



# BULLETIN

NATE – nápojová technika a.s., Chotěboř

november 2014

## REVOLUTION IN FILLING SYSTEMS

### FINGER ON THE BEAT

Milestones in the history of the company  
NATE – nápojová technika a.s.

### „PROJECT MADE TO MEASURE“

APO Fruchtsäfte GmbH.



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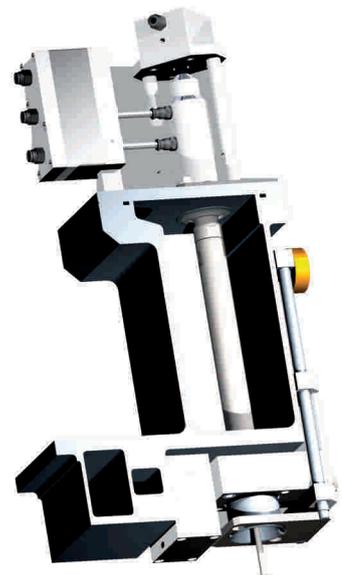
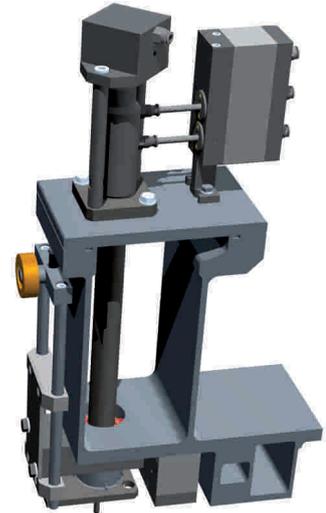
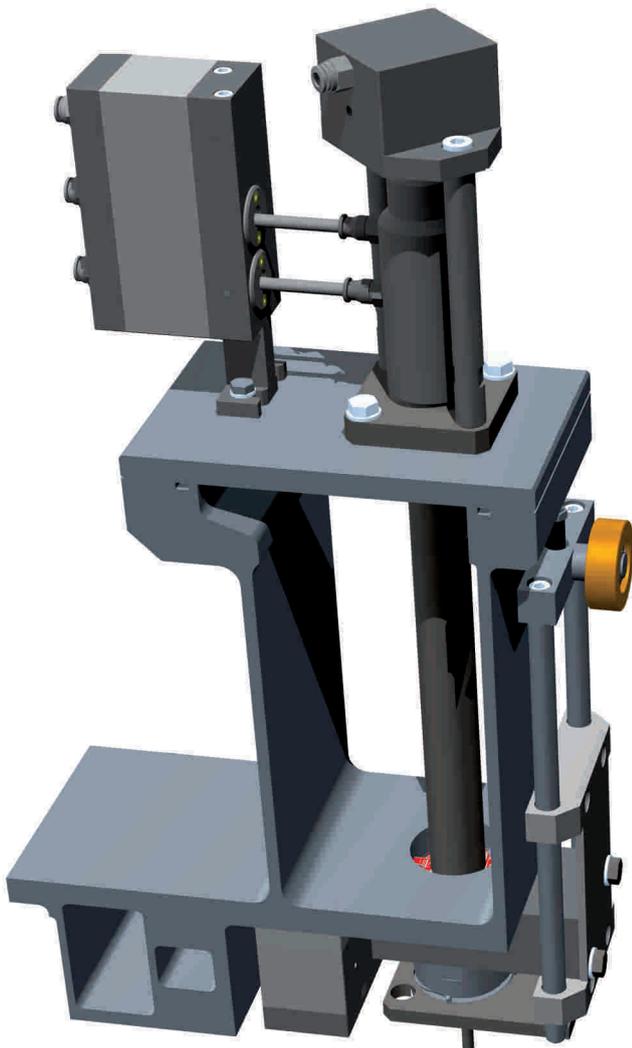
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# REVOLUTION IN FILLING SYSTEMS

## LEVEL OVERPRESSURE FILLING WITH ELECTRONIC CONTROL

- **SAVED 500 hi A YEAR WITH THE OUTPUT OF 10 000 bottles/hour**
- **SAVINGS IN CO<sub>2</sub>**
- two filling speeds
- only minimum parts come into contact with drink
- higher filling accuracy
- low drink losses during blowout
- possibility to configure the valve for different types of drinks and bottle sizes



# MILESTONES IN THE HISTORY OF THE COMPANY

## NATE – nápojová technika a.s.

### FINGER ON THE BEAT

The 60-year history of the company NATE has wielded extensive experience and a number of achievements. The company operations have always reflected the needs of their customer's, which the company adapts its production up to strategic planning, including new technologies. As a result of its deliveries of individual parts as well as complete filling lines, the company has built a high-quality KNOW-HOW.

