



Unscrambling
Positioning
Filling Capping
Elevating
Transferring
Aerosol Technology
Depalletizers
Punching and Wadding
Special Machinery





Hello! Welcome!

A warm and friendly „Hello, how are you?“ welcomes all our customers, guests, and visitors to our store. We are located in Northern Germany in the beautiful town of Lohne.



You can find us only a few minutes off the Autobahn A1 logistically an ideal location. It is here where highly motivated and qualified employees design and manufacture innovative machines that unscramble bottles and caps, and construct complete lines that sort, align, fill, and cap bottles for renowned companies in the beverage and cosmetic industry. This is why TÖLKE Special Machinery can be found all over the world.

Success and growth require space.

After the old production facility outgrew its size, in 2004 TÖLKE built a new corporate office with adjacent production halls on an area measuring 8,000 m². In 2011, however, the production facilities had to be expanded. Our motto is „Everything from a single source.“ This removes our dependency on suppliers and provides us with the opportunity to be flexible and to respond quickly to any demands.

Look and find out for yourself.





Efficiency results from experience.

Many family businesses started the same way – someone had the courage and the idea to create something onto which following generations connected to and build upon.

Franz Tölke was this someone who in 1965 founded the limited partnership by the same name in the town of Lohne, Germany. At the time, the team consisted of 15 employees, building mainly machines for the beverage industry. In particular, cork capping machines for sparkling wine producers such as HENKELL and KUPFERBERG were built. Capping machines for distiller ASBACH in Rüdeseim, Germany were also built.



After the early death of Franz Tölke in June of 1967, his son Franz-Josef Tölke succeeded him. In addition to the capping machines that were already produced very successfully, unscrambling machines for lids and containers for the cosmetic industry followed. Franz-Josef Tölke managed the company for 34 years, increasing its staff to a total of 45 employees, until his early and unexpected death in February 2001.

Since then, Franz-Josef Patzelt, Christian Tölke, and Hubert Kröger guide and manage the company that now employs more than 100 highly qualified men and women.

Wow! TÖLKE.

For about 50 years, we have used a very elementary principle and turned it into innovative and reliable machines for the packaging industry.

Actually, placing a few bottles in their upright position is not a big challenge. However, unscrambling up to 800 bottles per minute, and automatically placing them in their correct position for filling, printing, and labelling that is a challenge! Nevertheless, for us, this is only one of many „magics“ that our designers, developers, and engineers can do.

It is precisely that know-how of more than 100 qualified employees that elevated FRANZ TÖLKE GmbH to one of the most renowned companies in Germany when it comes to the manufacture of special machinery.



Tölke turns everything upside down. But with precision!

No matter how you look at it, one thing is certain: When employing the TÖLKE bottle unscrambler, up to 800 bottles per minute are always in their precise location!



Bottle unscrambler

TÖLKE bottle unscramblers are used for feeding the bottles correctly to filling machines, printing machines, labelling machines, etc. The bottles are transferred either free-standing onto a conveyor belt or into pucks.

By using partitions on several levels (feeding, pre-orientating, sensing, orientating, discharging), the functions are simplified. Mechanical or optical scanning makes the sensing function very reliable routine.

Hoppers with a capacity of up to 30,000 liters can be used to store bottles. The hoppers are installed upstream of the bottle unscramblers.

Bottle unscramblers can be manufactured in different sizes (\varnothing 1,000 - 2,600 mm), depending on the output requirement, size, and shape of the parts to be supplied.

By combining the bottle unscrambler with a bottle orienting unit, asymmetric, printed, or labelled bottles can be oriented properly. If needed, the bottles can be inserted accurately into labelling pucks.

TÖLKE bottle unscramblers have an output capacity of up to 800 bottles per minute. A wide range of articles can be handled, from 5 mL to 6,000 mL.

In addition to the very careful handling of the bottles, our bottle unscramblers can be refitted easily to other individual bottle sizes.

Simple and fast format changes are possible without the use of tools and allow setting up bottles of various shapes and sizes.

800 bottles per minute



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By using a uniform and high-capacity machine, sensing and turning the bottle in a concerted manner guarantee a reliable sorting of the articles. The products can be discharged either with their bottleneck pointing up or down. Furthermore, in addition to the existing conveyor belt system, different puck systems can be integrated.

When compared with other machines, our bottle unscramblers operate at a very low noise level and can be utilised in different branches of industries.

Output overview:

- » Capacity up to 800 bottles per minute
- » A large variety of articles (5 mL to 6,000 mL)
- » Careful handling of the bottles
- » Simple refitting to other bottle sizes
- » Changing the format parts without tools
- » Optional automatic format converter
- » Constantly high rate of occupied pockets
- » Safe unscrambling through sensing and concerted turning of the bottles
- » Discharging the articles with bottleneck pointing up or down
- » Existing conveyor belt systems / integratable puck systems
- » Low noise level
- » Different types of pucks are available

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„A tidy house, a tidy mind“

Right on! TÖLKE cap sorters make it possible to properly position up to 2,000 caps, lids, etc. Respectable, isn't it?



Cap sorter

TÖLKE cap sorters are suitable for separating, orienting, aligning, and feeding caps, lids, or other smaller parts. They are used for feeding the components correctly to the capping machine, printing machine, optic controls, etc.

A belt or an air conveyor transports the caps. Our cap sorters can be equipped with an automatic height adjustment, which can be coupled with other machines. Depending on the output requirements, cap sorters can be manufactured in different sizes (Ø 500 - Ø 2,600 mm).

