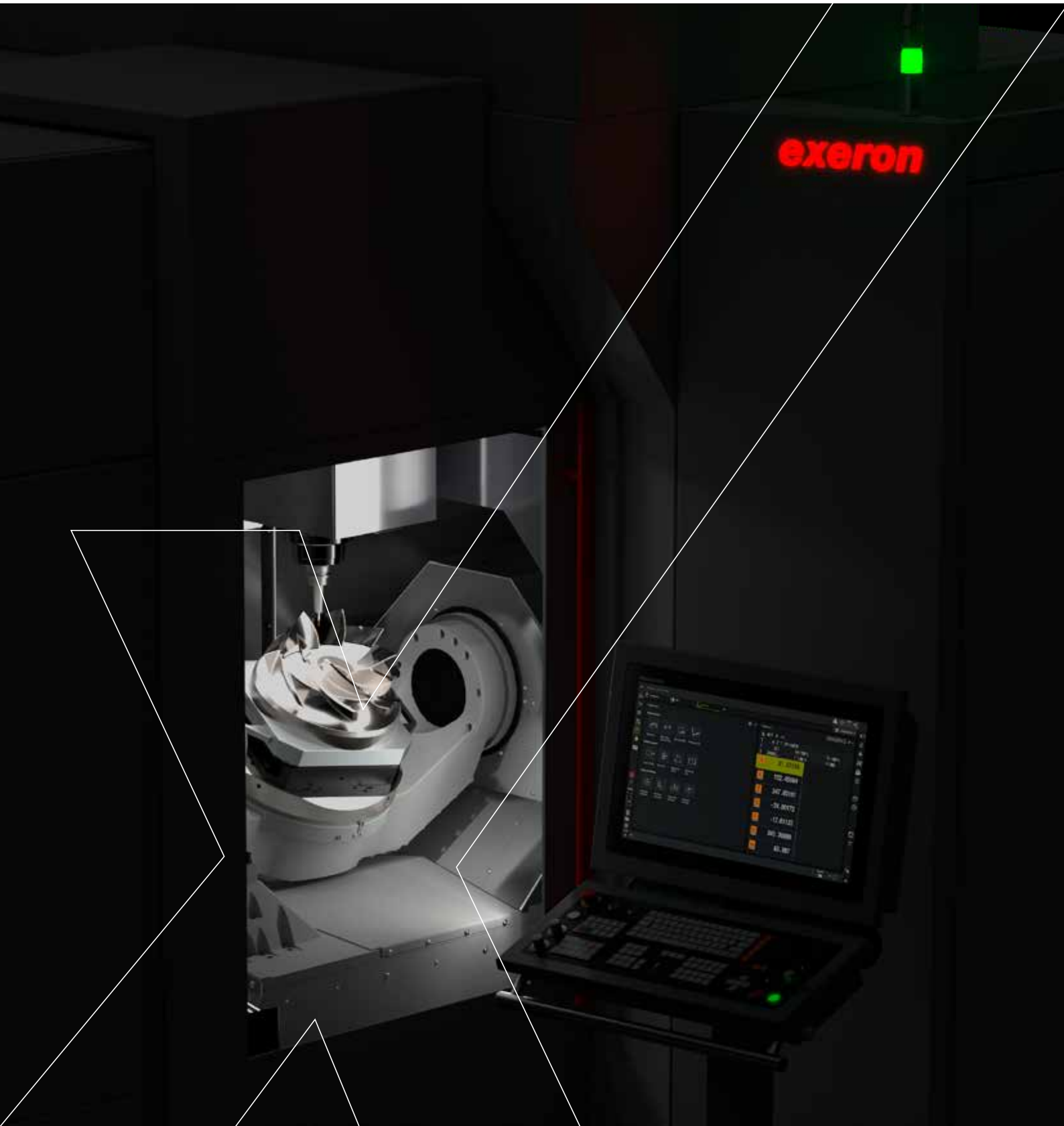
exeron
EXPERTS IN EDM + HSC

HSC GENERAL OVERVIEW



HIGH-SPEED MILLING WITH EXERON

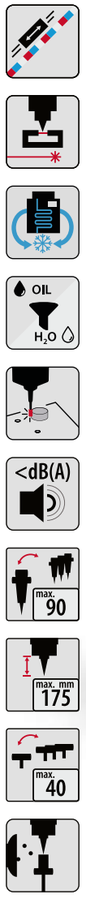
Pioneering high-speed milling has a name: exeron. Our HSC series impresses with maximum efficiency, absolute precision and excellent quality in the machining of workpieces. Our development is geared towards the varying requirements of our customers. Whether proven standard solutions or special customer-specific applications – our HSC series fulfils all requirements. Comprehensively thought through and automatable.

A love of innovation and more than 40 years of experience make the difference. On this basis, we develop machines that give you clear advantages on the market. With exeron you have a strong partner in various areas in the world of the high-speed milling. Our HSC series covers a wide spectrum: from compact systems for small workpieces to an impressive workspace of 800 x 900 x 540 mm and 210 tool pockets. For even more efficiency and productivity in your tool and mould making. Designed and made in Germany.

SAMPLE PARTS

HSC MP7

Versatile, extremely precise, highly efficient: The HSC MP7 sets new standards for modern milling machines in the high-end range. Mechanical engineering with high stiffness and damping optimised for linear direct drives ensures that the machine is ideally prepared for optimal machine dynamics, maximum precision and perfect workpiece quality.



