

PROCESSING EQUIPMENT CAPACITIES, CAPABILITIES AND TOLERANCES

PLASMA CUTTING	FLAME CUTTING	LASER CUTTING	BEVELING	ROLLING	MACHINING	FORMING																												
<p>MAX PLATE: 144" x 900"</p> <p>HPR260XD</p> <table border="0"> <tr> <td>THICKNESS</td> <td>TOLERANCE</td> </tr> <tr> <td>11GA – 1 1/8"</td> <td>+/- 0.040</td> </tr> </table> <p>ID HOLES 1 x thickness</p> <p>HP4070</p> <table border="0"> <tr> <td>THICKNESS</td> <td>TOLERANCE</td> </tr> <tr> <td>11GA – 1"</td> <td>+/- 0.040</td> </tr> </table> <p>ID HOLES 1.5 x thickness</p> <p>HPR400XD</p> <table border="0"> <tr> <td>THICKNESS</td> <td>TOLERANCE</td> </tr> <tr> <td>11GA – 2"</td> <td>+/- 0.040</td> </tr> </table> <p>ID HOLES 1 x thickness @ 3/16" – 3/4" 1.5 x thickness @ > 3/4"</p> <p>KERF ANGLE: +/- 1° – 3° as plate thickness increases</p>	THICKNESS	TOLERANCE	11GA – 1 1/8"	+/- 0.040	THICKNESS	TOLERANCE	11GA – 1"	+/- 0.040	THICKNESS	TOLERANCE	11GA – 2"	+/- 0.040	<p>MAX PLATE: 144" x 720"</p> <p>10-TORCH OXY/FUEL</p> <table border="0"> <tr> <td>THICKNESS</td> <td>TOLERANCE</td> </tr> <tr> <td>< 1 1/2"</td> <td>+/- 1/16"</td> </tr> <tr> <td>1 5/8" < 2 1/2"</td> <td>+/- 3/32"</td> </tr> <tr> <td>2 5/8" < 4"</td> <td>+/- 1/8"</td> </tr> <tr> <td>4 1/4" < 7"</td> <td>+/- 3/16"</td> </tr> </table> <p>ID HOLES 1 x thickness</p> <p>KERF ANGLE: +/- 2°</p>	THICKNESS	TOLERANCE	< 1 1/2"	+/- 1/16"	1 5/8" < 2 1/2"	+/- 3/32"	2 5/8" < 4"	+/- 1/8"	4 1/4" < 7"	+/- 3/16"	<p>MAX PLATE: 60" x 120"</p> <p>4000W</p> <table border="0"> <tr> <td>THICKNESS</td> <td>TOLERANCE</td> </tr> <tr> <td>< 1/2"</td> <td>+/- 0.005"</td> </tr> <tr> <td>5/8" < 3/4"</td> <td>+/- 0.010"</td> </tr> </table> <p>SAW CUTTING</p> <p>SQUARE CUT</p> <p>MAX PART: 16" x 16" x 40"</p> <p>TOLERANCE Dimensional: +/- 1/32"</p> <p>MITRE CUT</p> <p>MAX PART @ 45° 12" x 12" x 40"</p> <p>TOLERANCE Dimensional: +/- 2°</p>	THICKNESS	TOLERANCE	< 1/2"	+/- 0.005"	5/8" < 3/4"	+/- 0.010"	<p>MAX PART: application-specific</p> <p>MECHANICAL</p> <p>MAX BEVEL DEPTH 5/8" @ 25° – 45°</p> <p>MIN BEVEL DEPTH 1/8" @ 25° – 55°</p> <p>ANGULAR TOLERANCE: +/- 1°</p> <p>FLAME</p> <p>MAX BEVEL DEPTH Application-specific</p> <p>BEVEL ANGLE 10° – 60°</p> <p>ANGULAR TOLERANCE: +/- 2°</p>	<p>MAX PART: application-specific</p> <p>PLATE</p> <p>MAX WIDTH: 10'</p> <p>MAX THICKNESS: 1 1/8"</p> <p>MAX ID: 120"</p> <p>MIN ID: 14"</p> <p>TOLERANCE: Ø +/- 1/8"</p> <p>STRUCTURAL</p> <p>MAX ANGLE: 5" x 5" x 1/2"</p> <p>MIN ANGLE: 1" x 1" x 1/8"</p> <p>MIN ID: 14"</p> <p>TOLERANCE: Ø +/- 3/16"</p>	<p>MAX PART: application-specific</p> <p>VMC</p> <p>MAX PART: 18" x 37"</p> <p>MAX LIFT: 1000 lbs.</p> <p>MAX HEIGHT: 7"</p> <p>TOLERANCE Bore: +/- 0.0005" Position: +/- 0.001"</p> <p>MANUAL MILL</p> <p>MAX PART: X=36" Y=14" Z=15"</p> <p>MAX LIFT: 50 lbs.</p> <p>TOLERANCE +/- 0.0005"</p> <p>HEAVY DUTY LATHE</p> <p>MAX DIAMETER: 16"</p> <p>MAX LENGTH: 60"</p> <p>SPINDLE BORE: 3"</p> <p>MAX RECTANGLE: 8" x 10"</p> <p>TOLERANCE Bore: +/- 0.005"</p> <p>RADIAL ARM DRILL</p> <p>MAX WIDTH: 60"</p> <p>MAX HOLE: Ø 2 1/32"</p> <p>MAX LIFT: 1000 lbs.</p> <p>MAX RECTANGLE: 8" x 10"</p> <p>TOLERANCE Diameter: +/- 1/32" Position: +/- 1/16"</p>	<p>MAX PART: application-specific</p> <p>75 – 750 TON</p> <p>TOLERANCE Dimensional: +/- 1/16" Angular: +/- 1°</p>
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Information regarding tolerances and other processing capabilities is general in nature and for reference only. Factors such as material composition, thickness, part geometry and thermal effects may affect production results. Project-specific requirements will be established at time of quotation.

