

PLASMA CUTTING		FLAME CUTTING		LASER CUTTING		BEVELING	ROLLING	MACHINING	FORMING	
Max Plate Size 12' W X 75' L		Max Plate Size 12' W X 60' L		Max Plate Size 14' W X 50' L		Max Plate Size Application Specific	Max Plate Size Application Specific	Max Part Size Application Specific	Max Part Size Application Specific	
Hypertherm HPR260XD		10 Torch - Oxy-Fuel		4000-8000W		Mechanical Bevel	Plate Rolling	VMC	75 Ton – 1500 Ton	
TOLERANCE	THICKNESS	TOLERANCE	THICKNESS	TOLERANCE	THICKNESS	Max Bevel Depth 1/2" @ 25° to 45°	Large Roll - Max 10' long Max 1-5/8" thick Max ID 120" - Min ID 20"	Max Part Size 18" X 37" Max Lift 1000 lbs Max Height 7"	Bend Length up to 30' DIMENSIONAL TOLERANCE +/- 1/16" per bend	
+/- 0.040"	11GA-1-3/8"	+/- 1/16"	< 1-1/2"	+/- 0.005"	Gauge Mat'l					
HPR400XD		+/- 3/32"	1-5/8" < 2-1/2"	+/- 0.015"	3/16" – 3/8"	Min Bevel Depth 1/8" @ 25° to 55°	Small Roll - Max 8' long Max 5/8" thick Max ID 120" - Min ID 14"	TOLERANCE Bores +/- 0.0005 Position +/- 0.001	ANGULAR TOLERANCE +/- 1°	
TOLERANCE	THICKNESS	+/- 1/8"	2-5/8" < 4"	+/- 0.025"	> 3/8" – 3/4"					
+/- 0.040"	11GA-1-3/8"	+/- 3/16"	4-1/4" < 7"	+/- 0.030"	> 3/4" – 1"	ANGULAR TOLERANCE +/- 1°				
+/- 0.050"	> 1-3/8" – 2"	+/-1/4"	7-1/4" < 12"			Flame Bevel			FLATTENING	
Kerf Angle +/- 1° to 3° as plate thickness increases		Kerf Angle +/- 2°				Max Bevel Depth Application Specific	TOLERANCE +/- 1/8" on diameter	Manual Mill	Part thickness .080" – 3.5" Max. part width 120" Max. part length 650"	
True Hole Technology 3/16" – 3/4"		ID Holes 1 X Thickness		SAW CUTTING		Bevel Angles 10° to 60°	Structural Rolling	Maximum Part Size X=36", Y=14", Z=15"		
ID Holes 1 X Thickness ≤ 3/4"				SQUARE CUT		ANGULAR TOLERANCE +/- 2°	Max Angle 5" X 5" X 1/2"	Max Lift 50 lbs		
ID Holes 1.5 X Thickness > 3/4"				Max Part Size 20"W X 20"H X 40"L		DIMENSIONAL TOLERANCE +/- 1/32"		Min Angle 1" X 1" X 1/8"		TOLERANCE +/- 0.0005
BEVEL HEAD 360° TILT ROTATION 45° TORCH ANGLE				MITRE CUTS		Max Part Size @ 60° 20"W X 20"H X 40"L		Min Diameter (ID) 20"		Radial Arm Drill
				DIMENSIONAL TOLERANCE +/- 2°				TOLERANCE +/- 3/16" on diameter		Max Part Width 70"
										Max Hole Diameter 2-1/4"
							Max Lift 1250 lbs			
							TOLERANCE +/- 1/32" on diameter +/- 1/16" on position			

These tolerances are general and for reference only. Material composition, part geometry, lead-in/lead-out locations and thermal effect during cutting are variables that may impact tolerance realization. Tighter tolerances are held on the overall part profile, but stop/start marks and 90° corners may impact the general published tolerances.

