

Tolerance / Capabilities Chart				
Process	Machines	Capabilities	Standard Tolerance	Close Tolerance
Flame Burning	Titan, 4516	Up to 3" Thick	+/- 1/8"	+/- 1/16"
		Over 3" Thick; 8" Max.	+/- 1/4"	+/- 1/8"
		Track Torch	+ Is dependent upon sheet length - Is minimum length requested	
Plasma Burning (Carbon)	MPC, 4516, 3620	Up to 1" Thick	+/- 1/8"	+/- 1/16"
		Over 1" Thick	+/- 1/4"	+/- 1/8"
		Track Torch	+ Is dependent upon sheet length - Is minimum length requested	
Plasma Burning (Stainless)	MPC, 4516, 3620	Up to 1" Thick	+/- 1/8"	+/- 1/16"
		Over 1" Thick	+/- 1/4"	+/- 1/8"
		Track Torch	+ Is dependent upon sheet length - Is minimum length requested	
Laser	4 @ 5000 Watts Each	Up to 3/4" Carbon & Stainless or 1/2" Aluminum. 60" x 120" MAX	Up to 1/2" +/- .005" Over 1/2" +/- .010"	N/A
Sawing	H-28	Straight Cut 28" high x 28" wide & 28" O.D. Max	+/- 1/8"	+/- 1/16"
	H-22A	Straight Cut 18" high x 20" wide		
	V-18	Vertical Mitre up to 13"H x 18"W x 45 Deg. Straight Cut 18"H x 18" W.		
	M-20A	Horizontal Mitre up to 12" x 20" x 30 Deg. off horz. Straight Cut 20"H x 30" W.		
	HYD-MECH	Straight Cut 18"H x 18"W. (Cut-off saw)	No Tolerance	No Tolerance
Water Jet	2 Flow Jet	Up to 6" material 78" x 288" table size	Up to 1/2" +/- .010" 1/2" to 2" +/- .015" Over 2" +/- .020"	SPEED DEPENDENT
Angle Line	FICEP A164T	Min Angle 1-1/2" x 1-1/2" x 1/8" Max Angle 6" x 6" x 5/8"	+/- .060"	+/- .030"
		Min Flat Bar 3/16" x 2" Max Flat Bar 5/8" x 6"		
		Punching, shearing & notching in lengths up to 40' Min. Ø 1/16" larger than metal thickness; 1-1/4" Ø Max.		<b>NOTE:</b> 2 different holes/ slots per leg max.
Forming	5 total ranging from 235 ton to 485 ton	Up to 3/8" Thick +/- 1/16" Over 3/8" +/- 1/8" Length up to 16'	+/- 1 Degree *	Tolerances reviewed with customer
		* Floor Plate +/- 2 Degrees		
Machining	VF-3	20" x 40" Travel	Tolerances to be specified by the customer's requirements	
	VF-8	40" x 64" Travel		
	VF-11	40" x 120" Travel		
Iron Work	2 Machines	Cut to length	+/- 1/8"	+/- 1/16"
		Hole location	+/- 1/16"	+/- 1/16"
Shearing	2 Shears up to 12' wide 48" max length at back stops	Up to 5/16" thick	+/- 1/8"	+/- 1/16"
		Over 5/16" thick	+/- 1/8"	+/- 1/8"
		1/2" Max. Carbon	<b>Squareness</b>	
		5/16" Stainless	+/- 1/16"	+/- 1/16"
		3/8" Aluminum		

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<b>Timesaver</b>	1 Machine	3/4" thick x 8" min length x 36" width		

A-824-01-E