

VERIPACK

WONDERPACK

— the thermoforming people —

NEW PACKAGING TECHNOLOGIES

VERIPACK

NOW ALSO PRESENT OVER THE INDIAN MARKET

WONDERPACK has recently joined hands with VERIPACK a F.N.C. group company. Initially Wonderpack shall market and service of Veripack machines in India. The project stands out for interesting opportunities offered by the local market, with more than 800 millions consumers together with the Asian south-eastern fast emerging markets. After an accurate research and selection process, the choice of the local partner was principally driven by the purposes of reliability and quality, among of the usual business parameters.

Operating in the packaging field since 24 years, Wonderpack manufactures machines for the production of rigid trays and complete Compact Sheet Line Extruder. ISO 9001-2000 certified since February 1997, Wonderpack is made of high skill commercial and technical personnel with a consolidated professional background able to provide full Customer satisfaction from sales to after-sales service. This agreement strengthens Veripack presence abroad providing its Customers innovative packaging solutions &, most important, customized on the specific & always more diversified and sophisticated demand.

Within its products range, Veripack offers Form-fill-seal machines and Tray-sealing machines for food, non-food and medical industry; possible applications, with either rigid or flexible film or pre-formed trays, include vacuum, vacuum and MAP. In addition, it's possible to install on board the machines a wide range of accessories like automatic dousers, data printers, labellers, metal detectors or weigh selectors.

MAP - TECHNOLOGY-

The modified atmospheric packing
Nitrogen Flushing - vacuum gas injection technology.

WHAT IS MAP?

To extend the conservation of the product or improve the life of the product to be filled.

During the packaging process, the air is evacuated from the pack & is replaced by air with modified contents. One possible alternative to evacuation is gas flushing. Here the air is displaced by the modified atmosphere. These harmless inert gases are obtained from air & satisfy high purity requirements. "Packaged in an inert gas atmosphere" is all that needs to be declared in Europe.

This technology assures the outmost hygienic conditions throughout the process of packaging.

Every individual component of these machines is to comply with the toughest sanitary prescriptions.

A careful design, which makes washing simpler, avoids the deposit of dangerous residues. Most components give IP67 protection.

IP 67- Ingress Protection Environmental Protection

6 Totally Protected Against Dust

7- Protected Against The Effect Of Immersion Between 15 Cm To 1 Meter.

The Product Which You Are Going To Fill In Should Be Hygienic.

Mr. P.V.Narayanan Interview

Chair Professor & Advisor-SIES

Chairman-Advisory Council, SIES School of Packaging,
Navi Mumbai

Interviewer : What are the new trends in the consumer's attitude in India apart from the modern civilization?

PVN : Indian consumers are slowly and steadily moving into a new era of living. Joint family systems are slowly diminishing, individual taste & requirements are changing. Steadily increasing personal disposable income gives them a higher purchasing power. The consumer today looks for brands, convenience, value & are

Interviewer : India is one of the world's major food producers. As per the research of the Indian food industry, the total food production in India is likely to double in next 10 years. Do you have to say anything about it? To cater this growing market what would be your valuable suggestion to gain the opportunity?

PVN : India has become a leading food producer in the world (Fresh fruits, Vegetables & grains, cereals, pulses). The farms are spread over the country & the processing centers are concentrated in the urban. This demands transportation over longer distances and climatic conditions vary considerably. All these result in a higher percentage of food losses and spoilage. The natural wealth thus is wasted. The country needs proper storage, refrigerated transport and cold / cool storage / warehousing besides setting up of processing and packaging centers nearer the orchards & farms. These will help to considerably minimize the spoilage & losses.

Interviewer : Food packaging industry is primarily concerned with packaging activities regarding protection of food products from biological, physical or chemical agents. With the growth of modern civilization, people are getting more concerned with hygiene & quality of the food industries. In near future it is going to be a booming industry. What do you say?