- Holistic active temperature control
- High-quality interior design in stainless steel
- Large distance between spindle nose and table as well as generous Z-axis travel distance
- Convenient and powerful CNC control technology – Heidenhain TNC 7
- Covered measurement system
- Internal spindle length sensor system
- Preparation for automation

	HSC MP7/3 three axes	HSC MP7/5 five axes
Travelling distances X x Y x Z	730 x 340 x 400 mm	730 x 250 x 400 mm
Travelling distances B x C		B ±105° x C infinite
Workspace X x Y x Z	640 x 340 x 400 mm	640 x 250 x 400 mm
Clamping table/faceplate	580 x 460 mm	Ø 185 mm
Distance table/spindle nose	550 mm HSK-E40	450 mm HSK-E40
Workpiece weight max.	550 kg	60 kg
Dimensions W x D x H	2,400 x 2,370 x 3,000 mm	2,400 x 2,370 x 3,000 mm
Spindle speed	42,000 rpm HSK-E40	42,000 rpm HSK-E40
Spindle power S1/S6–40%	10 kW/13.5 kW HSK-E40	10 kW/13.5 kW HSK-E40
Tool magazine	30/60/90 HSK-E40	30/60/90 HSK-E40
Rapid traverse X x Y x Z	40 m/min.	40 m/min.
Rotation speed B/C		190/250 rpm
CNC control	Heidenhain TNC 7	Heidenhain TNC 7

Option
Integrated pallet changer HSC MP7/P

Complete, efficient, trendsetting: The optional pallet changer makes the HSC MP7 ideal for the fully automatic, high-precision production of electrodes and parts. The integrated workpiece handling system, which is completely separated from the workspace, enables considerably greater machine utilisation to be achieved.

Your advantages:

- Available for various clamping systems
- Two magazine levels with max. 40 pallet places
- Maximum transfer weight pallet changer 15 kg

HSC MP9

Flexible, precise, efficient: Our latest family member, the HSC MP9, combines microprecision with the big ideas of an innovative series. The pioneering machine development is based on intensive discussions with users – it is characterised by maximum precision, large machining volumes, efficiency, reliability and longevity.

- Holistic active temperature control
- High-quality interior design in stainless steel
- Large distance between spindle nose and table as well as generous Z-axis travel distance
- Convenient and powerful CNC control technology – Heidenhain TNC 7
- Laser measurement system outside the workspace
- Internal spindle length sensor system
- Preparation for tool and workpiece automation

	HSC MP9/5 five axes
Travelling distances X x Y x Z	955 x 625 x 400 mm
Travelling distances B x C	B ±105° x C infinite
Workspace X x Y x Z	725 x 625 x 400 mm
Clamping table/faceplate	Ø 412 mm
Distance table/spindle nose	600/574 mm HSK-E40 586/560 mm HSK-E50
Workpiece weight max.	250 kg
Dimensions W x D x H	2,610 x 3,080 x 3,150 mm
Spindle speed	42,000 rpm HSK-E40 36,000 rpm HSK-E50
Spindle power S1/S6–40%	10 kW/13.5 kW HSK-E40 24.8 kW/33 kW HSK-E50
Tool magazine	30/60/90/120 HSK-E40 27/54/81/108 HSK-E50
Rapid traverse X x Y x Z	60 m/min.
Rotation speed B/C	100/100 rpm
CNC control	Heidenhain TNC 7