The change parts are located on pegs so that a format change can be made within the shortest time without using any tools. The contour of the caps is reproduced in the format parts. This makes an exact location possible.

An additional application area for our sorters is the supply and alignment of pumps and spray nozzles.

The output capacity of our machines includes feeding up to 2,000 caps per minute correctly into the capping machine. TÖLKE cap sorters are extremely user-friendly. Due to their very low overall height, the quick change of formats without any tools and no subsequent adjustments, quick conversion of the machine is possible.

The caps are treated very carefully and are not subject to mechanical forces. Sorting of different cap formats partly without changing parts. Additional controls can be integrated.

If needed, hoppers with a capacity of up to 5,000 litres can be used. The hoppers are installed upstream of the cap sorters.

Sorting 2.000 caps per minute



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If needed, hoppers with a capacity of up to 5,000 litres can be used. The hoppers are installed upstream of the cap sorters.



Output overview:

- » Output up to 2,000 caps / minute
- » User-friendly and easy to change to other formats due to a low overall height (upper edge discharge conveyor = upper edge cap sorter)
- » Quick change of formats without tools
- » No adjustment necessary after format change
- » Caps are not subject to pressure due to mechanical forces
- » Sorting of different cap formats partly without changing parts
- » Additional controls can be integrated
- » Hoppers with a capacity of up to 5,000 litres for storing the articles can be added upstream of the sorter

„TÖLKE offers me a modern work-
place, an open and comfortable busi-
ness atmosphere where decisions are
made without red tape. It really is fun
to work here!“

Florian Soika, Metal Cutting Mechanic
working for TÖLKE since 2011

Did you spring a leak? What a silly question!

Of course, all types of caps and lids closed with TÖLKE cappers are 100% leak-tight; regardless whether they were pressed on or screwed on.



Capper

TÖLKE cappers are suitable for capping a great variety of containers. The standard equipment includes continuously running cappers (Type ROTARY) as well as intermittently working cappers (Type UNI). The necessary type is chosen according to the requirements and the specification profile of the machine. If several different caps (e.g. plugs + cap or pump + cap or others) are to be placed onto one container this process can be combined.

When using the model with servo drives for the capping heads, the operator panel is used to adjust different parameters of the capping machines.

It is also possible to store set values in an administration data file and to choose these values together with the format selection. By combining the capper with a TÖLKE cap sorter, the required caps can be provided in sufficient quantity and supplied in the correct orientation for the capping process.

TÖLKE cappers have an output up to 500 bottles per minute. The packaging cycle for each bottle is only 0.12 seconds.

A wide spectrum of bottles can be handled, which includes bottles in sizes from 5 mL to 6,000 mL. Our machines are suitable for press-on and screw-on caps and lids of all types, including other safety caps. The products are capped via torque or angle. A central drive with couplings or a servo drive is used to power the capping heads.

0.12 sec processing cycle for each bottle

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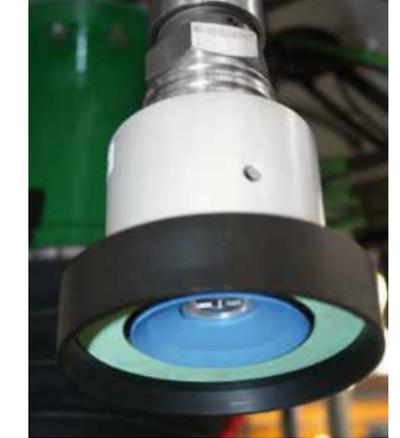


A quick change without the use of any tools makes it possible to transfer easily to other individual bottle sizes.

In addition to the existing belt conveyor, a puck system as well as additional alignment of the caps can be integrated.

Your products are not subject to unnecessary loads. The integration of electrical and mechanical cap sorters allows for the precise inspections and the removal of filled and capped bottles that proved to be flawed.

Furthermore, the motor-driven height adjustment makes a conversion simple and saves time.



Output overview:

- » Output up to 500 containers / minute
- » A wide range of containers can be processed (e.g. bottles from 5 mL to 6,000 mL)
- » Suitable for press-on and screw-on caps and lids of all types (including other safety caps)
- » Capping via torque or angle
- » A central drive with couplings or a servo drive is used to power the capping heads
- » Simple refitting to other bottle sizes
- » Changing the format parts without tools
- » Cap orientation can be integrated
- » Existing conveyor belt systems / integratable puck systems
- » Cap and/or bottle are not subject to unnecessary loads
- » Electric and mechanical integration of the cap sorter
- » Inspecting and discharging capped or filled bottles found to be flawed
- » Quick conversion due to motor-powered height adjustment
- » The operator panel can be used to adjust all parameters for the capping heads (speed, torque, rotational angle, head position when mounting the cap, turning counterclockwise)

Only what's inside counts!

Very well then! What's outside counts, too. Because TÖLKE filling machines let you fill 5 mL to 6,000 mL bottles – and that 350 times per minute!



TÖLKE filling machines have a capacity of up to 350 bottles per minute and are suitable for a filling quantity of 5 mL to 6,000 mL.

A variety of devices such as mass-flow measurement devices (MDM) and inductive measurement devices (IDM), the metering piston, or load cells are used to meter the filling process. By using a panel to enter the values into the above-mentioned metering types, the values can be infinitely adjusted.

