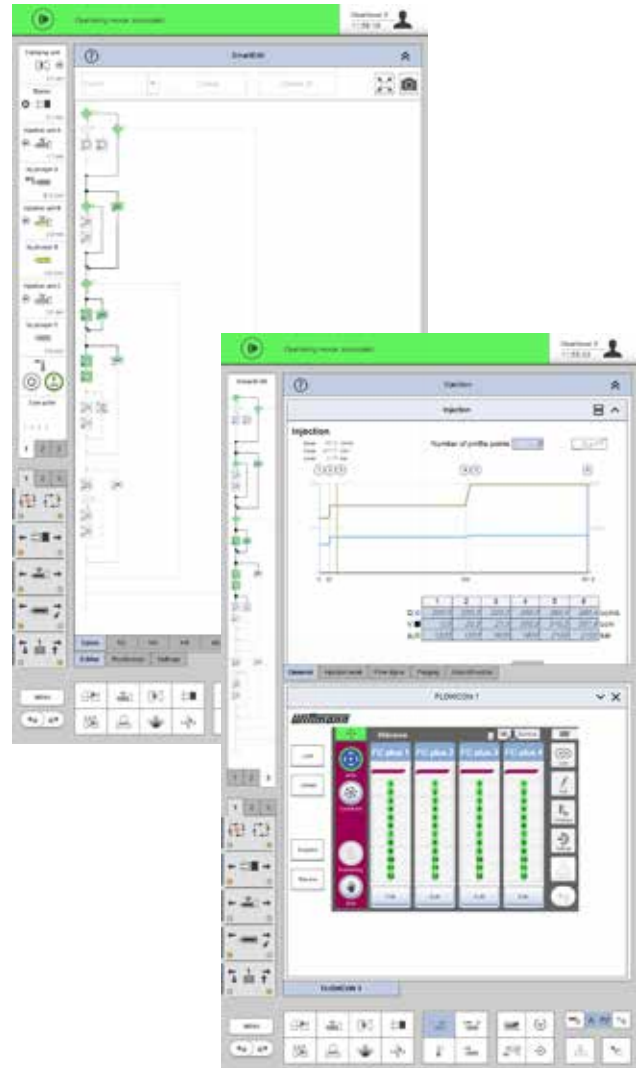
SmartEdit is a visual, icon-based cycle sequence programming facility, which enables direct addition of special functions (core pulls, air valves, etc.) based on a standard process via touch operation on the control system's monitor. In this way, a total user-defined sequence can be compiled from a sequence menu. This machine cycle, visualized either horizontally or vertically, can be adjusted simply and flexibly to the process requirements by finger touch with "drag & drop" movements.

The advantages

- Icon visualization ensures clarity.
- Clear events sequence through node diagram
- Alterations without consequences through "dry test runs"
- Theoretical process sequence can be quickly implemented in practice.
- Automatic calculation of the automation sequence based on the actual set-up data set without machine movements

» SmartScreen

- Partitioning of screen displays to visualize and operate two different functions simultaneously (e.g. machines and auxiliaries)
- Uniform design of the screen pages within the WITTMANN Group
- Max. 3 containers can be addressed simultaneously for the SmartScreen function.
- Adjustments of set values can be effected directly in the set value profile.



Remote communication

» QuickLook 4.0

Production status check via smartphone – simple and comfortable:

- Production data and statuses of all essential appliances in a production cell
- Complete overview of the most important production parameters
- Access to production data, error signals and user-defined data
- The production cell overview offers a clear, simple overview of the production cell's general condition and that of its individual Wittmann 4.0 appliances.

» Global online service network

- Web-Service 24/7: direct Internet connection to WITTMANN BATTENFELD service
- Web-Training: efficient staff training by means of the virtual training center