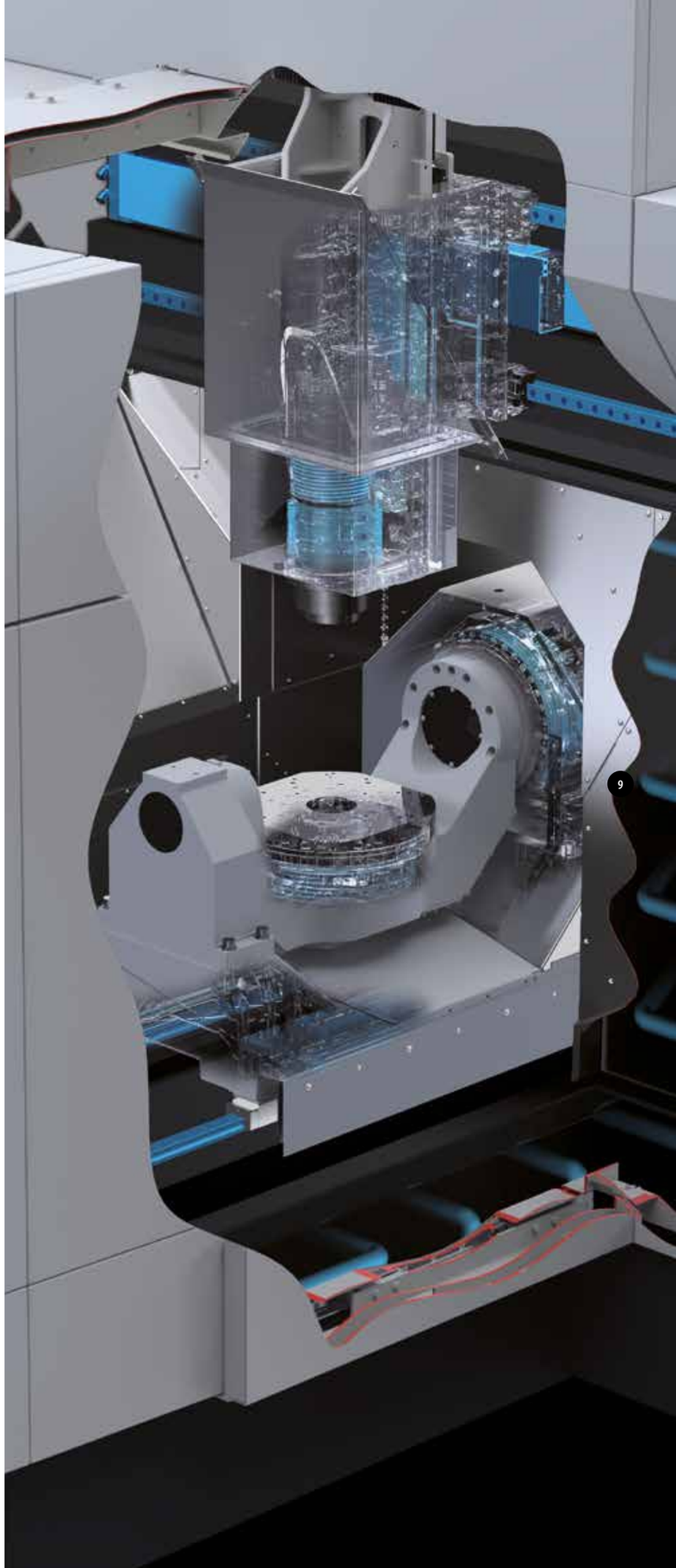
COOL BASE CONCEPT

Meeting the highest standards during daily operation requires a sophisticated cooling system so that you can keep a cool head at all times, even during the hottest production phases. The pioneering exeron cooling concept consists of:

- Combined gantry and bed cooling
- Spindle and surface cooling
- Cooling of all axes, including slides, linear guides and drives

Your advantages:

- More power
- More precision
- More durability



HSC MP11

Large, economical, durable: The HSC MP11 rounds off the size of the HSC MP line upwards.
Various practical customer requirements were incorporated into the development of the machine: Precision, large machining capacity, profitability, reliability and durability. In addition, the largest family member is characterised by numerous clever ideas. Combining all innovative improvements in a single system results in maximum precision and efficiency.

- Holistic active temperature control
- High-quality interior design in stainless steel
- Design for minimum quantity lubrication, dry, cutting oil, minimum and wet machining
- Internal spindle length sensor system
- Tool magazine for up to 210 tool pockets
- Preparation for various automation and cell solutions with tool and workpiece automation
- Comfortable and powerful CNC control technology of the latest generation - Heidenhain TNC 7

	HSC MP11/3 three axes	HSC MP11/5 five axes
Travelling distances X x Y x Z	1,055 x 900 x 540 mm	1,055 x 760 x 540 mm
Travelling distances B x C		B ±105° x C infinite
Workspace X x Y x Z	800 x 900 x 540 mm	800 x 760 x 540 mm
Clamping table/faceplate	850 x 1,060 mm	412 x 412 mm
Distance table/spindle nose	720/694 mm HSK-E40 706/680 mm HSK-E50	720/694 mm HSK-E40 706/680 mm HSK-E50
Workpiece weight max.	1,000 kg	350 kg
Dimensions W x D x H	2,390 x 4,500 x 3,350 mm	2,390 x 4,500 x 3,350 mm
Spindle speed	42,000 rpm HSK-E40 36,000 rpm HSK-E50	42,000 rpm HSK-E40 36,000 rpm HSK-E50
Spindle power S1/S6–40%	10 kW/13.5 kW HSK-E40 24.8 kW/33 kW HSK-E50	10 kW/13.5 kW HSK-E40 24.8 kW/33 kW HSK-E50
Tool magazine	max. 210 HSK-E40 max. 189 HSK-E50	max. 210 HSK-E40 max. 189 HSK-E50
Rapid traverse X x Y x Z	80 m/min.	80 m/min.
Rotation speed B/C		100/100 rpm
CNC control	Heidenhain TNC 7	Heidenhain TNC 7

MORE SPACE FOR GREAT IDEAS

The HSC MP11, which is constructed in the gantry design, is available in a 3-axis and 5-axis configuration.
The 5-axis version deliberately relies on the counter bearing solution for the 4th axes. The possibilities of wet and graphite machining round off the wide range of applications of the HSC MP11.
The latest generation of Heidenhain control and axis control technology ensures the best results in interaction with the maintenance-free linear direct drives.

Your advantages:

- Large workspace
- Perfectly accessible despite large dimensions
- Maximum precision even with large workpieces

HSC 600

Space-saving, dynamic, universal:
The HSC 600 is a powerful high-end machining solution for universal 5-axis use in tool and mould making. The extremely small footprint of this high-end machine also makes it ideal for use in locations where space is limited.