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350 bottles per minute

Filling machines

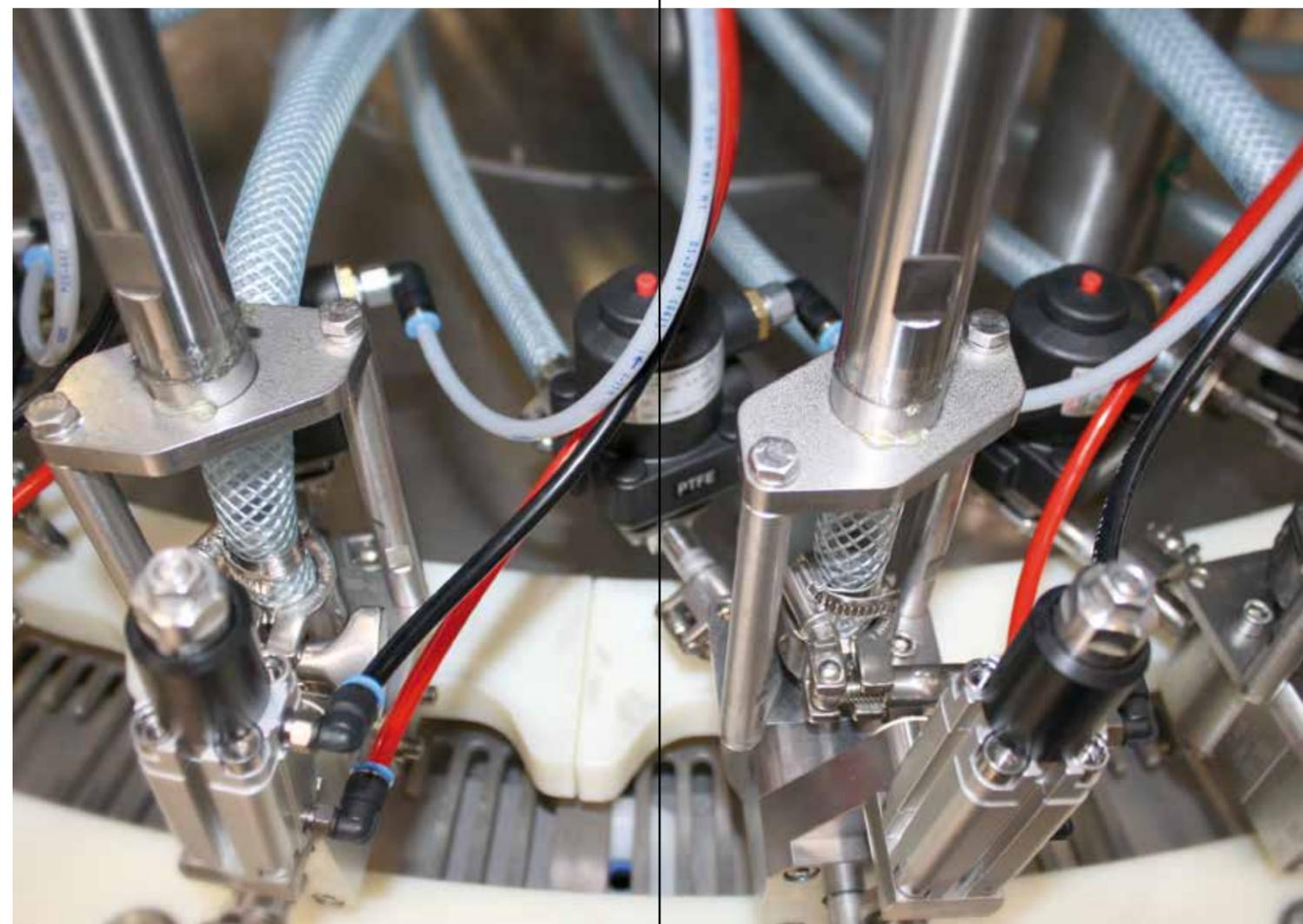
TÖLKE filling machines are perfectly suited for filling different containers with fluids and solids. Our range of standard filling machines includes linear or rotary models. The necessary type will be chosen according to the requirements and the specification profile of the machine. The rotary model also offers a combination with one or several of the following functions:

- » Inserting plugs
- » Screw-on caps, push-on caps or pumps
- » Orienting of bottles/caps
- » Turning/placing the bottle upside down

By using the mass-flow measuring technique, a high filling accuracy is achieved.

In comparison with inductive measuring devices, they are independent of any product conductivity in the filling. Because of this, the filling machines can be used for filling oils or liquids, i.e. products without a homogeneous distribution of conductive parts. During the mass-flow measurement, the filling quantities are adjusted infinitely by entering the values from a panel. The filling product flows through a measuring tube. Other add-ons are not necessary. This has the following results:

- » product is subject to minimum loads
- » better cleaning options
- » less wear parts
- » simple adjustment of filling quantities
- » large filling areas



