

**ONE PLANT
ONE CITY
TWO WHEELS.**



**BMW
GROUP**
Plant Berlin

BMW Motorrad

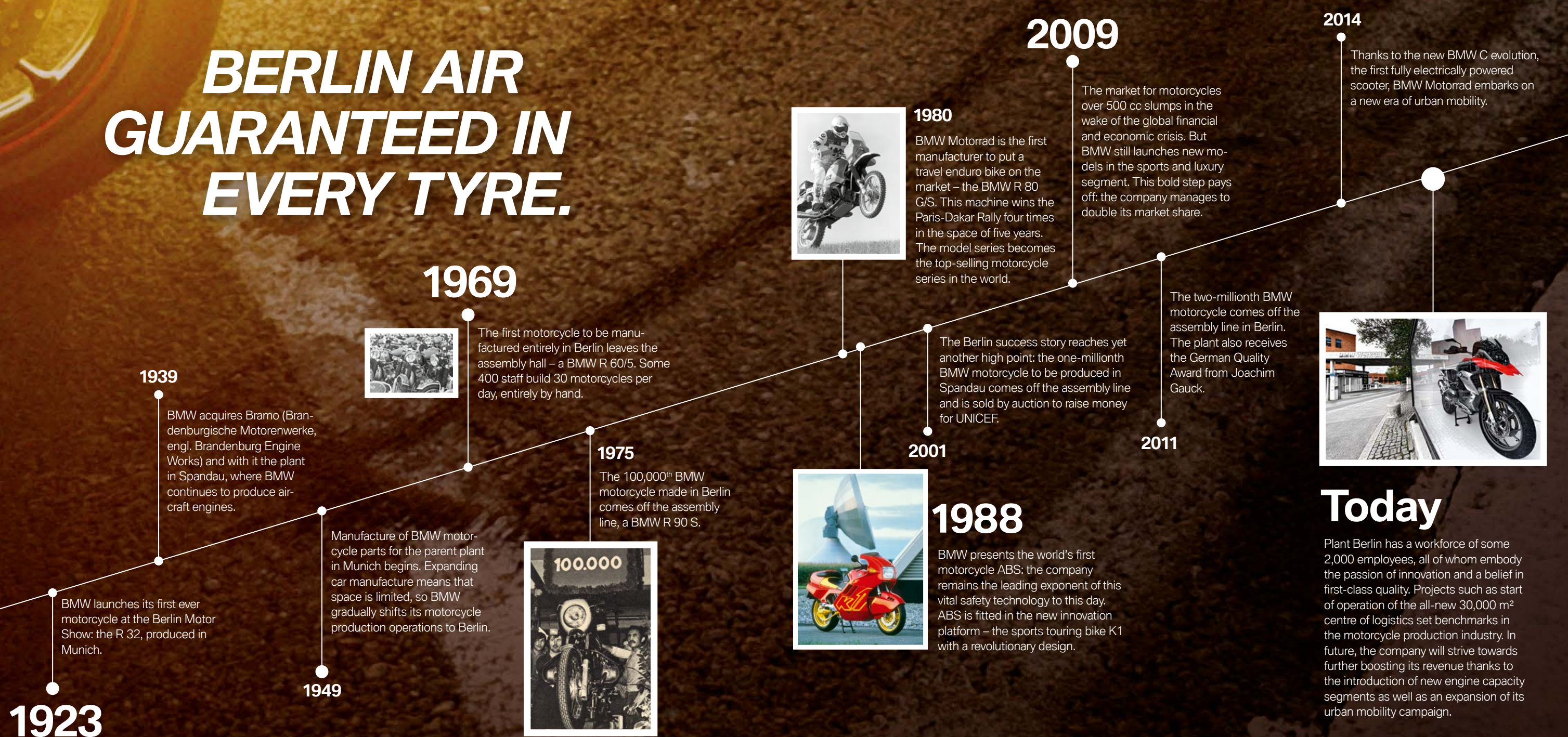


Since
1969

we have been building
BMW motorcycles and
scooters in Spandau, and
we will continue to do so
in the future.