PVN : Both food processing and packaging sectors have to follow international hygiene standards as the ultimate consumers' health is of significant concern. That there is a high potential growth for the processed food industry cannot be debated. The processed food and packaging industries are complementary and supplementary to each other. Either of them needs to adopt state of art technologies. India also has an excellent export potential for both fresh & processed foods. In such cases the different and probably more stringent regulations are to be met.

Interviewer : Would you please advise us on the current market scenario, especially in the Indian food producers?

PVN : Purchasing in bulk has given way to institutional and retail packs. This provides a greater opportunity for the packaging sector to develop creative and innovative ideas. Marketing practices have shifted to departmental stores and super markets. Competition is ever increasing. One finds on the shelf virtually every day something new more of physical changes in the packs (shapes and sizes) and attractive graphics. The package development program should aim at shelf friendly packages and stand out among the competitive brands. It should evolve itself as a brand promoter.

Interviewer : What strategy over the Indian market?

PVN : There can not be a fixed strategy in as much as the market is dynamic. Changing consumer perception will be the influencing & driving forces. The primary strategy will be to create a value added product, an enhanced Qualitative pack that arouses a curiosity & creates “a look again” effect Move towards a more ecofriendly package and get a “market gain”.

Interviewer : Would you please advice us on the current market segments of the Food Industry?

PVN : Every processed food is a market by itself. The RTE and RTC segments probably are the fast growing ones. Heat and eat and Microwave and eat are the concepts. As of now the country has a very high percentage of young population. They are the market drifters and takers. Retort, Asceptic, Thermoform, stand- up & Flexible bottles seem to be gaining momentum and will grow at a faster pace.

Interviewer : Looking at the current market scenario and the current market segment according to you, which industries could have higher benefit in using Veripack Form-fill-seal and Tray sealers machines?

PVN : The strength of Veripack is indeed in the thermoform areas. The technology however should be adoptable both for monolayer thermoforms and multilayer thermoforms. The system should also be versatile to produce thermoformed shell containers. Specific application areas could be cut vegetables, cut fruits, Dairy products, meat products, ready to serve containers, on one hand with emphasis on food and on the other non food areas like electronics and high end products of higher costs.

Interviewer : Going back to the new technology again, according to you what is expectations of development in the packaging industry?

PVN : With respect to the Indian industry the thermoform technology is known but at a traditional level. The potential applications are yet to be tapped. Package development and applications for processed food industry will be the core & value added growth areas. Referring to multilayer structures meat, cheese, yoghurt, sea foods horticulture, flower and the like should be looked into besides. Applications where gas flush & MAP technology stands to offer higher shelf life. The other major area could be medical device packaging.

Interviewer : Do you think this new technology suitable to sustain this development? If yes, then what do you think, how would Veripack machines benefit the Indian food Processors?

PVN : The multiple capability of the group of machines addressing to focused areas will be the benefit of the technology. Exports should open up yet another potential area both direct and indirect.

Interviewer : What is SIES focusing in order to enhance and stimulate this process?

PVN : Industrial awareness program, extension of testing and quality control facilities, package development are the key areas of technical assistance provided by SIES-SOP. With the installation and commission of the proposed Thermoform Fill- Seal machine at SIES- SOP. The same will facilitate to achieve multipurpose objectives such as:

- (a) Training of shop floor and supervisory level industry people.
- (b) Training of aspiring technology personnel undergoing packaging science and Technology Programmes enabling them to step into industry with theoretical knowledge and practical experience.
- (c) Undertake Machine Material interactive programme to facilitate industry to identify the right material and right operational needs.
- (d) Prepare prototype samples and their assessment to confirm product package Credibility.

Interviewer : Which technologies will be the most effective to face the challenges of the today's Competitive market of packaging industry

PVN : It will be difficult to pinpoint specific technologies that will benefit the packaging Industry. Technological developments are witnessed in every material and process sectors. If one has to take a consolidated view, technologies that enable Source reduction, sustainability, enhanced product protection & preservation, Productivity, user friendly with economical benefit should be the front runners. The Indian consumer though is moving towards sophistication is still cost driven & economies will be the buzzword.