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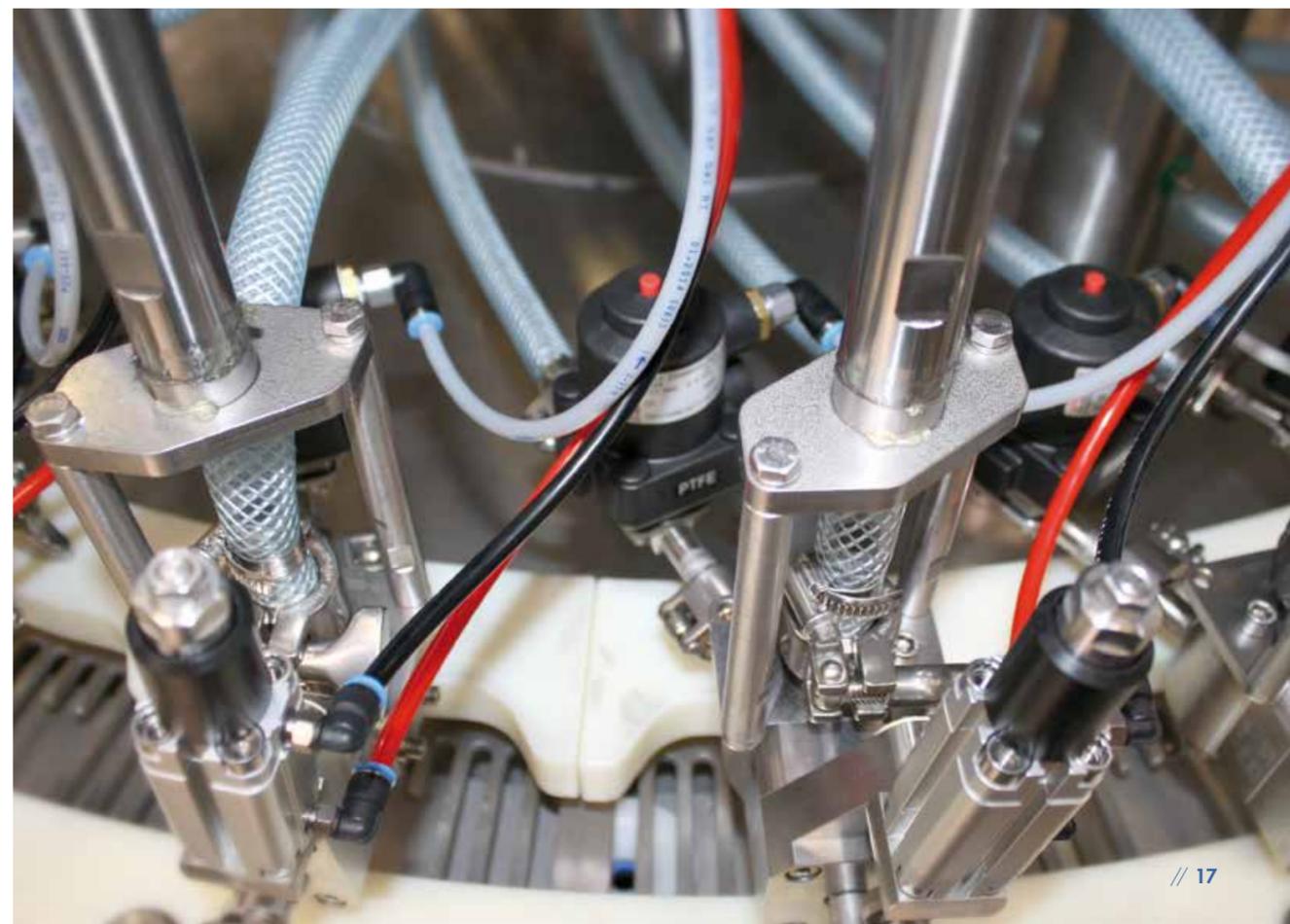


Available conveyor systems or puck systems can be integrated. CIP (Clean In Place) and SIP (Steam In Place) systems can be integrated.

The filling machine can be operated without or with different types of pucks. This results in a high flexibility for a variety of formats.

Output overview:

- » Capacity up to 350 bottles per minute
- » Suitable for filling quantities of 5 mL to 6,000 mL
- » Metering with the use of
 - Mass-flow measurement devices (MDM)
 - Inductive measurement devices (IDM)
 - Metering pistons
 - Load cells
- » Smooth adjustment by entering the relevant values in a panel
- » Simple refitting to other bottle sizes
- » Changing the format parts without tools
- » Existing conveyor belt systems / integratable puck systems
- » CIP (Clean In Place) & SIP (Steam In Place) systems can be integrated
- » Low noise level
- » To be used without or with different types of pucks



„You might say I am part of the furniture, but I'm not put on the shelf yet. At TÖLKE, our younger members benefit from the expertise that our senior staff shares with them. However, this is not a one-way street, we learn from our youngsters when it comes to the latest technological developments!“

Günter Tölke, Installation Department
joined TÖLKE in 1966



**I have never
been elevated
that fast!**

It deserves the highest recognition if TÖLKE elevators can supply up to 800 bottles and 2,000 caps per minute!



Elevators

Elevators made by TÖLKE are suitable for storing and feeding different kinds of bulk material.

They are used for storing caps, lids, or other small parts. These bulk materials are delivered to the machinery down the line, such as punching and wadding machines, cap sorters, bottle unscramblers, and capping machines. During this process, the products are lifted from a hopper and delivered from the top to the downstream machine.

Depending on the output requirements, storing time, size, and shape of the products, the elevators are designed in various sizes.

Based on the modular structure of the elevator and the elevator beam, the transfer position of the parts can be adapted according to the requirements.

TÖLKE elevators can store and supply up to 2,000 caps and 800 bottles per minute.

The processing cycle for each cap is only 0.03 seconds.

Hoppers from 50 liters to 30,000 liters can be used for storing the bulk material. No pressure is exerted onto the bottles/caps through mechanical forces. A revisional operation for emptying residual bulk material is optional.

The noise level of the machine is very low when compared with similar equipment. Furthermore, the infeed level is very low and changing format parts is not necessary for different materials.