- Optimised workspace for 5-axis machining
- Maximum dynamics through torque drive in the swivel axes for the 5-axis simultaneous machining
- Extremely small footprint
- Ideal accessibility for operators and automation concepts
- Construction with high stiffness for optimal machine dynamics, high precision and perfect workpiece quality
- Temperature-controlled machine base frame made from mineral cast with extreme stiffness and high thermal inertia
- Direct travel measuring systems – resolution 0.01 µm
- Vector-controlled high-frequency spindles for the use of tools from 0.2 to 25 mm in diameter
- Heidenhain CNC control technology specially designed for HSC technology

	HSC 600/3 three axes	HSC 600/5 five axes
Travelling distances X x Y x Z	585 x 550 x 400 mm	650 x 550 x 400 mm
Travelling distances B x C		B ±100° x C infinite
Clamping table/faceplate	530 x 900 mm	Ø 410 mm
Distance table/spindle nose	600 mm HSK-E40 586/560 mm HSK-E50	600 mm HSK-E40 586/560 mm HSK-E50
Workpiece weight max.	600 kg	200 kg
Dimensions W x D x H	2,250 x 2,400 x 2,900 mm	2,250 x 2,400 x 2,900 mm
Spindle speed	42,000 rpm HSK-E40 36,000 rpm HSK-E50	42,000 rpm HSK-E40 36,000 rpm HSK-E50
Spindle power S1/S6–40%	10 kW/13.5 kW HSK-E40 24.8 kW/33 kW HSK-E50	10 kW/13.5 kW HSK-E40 24.8 kW/33 kW HSK-E50
Tool magazine	30/60/90 HSK-E40 27/54/81 HSK-E50	30/60/90 HSK-E40 27/54/81 HSK-E50
Rapid traverse X x Y x Z	50 m/min.	50 m/min.
Rotation speed B/C		80/80 rpm
CNC control	Heidenhain TNC 7	Heidenhain TNC 7

Integrated tool measurement

All high-speed cutting centres from exeron are equipped with high-precision laser measurement systems “Made in Germany” as standard.
This means that a high degree of precision and reliability can be achieved even in the toughest of conditions and with long program runtimes.

Your advantages:

- Highly dynamic measurement of all tool characteristics
- Continuously good part accuracy
- Detection of changes in geometry and tool breakage

AVAILABLE OPTIONS

Axis drives

Feed axes with highly dynamic linear direct drives

Feed axes with ball screw drive technology

Oil/emulsion

Emulsion system with swarf conveyor and belt filter. Available as high-pressure or low-pressure versions

exoclean cutting oil system with environmentally friendly backflush filter, fire extinguishing system and electrostatic oil mist extraction

Tool measurement

High-precision laser measurement system for setting and monitoring tools

Spindle

High-frequency spindle with ceramic ball bearings with up to 42,000 rpm and tools with a length of up to 210 mm

Low noise concept

Noise minimisation thanks to an acoustically optimised, encapsulated workspace

Cool base concept

Intelligent cooling system for the maximum temperature stability of all accuracy-relevant machine components

Dust extraction

High-performance extraction for graphite machining

High-performance extraction for graphite machining, optionally with directed supply air flow

exogrind

Coordinate grinding and milling on the same machine, including HMI assistance and dressing spindle.
Optionally available with structure-borne sound sensor and headphones.

Tool changer

Integrated tool magazine with capacity for up to 210 tools

Pallet changer

Integrated workpiece handling system with capacity for up to 40 pallets

Tool cleaning

High-pressure spray mist to reliably remove soiling from the tool

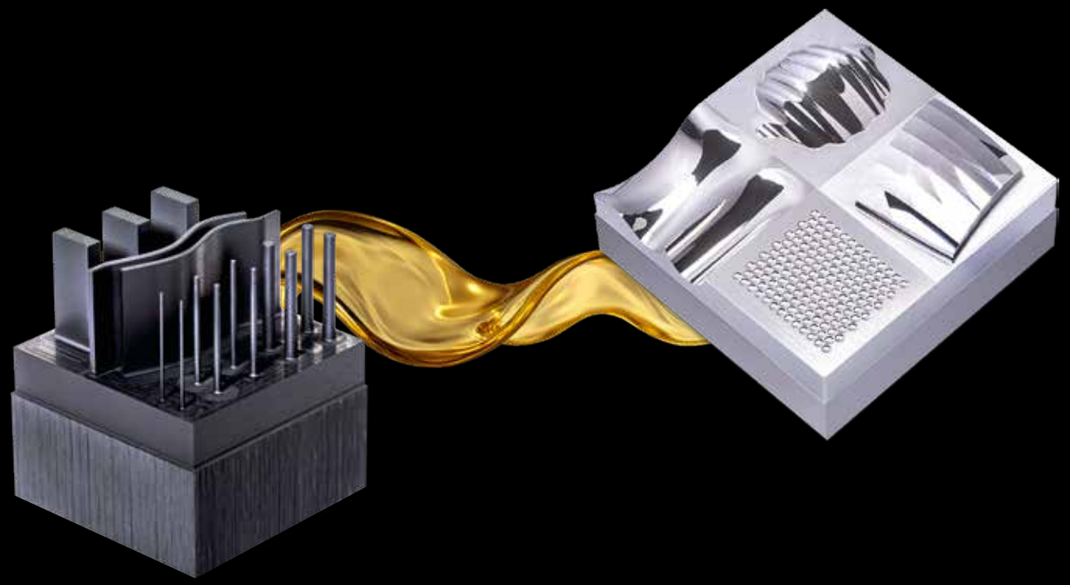
CHALLENGE US!