WITTMANN 4.0

Communication in and with production cells

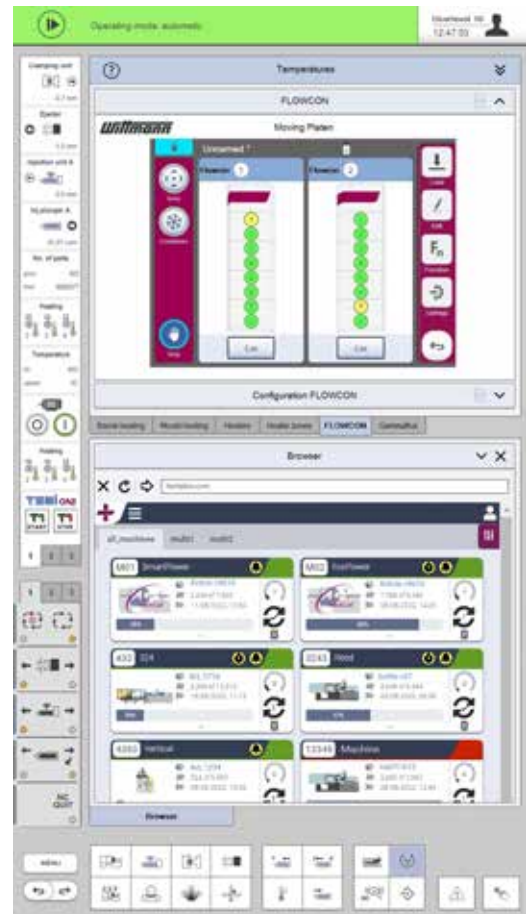
With its communication standard Wittmann 4.0, the WITTMANN Group offers a uniform data transfer platform between injection molding machines and auxiliary equipment from WITTMANN. In case of an appliance change, the corresponding visualizations and settings are loaded automatically via an update function, following the principle of "Plug & Produce".

Connection of auxiliaries via Wittmann 4.0

- » **WITTMANN Flowcon plus water flow regulator, Gravimax blenders and Aton dryers**
 - Units directly addressed and controlled via the machine's control system
 - Joint saving of data in the production cell, the machine and in the network via MES
- » **WITTMANN robots with R9 control system**
 - Operation of robots via the machine's monitor screen
 - High-speed communication between machine and robot to synchronize movements
 - Important machine movements can be set via the R9 robot control system
- » **WITTMANN Tempro plus D temperature controllers**
 - Setting and control of temperatures via the machine's control system possible
 - All functions can be operated either on the unit or via the machine's control system

Integration in MES system

The integration of machines and complete production cells in an MES system is a prerequisite for an efficient and transparent production facility according to the Industry 4.0 concept. Depending on customers' requirements, small and medium-sized companies as well as global players are offered a compact MES solution based on TEMI+. With the Windows® 10 IoT operating system it is also possible to have selected status information from all connected machines on the production floor shown under Smart-Monitoring on the display screen of every machine.



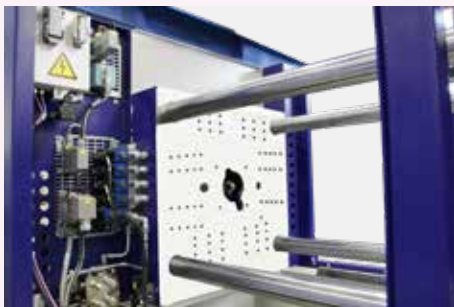
Wittmann 4.0 system

With Wittmann 4.0, a machine and its robots and auxiliaries are transformed into a uniform technical organism, which communicates externally via a specific IP address. Such a "Single point entry" with an integrated internal firewall substantially increases cyber security.

OPTIONS

Modular and flexible

Wittmann



SmartPower

The option highlights

- » **Parallel movements**
Additional pump modules for parallel movements
 - for ejectors and core pulls
 - for higher performance (fast injection)Building-up the nozzle contact pressure during mold closing
- » **Servo-electric plasticizing**
As an alternative to the standard screw rotation drive by a hydro motor, a direct drive with a servo motor is available as an option. It reduces energy consumption and offers additional functions for parallel operation of the clamping and plasticizing units.
- » **Fast mechanical mold change**
 - Quick mold clamping systems are available as an option, ranging from a manually operated bayonet mechanism up to a magnetic plate system.
 - Fast ejector coupling
- » **Fast media connection**
For the ergonomically positioned standard connection points for cooling water, air and core-pull hydraulics, fast coupling plates (individual and system plates) are available as options, as well as power plug systems for the hot-runner heating circuits, temperature and pressure sensors, and coding signals.
- » **WITTMANN auxiliaries**
The comprehensive range of WITTMANN auxiliary appliances offers the right solutions for all secondary processes of injection molding, including parts handling, material feeding and drying, sprue recycling and mold cooling. Via the optional Wittmann 4.0 integration package, all additional appliances can be integrated into the production cell according to the "Plug and Produce" principle.