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Output overview:

- » Output up to 2,000 caps per minute and 800 bottles per minute
- » Hoppers from 50 liters to 30,000 liters can be used for storing bulk material
- » No pressure exerted onto the bottles/caps through mechanical forces
- » Possibility of revisional operation for emptying residual bulk material
- » Low noise level
- » No change of format parts for different bulk materials
- » Low infeed level



Take me!
Take me!

In, out, turn left, turn right, and even upside down; imagine this up to 800 times per minute. TÖLKE transfer units know how to treat a bottle!



Transfer units

TÖLKE transfer units are suitable for lifting bottles out of pucks and inserting them into pucks. Containers can be transferred onto a conveyor or taken from a conveyor while standing on the conveyor without any support. In addition, the transfer unit can orient the container in a certain direction or put the container upside down (for upside-down bottles).

Furthermore, the containers can be encoded (using inkjet, laser, or others). If the transfer unit is equipped with a worm gear, there is an option to combine the first puck cycle with empty pucks and a second puck cycle during which only filled pucks must be delivered. TÖLKE transfer units can be manufactured in different sizes, depending on the required

capacity, size, and shape of the parts to be handled. By combining the transfer unit with a bottle unscrambler, the containers can be set directly into perfectly fitting pucks.

We offer complete solutions, therefore, TÖLKE is able to supply different kinds of pucks for a variety of containers. Based on the demand, different production methods are used to make the pucks (injection moulding, casting, metal cutting, or others). Functions such as labelling freestanding bottles, securing round containers in order to attach screw caps, etc., are possible.



800
bottles
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TÖLKE transfer units can lift 800 bottles per minute, insert them into pucks, align them, or place them upside down.



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TÖLKE transfer units can lift 800 bottles per minute, insert them into pucks, align them, or place them upside down.

The range of container size can vary from 5 mL up to 6,000 mL. Careful handling of compartments is assured and changing to other bottle sizes is very simple. Changing the format parts is done without the use of any tools. Bottles can be discharged with the opening facing up or down, whether they are inside the pucks or free-standing. Existing belt and puck systems are easy to integrate.



Output overview:

- » Capacity up to 800 bottles per minute
- » A large variety of articles (5 mL to 6,000 mL)
- » Careful handling of the bottles
- » Simple refitting to other bottle sizes
- » Changing the format parts without tools
- » Discharging the articles with bottleneck pointing up or down
- » Bottle discharge either inside a puck or freestanding
- » Existing conveyor belt systems / integratable puck systems
- » Low noise level
- » Different puck types can be used

„It all starts with a few digital strokes, well, more or less. And after the design is done, which is always based on teamwork, looking at the machine in operation is a reason to be a little proud of!“

Michael Mählmann, Engineering Department
joined TÖLKE in 2007

I can work under pressure!

Even though aerosol cans are constantly under pressure, TÖLKE systems have no problem to align, to accumulate, and to apply spray and foam heads, and caps!



Aerosol technology

TÖLKE offers the following solutions in the field of aerosol technology:

- » Aligning /accumulating aerosol cans
- » Filling the active ingredients, including process technology, Product containers, pumps, etc.
- » Placing the valves, including storing and supplying the valves
- » Applying spray nozzles/foam heads/caps including storing in hoppers and supplying the caps

The design of the systems can be customer-specific and, therefore, can be optimised and adapted to meet installation-related requirements. Depending on the output requirements, lead-time, form, and shape of the product, our systems are designed in a variety of sizes. For all components, an ATEX certificate can be issued. This ensures that an application in an explosion-hazardous environment is possible.

TÖLKE aerosol machines are capable of processing 400 bottles/cans per minute. Converting to different bottle sizes is simple, and changing format parts does not require any tools. As an option, our aerosol machines are available with an automatic format changeover function.

Many machines have been proven and tested; thus, the correct supply of components is guaranteed.

Processing cycle per can: 0.15 sec



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Output overview:

- » Output up to 2,000 caps per minute and 400 cans per minute
- » A wide range of articles is available (cans Ø 10 - 200 mm)
- » Easy to change over to other products
- » Changing the format parts without tools
- » Integration of existing conveyor systems
- » Careful product handling
- » Integration of additional inspection functions and reject procedure of flawed products feasible
- » Power-operated height adjustment optional
- » Adaptable to the individual customer's needs



TÖLKE cleans up!

Literally, fully automatic. Careful, fast, and precise this is how TÖLKE depalletizes cans, glass jars, glass bottles, plastic bottles, lids, etc.



Depalletizer

TÖLKE depalletizers are suitable for automated clearing of aligned packaged goods received. Depalletizing glass jars, cans, glass bottles, plastic bottles, caps, etc., are typical applications. The systems are designed in accordance with the customer's specifications and, therefore, their installation-related requirements can be optimised.