Customer solutions

Every order is different. State-of-the-art HSC machines from exeron enable you to optimally fulfil your customers' requirements. We often find that the right solution already exists in our standard range – with some minor adjustments, if necessary. In case of more complex requirements, our technical expertise is an unbeatable advantage: We will develop the ideal machine for your milling tasks together with you. Your need, our consultancy service and our specialist know-how are guaranteed to lead to success. If you have any questions, please contact our Application Technology and Service departments directly. Our experts are your problem solvers. From the design to the start of production and ongoing operation.

Customer-specific solution:

Pallet changer with 160 workpiece pockets for very small workpieces in a magazine with high storage capacity. The HSC machine fully automatically withdraws the workpieces from the rotary magazine for machining. The operator benefits from excellent accessibility, which ensures that workpieces can be individually loaded into the magazine manually using the freely rotatable levels.



exogrind
GROUND TO PERFECTION

Precise finishing immediately after HSC machining

To achieve maximum precision and the most demanding surface finishes – particularly in tool and mould making – it may be necessary to supplement HSC machining with an additional machining step. This is exactly where exogrind comes in: coordinate grinding on exeron HSC milling machines takes care of the finishing of, for example, column drill holes, punches and mirror-finish surfaces. The key point is that you can carry out this step within the same set-up immediately after HSC machining.

Perfect results, faster

Many companies outsource this finishing touch – with additional costs and lead times. The "coordinate grinding" option now gives you the freedom to carry out the final finishing yourself. This translates into shorter throughput times, fewer dependencies on third parties and, at the same time, a clear competitive edge in terms of accuracy.

Prepared for any challenge

This option has been specifically designed with everyday practicality in mind, ensuring that the procedure is easy to use in day-to-day operations. The fluid-structure-borne sound sensor facilitates 5-axis grinding – delivering high flexibility without the risk of signal interference or flat batteries in wireless transmitters. The built-in graphic display of structure-borne sound signals supports the reliable and rapid calculation of the relevant grinding times directly on the large touchscreen – an absolute must-have for both beginners and professionals.

Our team would be happy to demonstrate the system's capabilities during a demonstration or trial run, and to help you develop expertise through training courses tailored to your needs.

exoclean
FILTRATION REFINED

Impressive filtering, perfect quality

exoclean is the perfect option for filtering and treating cutting oil for HSC milling machines. This system has been designed to reliably stabilise your machining process and keep all parameters within the optimum range throughout the entire production cycle. The focus is on excellent temperature control and filtration: The removal of the finest impurities and the outstanding temperature control ensure that process conditions remain consistent throughout. As a result, you can expect a consistently high standard of quality, even for your most demanding applications.

Your advantage, developed by exeron

Regardless of whether the oil is supplied externally or via the tool, it is always delivered by highly efficient pumps, ensuring optimum cooling and lubrication with every piece of swarf, around the clock. This results not only in unparalleled quality, but in many cases also in drastically reduced tool wear and, consequently, significantly lower costs.

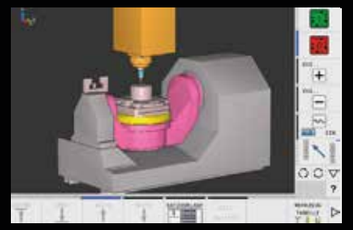
Efficient, quiet, environmentally friendly

Oil filtration is extremely energy-efficient, particularly when compared with a centrifuge offering a similar filtration capacity. At the same time, the filter system is significantly more economical and quieter in operation. exoclean also scores highly when it comes to sustainability: The filter candles are fully automatically flushed and reused, which reduces the effort required on your part and helps protect the environment.

HEIDENHAIN TNC 7: THE BEST FOR YOUR APPLICATIONS

With regard to control technology, at exeron we have full conviction in the Heidenhain TNC 7. With good reason. Its clear text programming means that it is not only easy to learn, but also the most. Ultimately, it "grew up" in tool and mould making, where the requirements for accuracy and surface quality are extremely high.

A further important advantage for you: We make the TNC 7 control software available to every customer in their language.



HSC motion guide of the highest quality
The TNC 7 not only smooths the milling paths, but also analyses the milling path curve with regard to vibrational excitations and thus prevents all machine vibration. In addition, it always adheres to the programmed tolerance during vibration-absorbing interventions in the motion guide. The also applies to tool alignments in the space – which produces unparalleled milling results in 5-axis simultaneous machining.

Automatic recalibration of the kinematic transformation
Accuracy requirements are becoming ever higher, especially in the area of 5-axis machining. For example, complex parts must be produced to precision and with reproducible accuracy, even over long periods of time. However, machine components are subject to relatively strong temperature fluctuations during machining as a result of axis movements and the spindle. The kinematic transformation chain should also be adapted to these changes in order to achieve optimal machining results. HEIDENHAIN controls with the KinematicsOpt software option will assist you with this complex task.

Dynamic collision monitoring (DCM)
Modern machine tools and controls help to make the machining process ever better and efficient. In order not to jeopardise the high productivity, collision-related interruptions and downtime must be prevented.
The dynamic collision monitoring (DCM) software option offers optimal protection. DCM cyclically monitors the workspace of the machine for possible collisions between machine components. The control interrupts machining in case of an impending collision and thus ensures increased safety for the operator and the machine. In this way, DCM prevents damage to the machine and the resulting costly downtime and improves the safety of unstaffed shifts.
However, DCM collision monitoring does not only work in automatic mode, but is also active during manual operation. For example, if the machine operator is on a collision course while setting up a workpiece, the control recognises this and stops the axis movement with an error message.