APPLICATION TECHNOLOGY

Competence above standard



Photo: Greiner Bio-One GmbH

» Clean-room injection molding

Whenever medical components or electronic parts must be produced in an environment free of particles, the SmartPower concept with its easy-to-clean mold space provides a good starting position, which can be adapted to more stringent requirements by optional equipment modules.



Photo: Kunststoff-Institut Lüdenscheid

» Cellmould structured foam technology

The production of structured foam parts by targeted addition of pressurized nitrogen dioxide to the plastic melt prior to injection into the mold has been a core competence of WITTMANN BATTENFELD based on in-house R&D for more than 30 years.



» Airmould - gas injection

Airmould is the process for gas-assisted injection molding developed by WITTMANN BATTENFELD. Its two variants are the Airmould internal gas pressure process and the external gas pressure process Airmould Contour.



» Combimould

When two or more plastic materials in different colors or with different attributes must be combined into one part, the SmartPower machines can be equipped with additional injection units in V, L, S or HH configuration and rotary tables with servo drive.



- » **LIM – Liquid Injection Molding**
LIM designates the injection molding process to manufacture elastic parts from 2-component LSR (Liquid Silicon Rubber). For processing LSR products, WITTMANN BATTENFELD uses proven modular machines and automation concepts, as well as special plasticizing systems adapted to the viscosity of LSR.



- » **PIM (CIM/MIM) – Powder Injection Molding**
Powder injection molding (PIM) is a manufacturing process for series production of components made of metallic or ceramic materials. PIM is the ideal production process for making complex, functional components in large batches and with stringent demands placed on the materials.



Photo: Wittmann Powertrain Components GmbH & Co. KG

- » **Thermoset injection molding**
Thermoset materials, plastics which cross-link into irreversibly rigid networks when exposed to heat, are experiencing a comeback in a growing area of application thanks to latest material developments. WITTMANN BATTENFELD offers the appropriate equipment packages, which can also be combined with SmartPower machines.

TECHNICAL DATA SmartPower



COMBINATIONS OF CLAMPING UNITS/INJECTION UNITS										
Clamping unit	Injection unit									
t	60	130	210	350	525	750	1000	1330	2250	3400
25	•	•	•							
35	•	•	•							
50	•	•	•	•						
60	•	•	•	•						
80	•	•	•	•	•					
90	•	•	•	•	•					
110		•	•	•	•	•				
120		•	•	•	•	•				
XL 120		•	•	•	•	•				
160					•	•	•	•		
180					•	•	•	•		
XL 180					•	•	•	•		
210						•	•	•		
240						•	•	•		
XL 240						•	•	•	•	
300						•	•	•	•	•
350						•	•	•	•	•
400						•	•	•	•	•

Material	Factor
ABS	0.88
CA	1.02
CAB	0.97
PA	0.91
PC	0.97
PE	0.71
PMMA	0.94
POM	1.15
PP	0.73

The maximum shotweights (g) are calculated by multiplying the theoretical shot volume (cm³) by the above factor.

Material	Factor
PP + 20 % Talc	0.85
PP + 40 % Talc	0.98
PP + 20 % GF	0.85
PS	0.91
PVC hard	1.12
PVC soft	1.02
SAN	0.88
SB	0.88
PF	1.3
UP	1.6

Dark grey boxes = thermosets

STANDARD

Base machine

Drop - voltage 230/400 V/3p+N-TN/TT, 50 Hz
Painting RAL 7047 tele grey 4 / RAL 5002 ultramarine blue
Air cooling system for drive unit, water cooling for feeding zone and oil cooler with solenoid valve
One-piece base frame with 3 disposal directions
Ejection area - coverage of ejection area according to EN201
Test-run with hydraulic oil HLP32 zinc free according to DIN 51524 T2 / purity level 17/15/12 according to ISO 4406 (Attention: oils is not included in delivery), lubricants according to H2-quality
Printed operating manual incl. user manual on USB flash drive in any EU language acc. to definition of country incl. type examination certificate TÜV Austria in German incl. protocol: electrical safety acc. to EN 60204-1
Injection moulding machine according to machinery directive 2006/42/EG incl. declaration of conformity and CE-marking

Hydraulics

Drive unit S0 with speed controlled servo motor for hydraulic pump to increase the energy efficiency
Hydraulics with oil cooler controlled in water inlet of cooling, oil level
Monitoring, oil filtration with electrical clogging indicator
Oil preheating of hydraulic drive