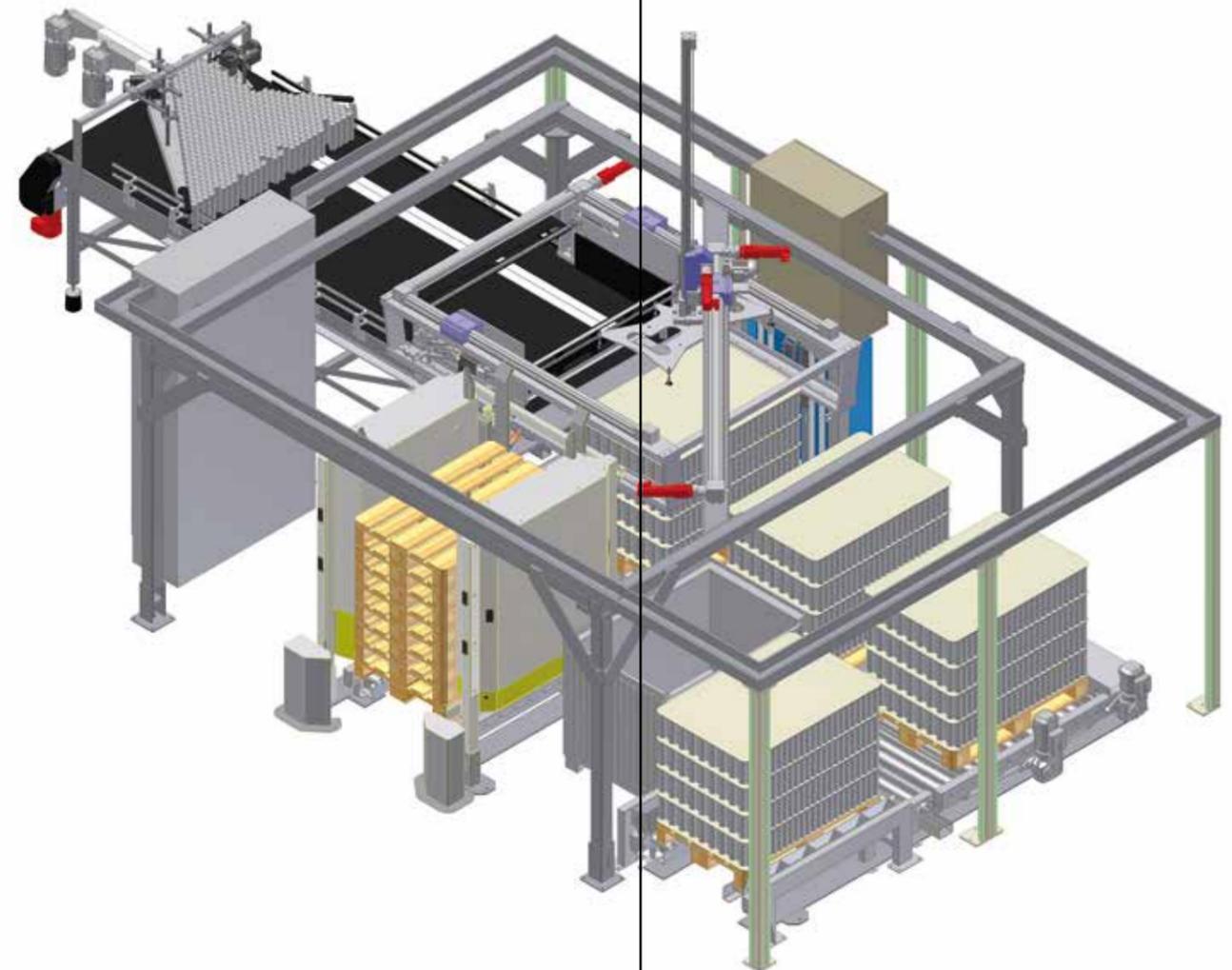
Depending on the desired degree of automation, a conveyor system is used to supply the pallets, or they may be placed directly into their proper position. The empty pallets are delivered to existing systems or to stacking systems, which can be supplied as an option. Underliners can be removed automatically and stacked up.



Depalletizers are PLC-controlled systems, using touch panels for the operation and visualization. The depalletizers are a rigid steel construction and can be painted upon the customer's request. In order to achieve the highest possible accuracy, the positioning axes are driven by a servomotor.

Automatic monitoring of all important functions guarantees high process reliability.

PLC-controlled, solid steel construction and automatic monitoring function



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Depalletizer

TÖLKE depalletizers are suitable for automated clearing of aligned packaged goods received. Depalletizing glass jars, cans, glass bottles, plastic bottles, caps, etc., are typical applications. The systems are designed in accordance with the customer's specifications and, therefore, their installation-related requirements can be optimised.