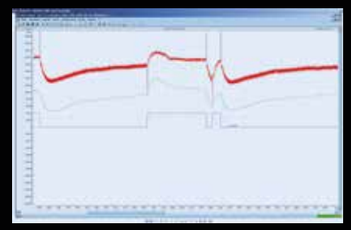
ASQ ADVANCED SURFACE QUALITY CONTROL

Conventional milling has its limits. Until now, the influence of certain physical effects – such as the "thermal squall effect" of milling spindles – were virtually unavoidable when milling complex surfaces. This resulted in inaccuracies in the surface quality that had to be subsequently compensated.

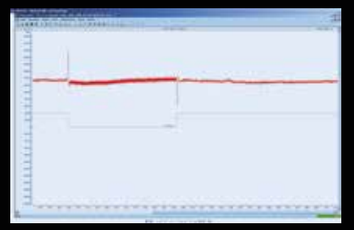
Our unique ASQ (Advanced Surface Quality Control) process prevents such inaccuracies and thus sustainably optimises the surface quality of milled parts. ASQ is a control engineering process based on the state model that is used to optimise surface quality and Z-accuracy.

By means of control-related interventions – such as absorbing minimal vibrations – it is capable of improving the quality of milled surfaces to such an extent that rework is reduced or completely unnecessary.

Z-accuracy without ASQ



Z-accuracy with ASQ



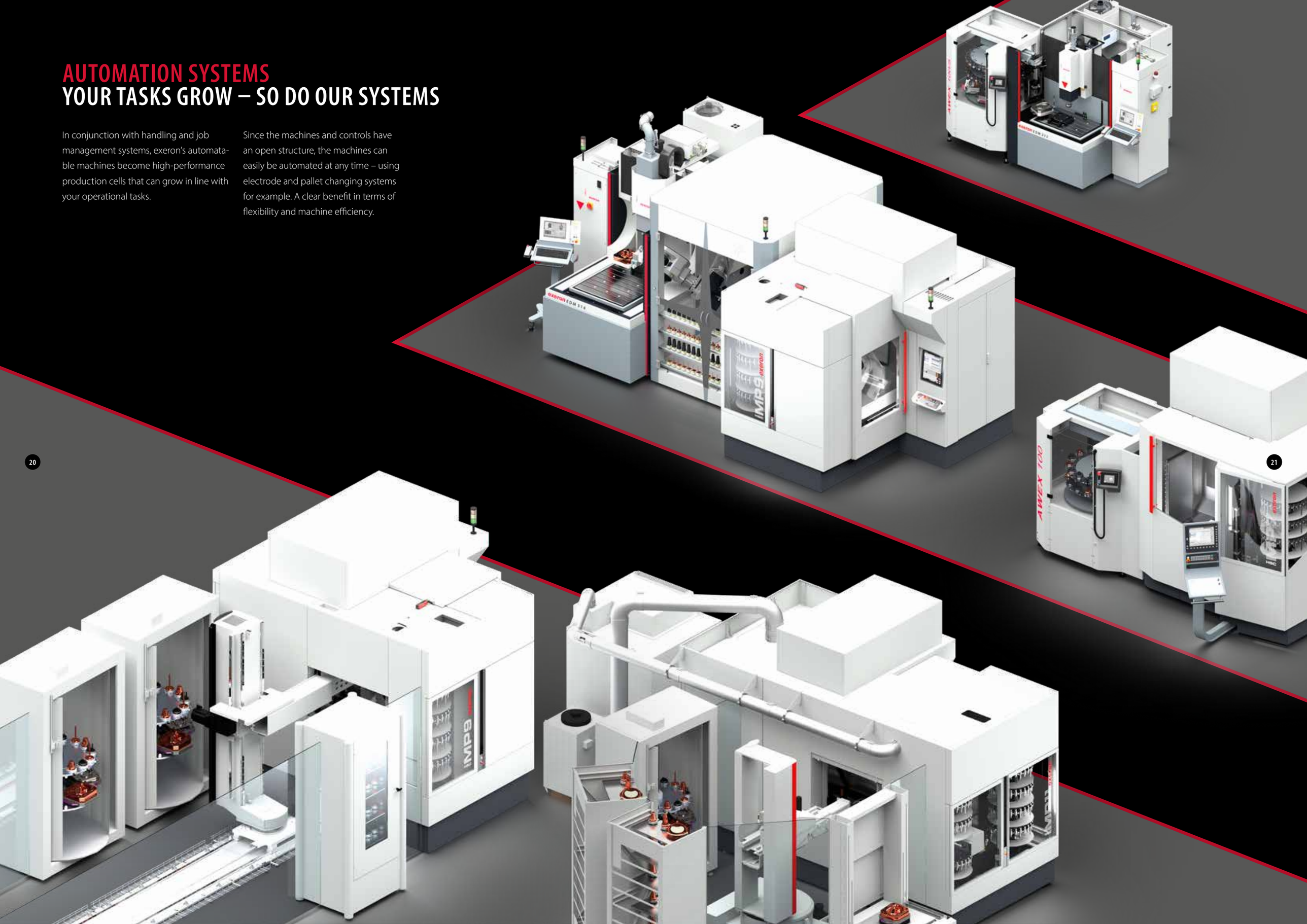
How does ASQ from exeron work?
By means of continuous state monitoring, ASQ can actively dampen and therefore compensate for physical effects such as the thermal squall effect of the milling spindle. In this way, the Z-accuracy – i.e. the accuracy of the vertical Z milling axis – is kept within much tighter tolerances than was previously possible. This is achieved by continuously monitoring the oscillation of the milling head via the ASQ software, for example. The advantages of ASQ very quickly become clear in an extra narrow tolerance band. The Z-accuracy that can be achieved with ASQ is considerably finer and always stays within this tolerance band after the ASQ calibration phase. Without ASQ, by contrast, oscillations often go beyond the tolerance limits – with significantly higher peaks.