EQUIPMENT LIST

PLASMA CUTTING / SCRIBING

- 2 200A Hypertherm HP4070D high-definition plasma
- 2 260A Hypertherm HPR260XD high-definition plasma
- 2 400A Hypertherm HPR400XD high-definition plasma
- 1 132" x 168' downdraft table
- 1 144" x 168' downdraft table

OXY-FUEL CUTTING

- 2 10-torch machines
- 1 144" x 150' cutting table

LASER CUTTING

- 1 Prima Industrie Domino HS 5-axis 4000W laser machine centre
- 2 Prima Industrie Platino 3-axis 4000W laser machine centre

SAW CUTTING

- 1 Hyd-Mech VW18-II semi-automatic bandsaw
- 1 Hyd-Mech H-16 dual post automatic bandsaw
- 1 Hyd-Mech H-14 dual post automatic bandsaw

MACHINING

- 2 Mazak high-speed VC510 VMC
- 2 Hurco VMC
- 3 Vertical mill
- 1 TOS heavy-duty lathe
- 2 Large-capacity radial arm drill

BEVELING

- 6 Pullmax X-97 mechanical bevellers
- 8 Gullco bug flame bevellers

FORMING

- 1 750 ton Dries & Krump press brake (16' long, 12' b/t housings)
- 1 350 ton Cincinnati press brake (14' long, 12' b/t housings)
- 1 250 ton Trumpf press brake (13' long, 12' b/t housings)
- 1 225 ton Haco press brake (14' long, 12' b/t housings)
- 1 225 ton Haco press brake (12' long, 10' b/t housings)
- 1 75 ton Kingsland 75XS ironworker

PLATE ROLLING

- 1 Haco 1 1/8" x 10' (4-roll double initial pinch)
- 1 Bertsch 1" x 8' (4-roll double initial pinch)
- 1 Haco 5/8" x 8' (4-roll single pinch)

STRUCTURAL ROLLING

- 1 Rondo R6S (6" x 6" x 5/8" angle)
- 1 Pullmax Z31 (3" x 3" x 5/8" angle)

PARTS FINISHING

- 2 Large-capacity vibratory tumbler
- 2 HD Ernst automatic deburring machine

MATERIAL HANDLING

- 20 10 ton overhead crane
- 9 5 ton overhead crane
- 6 Forklift (8,000 lbs. max. lift)

TRANSPORTATION

- 2 Quad flatbed trailer (80,000 lbs.)
- 2 Tandem trailer w/slide kit (40,000 lbs.)
- 1 Box trailer (40,000 lbs.)
- 1 Straight truck (24' bed, 30,000 lbs.)

FACILITY

120,000 sq ft. All material stored indoors.