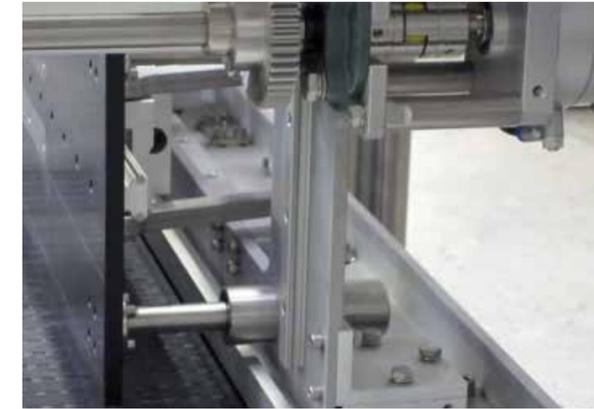
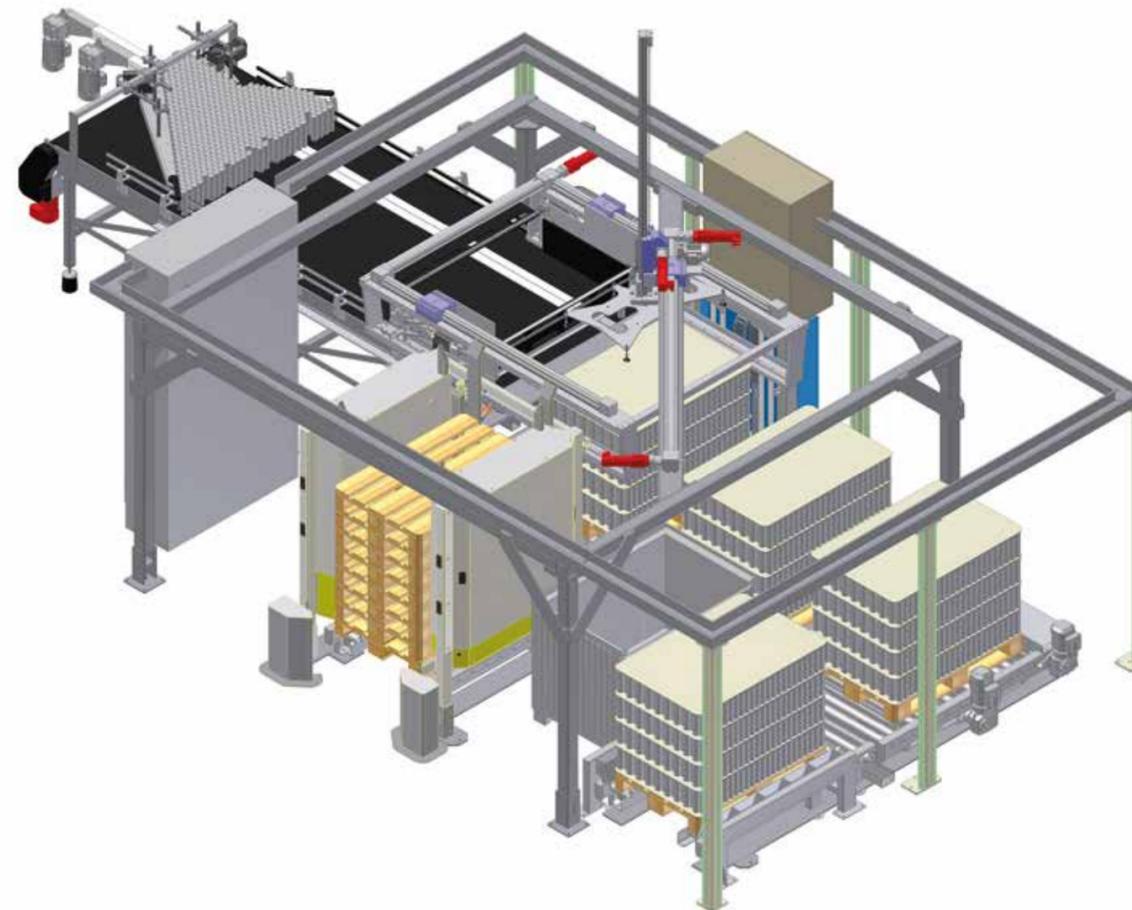
Depending on the desired degree of automation, a conveyor system is used to supply the pallets, or they may be placed directly into their proper position. The empty pallets are delivered to existing systems or to stacking systems, which can be supplied as an option. Underliners can be removed automatically and stacked up.



Depalletizers are PLC-controlled systems, using touch panels for the operation and visualization. The depalletizers are a rigid steel construction and can be painted upon the customer's request. In order to achieve the highest possible accuracy, the positioning axes are driven by a servomotor.

Automatic monitoring of all important functions guarantees high process reliability.

Our depalletizers are suitable for Euro-pallets, industrial pallets, or other customised designs. The program sequence can be easily traced, and the user can visualise the flow and alter the flow if necessary. The machine is easy to maintain and access. The automatic removal of underliners can be integrated. The supply of empty pallets to a pallet magazine is fully automated. Barcode readers are used to inspect the height of the can and select a specific program.



Output overview:

- » PLC-controlled systems with touch panel for control and visualisation
- » Rigid steel construction, painted upon customer's request
- » Positioner axes driven by servomotors for a high accuracy
- » Automatic monitoring of all important functions and high process reliability
- » Suitable for Euro-pallets, industrial pallets or other customised types
- » The program sequence can be easily traced, and the user can visualise the flow and alter the flow, if necessary
- » Low-maintenance and easy access
- » Integration of automatic underliner removal possible
- » Automatic supply of empty pallets to a pallet magazine
- » Height control for cans and program selection via barcode reader

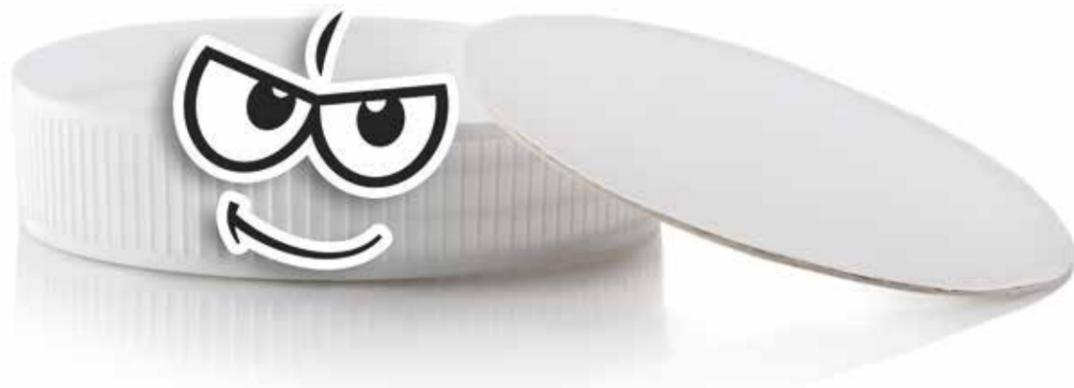


„Reimagine the impossible! If innovative products are to be delivered, filled, applied, pushed-in, weighted – or what else the customer desires – we find the solution. That’s a promise!“

Markus Kröger, Project Manager
joined TÖLKE in 1999

Don't flip your lid!