As it has already been mentioned, the company focuses on customer's requirements regardless of the type of order, be it filling into PET bottles, cans or glass bottles, filling dairy products, saturated and non-saturated drinks, fruit and vegetable juices or beer.

Nevertheless, all companies operations have the only and ultimate goal: **TO ENABLE THE CUSTOMER TO CREATE THE HIGHEST PROFIT POSSIBLE ON SUPPLIED MACHINES.**

#### COMPANY MILESTONES

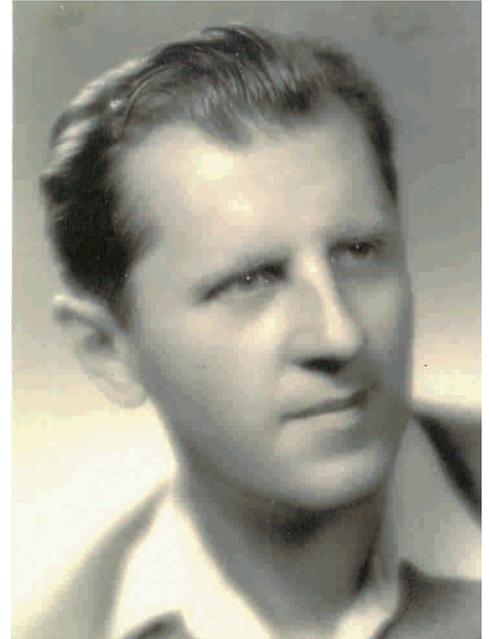
- 1936** establishment of Vilém Eckhart's machinery factory
- 1992** dividing of Chotěbořské strojírný and establishment of the NATE company
  - admission of new owner - NEWTON
- 2006** renaming the company to NATE – nápojová technika a.s.
- 2011** establishment of 2nd subsidiary - NATE – investment a.s.

#### BEST-SELLER

- ROTUS 60
- VERAL 60
- bottle washer TERMA
- volumetric filler

#### LAUNCHING NEW PRODUCTION SEGMENT

- 2001** PETBLOK 52/80/12 with level filling
- 2007** return to production of dairy industry machines



Mr. Vilém Eckhardt



VOLUME FILLING

## INNOVATIVE PRODUCTS

- 1989** launch of TERMA bottle washer
- 2001** launch of DELTA bottle washer
- 2004** first bottle filler with volumetric filling system
- 2005** launch of ATHENA bottle washer
- 2007** adaptation of DELTA bottle washer for decentralized drives and accumulation table innovations
- 2010** first volumetric filling system with long pipe and flow meters
- 2011** 19 l barrel washing and filling - barreltriblock DIONA
- 2012** launch of bottle washer for very low outputs
- 2013** first application for hot filling at 90°C
- 2014** pressure surface electronic controlled filling



## TRAINING FOR COMPANY EMPLOYEES

- 2009** Phase I and II of the training program Vzdělávejte se
- 2010-2012** Operational program Human Resources and Employment – Internal training system for NATE employees
- 2013** Vzdělávejte pro růst (Learn to grow) (language courses)
- 2014-2015** Operational program Human Resources and Employment



OPERAČNÍ PROGRAM  
LIDSKÉ ZDROJE  
A ZAMĚSTNANOST



## OVERVIEW OF BOTTLE FILLERS

- 2004** first bottle filler with volumetric filling system
- 2005** volumetric filler for filling glass and PET bottles closing machine for plastic and aluminium covers
- 2007** PET bottle filler with volumetric filling system first line with AROL closing machine for plastic caps
- 2007** first filling system with inductive flow meters first machine for closing PET bottles 38 mm
- 2009** first ULTRACLEAN covering
- 2010** first volumetric filling system including long pipe with flow meters
- 2012** first volumetric filling system including long pipe with flow meters filler with ring tank and ULTRACLEAN covering supply into the farthest destination
- 2013** first filler with flow meters for filling saturated and non-saturated drinks machine for two types of bottles – 28 mm and 38 mm
- 2013** first closing heads for crown caps with rinsing first horizontal sorting equipment for closures
- 2013** first application for hot filling at 90°C machine made for filling 14 types of bottles and 6 types of closures
- 2014** first application of separated drives of moving axes - Sew Eurodrive new bottle pressure devices
- 2014** first application of electro pneumatic control of level filling valves



