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## ***EQUIPMENT AND FACILITIES***

Facility Size: 125,000 sq. ft.

Manufacturing: 70,000 sq. ft.

Assembly: 27,000 sq. ft.

Welding: 20,000 sq. ft.

Inspection: 3,500 sq. ft.

20 overhead cranes (up to 40 tons each) with lifting capability of 160,000 pounds in machining bay

Taylor Rigger's 80,000 lb. capacity special fork truck with boom

Pick-up and delivery service

### ***Multi-Process Machining (Horizontal/Vertical)***

Milling, Turning, Facing, Drilling, & Boring

**Union PCR-160 RAM Type CNC Horizontal Boring Mill (2011):** 17" x 22" RAM, 6 5/16" diameter spindle; 590" x-axis, 236" y-axis, 59" z-axis, 29" w-axis; CNC right angle head, automatic head changer for heads and turning/facing block, 157" x 157" b-axis rotating and turning table, 118" v-axis infeeding table; 120 ton capacity, Heidenhain iTNC-530 control, tool changer vertical/horizontal (60 tools), 189" x 314" long floor plate field.

**Bost VTL 60 CY Traveling Table Vertical Turning, Boring and Milling Machine (2012):** 236" swing; 141" turning height, 79" RAM travel, 157" table diameter with table extensions to 216" diameter 8-jaw, live spindle (3000 RPM), hydraulically clamping right angle milling attachment, 236" x-axis travel, 157" y-axis travel, adjustable cross rail, automatic head changing, Siemens 840D control, automatic tool changer (28-milling, 12-turning)

**BOST T4F Horizontal Turn/Mill (2012):** 79" swing, 354" center distance, 44,000 pound capacity between centers without steady rest, 93 HP turning power, guillotine turning with Capto C6 tooling, 68 HP milling tower, b-axis head +/- 90 degrees, HSK-125 tooling, 60 station ATC, Qty. (5) steadies 10 5/8 - 22 1/2 capacity, qty. (1) steady 15 3/4 - 35 1/2 capacity, boring attachment 8" capacity, probing, camera, Siemens 840D control

**Ibarmia THC 1600 Multiprocess (2014):** 79" X-axis, 59" Y-axis, 59" Z-axis, 7000 RPM 2 axis continuous milling, drilling, facing, turning & boring head. 84HP main spindle with HSK A-100 spindle taper. 63" Diameter, 300RPM maximum speed rotary table with 17,600 lb load capacity. Siemens 840D Smartline control, Renishaw Tool robe, Renishaw Touch Probe, tool changer (60 tools)

## ***Milling Department (Horizontal Boring Mills)-CNC***

3, 4, & 5 Axis CNC Milling

**Union PCR-150 RAM Type CNC Horizontal Boring Mill (2002):** 17" x 22" RAM, 6" diameter spindles; 396" x-axis, 157" y-axis, 39.37" z-axis, 29" w-axis; full A-C axis contouring universal head with automatic head changer; Heidenhain iTNC-530 control; tool changer (40 tools)

**Union PC-150 CNC Horizontal Boring Mill (2010):** 6" diameter spindle; 396" x-axis, 138" y-axis, 30" z-axis, 29" w-axis; 98" x 98" contouring rotary table, 30-ton capacity, 2.5° automatic indexing head, Heidenhain iTNC-530 control; tool changer (40 tools)

**Union KCU-150 HDT CNC Horizontal Boring Mill (2008):** 6" spindle, 126" x-axis, 118" y-axis, 59" z-axis, 29" w-axis, 79" x 98" contouring rotary table, integrated facing head, Siemens 840D control, and tool changer (60 tools)

**Union KC-150 HDT CNC Horizontal Boring Mill (2006):** 6" spindle, 157" x-axis, 118" y-axis, 98" z-axis, 29" w-axis, 78" x 118" contouring rotary table (44,000 lb load capacity), KFUD3 automatic 1° universal head, automatic head changer, Heidenhain iTNC-530 control, tool changer (60 tools)