BERLIN AIR GUARANTEED IN EVERY TYRE.



BERLIN. A PLACE WITH A HISTORY AND A FUTURE.

**Capital city, global hub, epitome of the modern age:
Berlin is synonymous with individual style and reflects
a commitment to motorcycling.**

No other city more authentically embodies dynamic performance, pioneering ideas and an eventful history than Berlin. The BMW plant in Berlin is one of the BMW Group's most tradition-steeped production sites. This is where the acceleration, banking capacity and sound of a BMW motorcycle are born - it is a place that produces legends.

Today

Plant Berlin has a workforce of some 2,000 employees, all of whom embody the passion of innovation and a belief in first-class quality. Projects such as start of operation of the all-new 30,000 m² centre of logistics set benchmarks in the motorcycle production industry. In future, the company will strive towards further boosting its revenue thanks to the introduction of new engine capacity segments as well as an expansion of its urban mobility campaign.

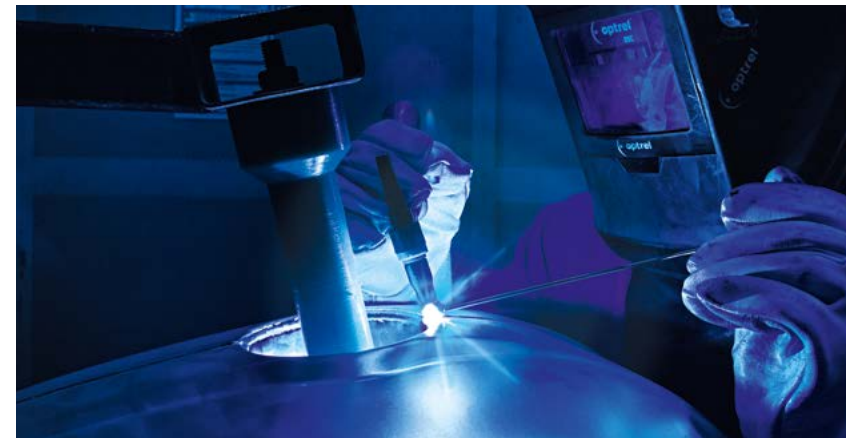
MECHANICAL PRODUCTION

ON FIRE FOR PRECISION.

This is where the core engine parts are made such as the casing, cylinder heads, crankshafts and rods. We also produce frames and fuel tanks in the plant's own welding shop.

Even the finest saw is too rough for us, so we use lasers to cut our rods. This enables us to create forged crankshafts from a single piece of solid material, which is how we achieve the running smoothness and reliability that is so characteristic of BMW motorcycles. We "nitrify" the crankshafts - in other words we harden them using nitrogen at 600 degrees.

Aluminium fuel tanks are extremely beneficial in terms of weight. We are the only motorcycle manufacturer to master the art of hand-welding 1.5 mm sheets of metal in serial production.



We produce

4,000

parts per day for motorcycle
production and assembly, timed
to the nearest minute.

ENGINE PRODUCTION

OPEN-HEART SPECIALISTS.

An athlete has to have power and stamina – and that requires a strong, healthy heart. The same applies to our motorcycles. This is why nothing about the way we produce our engines is left to chance.

Perfectly prepared and fitted like a surgeon's operating table, parts carriages follow the engines during assembly. There are a total of up to 600 parts specific to particular countries and customers. It takes about two hours to finish building an engine, after which it undergoes cold testing and a leak test.



Every day we assemble up to

560

high-performance boxer, 4-cylinder
and 6-cylinder engines.



PAINTSHOP

BRILLIANT HARMONY BETWEEN MAN AND TECHNOLOGY.

The paintshop brings together innovative technologies and traditional craftsmanship. Seven computer-controlled robots are in operation at one of the world's most state-of-the-art facilities.