How do parts with ASQ from exeron turn out?
ASQ substantially increases the surface quality. For example, a surface roughness of Ra = 0.03 µm is possible with brass, while for steel with a Rockwell hardness of 58 HRC the figure is 0.08 µm. With a tolerance of S diff, max = 0.4 µm, quadrant transition errors now only fall within the range of the wavelength of light and therefore within the visibility limit. These results can only otherwise be achieved with hydrostatic drive and bearing technology.
In a nutshell: With ASQ, we demonstrate the true meaning of excellent mechanical engineering – at a perfect price/performance ratio.

AUTOMATION SYSTEMS
YOUR TASKS GROW – SO DO OUR SYSTEMS

In conjunction with handling and job management systems, exeron's automatable machines become high-performance production cells that can grow in line with your operational tasks.

Since the machines and controls have an open structure, the machines can easily be automated at any time – using electrode and pallet changing systems for example. A clear benefit in terms of flexibility and machine efficiency.



OUR APPLICATION TECHNOLOGY
EXPERTISE LIVE

You are dealing with a difficult task and seek a competent partner. This where our application technology experts come into play – they love a challenge. They will seek the ideal solution and the optimum milling machine to enable you to machine workpieces efficiently and economically. With their extensive know-how, our Application Technology department is the link between Development and customers. Our specialists combine individual consultation, in-depth specialist knowledge and long-time experience to provide comprehensive problem-solving expertise. They will develop and test new technologies and software for you and incorporate the latest market requirements into our machines.

In any case, our application technology experts also act out of conviction in the best possible sense: They will help you to utilise the full capability of our systems. In the process, they will develop customer-specific solutions together with you if necessary. Challenge us. We will gladly carry out a trial machining run with your workpiece because we know that the decision to opt for one of our innovative machines will be an easy one. We will be supported by a modern measuring centre that attests to the high machining precision and simultaneously fulfils our high quality requirements.

Have we convinced you? Then we look forward to starting a cooperative partnership. We will guide you through the commissioning of your new exeron machine, support you with tailored operator training and advanced courses for maximum production success and answer any questions you may have at any time during ongoing operation. We are there for you when you need us.

EXERON SALES PARTNERS AROUND THE WORLD

We speak your language. We mean this literally and figuratively. Because we are present worldwide, you can always expect competent employees from your country, who understand you perfectly as a native speaker. As well as the concerns or problem you are dealing with.

Wherever you are, we are close at hand. With service locations and showrooms where you can see our EDM and HSC machines and experience them at first hand. That is exactly what you want! You see, we understand each other.

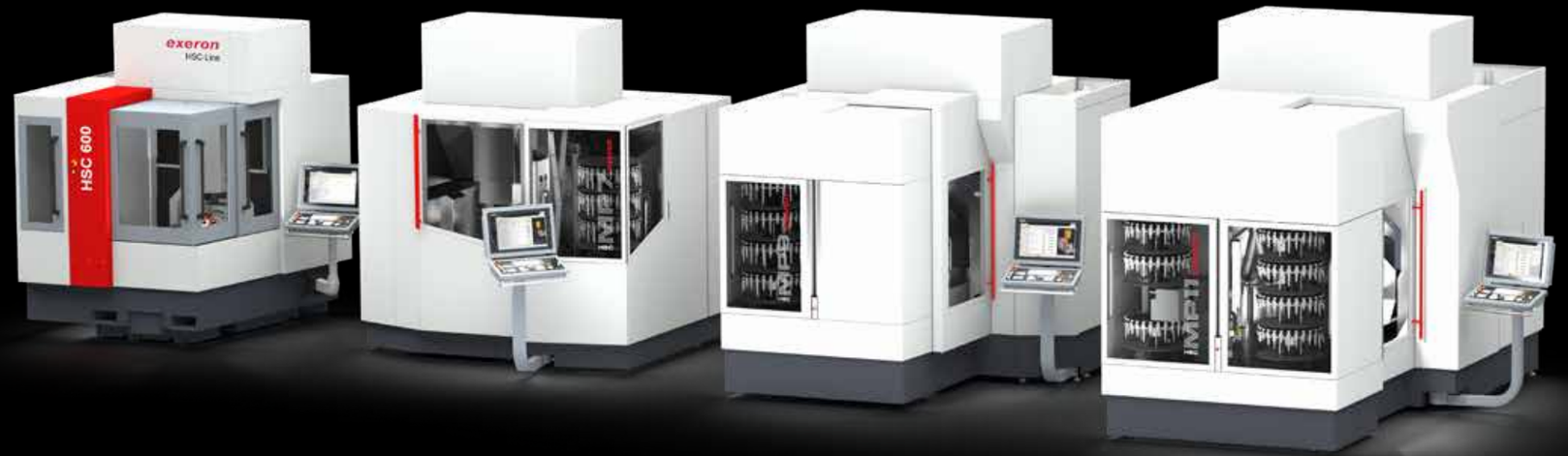
EXERON EUROPE

THE HSC LINE

We will gladly provide you with an overview of all exeron High-speed milling machines. You can find all the relevant details here and thus make a direct comparison. Technical changes that serve to further develop our machines may lead to deviations of individual parameters.

