



Main Plant

WALKER

TOOL & DIE, INC.



South Bldg

EQUIPMENT LIST

Square Footage: Main Plant = 96,850 ♦ South Building = 12,600

2411 Walker Avenue, N.W. ♦ Grand Rapids, Michigan, USA ♦ 49544-1301
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Press Specifications

Press:	Main Plant									South Bldg	
	Clearing	Clearing	Verson	Clearing	Cleveland	Wean-McKay	Minster	Toledo	Toledo	Bliss	Clearing
Tonnage	1500	1000	1000	600	450	250	250	200	200	380	200
Type of Press	Mechanical	Mechanical	Mechanical	Mechanical	Mechanical	Mechanical	Mechanical	Mechanical	Mechanical	Mechanical	Mechanical
Rolling Bolster	Yes	Yes	Yes	Yes	Yes	No	No	No	No	No	No
Bolster Size Front to Back	72	84	72	72	80	48	46	45	37	71	42
Bolster Size Left to Right	144	144	132	144	132	84	90	60	59	108	60
Air Cushion	NA	NA	7.00	NA	NA	NA	6.50	NA	6.00	No	No
Max. Shut Ht. (w/o risers)	59.38	59.88	44.30	50.63	61.30	32.50	38.38	23.50	26.50	42.00	23.50
Min. Shut Ht. (w/o risers)	42.13	45.88	28.30	26.63	51.30	24.75	26.25	18.50	21.00	37.25	15.00
Max. Shut Ht. with risers	43.38	39.88	32.80	NA	35.30	26.50	26.50	15.63	21.00	-	-
Min. Shut Ht. with risers	26.13	25.88	16.80	NA	25.30	18.75	14.38	10.63	15.75	-	-
Ram Adjustment	17.25	14.00	16.00	24.00	10.00	7.75	12.13	5.00	5.25	5.25	8.50
Stroke Length	18.00	28.00	14.00	24.00	24.00	16.00	14.00	10.00	10.00	22.00	12.00
Strokes per Minute	12	15	12	16	20	20	28	24	50	18	41
Width of Window	68.00	72.00	54.00	48.00	46.00	21.25	16.00	8.50	8.50	24.00	17.00
Coil Feeder	No	Yes	No	No	No	No	No	No	No	Yes	No
Max. Coil Width	-	48.00	-	-	-	-	-	-	-	24	-
Max. Coil Weight	-	6,000	-	-	-	-	-	-	-	10,000	-
Coil I.D. Range	-	18" – 22"	-	-	-	-	-	-	-	15"	-
Max. Coil O.D.	-	72"	-	-	-	-	-	-	-	20"	-
Max. Stock Thickness	-	0.200	-	-	-	-	-	-	-	0.100	-

CAD/CAM

Computer Aided Design & Manufacturing Software/Hardware:

43	Siemens (Unigraphics) NX Floating Licences & Workstations
14	Siemens NX-Viewer Floating Licenses
13	Siemens NX-Viewer Workstations
1	DSS CATIA V5 PLM Express Floating License
7	DSS CATIA V5 Mechanical Design Floating License
4	DSS CATIA V5 Prismatic / 3 Axis Surface Machining Workstations
3	DSS Enovia V5 Viewing Workstations
200	Actify Spinfire Professional Floating Licenses
1	ETA DynaForm Simulation Software
1	Fastform Blank Nesting Software
2	AutoForm Forming Simulation Workstations
4	AutoForm Forming Parallel Solving Cluster Nodes
13	Sescoi WorkNC Software and Workstations for Shop Floor CNC Mill Programming
2	DP Technology ESPRIT Wire EDM Programming Workstations
1	HP DesignJet T2300 Printer/Plotter (Main)

Wire EDM & Laser Equipment

Wire EDM Machines	"X" Limit	"Y" Limit	"Z" Limit	Deg. Taper	Max Weight
Main Plant:					
Charmilles CUT400 Sp	31.5	21.7	19.7	30	6,614 lb.
Charmilles RoboFil 510	27.5	15.7	15.7	30	4,408 lb.
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Charmilles RoboFil 440	21.6	13.7	15.7	30	3,306 lb.
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Charmilles RoboFil 440cc	21.6	13.7	15.7	30	3,306 lb.
Fanuc Series W2	13.8	19.7	11.8	15	772 lb.