## OVERVIEW OF BOTTLE WASHERS



- 2005** supply to the international company BBH, the highest output bottle washer so far
- 2007** innovated design of DELTA bottle washers with decentralized drives
- 2009** supply to the international company PEPSICO innovated decentralized drives SEW, innovated accumulation table
- 2010** bottle washer for wide range of bottles (0.2 – 1.0l)
- 2010** new market segment - first bottle washer for 19 l barrels
- 2011** higher output bottle washer of stainless steel design
- 2012** new market segment - installation of new type of bottle washers designed for small breweries output 1,500 – 6,500 bottles an hour design make of the machine, awarded in the AWARDS competition
- 2014** supply to a top Czech brewery
- 2014** new market segment - installation of new type of bottle washers designed for small breweries output 1,500 – 6,500 bottles an hour design make of the machine, awarded in the AWARDS competition
- 2014** innovated version for washing 19l barrels with arm applied section of barrel pre-washing and retracting jets with rotating heads in the washing section

## OVERVIEW OF CHECKING DEVICES

- 2005** first machine with "full" check of empty glass bottle before filling  
(Check of neck, bottom, wall, residual liquid)
- 2007** machine made for the highest output so far - ca 36 000 BPH
- 2009** check of bottle shape and colour  
1st use of Keyence camera system
- 2010** check of presence and precise fitting of closure  
level check  
check of presence of all-around label
- 2010** check of full crates
- 2010** check of presence and correct position of all-around label  
camera installed in Gernep labelling machine
- 2012** 1st machine fitted with Bassler digital cameras
- 2013** check of presence and correct position of front, back and neck labels + check of presence of date on label  
cameras installed in Gernep labelling machine
- 2014** camera check of level and closure



## OVERVIEW OF SODAMIXES

- 2001** first machine of the OSN series
- 2002** innovated design, changed principle of water measuring, shift to Siemens control
- 2008** innovation of electric equipment, shift to Siemens control
- 2008** last machine of the VSN series
- 2009** design for 3 components, dosing syrup through flow meter, change in CO<sub>2</sub> regulation
- 2010** online refractometer fitted at the machine output
- 2010** installation of dosing pump for very low mixing ratios (1:500)
- 2011** machine innovation, change in CO<sub>2</sub> regulation
- 2012** 1st machine in Czech Republic
- 2013** machine design only for non-saturated drinks
- 2014** dosing water and syrup through flow meters

## "PROJECT MADE TO MEASURE"

### APO FRUCHTSÄFTE GmbH.

At the end of 2013, we manufactured a machine for our Austrian customer, which (from the point of complexity) is the most complicated machine ever made at NATE.



#### IT IS NO WONDER BE BECAUSE IT IS PREPARED TO FILL:

- flavoured saturated mineral waters with CO<sub>2</sub> content up to 6g/l
- saturated and non-saturated mineral waters
- hot filling of fruit juices (soft drinks) – temperature up to 80°C (hot fill)
- filling beer at a temperature up to 15°C

This machine is also exceptional in that it is ready to accept 14 various bottle formats from 0.2 to 1.0 l and it is fitted with a closing machine designed for six types of caps.

#### BOTTLE TYPES:

- glass bottles (0.2, 0.33, 0.5, 0.75, 1.0 l)
- PET bottles (0.33, 0.5 l)
- aluminium (0.2, 0.275, 0.33 l)

#### TECHNICAL ADVANTAGES OF THE MACHINE:

- a wide range of drinks to fill
- beer filling at a temperature up to 15°C – saved energy on cooling
- minimum residual liquid upon completion of filling
- CO<sub>2</sub> consumption:     PET bottle – 800 g/hl  
                                  Glass bottle – 300 g/hl
- O<sub>2</sub> increase:            PET bottle – 0.05 mg/l  
                                  Glass bottle – 0.05 mg/l
- drink temperature monitoring
- electro-pneumatic controlled filling valve => enables automatic setting of filling of various types of drinks with different requirements on the course and speed of filling.