Regardless of the shapes, sizes, materials, and thicknesses of wads you selected, whatever we punched out, will fit. Period! You can be assured. So don't flip your lid! ;-)



Punching and wadding machinery

TÖLKE punching and wadding machines are suitable for punching and inserting different kinds of wads into caps. TÖLKE cap unscramblers or other existing feeding equipment installed upstream are used to supply the machine.

The punching and wadding tools are especially designed and manufactured for every machine. This ensures that any type of tape material can be processed. The wadding machines can also handle prefabricated wads.

TÖLKE punching and wadding machines can process different shapes, sizes, materials, and thicknesses of wads.

The output can reach up to 400 pieces per minute (Ø10 up to Ø120 mm).

The changeover to other cap sizes is very easy. The caps are not subjected to unnecessary loads. Cap sorters are electrically and mechanically integrated. Wads placed incorrectly can be inspected and rejected if necessary.

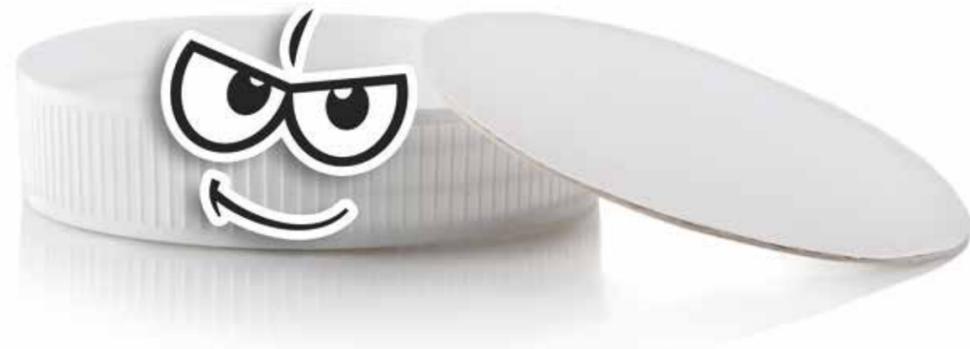
Hot-melt glueing devices, an automatic lubrication system, and additional functions such as an image processing system for inspection purposes can be integrated. Single lane or double lane design of the machine is available.

400 pieces per minute



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Output overview:

- » TÖLKE punching and wadding machines can process different shapes, sizes, materials, and thicknesses of wads.
- » Capacity up to 400 pieces per minute
- » A wide range of articles is available (cans Ø10 – 200 mm)
- » Simple refitting to other bottle sizes
- » The container are not subjected to unnecessary loads
- » Electric and mechanical integration of the cap sorter
- » Wads placed incorrectly can be inspected and rejected if necessary
- » Hot-melt glueing devices, an automatic lubrication system can be integrated
- » Single lane or double lane design of the machine is available
- » Additional functions such as an image processing system for inspection purposes can be integrated



Reimagine the impossible!

If innovative products are enwrapped, filled, applied, pushed in, weighted—or what else you might be able to think of, TÖLKE special machines are built and delivered precisely for that purpose.



Special machinery

TÖLKE Special machinery

Innovative products require innovative solutions. With its program of special machinery, TÖLKE is able to offer a wide range of solutions for such challenges. New solutions are developed or long-established concepts are improved, always in close collaboration with our customers.

Will be happy to plan with you and implement your complete filling and packaging system. Or we can assist you designing suitable machine components for your small- or large-scale production. As an innovative and state-of-the-art enterprise, our aim is to secure our customers' competitive edge by implementing their individual solutions in the area of special machinery and equipment.

Many years of experience in the area of designing special machinery made us experts in the area of automation engineering.

This allows us to resort to many reliable machines that are already in service, and we use this knowledge to support you with the implementation of your automation projects. We work closely with our customers to find the right engineering concepts and solutions. Based on the technical requirements, interfaces within the installation and production processes are determined and, therefore, guarantee the best possible production sequence.

Customized solutions for individual requirements



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TÖLKE has already delivered the following systems:

- » Winding machines for paperboard and paper sleeves
- » Complete filling lines for chocolate dragées
- » Placer for paper collars
- » Bulging devices and plug inserter for paper rolls
- » High performance punching systems for sleeves
- » Systems for punching wads and insert into wad magazines
- » Weighing systems for the integration into existing systems



Holistic thinking and working

From the first digital line to the first component and finally to programming

To remain focused and to have the understanding for complex interrelationships, at TÖLKE, this is not only important, but also essential in order to find a solution to individual tasks in the area of automation engineering. Our designers understand this in order to provide the mechanical engineer with the best possible concept. Our electronic engineers switch hundreds of relays. Our programmers take care of the control systems and develop a simple operator environment for the user of the machine.



Matthias Tölke,
Electrical engineer

„Only if one understands the entire complexity it will be possible to achieve something that, in the end, the machine is supposed to do! And sometimes a little more...“



Simple and intuitive – this is precisely what the operator interface must be. It comes with touch panel and IP protective housing as standard.