The robots are capable of painting components of varying sizes and geometry in more than 50 colours and in no fixed sequence. They do so using nothing but environment-friendly, water-based paints.

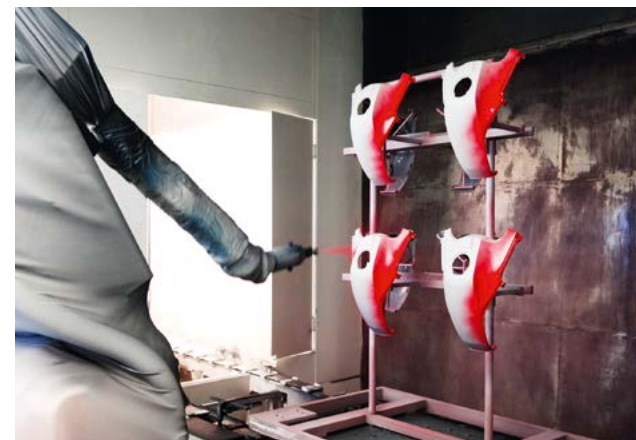
The skills of experienced painting specialists are still required for many tasks, however. A calm hand is often crucial, especially when applying tape applications. On special occasions we still have our experts draw traditional decorative lines on the fuel tank, giving a BMW motorcycle its unique style and individual flair.



Every day we produce up to

7,000

parts in more than 50 different colours.
With its perfect finish, each BMW motorcycle is an individual masterpiece.



MOTORCYCLE ASSEMBLY

AS INDIVIDUAL AS THE RIDER.

The manufacture of every motorcycle starts with the so-called 'marriage': the frame is connected to the engine. This is followed by other components, from the drive shaft to the fuel tank.

A motorcycle can comprise up to 2,000 parts – and we produce every single machine according to individual customer wishes. For Norwegians we add heated grips, for instance, and for Australians we mount studded tyres. We check each individual motorcycle against over 1,000 parameters, as well as putting it on the roller bench for a riding test.



During peak periods,
as many as

800

two-wheelers come off
the assembly line every
day.



FACTS AND FIGURES.

Our staff come from

22

different nations.

Our motorcycles come off the assembly line at a rate of one every

70

seconds.

The total size of the factory premises is equivalent to

31

football pitches.

19

years is the average length of service of our employees.

At Plant Berlin we build about

25

different motorcycle models at the same time.

