

Facilities List

The Bechdon Company Inc. • 300 Commerce Drive, Upper Marlboro MD 20774 • 301-249-0900

AS9100 Revision D and ISO 9001:2015 Certified Quality Management System

42,416 Sq. Ft. Manufacturing Area Serviced by (11) Bridge Cranes with Max. 10 Ton Lifting Capacity

Computer Numerically Controlled Milling Equipment

- 1 Kiwa KH-4500 Horizontal Machining Center with 6 pallet changer and 220 position tool changer. Equipped with touch probe measuring system. Longitudinal travel (X) 25.2"; Cross travel (Y) 29.1"; Vertical travel (Z) 26.8". Spindle speed up to 20,000 RPM. Fanuc 31i Control. (2016)
- 1 DMG Model DMF 360 Vertical Linear Traveling column machine with 3 axis capability and 60 position tool changer. Equipped with laser tool measurement system (length and diameter) and touch probe measuring system. Longitudinal travel (X) 141.7"; Cross travel (Y) 43.3"; Vertical travel (Z) 35.4". Spindle speed up to 24,000 RPM. Siemens Sinumerik 840D sl Control. (2014)
- 4 DMG Model DMF 360 Vertical Linear Traveling column machine with 5 axis capability and 120 position tool changer. Equipped with laser tool measurement system (length and diameter) and touch probe measuring system. Longitudinal travel (X) 141.7"; Cross travel (Y) 43.3"; Vertical travel (Z) 35.4". Spindle speed up to 24,000 RPM. Siemens Sinumerik 840D sl Control with Celos. **(2019, 2020, 2 ARRIVING SEPTEMBER 2021)**
- 1 DMG Model DMC80U Nutating Head 5 axis Machining Center with pallet changer and 120 position tool changer. Equipped with laser tool measurement system (length and diameter) Longitudinal travel (X) 31.5"; Cross travel (Y) 31.5"; Vertical travel (Z) 31.5". Spindle speed up to 18,000 RPM. Heidenhain iTNC 530 Control. (2010)
- 1 DMG Model DMF 500 Vertical Linear Traveling column machine with 5 axis capability and 120 position tool changer. Equipped with laser tool measurement system (length and diameter) Longitudinal travel (X) 196.8"; Cross travel (Y) 36.2"; Vertical travel (Z) 32.3". Spindle speed up to 16,000 RPM. Heidenhain iTNC 530 Control. (2006)
- 1 Kuraki KBT-13EA 6 axis CNC Horizontal Boring Mill with Fanuc control and 60 position tool changer. Longitudinal travel (X) 118"; Vertical travel (Y) 90.5"; Column travel (Z) 51"; Spindle travel (W) 27.5"; 4th axis in the X-Y plane; Rotary index table 70.5" x 86.5"; Table load capacity 33,000 pounds. Positioning accuracy + .0004. Inch/metric. Machine is equipped with a 48" dia. rotary table which provides the 6th axis. (2003)
- 1 Kuraki KBT-13PDX-A 4 axis CNC Horizontal Boring Mill with Fanuc 15M control and 40 position tool changer. Longitudinal travel (X) 118"; Vertical travel (Y) 90.5"; Column travel (Z) 51"; Spindle travel (W) 27.5". Positioning accuracy ±.0004. Machine is equipped with a 40" dia. rotary table which provides the 4th axis machining capability. Inch/metric. (1994)
- 2 Kuraki KBH-16 6 axis CNC Horizontal Boring Mill with Fanuc control and 90 position tool changer. Longitudinal travel (X) 78"; Vertical travel (Y) 59"; Column travel (Z) 51"; Spindle travel (W) 15"; 4th axis rotation in the X-Y plane; Rotary index table 55" x 63"; Table load capacity 14,000 pounds. Positioning accuracy ±.0004. Inch/metric. Spindle speed max. 12,000 RPM. (2008 - 2010)
- 1 Kuraki KBT-11WDX 6 axis CNC Horizontal Boring Mill with Fanuc control and 40 position tool changer. Longitudinal travel (X) 78"; Vertical travel (Y) 59"; Column travel (Z) 57"; Spindle travel (W) 19"; 4th axis rotation in the X-Y plane; Rotary index table 55" x 63"; Table load capacity 14,000 pounds. Positioning accuracy ±.0004. Inch/metric. (1997)
- 3 Kuraki KBM-11A 4 axis CNC Horizontal Boring and Machining Center with Fanuc control and 30 position tool changer. Longitudinal travel (X) 59"; Vertical travel (Y) 48"; Column travel (Z) 27"; Spindle travel (W) 12"; 4th axis rotation in the X-Y plane; Rotary index table 37" x 41"; Table load capacity 11,000 pounds. Positioning accuracy ±.0004. Inch/metric. (1999) (2001) (2002)