Clamping unit

Clamping force and closing and opening forces adjustable
Mold safety program
Moving platen supported by positioned linear guides
Mold platen according to EUROMAP 2, clamping surface metallic bright, rest painted
Fixing holes for robot on fixed platen as per EUROMAP 18
Hydraulic multi stroke ejector
Clamping cylinder plunger induction hardened & hard chrome-plated, ejector piston hard chrome-plated, position sensor with linear potentiometer

Injection unit

Hydraulic screw drive
Injection axis/nozzle carriage - injection, holding and back pressure controlled with defined nozzle carriage pressure
Plasticizing unit: screw in nitrated steel & barrel in AK+ for processing thermoplastics, w/o grooves, standard nozzle head, 3 zone universal screw, quick acting check valve (3 parts), heater bands up to 350 °C w/o insul.
Thermocouple failure monitor
Maximum temperature supervision
Plug-in ceramic heater bands
Temperature control of feed throat integrated
Swivelling injection unit
Injection cylinder piston rod hard chrome-plated and linear guides in standard design, position sensor with linear potentiometer
Selectable barrel stand-by temperature
Decompression before and/or after metering
Physical units - bar, ccm, mm/s etc.
Screw protection
Auxiliary screw speed indication
Linear interpolation of holding pressure set values
Bar chart for barrel temperature with set value and actual value display
Selectable injection pressure limitation
Changeover from injection to holding pressure depending on stroke, time and pressure
Open nozzle R35
Splash guard and barrel covering in standard execution according to EN 201, L/D 22 protected via limit switch
Material hopper 6 litres (MH206) for automatical material feed, sliding device with shut-off function for material with sliding guide

Safety gate

Covering injection side - maintenance door screwed together
Safety gate in standard execution, acrylic glass light-blue 309 / frame RAL 5002
Safety gate at operator and non-operator side manually operated

Electrics

Control zone for nozzle heater band 230 V
AmbiLED-status indicator
Fuse protection for sockets
Switch cabinet cooling - circulation fan for environment temp. to 30 °C
Emergency stop switch button
Printer socket
USB - 1 x operating unit
1 Ethernet interface (switch cabinet)
Printer via USB connection or network

Control system

Control system Unilog B8 - 21,5" multi-touch screen (full HD)
Control panel with selectable haptic keys
Software for operating hours counter
Closing/Opening - 5 profile steps
Ejection forward/back - 3 profile steps
Nozzle forward/back - 3 profile steps
Injection/Holding pressure - 10 profile steps
Screw speed/Back pressure - 6 profile steps
Parts counter with good/bad part evaluation
Purging program through open mold
Stroke zero offset settings
Start-up program
Switchover to holding pressure MASTER/SLAVE by injection time, screw stroke/injection volume and injection pressure
Self-teaching temperature controller
Display of temperature inside electrical cabinet
Seven-day timer
Access authorization via USB interface, password system and RFID authorization system (1 x check card IT-level-15, 1 x token customer level-30 and 1 x token customer service level-20 are included in delivery)
Freely configurable status bar
Physical, process-related units
Automatic dimming
Logbook with filter function
User programming system (APS)
Userpage
Note pad function
Cycle time analysis
Hardcopy function
Internal data storage via USB connection or network
Online language selection
Online selection of imperial or metric units
Time monitoring
Basic Quality Monitoring (1 freely configurable network connection, quality table with 1000 storage depth, events protocol (logbook) for 1000 events, actual value graphics with 5 curves, 1 envelope curves monitoring)
Injection integral supervision
Metering integral supervision
Alarm message via e-mail
SmartEdit - sequence editor
QuickSetup - assistance program for initial parameter setting
Energy consumption monitoring for motors and heating

Base machine

Regional packages, country-specific
 Drop 1, special voltage, drop 2
 Handling package with open machine safety gate on non operator side
 Parts hopper
 Parts chute for separation of good/bad parts or photoelectric ejection check