BRANNON STEEL will always endeavor to meet customer specified tolerances unless otherwise noted at time of quotation.

EQUIPMENT LIST

PLASMA CUTTING/BEVELING/SCRIBING

2 – 400 Amp Hypertherm HPR400XD High Definition Plasma Contour Bevel Machines – 10' wide X 58' long down draft table
2 – 400 Amp Hypertherm HPR400XD High Definition Plasma – 12' wide X 168' long down draft table
4 – 260 Amp Hypertherm HPR260XD High Definition Plasma – 11' wide X 168' long down draft table

LASER CUTTING

Messer 8000 W Metalmaster Excel Fiber Laser on 8' X 30' shuttle table
NTC TLX-14 7000 W Large Format Plate Laser on 14' wide X 50' long downdraft table
3 – Prima/FinnPower 5000 W Fast-axial flow laser machine centres

OXY-FUEL CUTTING

2 – 10 torch machines – 12' wide X 60' long cutting bed

SAW CUTTING

Hydmech V-20 APC 60 degree mitre automatic bandsaw
Hydmech H-22A-120 dual post automatic bandsaw
Hydmech H-16 dual post automatic bandsaw
Hydmech H-14 dual post automatic bandsaw

FORMING

1500 Ton Baykal APHS 45700 Hydraulic Tandem Press Brake (30' bending length)
330 Ton Baykal APHS 37300 Hyralic Press Brake
350 Ton Cincinnati Press Brake
250 Ton Trumpf Press Brake
75 Ton Kingsland 75XS Ironworker

BEVELING

2 – Steelmax DBM50 Double Bevel Machines, 6 – Pullmax X-97 Mechanical bevelers
8 – Gullco Bug Flame bevelers, 6 – Heck 9000 Mill Hand bevelers, 1 – Koike IK-70 Circle beveler

MACHINING

1 – Mazak Nexus 530C VMC. 20" x 42" working surface, 18 x 37 x 7" max part size, 25HP, 12,000 RPM, spindle w/chip blaster.
2 – Mazak High-speed VC 510 VMC. 20" x 42" working surface, 18 x 37 x 7" max part size, 25HP, 12,000 RPM, spindle w/chip blaster.
1 – Fortworth Vertical/Horizontal Heavy Duty Knee Mill, 14" X 32" travel, 14 x 32 x 6" max part, rigid tapping, 5 & 10hp spindles.
2 – Lilian Vertical Mills knee mills, 14" X 30" travel, 11 x 30 x 5" max part size, Acu-Rite digital XY readout, 5hp spindle
1 – Koaming KMR1600 Radial Arm Drill, 70" width max, 2 1/4" max hole size, rigid tapping

PLATE ROLL

Davi MCB I-30 1-5/8" x 10' Four roll double initial pinch
Haco 5/8" x 8' Four roll single pinch

FLATTENING

ARKU FlatMaster 140-200 Flattening Machine
350 Ton RK Machinery H-Frame Flattening Press
225 Ton Haco Press Brake

STRUCTURAL ROLL

Rondo R6S - 6" x 6" x 5/8" Angle

PARTS FINISHING

Wheelabrator Shotblaster Model MAXMESH 33-4-15 (Max width 32"), Goff 6 cu ft Tumble Blast Cabinet
HD Ernst Automatic Deburring Machines, 2 – Jonsen SC 1030 2D+JS Finishing Machines, 2 – Large Capacity Vibratory Tumblers

QUALITY ASSURANCE

Creiform Handyprobe Portable CMM and Roamer Arm CMM and full QA reporting capabilities

FACILITY & HANDLING CAPACITIES All material stored indoors

Over 200,000 sq ft operating 24/5
20 – 10 Ton and 25 – 5 Ton overhead cranes

TRUCKS

4 – Tractors with trailers - 2 @ 50,000 lbs and 2 @ 80,000 lbs, 2 – Stake truck 24' bed @ 30,000 lbs