

Main Plant
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Metal Fabrication Division
1805 Pewaukee Road
Waukesha, WI 53188

Capabilities & Equipment

CAD / CAM Software

- Solidworks
- AutoCAD with Diemaker
- FASTFORM
- DRBLANK
- GibbsCAM
- Esprit

Full Service Tool Room

- (8) Bridgeport EZ-Trak SX mills
- 2D CNC / manual

Amada Meister V3 CNC surface and form grinder

- 6" x 18" table
- 2 axes plus table axis
- 10 wheel management system

(10) Surface grinders

- Maximum table size: 16" x 32"

Moore Model G18 jig grinder

- Table: 11" x 24"
- Travel: 11" x 18"
- 20, 40 and 60,000 RPM spindle heads
- RSF Electronics digital readout

DedTru 388 centerless grinding system

- Maximum work height: 7"
- Maximum work length: 12"

(5) Drill presses

- Maximum radial arm length: 4'

Fabrication

Safan 300-4100, High speed electric brake press

- Press capacity: 330 tons x 161" length capacity
- Auto sheet thickness measuring and 6-axis back gauging

Trumpf TruBend 5085 CNC press brake

- Press capacity: 85 tons x 87" bending length

Bystronic, Xpert 40 high speed brake

- Press capacity: 44 tons x 40" bending length
- 3X faster working speed than other hydraulic brakes

Fabrication (Cont.)

(2) Trumpf 5030 Fiber Lasers - TruFlow 5000 watt laser

- Max sheet 60" x 120"
- Auto loading/unloading for unattended operation
- cuts 3x faster than Co2 in materials under 3/8" thick

Trumpf TruPunch 1000 punching machine

- Maximum punching force: 20 tons
- Maximum punching rate: 600 SPM
- Maximum sheet size: .250" x 48" x 120"

3 Welding Bays

- Lincoln Wire-Matic 140 & 250 welder
- Lincoln Square Wave TIG 355 welder
- Federal 100 KVA Spot Welder / 30" throat

- Americor Plate Roller - 5' x 10 ga capacity

- Timesaver deburring - 36" wide capacity
- Haeger HP-6 hardware insertion press Auto-feeder
- Assembly & Testing stations
- Overhead crane capacity 5 tons
- Forklift capacity 5,000 lbs.

Quality Assurance

ISO 9001:2008

SmartScope Flash 200 video measuring machine

- Measuring range: 8" x 8" x 6"
- Accuracy to < .0001" (3.2 microns)

Brown & Sharpe FX7107 Global automatic CMM

- PC DMIS 4.3 software
- Measuring range: 25" x 39" x 25"

Brown & Sharpe Micro Excel 765 CMM

- Measuring range: 30" x 26" x 20"

Virtek Laser QC 1200

- Measuring range: 8" x 48" x 48"

Romer Arm Model 7540

- Measuring range: 13.1 feet

Mitutoyo LH600 Computerized Linear Height Gage

- Measuring range: 24"

OGP 14" Focus Contour Projector - 10x to 50x

Jones & Lamson FC14 Optical Comparator -10x to 100x

Imada ZTS-550 Digital Force Gauge

Hipot testers

Capabilities & Equipment

Metal Stamping

**All presses include press automation, die protection and automatic coil feed line*

Multiple air presses ranging 6-12 tons

30 ton Bruderer BSTA30 press*

60 ton Minster with 2" stroke, up to 400 SPM*

75 ton Bliss C2 single stroke gap frame press*

88 ton Minster OBI press

100 ton Bliss*

100 ton Minster Piece-Maker straight side press*

• Bolster: 31" x 48" - SPM: 0 to 120

• Maximum stock: 12" wide x .130" thick

100 ton Minster Piece-Maker straight side press*

• Bolster: 31" x 60" - SPM: 0 to 250

• Maximum stock: 14" wide x .240" thick

175 ton Bliss SG2 straight side press*

• Bolster: 30" x 84" - SPM: 30 to 60

200 ton Komatsu OBW gap frame press*

• Bolster: 33" x 95" - SPM: 0 to 50

• Maximum stock: 18" wide x .187" thick

Wire EDM

Agiecut Progress VP3

• Maximum Travel: 19.68" (X) x 13.77" (Y) x 16.77" (Z)

• Maximum Work piece: 41.3" x 26.6" x 16.77" high

• Minimum wire diameter: .006"

• Achievable tolerance: < .0001"

(2) Agiecut Progress VP2

• Maximum Travel: 13.77" (X) x 9.84" (Y) x 10.87" (Z)

• Maximum Work piece: 29.52" x 21.65" x 9.84" high

• Minimum wire diameter: .003"

• Achievable tolerance: < .0001"

Agie 250 HSS

• Maximum Travel: 15.74" (X) x 9.84" (Y) x 9.88" (Z)

Sodick K1C hole drilling EDM

• Hole diameter range: .012" - .120"

• All wire EDMs cut fully submersed and feature automatic threading

• EDM room is climate controlled

CNC Machining

(2) OKK VM5 CNC Vertical Machining Centers

• Travel: 40" (X) x 20" (Y) x 20" (Z)

• 20 tool magazine, 50 Taper

OKK HM500S CNC Horizontal 4-Axis Machining Center

• Travel: 24.8" (X) x 24.41" (Y) x 27.95" (Z)

• Pallet changer

• 60 tool magazine

Robo Drill D21LiA5

• Travel: 27.5" (X) x 15.7" (Y) x 13.00" (Z)

• 24,000 RPM Spindle

• 21 tool magazine

Hurco VM20 with 4th axis

• Travel: 40" (X) x 20" (Y) x 20" (Z)

• 20 tool magazine

(2) Hurco VMX42 with 4th axis

• Travel: 42" (X) x 24" (Y) x 24" (Z)

• 24 tool magazine

Hurco VMX64

• Travel: 64" (X) x 34" (Y) x 30" (Z)

• 40 tool magazine

(2) Haas VF2YT

• Travel: 30" (X) x 20" (Y) x 20" (Z)

• 40 tool magazine

Samsung SL25BMC/1000 CNC lathe with 3" bar feeder

• Cutting diameter: 14.37"

• Maximum cutting length: 40.16"

• Live tooling for drilling and milling operations

Samsung SL20 CNC lathe with 2.6" bar feeder

• Cutting diameter: 11.80"

• Maximum cutting length: 20.50"

(2) Samsung SL15 CNC lathe with 1.8" bar feeder

• Cutting diameter: 11.8"

• Maximum length: 11.8"

• Live tooling for drilling and milling operations

Aquamaster Conveyorized Parts Cleaner CB-1200E

• 12 x 12" capacity

Crystal Clean Heated Aqueous Parts Cleaner

• 24 x 24 x 4.5" capacity