a family company that has been in the market since 1952

15 employees

customer's motto: **ALKOHOLFREI – PREISWERT – ORIGINAL**

speciality: MAKAVA BIO ice tea

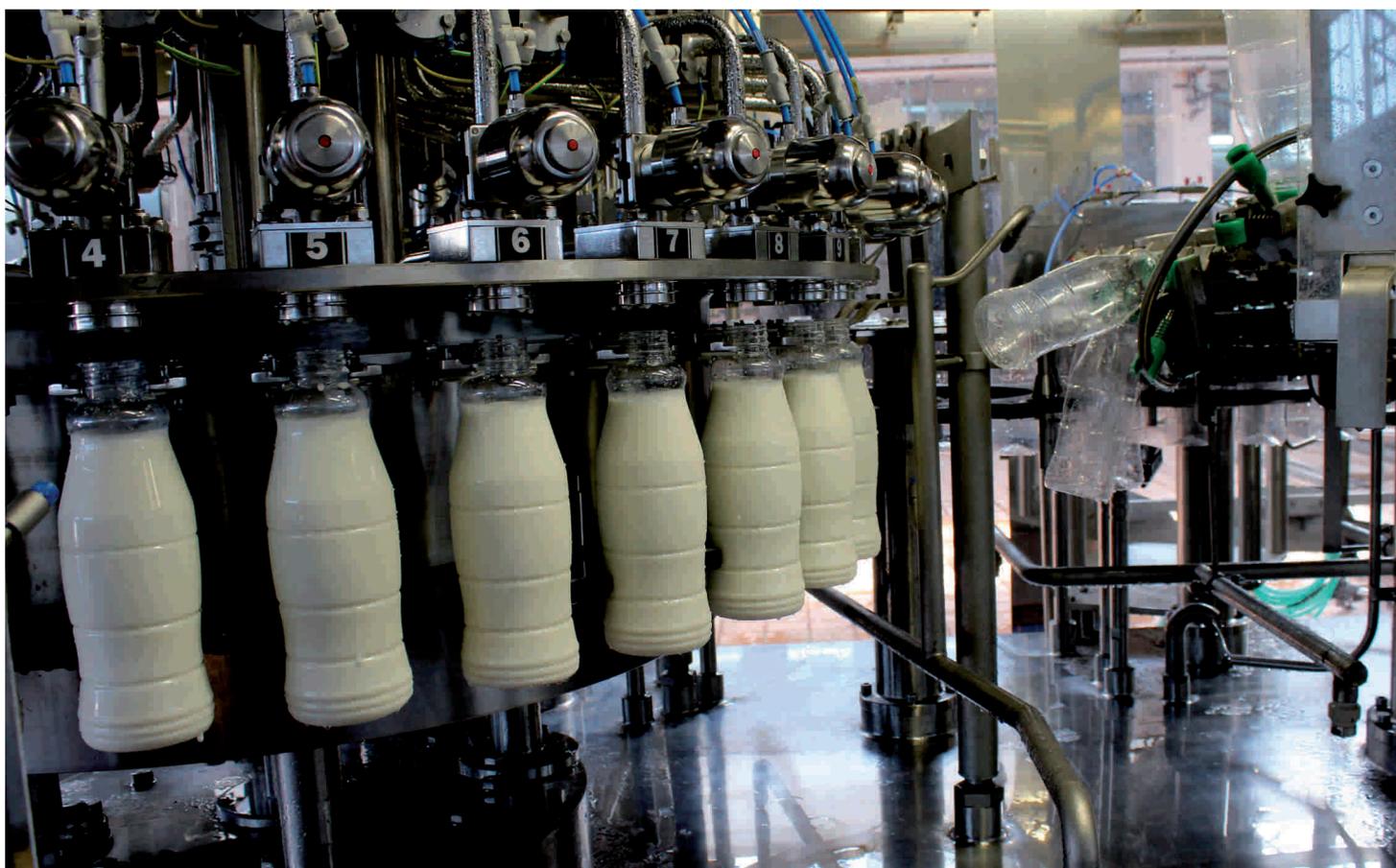
## MILK FILLING IN KORENOVSK



**Another successful job of this year was the delivery of a milk filling line for filling milk into 1.0l PET bottles for the firm Korenovskyy Konservno-Molochnyy Kombinat in Korenovsk. The supply consisted of the PETBLOK 24/32/6 with the output of 7000 bottles per hour.**

The assembly at the customer's was divided into two stages due to building reconstruction works. The installation of the NATE line was completed without any problems whatsoever. The delivery included the already mentioned PETBLOK 24/32/6, a bottle setter by SMF, air conveyors, disinfection stations, bottle conveyors, DIMAC packing machine, package conveyors, FINPAK labelling machine, central lubrication, line switchboard, conveyor switchboard and an accumulation table for 400 bottles.