Interviewer : If we divide the INDIA in four regions which region you think has the high potential?

PVN : Northern region since the recent past has taken a lead with respect to packaging & food sector. Western region continues to be the hub. Southern region has shown a satisfactory growth which cannot be said in respect of the Eastern region.

Interviewer : As per the various market survey in growth of food packaging Industry by end of 2010 global packaging market will reach to euro 5.4 billion with a growth rate of 4.3%. It is anticipated that consumption of snack foods like chocolate, nuts etc. will promote the demand of packaging cater to this demand in India, what is the most potential regions, considering INDIA in four region, NORTH, WEST, EAST SOUTH

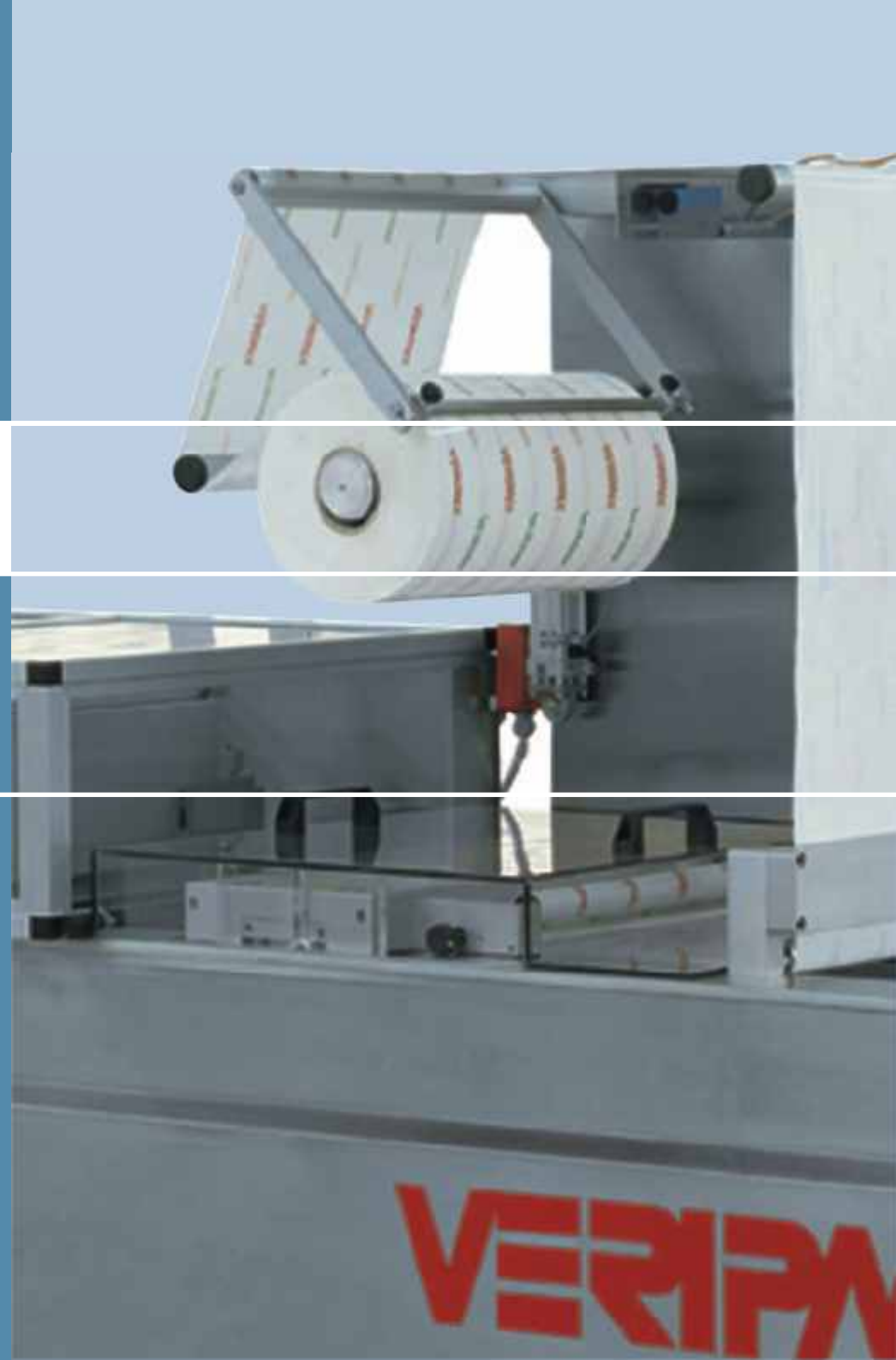
PVN : The processed food industry is estimated to be valued at US dollars 200 billion by 2015 and by the next decade should touch US dollars 300 billion. The consumer packaging market is estimated at Rs.180 billion (3.7 billion US \$). The packaging sector is set to grow over 10 percent. There are nearly 700 units engaged in the manufacturing of packaging machineries. Flexible packaging should record a higher growth when compared to others. The food sector seems to be stronger in the northern belt and growth in packaging sector probably equally shared between North and West.