Do you have any further questions – about special requirements or the implementation of individual specifications, for example? Then get in touch! Our experts will be happy to advise you. We look forward to talking to you.

Made in Germany



	HSC 600/3	HSC 600/5	HSC MP7/3	HSC MP7/5
Travelling distances X x Y x Z	585 x 550 x 400 mm	650 x 550 x 400 mm	730 x 340 x 400 mm	730 x 250 x 400 mm
Travelling distances B x C		B ±100° x C infinite		B ±105° x C endlos
Workspace X x Y x Z	585 x 550 x 400 mm	650 x 550 x 400 mm	640 x 340 x 400 mm	640 x 250 x 400 mm
Clamping table/faceplate	530 x 900 mm	Ø 410 mm	580 x 460 mm	Ø 185 mm
Distance table/spindle nose	600 mm HSK-E40 586/560 mm HSK-E50	600 mm HSK-E40 586/560 mm HSK-E50	550 mm HSK-E40	450 mm HSK-E40
Workpiece weight max.	600 kg	200 kg	550 kg	60 kg
Total dimensions W x D x H	2,250 x 2,400 x 2,900 mm	2,250 x 2,400 x 2,900 mm	2,400 x 2,370 x 3,000 mm	2,400 x 2,370 x 3,000 mm
Spindle speed	42,000 rpm HSK-E40 36,000 rpm HSK-E50	42,000 rpm HSK-E40 36,000 rpm HSK-E50	42,000 rpm HSK-E40	42,000 rpm HSK-E40
Spindle power S1/S6 – 40%	10 kW/13.5 kW HSK-E40 24.8 kW/33 kW HSK-E50	10 kW/13.5 kW HSK-E40 24.8 kW/33 kW HSK-E50	10 kW/13.5 kW HSK-E40	10 kW/13.5 kW HSK-E40
Tool magazine	30/60/90 HSK-E40 27/54/81 HSK-E50	30/60/90 HSK-E40 27/54/81 HSK-E50	30/60/90 HSK-E40	30/60/90 HSK-E40
Rapid traverse X x Y x Z	50 m/min	50 m/min	40 m/min	40 m/min
Rotation speed B/C		80/80 rpm		190/250 rpm
CNC control	Heidenhain TNC 7	Heidenhain TNC 7	Heidenhain TNC 7	Heidenhain TNC 7

	HSC MP9/5	HSC MP11/3	HSC MP11/5
Travelling distances X x Y x Z	955 x 625 x 400 mm	1,055 x 900 x 540 mm	1,055 x 760 x 540 mm
Travelling distances B x C	B ±105° x C infinite		B ±105° x C infinite
Workspace X x Y x Z	725 x 625 x 400 mm	800 x 900 x 540 mm	800 x 760 x 540 mm
Clamping table/faceplate	Ø 412 mm	850 x 1,060 mm	412 x 412 mm
Distance table/spindle nose	600/574 mm HSK-E40 586/560 mm HSK-E50	720/694 mm HSK-E40 706/680 mm HSK-E50	720/694 mm HSK-E40 706/680 mm HSK-E50
Workpiece weight max.	250 kg	1,000 kg	350 kg
Total dimensions W x D x H	2,610 x 3,080 x 3,150 mm	2,390 x 4,500 x 3,350 mm	2,390 x 4,500 x 3,350 mm
Spindle speed	42,000 rpm HSK-E40 36,000 rpm HSK-E50	42,000 rpm HSK-E40 36,000 rpm HSK-E50	42,000 rpm HSK-E40 36,000 rpm HSK-E50
Spindle power S1/S6 – 40%	10 kW/13.5 kW HSK-E40 24.8 kW/33 kW HSK-E50	10 kW/13.5 kW HSK-E40 24.8 kW/33 kW HSK-E50	10 kW/13.5 kW HSK-E40 24.8 kW/33 kW HSK-E50
Tool magazine	30/60/90/120 HSK-E40 27/54/81/108 HSK-E50	max. 210 HSK-E40 max. 189 HSK-E50	max. 210 HSK-E40 max. 189 HSK-E50
Rapid traverse X x Y x Z	60 m/min	80 m/min	80 m/min
Rotation speed B/C	100/100 rpm		100/100 rpm
CNC control	Heidenhain TNC 7	Heidenhain TNC 7	Heidenhain TNC 7

Technical details subject to change

exeron
EXPERTS IN EDM + HSC

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Made in Germany

exeron combines EDM and HSC competence to sustainable success for its customers and offers this as a manufacturer of efficient, reliable and durable eroding machines (EDM) and high-speed milling machines (HSC) as well as handling systems (automation) "Made in Germany". exeron stands for professionalism, quality, customer orientation, flexibility and service competence.

We reserve the right to make design changes and other changes to technical data and performance features insofar as they serve technical progress, mistakes, printing, calculation, writing and calculation errors.

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