**Union TC-150 CNC Horizontal Boring Mill (2010):** 6" diameter spindle; 98" x-axis, 98" y-axis, 59" z-axis, 29" w-axis, 63" x 78" contouring rotary table; Heidenhain iTNC-530 control; tool changer (40 tools)

**Union TC-130 CNC Horizontal Boring Mill (1997):** 5" diameter spindle; 118" x-axis, 98" y-axis, 59" z-axis, 29" w-axis, 63" x 78" contouring rotary table; Heidenhain iTNC-426 control; tool changer (40 tools)

**Union TC-130 CNC Horizontal Boring Mill (2000):** 5" diameter spindle; 98" x-axis, 98" y-axis, 59" z-axis, 29" w-axis, 63" x 78" contouring rotary table; Heidenhain iTNC-426 control; tool changer (60 tools)

**Union T-130 CNC Horizontal Boring Mill (1994):** 5" diameter spindle; 118" x-axis, 78" y-axis, 59" z-axis, 29" w-axis, 63" x 78" contouring rotary table, and Heidenhain iTNC-407 control

**Union T-110 CNC Horizontal Boring Mill (2005):** 4.375" diameter spindle; 80" x-axis, 63" y-axis, 59" z-axis, 22" w-axis, 49" x 63" contouring rotary table; Heidenhain iTNC-530 control

**Union BFT-90 Horizontal Boring Mill (1990):** 4" diameter spindle; 60" x-axis, 50" y-axis, 48" z-axis, 24" w-axis; 50" x 55" rotary table, Heidenhain iTNC-530 control

## ***Milling Department (Universal Mills)-CNC***

3, 4, & 5 Axis CNC Milling

**MTE FBF 8000 X-Travelling Column Universal Milling Machine (2014):** 20.5" x 20.5" RAM, 315" X-axis, 157" Y-axis, 70.8" Z-axis (RAM), 4000RPM, 64" x 288" riser table, 79" x 98" contouring rotary table with 59" V-axis travel, 2-axis automatic orthogonal milling head

1x1 degree, straight milling adapter with Henninger right angle milling head, pick up station for multiple heads, 48" diameter trunion table with tailstock, Heidenhain iTNC530 control

**Union FC-1 CNC Traveling Column Universal Milling Machine (2006):** 15" x 18" RAM, 396" x-axis, 102" y-axis, 63" z-axis (RAM), 5000 RPM, 96"x 356" floor plate field, 79"x 98" contouring rotary table, 2-axis 1° automatic indexing head (A-C axis positioning), Heidenhain iTNC-530 control, tool changer (24 tools)

**MTE BF 5200 CNC Universal Machining Center (2009):** 197" x-axis, 79" y-axis, 48" z-axis, 48" x 205" table surface, 2.5° automatic indexing head (both joints A-C axis); Heidenhain iTNC 530 control, and tool changer (24 tools)

**MTE FBF-4000-S Unverisal Machining Center (2011):** 17" x 19" RAM; 157" x-axis, 79" y-axis, 48" z-axis (RAM), 3000 RPM, 59" x 157" floor plate field, quantity (2) 59" x 59" contouring rotary tables, 2.5° x 2.5° automatic indexing (both joints A-C axis), Heidenhain iTNC-530 control

**MTE BF 2200 CNC Universal Machining Center (2012):** 80" x-axis, 59" y-axis, 48" z-axis; 48" b-axis contouring rotary table; 2.5° indexing head (both joints A-C axis); Heidenhain iTNC 530 control

**MTE RT-30/14 x 16 Universal Machining Center (2011):** 17" x 19" RAM, 118" x-axis, 59" y-axis, 48" z-axis (RAM), 3000 RPM, 55" x 63" contouring rotary table, 1° x 2.5° automatic indexing head (both joints A-C axis), Heidenhain iTNC-530 control, tool changer horizontal/vertical (40 tools).