Hydraulics/Pneumatics

Drive unit with speed controlled servo motor for hydraulic pump incl. additional pump for core pull movement, parallel ejection and fast injection
 Drive unit with speed controlled servo motor for hydraulic pump incl. additional pump for core pull movement, parallel ejection and fast injection via hydraulic accumulator parallel to clamp force build-up
 Hydraulics with increased oil cooler
 Raw filter in water inlet of cooling incl. adapter with ball valve for oil maintenance on oil tank
 Hydraulic core pull for clamping plate, interface according to EUROMAP 13, incl. or without core pull pressure release
 Pneum. core pull on clamping plate/nozzle plate, incl. pressure regulator
 Hydraulic manifolds for one mold shut-off nozzle or more
 Air valves on nozzle plate/clamping plate
 Compressed air pressure maintenance unit incl. 1 or more way pressure regulation incl. directional exhaust valve with blocking function

Clamping unit

Mold platen according to SPI, JIS, T-slots
 Mold platen incl. cooling channels
 Mold platen chemically nickel-plated
 Manuel tie-bar retract device
 Hydraulic ejector in reinforced execution
 Unscrewing device in lieu of ejector
 Double check valve to keep ejector in end-position
 Ejector cross according to EUROMAP/SPI
 Mechanical or pneumatic ejector coupling
 Ejector platen safety
 Mechanical mold safety mechanism

Injection unit

High torque hydraulic screw drive/High revolution hydraulic screw drive
 Screw drive by servo motor for parallel recovery
 Injection, holding and back pressure controlled via servo valve
 Injection active closed loop, holding and back pressure controlled via servo valve
 Check valve to hold screw in position after end of dosing
 Corrosion resistance injection unit
 Plasticizing unit AK+ in wear and corrosion resistant execution
 Plasticizing unit AK++ in high wear and corrosion resistant execution
 Plasticizing unit AKCN in wear and corrosion resistant execution, for processing PMMA and ABS and PC
 Grooves in the feeding zone
 Barrier section, screw with mixing section
 Ball type screw tip
 Melt pressure transducer, melt temperature sensor
 Heater bands up to 450 °C
 Plasticizing unit in special execution for LIM, MIM, CIM, thermoset, PVC
 Barrel insulation
 Open nozzles in special execution
 Needle type shut-off nozzle operated with spring, pneumatically or hydraulically
 Barrel covering and splash guard in special execution
 Vacuum package incl. vacuum pump
 Material hopper in special execution
 Hopper magnet

Safety gate

Safety gate clamping side, rear side and/or operator side elevated, lowered or extended
 Insider package WITTMANN rear side incl. conveyor belt
 Safety gate clamping side electrically operated
 Front side gate safety system for manual part removal incl. clearance of ejector

Cooling and conditioning

Cooling water distributor with/without blow-off valve
 Solenoid valve for cooling water distributor
 Machine cooling by T-piece in inlet pipe
 Filter back flushable/water pressure supervision in inlet pipe
 Distributor block on nozzle plate/clamping plate

Electrics

Temperature control zones for hot runner
 Acoustic element integrated in signal lamp
 Socket combination
 Additional fan in electric switch cabinet for increased environment temperature
 Cabinet air conditioner
 Additional emergency stop switch button
 Interface for robot, conveyor belt, TCU, dosing unit, Airmould, mold surveillance, production data logging system, RJG eDart, Priamus BlueLine, danger zone boundary, ejection in mold middle plate, brushing device, relay signals

Control system

Cavity pressure switchover
 BNC sockets for injection process analysis
 Expert Quality Monitoring (4 freely configurable network connections, quality table with 10000 storage depth, events protocol (logbook) for 10000 events, actual value graphic with 16 curves, 4 envelope curves monitoring, SPC charts, trend diagrams)
 Mold identification
 Special programs on customer request
 HiQ Cushion - melt cushion control
 HiQ Flow - injection integral control
 HiQ Melt - monitoring of material quality
 Software Tandemmould, multiple data sets
 Energy consumption analysis
 Clamp force supervision
 Injection compression and venting program
 Initiation of next cycle by closing safety gate
 Special program ejector intermediate stop/ejection of cold slug
 Additional output card/input card, freely programmable
 Integration package Wittmann 4.0
 CMS Basic

Additional equipment

Plinth for robot
 Tool kit
 Levelling pads
 Lighting in mold space
 Mold clamping systems in mechanical, electrical or hydraulic execution
 Integration package (robot, feeder, dosing unit, TCU, mold integration)
 WITTMANN BATTENFELD web service during warranty period free of charge
 Remote control package

The Wittmann logo is displayed in a stylized, italicized font within a magenta-colored parallelogram shape.

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