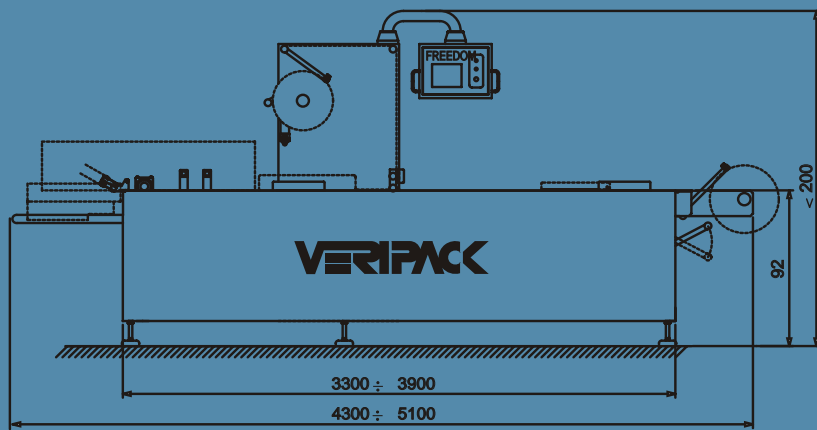
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> [Freedom]

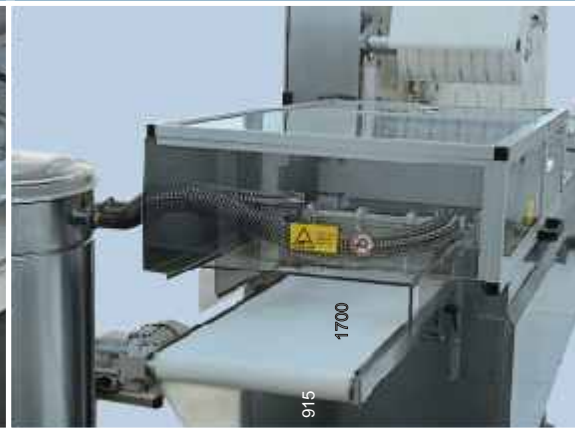
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[Freedom]



La serie di termoformatrici modello FREEDOM che si contraddistingue per compattezza ed affidabilità, rappresenta la sintesi tra le esigenze della piccola e media produzione e le caratteristiche di qualità e sviluppo tecnologico presenti nelle serie maggiori.

Costruite in acciaio inox, garantiscono affidabilità e durata nel tempo; sono state studiate per favorire le operazioni di pulizia ed evitare il deposito di residui.

Le applicazioni delle termoformatrici FREEDOM sono molteplici, sia nel campo del food: carne, pesce, salumi, formaggio, gastronomia, pasta fresca, dolci, ecc., che del non food: strumenti medicali, pezzi di ricambio, componenti di bricolage, ecc.

