



# **WALKER**

## **TOOL & DIE, INC.**

# **EQUIPMENT LIST**

*Square Footage: Main Plant = 96,850*

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## Press Specifications

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

**CAD/CAM**

**Computer Aided Design & Manufacturing Software/Hardware used at Walker:**

Siemens NX Workstations
Siemens NX-Viewer Workstations
DSS CATIA V5 Workstations
Actify Spinfire Professional Software
ETA DynaForm Simulation Software
Fastform Blank Nesting Software
AutoForm Forming Simulation Workstations
AutoForm Forming Parallel Solving Cluster Nodes
Hexagon WorkNC Software and Workstations for Shop Floor CNC Mill Programming
Hexagon ESPRIT Wire EDM Programming Workstations
HP DesignJet T2300 Printer/Plotter

## CNC Milling Equipment

<b>CNC Machining Centers - Main Plant</b>	<b>"X" Limit</b>	<b>"Y" Limit</b>	<b>"Z" Limit</b>	<b>"W" Limit</b>	<b>Table Size</b>
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
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 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
Makino F8 Vertical Machining Center	51.18	31.49	25.59		61.02 x 31.49
Okuma MCV All Vertical Machining Center	157.48	78.74	17.72	33.46	59.06 x 161.42
Okuma MCR-A5CII 5 Face 3+2 Vertical Machining Center	165.35	122.04	31.49	39.37	157.48 x 78.74

## Wire EDM & Laser Equipment

Wire EDM Machines	"X" Limit	"Y" Limit	"Z" Limit	Deg. Taper	Max Weight
<b>Main Plant:</b>					
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.
Charmilles RoboFil 510	27.5	15.7	15.7	30	4,408 lb.
Charmilles RoboFil 440	21.6	13.7	15.7	30	3,306 lb.
Charmilles RoboFil 440	21.6	13.7	15.7	30	3,306 lb.
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.

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

**Non-CNC Milling Equipment**

<b>Vertical and Horizontal Mills - Main Plant</b>	<b>"X" Limit</b>	<b>"Y" Limit</b>	<b>"Z" Limit</b>		
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		

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

## Quality Control Equipment

<b>Main Plant</b>	<b>"X" Limit</b>	<b>"Y" Limit</b>	<b>"Z" Limit</b>	<b>Probe Type</b>
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

<b>List of Misc. Equipment - Main Plant</b>		<b>Size/Description</b>
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	
<b>List of Misc. Equipment - South Bldg.</b>		<b>Size/Description</b>
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**

<b>List of Delivery Equipment</b>	<b>Size/Description</b>
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	