



Minnesota Facilities Equipment List

FACILITY

192,160 sq. ft. of Fabrication and Assembly Space
10,000 sq. ft. of Warehouse Space
465,000 sq. ft. of Outside Storage Area
14,802 sq. ft. of Administrative and Engineering Space
5,900 sq. ft. of Manufacturing Support Space

FINISHING

Conveyorized Powdercoat Paint System with 5-Stage Phosphate Cleaning System
Batch Powdercoat Paint System
Seven-Stage Wash Laser Oxide Removal Process

QUALITY ASSURANCE

ISO 9001 Certified
2 – Coordinate Measuring Machines
6 – SPC Data Collectors
Magna Glo Fluorescent Dye Penetrant

LASER

2 – 2,800 Watt Laser Centers with Automatic Load/Unload System
1 – 4,400 Watt Laser Centers with Automatic Load/Unload System

PLASMA

HyDefinition Plasma Cutting to 1/2"
Standard Plasma Cutting to 1"
1 – 177 CNC Punch with Plasma

TURRET PUNCH

1 – 33 Ton 20 Station Turret with Automatic Load/Unload System
1 – 33 Ton 21 Station Turret

PRESS BRAKES

9 – CNC Press Brakes, 35 Ton – 400 Ton

PRESSES

Pem-Serter Hardware Insertion Press

SHEARS

1 – Shear, Capacity up to 1/4" x 10'
1 – Shear, Capacity up to 1/2" x 12'

CNC MACHINING

1 – CNC Horizontal Machining Center, Work Envelop X-120", Y-60", Z-40",
Four Station Pallet Shuttle with 10,000 lbs. per Pallet Capacity
2 – CNC Horizontal Machining Center, Work Envelop X-31", Y-29", Z-30",
2 – 24 Pallet Stations with 2,640 lbs. Table Capacity
1 – CNC Horizontal Machining Center, Work Envelop X-28.7", Y-28.7", Z-31.5",
2 – 19.7" Pallet Stations with 1,540 lbs. Table Capacity
1 – CNC Vertical Machining Center, Work Envelop X-64", Y-32", Z-30"
1 – CNC Vertical Machining Center, Work Envelop X-50", Y-20", Z-25"
1 – CNC Vertical Machining Center, Work Envelop X-120", Y-32", Z-30"

SAWS

3 – Automatic Saws, Capacity up to 18" x 20"
8 – Semi-Automatic Saws, Capacity up to 18" x 25"

WELDING

7 – Robotic Welding Cells
30 – Pulse Arc Welding Machines
4 – GTAW Welding Machines
4 – Spotwelders up to 150KVA
4 – Stud Welders, 1/4" through 1-1/8"
15 – Weld Positioners, 100 lbs. to 15,000 lbs. Capacity

TUBE BENDING

1 – 3-Axis CNC Rotary Draw Tube Bending Machine, 2" Schedule 80 Pipe Capacity
1 – 3-Axis CNC Rotary Draw Tube Bending Machine, 1" Schedule 80 Pipe Capacity
1 – Manual Pipe and Tube Bender, 3" OD Capacity

ROLLING

2 – Plate Bending Roll, 4' x 7/16" Capacity
2 – Hydraulic Angle Rolls, 1-1/2" x 1-1/2" x 3/16" Capacity

DRILL-SAW LINE

1 – Automatic CNC Drilling System combined with Band Saw, 40" x 20" Capacity
1 – Automatic CNC Coping System with Oxy-Fuel and Plasma Torch,
40" x 20" Capacity