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- 1 Kuraki KBM-11EM 6 axis CNC Horizontal Boring Mill with Fanuc control 5-5000 RPM and 30 position tool changes. Longitudinal travel (X) 59"; Vertical travel (Y) 47"; Column travel (Z) 27"; Spindle travel (W) 13"; 4th axis rotation in the X-Y plane; Rotary index table 37" x 41"; Table load capacity 14,000 pounds. Positioning accuracy $\pm .0004$. Inch/metric. (2018)
- 1 Samsung SX 4000 Horizontal Machining Center 2 Pallet 15000 RPM (2019)
- 1 Fanuc a-T21if RoboDrill Vertical Machining Center with 21 position tool changer. Longitudinal travel (X) 20"; Cross travel (Y) 16"; Vertical travel (Z) 12". Spindle speed up to 24,000 RPM. (2010)
- 2 Matsuura MC-1000V 4 axis Vertical Machining Center with 30 position tool changer. Longitudinal travel (X) 40"; Cross travel (Y) 20"; Vertical travel (Z) 22". One machine is equipped with a 16" dia. rotary table which provides the 4th axis machining capability. Inch/metric. (1983) (1985)
- 5 Matsuura MC-800VG 4 axis Vertical Machining Center with 30 position tool changer. Longitudinal travel (X) 31.5"; Cross travel (Y) 20"; Vertical travel (Z) 22". Machine is equipped with a 16" dia. rotary table which provides the 4th axis machining capability. Inch/metric. (1997) (2000) (2001) (2002)
- 1 Matsuura MC-760VX 3 axis Vertical Machining Center with 30 position tool changer. Longitudinal travel (X) 30"; Cross travel (Y) 17"; Vertical travel (Z) 19". Inch/metric. (1995)
- 1 Bridgeport Series II 3 axis Combination CNC and manual Vertical Milling Machine with EZ-TRAK DX Control. Longitudinal travel (X) 32"; Cross travel (Y) 14.5"; Vertical travel (Z) 17". Inch/metric. (1997)
- 2 DMG 50 T CNC Milling Center with a universal swivel rotary table for 5 sided machining in a single setup. Longitudinal travel (X) 19.69"; Cross travel (Y) 15.75"; Vertical travel (Z) 15.75". Position accuracy .0002, repeatability .0001, angular rotary accuracy .001/degree. Inch/metric. (2000) (2002)
- 2 DMG Model DMU 60 T 5 axis Milling Center. Longitudinal travel (X) 24.8"; Cross travel (Y) 22"; Vertical travel (Z) 22". 12,000 & 18,000 RPM Spindles. Position accuracy .0002, repeatability .0001. 23" dia. rotary table. (2006)