**Parpas THS 100 CNC Universal Machining Center (2009):** 59" x-axis, 48" y-axis, 40" z-axis, 40" x 40" full b-axis rotary table, infinite positioning head (both joints A-C axis); Heidenhain iTNC 530 control and tool changer (24 tools)

**MTE K-15 CNC Horizontal Mill (2006):** 13" x 15" RAM, 59" x-axis, 39" y-axis, 31.5" z-axis, 26" x 26" contouring rotary table, Heidenhain iTNC-530 control

**MTE K-15-RT CNC Universal Machining Center (2010):** 13" x 15" RAM, 48" x-axis, 34" y-axis, 31.5" z-axis, 23 5/8" x 23 5/8" contouring rotary table, 2.5° x 2.5° automatic universal head, 3000 RPM, Heidenhain iTNC 530 CNC control, horizontal and vertical ATC (40 tools)

## ***Milling Department (Vertical Mills)-CNC***

3, 4, & 5 Axis CNC Milling

**(2) Northwood NW FT 138 CS Vertical Bridge Mills (2007):** 168" x-axis, 100" y-axis, 14" z-axis, 96" x 156" work table, vacuum chucks, 20 H.P., CAT 40 taper, 10,000 RPM spindle speed, FANUC Oi control, (32-tools)

**(2) Lymco Perfect Jet Bed Mill CNC – 36MB (2012):** 40" x-axis, 20" y-axis, 22.5" z-axis, 15.75" x 50" table surface; Heidenhain iTNC-620 control

## ***Milling Department-Manual***

**Devlieg Jig Mill 4K-60:** 60" x-axis, 48" y-axis, 24" w-axis; 36" pallet travel; 28" x 28" air-lift rotary table

**Bridgeport Knee Mills.** Quantity 3

## ***Turning Department (Horizontal)-CNC***

**Ryazan Model RT317RF3 CNC Horizontal Lathe (2006):** 67" swing, 47.2" swing over slide, 236" center distance, Sauter 12-station automatic turret, steady rests, bar rest, 8"Ø boring bar attachment with the ability to bore up to 80" deep, 55,115 lbs. maximum work piece weight, 5-630 RPM, 80 H.P., Fanuc OT control, (12 tools)

**Hankook Protec 9NC CNC Horizontal Lathe (2004):** 37.4" swing, 24.2" swing over slide, 157" center distance, duplomatic, 8-station automatic turret, boring attachment, steady rests, 10" spindle thru hole, front and rear 32" 4-jaw chucks, 32" 3-jaw chuck, 5-630 RPM, 35 H.P., Fanuc 21i-T control, (8 tools)

**Daewoo Puma 400L (1998):** 28" swing; 19" swing over carriage; 82" center distance; 21" chuck diameter; Fanuc 18iTA control; (12 tools)

**IKEGAI CNC Turning Center (1997):** 15" swing, 22" center distance, 10" diameter chuck; Fanuc 18LT control (12 tools)

## ***Turning Department (Horizontal)-Manual***

**American Pacemaker Lathe:** 50" swing; 40" swing over slide; 252" center distance; 36" chuck diameter; Heidenhain 2-axis D.R.O.

**Timemaster Gurutzpe Lathe:** 41" swing; 34" swing over slide; 80" center distance; 43" chuck diameter

**Kingston HR-5000 Lathe:** 44" swing, 30" swing over slide; 200" center distance; 28" chuck diameter

**Kingston HR-3000 Lathe:** 44" swing; 30" swing over slide; 120" center distance; 39" chuck diameter

**(2) Sharp 2680C Manual Engine Lathes:** 26" diameter swing, 17 ¼" swing over cross slide, 80" center distance, taper attachment, acu-rite 200S DRO.