La possibilità di utilizzare diverse tipologie di film, la grande facilità di uso unita alle molteplici possibilità di applicazione, la manutenzione limitata e semplice, fanno della FREEDOM la macchina ideale per ogni azienda.

E

The thermoforming machines model FREEDOM are extremely compact and reliable. They satisfy the needs of small to medium production cycles with the quality and technological features of the greater series.

They are made of stainless steel and designed for easy cleaning, to prevent the build-up of working residues and to guarantee long-term durability.

The applications can either be in the food sector (meat, fish, cold cuts, cheeses, pastry, fresh pasta, sweets, etc.) or in the non-food area (medical instruments, spare parts, do-it-yourself items, etc.).

The possibility to use different types of films, the simple operation, the different fields of application together with easy and limited maintenance, make the Freedom form-fill-seal machine the right choice for any company.

F

La thermoformeuse FREEDOM, par sa petite taille et sa grande fiabilité, répond aux besoins des petites et moyennes productions, tout en bénéficiant de la qualité et de la technologie présentes dans les séries plus grandes.

Construites en acier inoxydable, les thermoformeuses FREEDOM ont été conçues pour faciliter les opérations de nettoyages, éviter le dépôt de résidus et garantir leur fiabilité dans le temps.

Les applications des thermoformeuses FREEDOM sont nombreuses tant dans le domaine alimentaire (viande, poisson, charcuterie, fromage, gastronomie, pâtes fraîches, etc.) que dans le domaine non alimentaire (instruments médicaux, pièces détachées, outils de bricolage, etc.).

La possibilité d'utiliser différents types de films, la grande facilité d'emploi, les nombreuses opportunités d'application et une maintenance limitée et simple, font de la thermoformeuse FREEDOM la machine idéal pour tous les domaines.

VERIPACK®

> [Freedom]

CARATTERISTICHE TECNICHE - TECHNICAL FEATURES - CARACTERISTIQUES TECHNIQUES

Peso - Weight - Poids	Kg	> 800
Distanza fra le teste - Die distance - Distance entre les têtes	mm	1750-2600
Fascia del film - Web width - Largeur du film	mm	321-421
Materiali - Materials - Matériaux:	carta	
Film inferiore - Lower film - Film inférieur	rigido, flessibile - rigid, flexible	
Film superiore - Upper film - Film supérieur	alluminio, flessibile, carta - aluminium, flexible, paper	
Ø delle bobine (max) - Reel diameter (max) - Ø des bobines (max):		
Film superiore - Upper film - Film supérieur	mm	350
Film inferiore - lower film - Film inférieur	mm	400
Ø del madrino - Core diameter - Ø de la broche		3"
Passo di avanzamento - Feed length - Pas d'avance	mm	fino a - up to 320
Profondità di termoformatura - Forming depth - Profondeur de thermoformage	mm	80/120/140
Tensione - Power supply - Tension		400 V 50/60 Hz
Potenza elettrica installata - Installed power - Puissance électrique installée (esclusa pompa vuoto) - (without vacuum pump) - (sans pompe à vide)	KW	> 7
Aria compressa richiesta - Compressed air required - Air comprimé requis:		
Pressione - Pressure - Pression	bar	6-8
Quantità secondo formato e velocità - Q.ty depending on format and speed	NI/min	800-1000
Quantité selon le format et la vitesse		
Acqua di raffreddamento - Cooling water - Eau de refroidissement		
Pressione - Pressure - Pression	bar	2 min
Quantità - Quantity - Quantité	l/h	80 approx.
Impianto vuoto e gas - Vacuum and gas system - Système de vide et gaz	bar	4
Controllo vuoto e gas - Vacuum and gas control - Contrôle de vide et gaz	millibar	1-1100



Caratteristiche tecniche

Technical features

Caracteristiques Techniques

SISTEMA DI AVANZAMENTO

Con motore passo-passo che permette grande precisione e facili cambi di passo.

CAPACITÀ BOBINE

Possono essere utilizzate bobine fino a 350 Ø mm film superiore e Ø 400 mm film inferiore con anima da 3" o 6" (con adattatore).