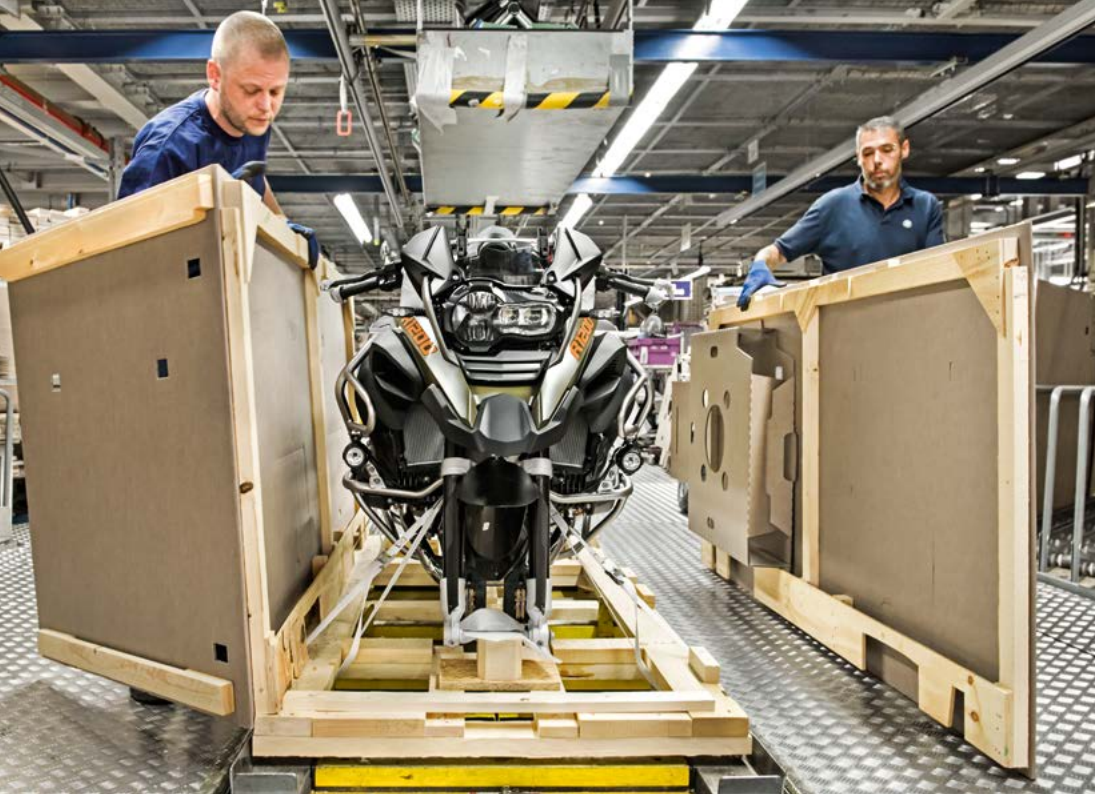
More than

20,000

visitors take a guided tour of the plant every year.

28

litres is the average volume of a motorcycle tyre. This makes us the biggest exporter of Berlin air.



LOGISTICS

MATERIAL FLOW AND SHIPPING. OFF AND AWAY.

In order to ensure production runs smoothly, we make sure the right material goes to the right place at the right time. Transportation to our customers all over the world has to be well planned, too.

Everything starts in the supply centre, which offers a direct connection to all production areas. From here, tugger trains are delivering parts to numerous stops throughout the plant. So-called providers ensure that there is always a sufficient number of parts available. Like that, more than one million parts are moved a day.

We export about 80 per cent of our motorcycles to more than 130 countries. For transportation inside Europe we deploy reusable steel boxes, thereby saving some 1,000 tons of material per year. Machines destined for overseas are packed in sturdy boxes made of wood and cardboard and are loaded onto trucks right away. This ensures our customers receive their motorcycles securely packaged and as quickly as possible.



In our highly modern logistics centre, including a high rack warehouse, more than

1,000,000
parts are moved a day.

OUR EMPLOYEES

HEALTHY AND CHEERFUL. FOR THEIR ENTIRE WORKING LIFE.

**Year by year we offer sound a training program for committed youngsters.
And we provide opportunities for longstanding, experienced colleagues
to keep in shape both mentally and physically, too.**

There are a total of 80 young women and men following our three-year training program, which prepares them to take up an industrial, technical profession in the motorcycle sector. Job profiles on offer include industrial mechanic, mechatronics assistant and process mechanic for coating technology.

To ensure all colleagues stay dynamic and healthy throughout their working lives, we provide not just ergonomic workspaces but also a fitness centre and rooms for both active and passive pursuits: the former include punching bags and table football, while daybeds and relaxing music are available in the latter. We also attach great importance to professional development.



From 1 July to

31.8.

young people can apply to join our training program, which starts the following year.

bewerber.hotline@bmwgroup.com
www.bmw-werk-berlin.de



SOCIAL ENGAGEMENT AND ENVIRONMENTAL PROTECTION

THE PLANT AND ITS LOCAL AREA. A MATTER OF GIVE AND TAKE.

Our local area gives us incredible benefits: space for our production, water and energy, motivated employees and an attractive neighbourhood. This is why it's so important to us to give a lot back.

Whether financial support, personal assistance or donations in kind: our social responsibility is reflected in our support for various charitable projects and organisations.