The line was successfully handed over to the customer on 8.7.2014.



## "PATIENCE PAYS OFF"

### ANGUS DUNDEE DISTILLERS PLC

**Already in 2012 we realized our first and successful project for a whisky producer, Angus Dundee Distillers** in the Scottish village of Tomintoul.

In 2012, negotiations were held about moving a line with the output of 12 000 bottles per hour. This project was followed in 2013 by a delivery of the NMP 1200 palletization, package conveyors and electric switchboard. In 2014, the final project is nearing its completion in the form of the delivery of the NMP 1200 palletization and the new bottle depalletization of the NMD 1000 series.

60 years of experience with distilling, filling and exporting of Scottish whisky and other spirits all over the world

whisky is exported into more than 70 countries in the world

the filling plant is situated in the town of Coatbridge near Glasgow

two distilleries: Tomintoul, Glencada



## WE ARE ENTERING NEW MARKETS

**In autumn 2013, a delivery was realized of a milk filling technology for our new Serbian customer AD Imlek.**

**IMLEK** is a regional company operating in the territory of Serbia, Monte Negro, Bosnia and Herzegovina and Macedonia. It buys milk from several thousand farmers and agricultural cooperatives in Serbia, meeting the European standards and the necessary quality criteria. The company IMLEK markets more than 80 different types of dairy products. It possesses the necessary certificates and approvals that are prerequisites for export into the European Union member states.

In the spring of 2014 this delivery of the milk filler was followed by another delivery of milk filler into Bosnia and Herzegovina.

The **PETBLOK 30/30/6** filler is designated for filling non-saturated drinks into 0,5 l, 1.0 l and 1.5 l PET bottles and for closing the bottles with plastic screw caps. The machine output is specified at 12 000 bottles per hour with 0.5 l bottles. The machine enables filling drinks at a temperature up to 15°C.

## ON REFRESHING WAVE WITH KOLI

### SODA PLANT SODOVÁRNA KOLÍN

**Two deliveries were made to Sodovárna Kolín, one in October 2013 and one in June 2014.** In autumn last year, washing technology was supplied. The original bottle washer KONTIMA 24/19A was replaced after 19 years in operation by a new bottle washer designated ATHENA 14/14.3 CN.

The original bottle washer was thus replaced by the new equipment, which meets the present strict technological requirements and regulations. In addition to that, the machine is equipped with the most up-to-date technical gadgets, for instance: the system of bottle and damaged cage skipping, pressure pre-injection or identification of damaged cage. The delivery also included replacement of the NPAK 2 loader and conveyor routes.

June 2014 became an important date for Sodovárna, too – a new line for washing and filling KEG barrels - NM KEG 60 and a KEG barrel external surface washer - MG 120 as well as conveyor ducts were installed.

more than 100 years of experience with beverage production (128 years to be exact)

already fourth generation family enterprise

largest producer of raspberry lemonade in Czech Republic

producer of soft drinks

wide range of products:

- 0.33 l GLASS, 0.5 and 2.0 PET
- 30 and 50 l KEG barrels

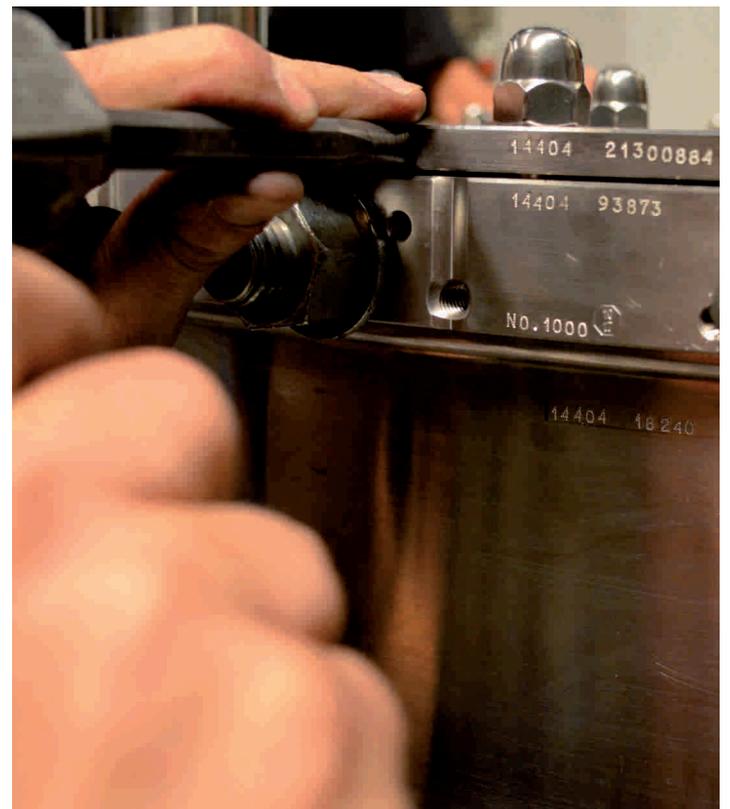


## WE HAVE PRODUCED 1000 PRESSURE TANKS

**In August this year we manufactured a tank for the PET 32 filler destined for Moldova.** It is the tank with the serial number 1000, counted since the establishment of the company Nápojová technika a.s. in 1993. This series of pressure vessels includes filler ring vessels, filler tanks for volume filling, sodamix tanks and until recently the product Mixer MX for Alfa Laval.

The last named product had to be discarded from our records of pressure vessels due to legal reasons. This category newly includes pipe exchangers for bottle washers. Now, this product is regarded a final product by Alfa Laval.

Regarding the number of produced pressure vessels of a given range for drink industry, our production is now comparable with the last twenty years of operation of our predecessor, Chotěbořské strojírný n.p., which produced more than 5000 vessels during the entire period of its operation.



# ONDRÁŠOVKA

## In 2014, several deliveries have been made to the Ondrášovka plant in Moravský Beroun.

In March 2014, the original labelling machine in the filling line for saturated and non-saturated drinks with the nominal output of 12,000 bottles/hour (1.5l). The original machine was replaced by a new one, marked OPERA 200 RT 12 T. The entire conveyor system was installed in relation to this delivery.

The NM KEG 30 machine was shipped from our production by 15.9.2014. It was officially handed over to the customer at the end of September. The entire process of washing and filling of KEG barrels is fully automatic and its function is verified on the basis of evaluation of data from the DataKeg inspection equipment.

### FUNCTION DESCRIPTION

- the entire process of washing and filling is controlled by means of the programmable control system SIEMENS SIMATIC S7, installed in the stainless switchboard box
- washing is carried out in several steps:
  - 1 pressing remains of old drink from a barrel into the sewer
  - 2 pulsating injection of mixed water
  - 3 pulsating injection of washing agent
  - 4 pulsating injection of hot water up to zero conductivity
  - 5 steam sterilization
  - 6 barrel blowing and subsequent pressurizing with CO<sub>2</sub>
    - barrel filling is done by means of a certified and calibrated flowmeter, and it is divided into several stages
    - great emphasis is put on sterility of the process by means of sterilizing the filling head before and after every filled barrel
  - 7 washing of the filled barrel fitting by hot water
  - 8 flushing the filled barrel fitting by disinfection agent

producer of Ondrášovka mineral waters and Šaraticé medical mineral water

the face of Ondrášovka mineral water is the Czech singer Lucie Bílá

the company has three NATE production lines

the latest commissioning took place in mid September - it involved the delivery of a KEG barrel washing and filling line



## PODĚBRADKA – “MORE TASTES TO LIFE”

**Poděbradka is a natural acidulous mineral water of the hydrogencarbonate-chloride-sodium-calcium type** with more than 100-year tradition and has beneficial effects on human organism. Its production meets strict standards and regulations to maintain excellent taste and customer´s satisfaction and loyalty.

The history of Poděbradka bottling dates back to 1908, when bottles were filled in chateau cellars at the rate of 6 - 8 bottles a minute.

The capacity of the first automated bottling line was 2000 bottles an hour. Mineral water production was rising steadily and reached approximately 11 022 hectolitres in 1923. After World War II, Poděbradka achieved a primacy. As the first mineral water producer, started to produce lemon and orange flavoured mineral water. During the course of time, people in Czech Republic and abroad became fond of the taste of Poděbradka.

**After 1993, the company Poděbradka s.r.o. was established, which later transformed into a joint-stock company. The operation was started of a new large-capacity production area in Velké Zboží on the outskirts of Poděbrady. Today, the company is part of an international corporation.**

At present, Poděbradka has five wells – two wells in Hořátkvi (HP 19 - 152 m deep and HP 20 - 160.5 m deep) and three wells in Velké Zboží (BJ 13 - 122.5 m deep, BJ 17 - 126 m deep and BJ 18 - 126 m deep).