FORMATURA

Per film flessibili la formatura può avvenire a scelta con aria compressa e/o con il vuoto. Per film rigidi si usa spesso una formatura con maschi meccanici ed aria compressa per garantire una migliore qualità degli imballi. Con la massima facilità sostituendo le parti interne dello stampo si possono ottenere diversi formati di vaschette.

CARICAMENTO

Può essere manuale o automatico a seconda dei prodotti e delle quantità.

SALDATURA

La saldatura con telaio a caldo può essere perimetrale o totale; i cicli possibili sono:

- vuoto e saldatura
- vuoto, reiniezione di miscela di gas inerti, saldatura
- semplice saldatura.

L'apertura facilitata della confezione è inoltre ottenibile grazie ad appositi accorgimenti.

TAGLIO LONGITUDINALE

A lama rotante per film flessibili e rigidi.
A pressione pneumatica e/o forbice per film rigidi.

TAGLIO TRASVERSALE

Con coltelli a lama per film flessibili.
Con zigrinatura per apertura facilitata.
Con trancia a fustella per film rigidi.
Con trancia ed asportazione striscia sagomata da 3 o più mm.

TAGLIO IN SAGOMA

Per alcuni prodotti particolari può essere previsto un taglio che segue la sagoma del prodotto, sia in flessibile che in rigido.

GLI SFRIDI

Vengono rimossi tramite un aspiratore o, dove necessario avvolti con un apposito aspo, oppure triturati.

PROTEZIONI

È stata riposta la massima cura per evitare l'accessibilità a zone pericolose della macchina. Una serie di sicurezze arrestano immediatamente il ciclo in caso di rimozione anche parziale di una protezione.

COMANDI

La **FREEDOM** è dotata di PLC e tastiera di programmazione. Possono essere memorizzati fino a 99 programmi, definendo tutti i parametri del ciclo tecnologico (tempi, temperature, grado di vuoto voluto nelle confezioni, passo di avanzamento, velocità delle catene, inserimento delle varie funzioni macchina). È disponibile un aiuto in linea per le varie fasi di programmazione. Un'ampia autodiagnostica consente all'utilizzatore di individuare immediatamente la causa di un fermo macchina o di un errore manifestatosi e di poter quindi intervenire prontamente e ripristinare il ciclo produttivo. Le catene possono essere comandate manualmente per una più facile introduzione del film.

VUOTO

La pompa a vuoto sino a 200 mc/h, 300 mc/h sulla F421 può essere incorporata. Sono possibili pure soluzioni con pompe a capsulismi o vuoto centralizzato.

FASCIA DEL FILM INFERIORE

FREEDOM può essere fornita per film da 321 a 421 mm di larghezza

ACCESSORI

La macchina può essere dotata di accessori quali:

- termoretrazione	- sistema iniezione gas
- datario a trasporto	- miscelatore per gas
- datario ad inchiostro	- etichettatrice

FEED SYSTEM

Step-by-step motor to give high precision and quicker speed adjustment.

REEL CAPACITY

Reels up to 350 mm diameter for upper film and 400 mm diameter lower film with 3" or 6" cores (with adapters).

FORMING

For flexible films the user can choose between compressed air and/or vacuum forming. With rigid film compressed air is often used with plug assistance to ensure a high quality of forming. Different shaped trays can be easily and quickly obtained by simply changing the inner part of the die.

LOADING

Manual or automatic, depending on product and quantities.

SEALING

Hot sealing plate can be either perimetric or full seal, with the following options:

- vacuum and sealing
- vacuum and injection of inert gas, followed by sealing
- simply sealing.

The sealing plate can be designed for easy-opening of the tray.

LONGITUDINAL CUTTING

Rotating blade for flexible and rigid film.
Pneumatic pressure and/or scissors type cut for rigid film.

CROSS CUTTING

With knife blades for flexible film.
With knurling for easy opening.
With guillotine for rigid film.
With guillotine and removal of shaped film with 3 mm or more.