**Webb Lathe:** 13" swing; 9" swing over slide; 36" center distance; collet chuck

## ***Turning Department (Vertical)-CNC***

**Lymco DV – 3000 MTD CNC Vertical Lathe (2014):** 134” swing, 98.4” cutting height, 59” RAM travel, 118” chuck diameter (8 jaw). Table speed to 100RPM, hydrostatic with 50,000lb. load capacity. 55” travel crossrail. Dual RAMS, (1) turning/boring only, (1) with a live spindle. Live spindle speed to 2500RPM and 35HP grinding attachment, Renishaw tool pre-setter, Renishaw part probe, Fanuc 18iT control, tool changer (16 tools)

**You Ji Cyclone YV1600 CNC Vertical Turning Center (2004):** 78.7” swing, 63” standard turning diameter, 71” maximum turning diameter, 60” maximum turning height, 35.4” RAM travel, 63” 4-jaw chuck, 50HP, Fanuc Oit-B control, (12 tools)

**Toshiba TUE-15 Vertical Boring Mill (1997):** 71” swing; 67” height under rail; 59” chuck diameter 4-jaw; Fanuc 18T CNC control; tool changer (12 tools)

**Lymco RAL-16M (2012):** 79” swing; 63” turning height; 35.4” RAM travel, 63” table diameter 4-jaw, 60 HP, Fanuc OiTD automatic tool changer (18-tools; 9 milling, 9 turning)

**TOS Hulin SKQ-12 Vertical Boring Mill (1993):** 56” swing; 52” height under rail; 49” table diameter 3-jaw; Fanuc 0TC CNC control; tool changer (12 tools)

## ***Turning Department (Vertical) Manual***

**Stanko IL532 Vertical Boring Mill:** 130” swing; 84” height under rail; 110” chuck diameter; two swiveling RAMs; threading; tracer; Heidenhain 4-axis D.R.O.

**King VTL:** 59” swing, 44” swing under rail, 35 ½” swiveling turret travel, 52” 3-jaw independent chuck; Heidenhain DRO.

**Toshiba TX13:** 50” swing, 39” swing under rail, 31” swiveling turret travel, 49” 4-jaw chuck; Heidenhain DRO

## ***Miscellaneous Equipment***

Surface Grinder: 13 inches x 40 inches

Mitts & Merrill Automatic Keyseater: 4” key capacity; 30” stroke

Mitts & Merrill Automatic Keyseater: 2-1/2” key capacity; 24” stroke

Vertical Press: 150 tons

## ***Finishing Equipment***

Pressure Washer Station: 20 feet x 30 feet

Paint Booth: 20 feet x 30 feet

Sand Blast Room: 20 feet x 30 feet

Metal polishing for food grade and chemical processing machinery

## ***Complete Welding and Fabricating Facilities***

Lincoln Submerged Arc Welder  
Microscopic Welding in Clean-Room Environment  
Miller Synchronwave TIG Welders: 300 amp. Quantity 3  
Lincoln Square Wave TIG Welder: 100 amp.  
Hobart Cyber Wave TIG Welder: 300 amp.  
CP-300 Miller MIG Welders: Quantity 2  
CP-200 Miller MIG Welders: Quantity 3  
Miller Wire Welder: 450 amp.  
TEC VSI MIG Welder: 450 L.  
Iron Worker: 30 tons  
Iron Worker: 65 tons  
Thermal Pak 5 Plasma Cutter  
Bigo Straight-Line Burner: Quantity 2  
Weld Positioners: 250 to 8000 pounds. Quantity 7  
Peerless Automatic Band Saw  
Do-All Contour Saw  
Marvel Miter Saw  
Kalamazoo 12 Cold Saw  
Model 8 Marvel Saw  
Ultrasound Machine: (for testing material thickness)  
Die Penetrant and Mag Particle Testing  
Vibratory Stress Reliever  
Hydrotesting Unit (for Pressure Vessels)

## ***Full Inspection Department***

Faro Arm  
Faro Laser Tracker  
Granite Table: 4 feet x 12 feet  
Granite Table: 6 feet x 6 feet  
Starrett Micrometers: 0–52 inches inside diameter and outside diameter  
Inner Micrometers: 0–8 inches  
Verniers: 0–96 inches  
Mueller Gages: 0–120 inches  
Master Gage Block Sets  
Mitutoyo Height Gages: 0–36 inches  
Gage Pin Sets  
Go/No-Go Thread Gages  
Dial Bore Gages  
Brinell and Rockwell Hardness Gage  
Profilometer (Surface Test Gage)