Computer Numerically Controlled Turning Equipment

- 1 Mori-Seiki NL 2500 SY/1250 CNC 4 axis Lathe with 14" dia. x 53" long turning capacity. 3.1" bar capacity thru Spindle with Y axis, live milling capability (12 positions) and a sub spindle for secondary operations. Roundness tolerance .00002". (2006)
- 1 Methods Slant 3 Turning Center with Fanuc 11T CNC control. 15.74" max. turning dia. x 28.9" distance between center. Inch/metric (1990)
- 1 Hardinge CHNC Chucker and Bar Machine with Siemens 810T control. 1.62" dia. bar feed capacity. (1986)
- 1 Proto TRAX Lathe. Combination Manual and CNC 18" max. turning dia. x 40" between centers. (2007)
- 1 Doosan Puma GT2600 CNC 2 axis Lathe with 18.1" x 25.9" turning capacity and 10" Chuck). Thru hole diameter 3.2" bar capacity. **(NEW 2020)**

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EDM Equipment

- 1 Charmilles Technologies ROBOFIL 640cc Submerged Wire Electrical Discharge Machine with maximum work piece of 51.2" x 39.4" x 19.7"; X-Y travel 31.5" x 21.7"; Z travel 19.7"; Maximum Taper Angle \pm 30 degrees; Table load capacity 6,614 pounds. Accuracy overall .00018"; Repeatability .00007" Inch/metric. (2006)
- 1 Charmilles Technologies ROBOFIL 440cc Submerged Wire Electrical Discharge Machine with maximum work piece of 47.24" x 27.56" x 15.75"; X-Y travel 21.65" x 13.77"; Programmable Z travel up to 15.75"; Maximum Taper Angle 30 degrees; Table load capacity 3,307 pounds. Accuracy + .0001. Inch/metric. (2003)
- 1 Charmilles Technologies ROBOFORM 40 CNC Die Sinking Electrical Discharge Machine with 6 position tool changer. Longitudinal travel (X) 19.7"; Cross travel (Y) 15.7"; Vertical travel (Z) 17.7". Inch/metric. (1997)
- 1 Sodick AQ55L CNC Die Sinking EDM with 7 position tool changer. Longitudinal travel (X) 13.7"; Cross travel (Y) 9.8"; Vertical travel (Z) 9.8". Inch/metric. (2003)

Equipment Other Than CNC

- 1 LeBlond Engine Lathe. 24" swing x 72" between centers. (1980)
- 2 LeBlond Engine Lathes. 15" swing x 54" between centers. Servo Shift. (1986)
- 2 Hardinge Tool Room Lathes Model HLVH. 12" swing x 30" between centers. Threading and taper attachments. Inch/metric. (1997)
- 2 Bridgeport Vertical Milling Machines with 48" tables, power feed and 12" cross travel. Equipped with digital readout systems accurate to .002 inches. Inch/metric. (1985-1998)
- 1 Okamoto Surface Grinder Model ACC-12-24ST. 12" x 24" capacity. (1995)
- 1 DoAll Vertical Band Saw. 26" throat with Hydraulic Table feed. (1971)
- 1 Cosen SH500M Semi-Automatic Horizontal Scissor Mitering Band Saw 13" round 11' x 19.7 Rectangular Capacity
- 1 Peerless Model #1400 Cut-off Saw with bar feed. (1979)
- 1 Haberle H-350 Cold Saw
- 1 Emmesi 350 Aluminum Chop Saw
- 1 Wellsaw Horizontal Band Saw Model 1000W. 10" x 18" capacity. (1976)
- 1 Chamberlain Vacu-blast Machine Model 200-P for part cleaning and finishing. (2005)
- 1 Sunnen Honing Machine Model MBB-1660K for holes ranging from .060" to 6.5" diameter. (1978)
- 1 K.O. Lee Surface Grinder Model SE 612

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Programming Equipment

- 3 Siemens NX/Unigraphics CAM Systems – with translators for Pro E, STEP, and Parasolids.
- 1 MasterCam 2021 Cam System with CIMCO Editor Pro **(NEW 2020)**
- 3 DP Technology Esprit CAD/CAM Systems
- 1 CAD/CAM Integration DNC System

Delivery & Handling Equipment

- 1 Ford F 550 Stake Body Truck; Bed: 96" x 168" (2016)
- 1 Ford E 450 Box Truck; 92" x 202" x 85" (2017)
- 1 Ford Transit Connect Van; 48" x 87" x 49" (2016)
- 2 Nissan Ego Electric Lift Truck, 3 ton. (1990)
- 1 Yale MRW030-E Walkie High Lift Stacker, 3000 lb. capacity
- 1 E-Z V Lift Hydraulic Pallet Jack with integrated scale, 4400 lb. capacity.