SHAPED CUTTING

For specific products the cutting can be made to follow the product shape either with flexible or rigid films.

TRIM REMOVAL

Off-cuts are removed by suction or, where necessary, can be wound on to a special spool or grinded.

GUARDS

Particular attention has been paid to prevent access to dangerous points in the machine. A series of cut-off switches stop the machine immediately if any guard is even partly removed.

CONTROLS

FREEDOM equipped with PLC and programming keyboard. Up to 99 programs can be stored, thus defining all parameters of the technological cycle (i.e. times, temperatures, vacuum level required for packages, drive pitch, chain speed and input of the various machine functions). An on-line help to the different programming phases is available. Self testing allows the user to immediately identify the cause of a machine stop or problem, thus promptly taking corrective actions to reset the production cycle. Chains can be manually controlled for easier film introduction.

VACUUM

A vacuum pump up to 200 mc/h, 300 m³/h for F421 may be incorporated.
Solutions using vacuum accelerator or centralised systems can also be used.

LOWER FILM WEB

FREEDOM may be adapted to take film width from 321 to 421 mm.

OPTIONALS

FREEDOM thermoforming machine can also be equipped with:

- | | |
|--------------------------|------------------------|
| - shrinking system | - gas injection system |
| - transport date printer | - gas mixer |
| - ink date printer | - labelling machine |

SYSTEME D'AVANCE

Avec moteur à courant continue permettant une grande précision de déplacement et un changement de pas aisé.

CAPACITÉ DES BOBINES

On peut utiliser des bobines de 350 mm maximum film supérieur, et de 400 mm maximum film inférieur avec mandrin de 3" o 6" (avec adaptateur).

FORMAGE

Pour les films flexibles le formage peut se faire par air comprimé et/ou vide. Pour les film rigides on utilise souvent un formage avec aides mécaniques et air comprimé afin de garantir une meilleure qualité des emballages. Très facilement, en remplaçant les parties intérieures du moule, on peut obtenir divers formats de confections.

CHARGEMENT

Il peut être effectué manuellement ou automatiquement, selon les produits et les quantités.

SOUDURE

La soudure peut être périphérique ou totale. Les cycles possibles sont les suivants:

- vide et soudure
- vide, réinjection de mélange de gaz inerte, soudure
- simple soudure.

La station de soudure peut être prévue de façon à permettre l'ouverture aisée de la barquette.

COUPE LONGITUDINALE

A lame tournante pour films souples et rigides.
A pression pneumatique et/ou coupe à ciseaux pour films rigides.

COUPE TRANSVERSALE

Avec couteaux à lame pour film souples.
A dents de scie pour ouverture facile.
Avec presse à découper pour film rigides.
Avec presse à découper et emporte-pièce de 3 mm ou plus.

COUPE EN PROFIL

Pour certaines applications, en film rigide ou souple, on peut prévoir une coupe qui suit la forme du produit.

LISIÈRES

La machine est équipée d'un aspirateur ou, si nécessaire, d'un enrouleur ou d'un coupe lisière.

PROTECTIONS

Le plus grand soin à été apporté afin d'éviter l'accès aux zones dangereuses de la machine. Une série de sécurités arrête immédiatement le cycle en cas de déplacement, même partiel, d'une protection.

COMMANDES

FREEDOM est équipée avec PLC et un clavier de programmation. On peut mémoriser jusqu'à 99 programmes. Tous les paramètres du cycle technologique (temps, température, vide souhaité dans les barquettes, pas d'avance, introduction de différents fonctions machine) peuvent être programmés.

Une aide en ligne est disponible pour toutes les phases de programmation. Un système d'auto-diagnose permet à l'utilisateur de réperer immédiatement la raison d'un arrêt de la machine ou d'une erreur et d'intervenir promptement pour rétablir le cycle productif. Les chaînes peuvent être commandées manuellement pour faciliter l'introduction du film.