Furthermore, we are very proud of our certified environmental management. State-of-the-art technologies and waste processing set high standards. In spring 2018, the operation of a CHP unit started. Besides the main goal, which is to produce power, the CHP unit also provides the basic load of thermal energy needed for our production.

The plant premises are also a home to many animals: For example, the channel that flows right through it is where ducks, herons or even raccoons are living. Since May 2018, up to 150,000 bees are living here, too. With the support of a professional beekeeper they are pollinating the blossoms within a radius of three kilometers and producing delicious honey.



About

150,000

bees are producing delicious
honey on the plant premises.



PLANT VISIT

NON-STOP FASCINATION.

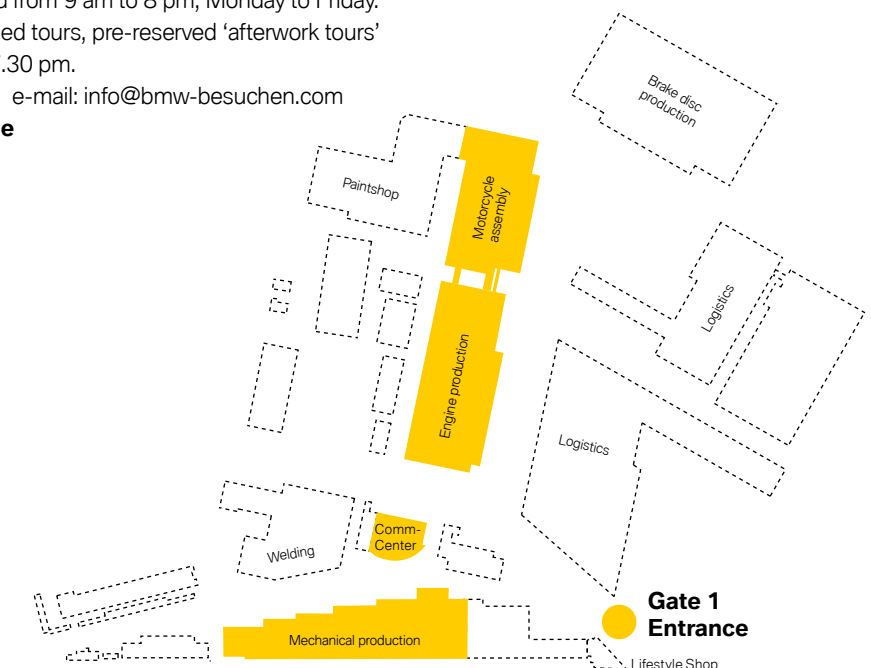
If you want to explore the fascination of our motorcycle production, there's nothing like being at the heart of the action. Our specialized tour guides are all passionate motorcyclists themselves.

We gear our guided tours individually towards the specific group in question: whether technology enthusiasts interested in production processes, school groups keen to find out about training opportunities or motorcycle fans who want to see how The Ultimate Riding Machine comes into existence. All guests get a close-up view of the assembly-line action and can literally take a look over our shoulder. For this reason they have to be at least 14 years of age and sign up in advance.

Guided plant tours are held from 9 am to 8 pm, Monday to Friday. In addition to our regular guided tours, pre-reserved 'afterwork tours' are also available starting at 7.30 pm.
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www.bmw-werk-berlin.de



We give our guests
a guided tour of the
production facilities that
lasts approximately
120
minutes.



FROM BERLIN TO THE WHOLE WORLD.

Our international production facilities are the backbone of our success: with sites in Brazil, Thailand, India and China, we build our motorcycles where demand is growing so we are able to respond to local customer needs.

In Thailand and Brazil we operate our own production facilities, in India and China our motorcycles are built by partners. The main plant in Berlin supports them and ensures they meet our high quality standards. Production continues to be primarily focused at our tradition-steeped site in Berlin Spandau.

INTERNATIONAL PRODUCTION



In 2017
Plant Berlin produced

8,500

assembly-kits for its
partner plants abroad.



www.bmw-werk-berlin.de

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