### Plasma/Oxy Cutting Systems

**Messer MG Titan II Cutting Machine**
- Features 2 MG Titan II Thermal Cutting Machines on a common rail
- 4 ALPHA Oxyfuel torches per Cutting Machine
- 1 HyPerformance Plasma HPR260 torch per Cutting Machine
- 10' x 80' self cleaning downdraft cutting table

### Laser Cutting Systems

**ByStronic BySprint Pro 4020 Fiber Laser** 6000 Watt
- 80” x 160” dual pallet tables

**Cincinnati CL-850 Laser** 5000 Watt
- 72” x 144” dual pallet tables

### Forming Equipment

**Accurpress 485 Ton Model 548514 Accell Series**
- Synchronized CNC Press Brake, 14’ capacity with automatic back gauging and crowning systems

**Strippit/LVD 350 Ton 8-axis CNC Brake Press** 10’ capacity

**Pacific Hydraulic 400 Ton Brake Press**
- 16’ capacity with automatic back gauging

**Roundo Plate Bending Roll Model PS255**
- double pinch type, 10' x 1/2” capacity, bar-on-edge capacity 3" x 1-1/8” angle capacity 3" x 3" x 3/8"

**New Dimension Roll Model P4.250** 4' x 1/4" capacity
Facilities List
Machining Centers - CNC

**Bridge Mill**

*Okuma MCR-A5CII Dual Column Bridge Mill*
100” X 200” X 70” work envelope, max table weight 59,400 lbs.
programmable 90 degree head, 5-side machining capability with coolant through the spindle, paired with 20,000 lb. crane

**Horizontal Machining Centers**

*Toyoda FH1250SX Twin Pallet*  
Axis travels; x = 87”, y = 63”, z = 72”, swing=96”

*Toyoda FA800 Twin Pallet*  
Axis travels; x = 53”, y = 45”, z = 45”, swing=63”

*Toyoda FH630SX Twin Pallet*  
Axis travels; x = 39”, y = 32”, z = 33”

*HAAS EC630 Twin Pallet*  
Axis travels; x = 40”, y = 33”, z = 35”

**Vertical Machining Centers**

2 *HAAS VF-6/50*  
Axis travels; x = 64”, y = 28”, z = 25”

4 Haas VF-5/50  
Axis travels; x = 50”, y = 26”, z = 25”

*HAAS VF-2YT*  
Axis travels; x = 30”, y = 20”, z = 20”

2 *HAAS HRT310 4th Axis Positioners*  
all HAAS VMCs are 4th axis capable

**Turning – CNC**

*Toshiba TUE-15 Vertical Turning Center*
71” max cutting diameter, 59” max height, max table weight 17,600 lbs.

*HAAS SL-40*  
55 hp CNC lathe with live spindle  
Max swing 25.5”  Max cutting length 44”

*HAAS ST-40T*  
55 hp CNC lathe with live spindle  
Max swing 25.5”  Max cutting length 44”

**Saw**

*HYD-MECH M16A*  
automatic horizontal band saw
18” x 27” capacity with miter cutting 7.5 HP 60 HZ

*301 East Main Street | P.O. Box 279 | Black River Falls, WI 54615 | 715-284-5376 | www.dsmfg.com | sales@ds-mfg.com*

*ISO 9001:2008 Certified*

*Contract Metal Fabrication, Machining, Welding, Assembly, and Finishing*
Welders and Positioners

Robotic Welding Cell

2 ABB IRB 2600 Six Axis Robots, IRBP K Servo Positioner
2 Lincoln Welding power supplies, load capacity 2,200 lbs. swing diameter 55”, max part length 157”

Robotic Welding Systems

ABB Lean Arc 500B - Includes one IRB 2400L six axis robot, one IRBP 500B 5 axis positioner, and one Lincoln Powerwave 455M weld power supply. Capacity 40” x 57” x 1100 lbs.

3 ABB Lean Arc 750B - Includes one IRB 2400L six axis robot, one IRBP 750B 5 axis positioner, and one Lincoln Powerwave 455M weld power supply. Capacity 40” x 57” x 1650 lbs.

ABB Lean Arc 1000K – Includes two IRB 2600-12 six axis robots, one IRBP 1000k 3 axis positioner, and two Lincoln Powerwave 455M weld power supplies. Capacity 55” x 157” x 2200 lbs

Manual Welding

12 Miller pulsed 450 amp mig welders
43 wire feed welders from 350 to 650 amps.
3 Ransome Work Positioners (2,000 lb., 1,000 lb., and 750 lb.)
3 Aronson 6,000 lb. Work Positioners.
Paint Systems

Batch Booth Coating System
Part capacity wet paint: 14’ x 14’ x 25’ Part capacity power coat: 14’ x 14’ x 20’
Indexable conveyor with 5 ton hanging capacity, in line wash system with
reclamation for cleaning and phosphatizing and dry cycle, wet paint booth with
bake cycle up to 200 º F, powder coat booth and bake oven 180° - 450º F.

Powered Conveyor System
Part capacity: 4’ x 4’ by 10’
Six-stage power spray wash booth with iron phosphatizing
3 spray booths, prime coat oven and topcoat oven booth with 450° capacity
1466’ of track and 1100 hooks rated at 300 lbs. each

Shot Blasters

Pangborn ES-2050 Wire Mesh Belt Blaster  48" X 36" work envelope,
8 265DD Genesis 26 1/2" 25 HP wheels, belt speeds 2 ft./min. to 20 ft./min.
Bronco 7’ Two Wheel Table Blaster
Bronco 6.5 Cu Ft. Tumble Blaster

Inspection Equipment

Brown & Sharpe Status 9158 DCC CMM  travels x = 900mm,
y = 1500mm,  z = 800mm, accurate within +/- 0.00035
Faro Fusion Series portable CMM  10’ spherical measurement range
Accurate within +/- 0.001”

Material Handling/Shipping

Various overhead cranes with 5-ton to 10-ton capacity
Various ½-ton to 2-ton jib booms
Case 621 Wheel Loader with fork attachment
8 forklifts with capacities from 5,000 lb. to 12,000 lb.