VIDE

La pompe à vide, jusqu'à 200 mc/h, 300 m³/h pour F421 peut être incorporée.
Des solutions avec pompes à lobes ou vide centralisé sont possibles.

LARGEUR DU FILM INFERIEUR

FREEDOM peut être conçue pour des films de 321 mm à 421 mm de largeur.

ACCESSOIRES EN OPTION

FREEDOM peut aussi être équipée avec:

- | | |
|-------------------------------|-------------------------|
| - système de thermorétraction | - système injection gaz |
| - dateur pour transposition | - Mélangeur de gaz |
| - dateur à encre | - étiqueteuse |

VISION

FILL SEAL MACHINE



VISION is the ideal solution for productions in need frequent format changes.

TECHNICAL SPECIFICATIONS

DESCRIPTION	SPECIFICATIONS
Maximum die dimensions	460 mm - 370 mm
Standard machine length with conveyor	3170 mm
Width	800 mm
Height	1750 mm
Air consumption (20 cycles)	75 Nm
Power supply used	4 Kw
Maximum speed	20 cycles/min
Maximum speed with vacuum and gas	8/10 cycles /min



TECHNICAL FEATURES

- Stainless steel and derlin containers sampling unit driven by inverter to grant accuracy and avoid the spilling of liquid products
- Handling of the lower mould by a pneumatic cylinder and mechanical locking to grant a perfect closure and resistance to the remarkable sealing trust.
- Sealing with large size pneumatic cylinder for specific extremely high pressures.
- Heat transfer coders for the printing of dates, batches, bar codes, recipes, etc.
- Photocell for closing film centering
- Moulds entirely made in stainless steel for better operation & maximum heavy-duty life.
- Feeding system for containers with belts in food type plastic materia.
- Alarms for process diagnostic with graphical indication of the intervention point.

WONDERPACK
 the thermoforming people

VERIPACK, A TRADITION FOR INNOVATION

Manufacturer of form-fill-seal machines since more than 40 years, the Italian company is now able to offer its packaging solutions over the Indian market.

Veripack is technology at the very edge of mechanical applications since 1927. It works in packaging business specialising in thermoforming for the last 40 years. Tradition, success and innovation are the key points in a process of continuous innovation that this company featured for three generations of entrepreneurs. Attention to R&D and maximum care to details, flexibility and determination, are the values on which Veripack grounds the creation of its products: machines with an efficient design that are able to meet the requirements of an increasingly diversified market. With these factors in mind Veripack, proposes a series of form-fill-seal machines; Entry, Freedom, Flexi and Progress. The range of models covers from the smaller to the bigger production volumes and a wide variety of applications both in food and non-food applications such as vacuum, modified atmosphere, blister and medical. This is a self-contained solution for primary packaging; starting from a plastic film reel, the machine provides the finished package ready for secondary package and loading on the truck. In order to supply diversified solutions, Veripack offers tray-sealing machines Vision and Panorama. The tray-sealing process starts from a pre-formed or mould injected tray, providing sealing and/or vacuum and MAP injection. Thanks to the adoption of various innovative solutions, they allow the whole packaging process with efficiency and remarkable productivity. The most common applications are those for products such as cheese, ready meals, sliced ham, salami, meat, sea-food, cakes or bakery products. Extremely safe and flexible, Vision and Panorama are suitable for frequent changes in workload or typology of the product format to be packaged. Not least, these operations can be performed by non-specialised staff and are completely tool-free, always strictly respecting the most stringent safety regulations.

In order to completely fulfil the Customer needs, both Veripack form-fill-seal and tray-sealing machines can be equipped with a wide range of accessories such as automatic dousers, vacuum pump, photocell for the centring of the upper film, heat transfer coder for printing dates, batches or bar codes, labellers, metal detectors and weigh selectors.

These machines for manufacturing process standing-out for many strong features and a key point: reliability, also certified by ISO 9001 (since 1994) and ISO 14001 (since 2005) standards, obtained through the maximum respect for the quality process and for the environment.