When drawn from the well, the water is only de-ironed and saturated with CO<sub>2</sub>.

The cooperation of Poděbradka and NATE began already in 2008, when a bottle conveyor was installed in Poděbradka facilities. At the beginning of 2014, another delivery took place, consisting of the PETBLOK 24/16/4 with ULTRACLEAN covers, a complete conveyor system and a chlordioxide station.

At present, the company Poděbradka concentrates on bottling two new products launched this year: genuine orange lemonade and genuine raspberry lemonade. Both beverages are available in a new type of bottle with a new design. But what can Poděbradka lovers expect in near future? “If we do as well as we have been doing so far, we would like to launch other new products. However, we must maintain our common assortment which still attracts our customers,” revealed Ing. Běhounek, Poděbradka plant director.



## INSTALLATION IN CUBA

## HATUEY BREWERY, SANTIAGO DE CUBA

In April - on 14.4.2014 to be specific, our company engineers departed to install the NM KEG 60 line for filling KEG barrels.

## THE DELIVERY INCLUDED:

- an NG 120 washer of KEG barrel outside surface
- an NM KEG 30 washer and filler of KEG barrels, including CIP
- gravity conveyors
- roller conveyors
- apron conveyors
- KEG barrel turner
- inspection scale of KEG barrels

The automatic inspection scale of barrel filling of stainless steel type is situated behind the KEG barrel washer and filler.

The electronic control unit indicates the weight of every barrel. If insufficient filling is detected, a signal is given and the barrel is automatically discarded => transferred onto a parallel conveyor.

The electronic unit ensures digital displaying of the weight of the corresponding barrel, signalization of incorrect filling, weighing of multiple barrels and signalization of automatic discarding of a barrel.



## “WASHER ON A HOOK”

### BREWERY PIVOVAR SVIJANY A.S., SVIJANY

A bottle washer designated **ATHENA 28/28.3 VN T L II** was in production since autumn 2013. At the end of February 2014 it was delivered to its final customer. The new owner was Pivovar Svijany a.s., a brewery that can pride with the output of 594 363 hectolitres of beer in 2013 and a number of awards.

A medium category machine of upgraded design was supplied to the customer. The washer had undergone many innovations, including:

- internal insulation of the water tanks
- “mountlochs” – cleaning and service openings (external insulation)
- modified design of cleaning and service openings – better quality thermal insulation of the machine surface

The washer is distinguished for a number of features, including:

- the front acoustic covers
- pressure pre-injection
- automatic filtering of pressure pre-injection
- evacuation of H<sub>2</sub> vapours by means of control flap
- sensors of H<sub>2</sub> concentrations
- thermal insulation of the caustic tank
- thermal insulation of the piping
- label press – with return of caustic agent into the soaking tank
- screens under the bottle chute





This order did not involve the bottle washer only. It also included the disassembly and assembly of the new technology.

First, it was necessary to remove the old bottle washer, filler and conveyors out of the bottling plant and to adapt the hall to meet the new European standards.

The new technology was transported into the brewery building through a hole in the roof, 11 m long and 5.7 m wide.

The space and conditions for installation were very difficult. At present, the installation has been completed and the brewery Pivovar Svijany a.s. can boast with completely new equipment, which meets all strict requirements.

#### BOTTLE WASHER DIMENSIONS:

- length: 9730 mm
- height: 3167 mm
- width: 4147 mm

the first notice of the brewery dates back to 16th century

at the end of 20th century, the company Pivovar Svijany s.r.o. is established. At the beginning of 21st century, the company transformed into joint-stock company

the brewery constantly increases its beer production; at present, the sales amount to 594 363 hectolitres of beer

the brewery offers a wide range of beers, with the most favoured being the light lager Kníže and the dark Kněžna (13%)

# COOPERATION WITH PEPSICO GENERAL BOTTLES

The beginning of 2014 saw a delivery to the company Pepsi-Cola General Bottlers in Poland. The supplied equipment was the 0.25 l glass bottle filler VERAL 60/16.