6-Axis Laser	"X" Limit	"Y" Limit	"Z" Limit	Table Size	Resonator
Mazak Laser-Path 50/100-3D	98.42	49.21	39.37	52 x 106	1500 Watt CO2

CNC Milling Equipment

CNC Machining Centers - Main Plant	"X" Limit	"Y" Limit	"Z" Limit	"W" Limit	Table Size
FPT Area 3+2 Axis Boring & Milling Machine	314.90	137.80	59.06		98.4 x 354.3
Giddings & Lewis Horizontal Boring Mill	144.25	115.00	34.23	38.90	72.0 x 144.0
Giddings & Lewis Horizontal Boring Mill	144.25	96.70	34.23	38.90	60.0 x 144.0
Hurco VMX 84 Machining Center	84.00	34.00	30.00		86.0 x 34.0
Makino A81 Horizontal Machine Center	35.40	31.50	40.10		(2) 25.00 x 25.00 Pallets
Makino A88E Horizontal Machining Center	35.40	31.50	38.20		(2) 25.00 x 25.00 Pallets
Makino A99E Horizontal Machine Center	49.00	43.25	49.00		(2) 31.50 x 31.50 Pallets
Makino PS95 Vertical Machining Center	36.20	20.00	18.10		46.0 x 20.0
Makino PS95 Vertical Machining Center	36.20	20.00	18.10		46.0 x 20.0
Makino PS95 Vertical Machining Center	36.20	20.00	18.10		46.0 x 20.0
Makino A92 Horizontal Machine Center (#115)	59.80	49.20	53.10		(2) 31.50 x 39.40 Pallets
Makino A92 Horizontal Machine Center (#116)	59.80	49.20	53.10		(2) 31.50 x 39.40 Pallets
Okuma MCV All Vertical Machining Center	157.48	78.74	17.72	33.46	59.06 x 161.42

Non-CNC Milling Equipment

Vertical and Horizontal Mills - Main Plant	"X" Limit	"Y" Limit	"Z" Limit		
6 Clausing Vertical Mills	26.00	12.00	14.00		
4 Hurco Vertical Mills	30.00	14.00	18.00		
1 Cincinnati Vertical Mill	36.00	14.00	16.00		
2 Cincinnati Horizontal Mill	34.00	14.00	14.00		
1 Cincinnati Vercipower Vertical Mill	50.00	12.00	18.00		
2 TRAK DPM Vertical Mill	31.00	16.00	20.00		

Vertical and Horizontal Mills - South Bldg.	"X" Limit	"Y" Limit	"Z" Limit		
1 Cincinnati Vertical Mill	34.00	14.00	14.00		
1 Bridgeport Knee Mill	26.00	12.00	14.00		

Quality Control Equipment

Main Plant	"X" Limit	"Y" Limit	"Z" Limit	Probe Type
DEA Omega 2305 CMM	60	100	40	Renishaw PH10M
Brown & Sharp Global 121510 CMM	48	60	40	Renishaw PH10MQ
Starrett Manual RCS6448-24 CMM	48	64	24	Renishaw PH8
GOM ATOS III Optical Scanner	n/a			Optical: up to 8 million points per scan
Faro Gold Series Portable Measuring System	Eight foot spherical capacity.			Hard probe or TP2 adaptable

Software in Use for Quality Control

Siemens (Unigraphics) NX
PcDmis CAD++
Catia V5

Grinding and Misc. Equipment

List of Misc. Equipment - Main Plant		Size/Description
10	Grand Rapids Surface Grinders	Up to 30 x 60 chuck capacity
1	Blanchard Grinder	48 inch swing
13	Bridge Cranes	Up to 25 ton capacity
8	Gantry Cranes	Up to 10 ton capacity
9	Lift Trucks	Up to 15,000 lb. capacity
13	Radial Arm Drill Presses	Up to 8 foot swing
2	LeBlond Lathes	Up to 19 inch swing
4	Band Saws	
3	Cut Off Saws	
1	Minac 18/25 Induction Heat Treat System	
1	Heller 11ft Sheet Metal Shear	
1	Niagra 6ft Sheet Metal Brake	
	Arc and Heliarc Welding Equipment	
List of Misc. Equipment - South Bldg.		Size/Description
2	Grand Rapids Surface Grinders	12" x 27" Capacity
1	Pedestal Grinder	
1	End Grinder	
1	Surface Grinder (Dry)	
1	Radial Arm Drill Press	Up to 5 foot swing
4	Bridge Cranes	Up to 10 ton capacity
1	Optical Comparitor	
1	Lincoln Wire Welder	
1	Band Saw	

Delivery Equipment

List of Delivery Equipment	Size/Description
1 Peterbilt Tractor with	
Drop-Deck 45' trailer with "Eagle Smart Tarp" slider system	47,000 lb. Payload Capacity
1 Kenworth Stake Truck	25,000 lb Payload Capacity
1 Ford F250 Pickup	