Other Equipment

- 1 Adira Hydraulic Shear 1/4" x 10 Feet. (2003)
- 1 Chicago 3' Box and Pan Brake. (1972)
- 1 Plate Bending Rolls 1/4" x 4 Feet.
- 1 Haegar Press HP-6B 6 Ton. (1988)
- 1 Miller Spectrum 875 Plasma Cutter.
- 1 Devorak Iron Worker Machine Model 1528 1/4" x 12" steel. (1978)
- 1 Blue M Stress Relieving Oven 24" x 24" x 24". Calibration maintained. (1976)
- 1 Grieve Oven 36" x 48" x 60". Stainless Steel. Calibration maintained. (1980)
- 1 1,700 sq. ft. humidity and temperature controlled work area
- 1 Enclosed Crossdraft Filtered Booth: L-26', W-14',H-9'(1985)
Tig/Mig welding equipment for in-house fixture building and construction

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Inspection Equipment

(1,080 sq. ft. humidity and temperature controlled inspection room)

- 1 Mitutoyo Bright Apex 916 CNC Coordinate Measuring Machine complete with temperature compensation, six position tool changer. Renishaw PH10M articulated probe system. Software: Mitutoyo MCOSMOS 3.2 provides programmable direct comparison to customer supplied or in-house CAD models. GEOMeasure 6000 provides advanced measuring capabilities, CADMeasure provides CAD functionality by interfacing with AutoCAD, SCANMeasure allows curves and surfaces to be measured and analyzed, STATMeasure allows advanced statistical analysis of gathered data. Measuring capabilities of 36" X axis x 63" Y axis x 20" Z axis. (2000) **(PC-DMIS SOFTWARE ADDED 2021!)**
- 1 Mitutoyo CHN 1612-30 Coordinate Measuring Machine. Renishaw PH10M articulated probe system. Software: Mitutoyo MCOSMOS 3.2 provides programmable direct comparison to customer supplied or in-house CAD models. GEOMeasure 6000, CADMeasure, SCANMeasure, STATMeasure. Measuring capabilities of 120" X axis x 48" Y axis x 64" Z axis. (1993) **(PC-DMIS SOFTWARE ADDED 2020)**
- 1 Mitutoyo B241 Coordinate Measuring Machine. Renishaw PH1 probe system. Measuring capabilities of 28" X axis x 40" Y axis x 24" Z axis. (1983)
- 1 Mitutoyo BH305 Coordinate Measuring Machine. Renishaw PH1 probe system. Measuring capabilities of 13" X axis x 20" Y axis x 12" Z axis. (1993)
- 1 Scherr-Tumico 1600 Optical Comparator, 12" x 7" Stage Travel, .00005" Resolution, 16" Screen, Includes Quadra Check 221 DRO with Edge Sensing, 2 axis Motor Drive, Joy Stick and Fine Position Jog Knobs. (2002)
- 1 Computer Workstation for calibration control, scheduling/records.
- 1 Granite Surface Plate 60" x 120".
- 1 Granite Surface Plate 36" x 48"
- 1 Misawa Seiki Hardness Machine.
- 1 Krautkramer Branson DynaMic Portable Hardness Tester.
- 1 Mitutoyo SJ201P profilometer.
- 1 Olympus Model 45MG Ultrasonic Thickness Gage
- 1 QuaNix 7500 Coating Thickness Gage.
- 1 Keithley 580 Micro-ohmmeter
- 1 Renishaw QC10 Ball/Bar system.
- 1 81 pc Mitutoyo gage block set
- 1 25 pc Mitutoyo gage block accessory set.
- Pratt & Whitney gage block and other certified measuring equipment.