## LIST OF DELIVERIES TO PEPSICO GENERAL BOTTLEERS

- 2014** Pepsi-Cola General Bottlers Poland Sp. z o.o., Poland - Filler VERAL 60/16
- 2013** PEPSICO CZ s.r.o., plant Praha, CZE - Inspection equipment EXAN LEVEL
- 2013** PEPSICO S.C.Quadrant Amroq Beverages S.R.L. plant Dragon, Bucharest, Romania - disassembly, renewal and installation of conveyor routes
- 2013** PepsiCo Russia - JSC "Wimm Bill Dann", Moscow, Russia - Rinser VL40
- 2012** PEPSICO S.C.Quadrant Amroq Beverages S.R.L., Romania - disassembly, renewal and installation of conveyor routes
- 2011** PEPSICO CZ s.r.o., Toma Teplice nad Metují, CZE - Reconstruction of low cap closing machine - Supply of complete glass bottle line with the output of 18,000 bottles per hour for filling saturated and non-saturated drinks into 0.3 l bottles
- 2009** Pepsi America, Vitarom Impex s.r.l., Covasna, Romania - Disassembly, reconstruction of the filler VERAL 64 ULTRACLEAN and the supply of conveyor routes
- 2008** PEPSICO CZ s.r.o., Toma Teplice nad Metují, CZE - Supply of inspection equipment, loader - unloader, crate washer and conveyor routes
- 2006** PPEPSICO s.r.o., Praha, CZE - Supply of conveyor routes
- 2003** PEPSICO s.r.o., Praha, CZE - Bottle washer DELTA 18/26



The company PepsiCo offers the widest assortment of food and drink brands in the world, including 22 various product series. The company incorporates several enterprises such as Quaker, Tropicana or Frito-Lay. It also owns several brands – Lipton or Cheetos Star Chips.

The output of the supplied machine differs according to the drink being filled. With Pepsi, the output is 32,200 bottles per hour, with Mirinda (saturated drinks) it is 28,000 bottles per hour and with TOMA fruit juices (non-saturated drinks) the output is 26,000 bottles per hour.



## SPECIFIC TRAINING IN THE COMPANY NATE

**The company NATE – nápojová technika a.s., similarly to other prosperous enterprises, attends** not only to its profits but also to economic, environmental or social aspects of social life as part of its CSR (Corporate social responsibility).



In the social area, the company attends not only to the needs of groups of people for whom social security need be provided but, above all, to the needs of its employees. The company offers them new possibilities of further education, qualification courses, specific and general training.

And this all thanks to the realization of the project called “Specific training in NATE”. The subject of the project is creating a flexible system of specific employee training that will react to the needs of company employees in the area of specific production processes. Training of employees will take place on the basis of production processes typical and unique, pursuant to NATE requirements.

The training project is focused on manufacture of electronic filling valve, bottle washer, inspection equipment and glass bottle closing machine. The project also includes professional training courses, which suitably complement the specific courses and add a logical frame to the presented project.

The anticipated impacts of the project on the target group of employees include increasing qualification, better team ability of job posts and an improvement in key knowledge and skills in the company environment. The impacts on the company include increased competitiveness and maintaining the company's market position, which is regarded as the main objective of the project.

However, the project has other objectives, too, including the already mentioned increased qualification of employees as a result of the specific and general training courses, preparation of company lecturers to ensure long-term sustainability of the project and subsequent creating of a system of specific training designated for company employees.

During the course of implementation of the project, the training courses will take place as part of practical training courses in production planning and management, technology and process of production and preparation of company lecturers. The implementation of the entire project will take place from January 2014 to April 2015, and it is ensured by the company BanCon, s.r.o.

## NATE AND SOCIAL AWARENESS

**Engagement of business companies in solving social issues was until recently perceived** on the economic level, that is from the point of costs cutting off the cake of profits.

Along with other companies, also NATE is aware of the necessity to engage in creating and forming the society where it operates. It contributes to its environment but, above all to itself, and thanks to its actions within the frame work of corporate social responsibility (CSR) it ensures its competitiveness in the market.

Companies implementing CSR in their actions try to create a so-called „shared value“, i.e. to generate benefits for the society by including social issues in their main business strategies.

Three main areas where the companies operate include the environmental, ecological and social sphere. The company NATE – nápojová technika a.s. has already for several years been interested in projects that have a potential in addressing the society as well as in bringing beneficial outputs. NATE not only supports projects helping the environment and environment protection, but also projects aimed at protection of endangered animal species. It supports its employees by providing qualification and educational training courses and lectures.

You can find detailed information on NATE social responsibility at our website, section “About us”.



**NATE - nápojová technika a.s.**  
EQUIPMENT FOR BEVERAGE INDUSTRY



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