



West Central Steel Machine Capabilities

Processing	Band Saws (7)	Material	Capability	Capacity	Tolerance*
Production Sawing	Band Saws (7)	Angle, Beam, Channel, Round/Square/Flat Bar, Round/Square/Rectangular Tube, Pipe, Tee	Cut to Length, Up to 60° Miter Cutting	18" x 47" Fractions of an Inch to 75' Long	±0.0625" Length ±1° Miter Cut ±2° Compound Miter Cut
Precision Sawing	Circular Saw (1)	Pipe, Rectangular/Round/Square Tube, Rounds, Squares	Cut to Length	0.625" OD Min 4" OD Max 3.125" OD Max Square 27" Shuttle	Up to 24" ±.003" Standard Cutting Tolerance
Structural 3D Laser Cutting	3D Lasers (3)	Angle, Beam, Channel, Pipe, Round/Square/Rectangular Tube, Tee	6 Axis Laser Cutting: Cut to Length, Bevels, Copes, Flush Cuts, Holes, Miter Cuts, Notches, Slots, Tapping	9.5" (rd) & 8" (sq) OD Max, .5" OD Min 0.75" Max Thickness (Mild Steel) 34' Max Cut Length Up to 45° Miter (Mild Steel)	±0.010" Cutting Over 12"
Structural 3D Plasma Cutting	3D Plasma (1)	Angle, Beam, Channel, Square/Flat Bar, Square/Rectangular Tube, Tee	Cut to Length, Bevels, Copes, Flush Cuts, Holes, Miter Cuts, Notches, Slots, High Quality Bolt Holes approved for Structural Steel by AISC, CISC & Other Institutions	18" x 48" 2" Max Thickness Up to 70' In Feed & Out Feed Up to 50° Head Tilt (Mild Steel)	±0.0625" Position Tolerance
Flat Laser Cutting	Flat Lasers (4)	Plate, Sheet	Small Intricate Pieces to Large, Oversized Parts with Accuracy	20 Gauge Min Up to 1" Thick Max Bed Size: Up to 13' Wide Up to 80' Long 5" Clearance	±0.010" Cutting
High Def Plasma/Oxy Cutting	HD Plasma/Oxy (3)	Angle, Beam, Channel, Plate, Sheet, Square/Flat Bar, Square/Rectangular Tube, Tee	Cut to Length, Part Making, Holes, Slots, Notches Bevels (V, Y, K & X) & Part Marking	HD Plasma: Up to 2" Thick Oxy: Up to 6" Thick Bed Size Up to 12' Wide Up to 63' Long Up to 45° Bevel 15" Clearance	HD Plasma: • <3/4" Thick: ±0.0625" Cutting, ±0.125" Squareness, 1-3° Edge Bevel Typical • >3/4" Thick: ±0.125" Cutting, ±0.25" Squareness, 2-7° Edge Bevel Typical • CNC Weld Prep Bevel – Up to 45°, ± 2° on Bevels Oxy: • <2" Thick: ±0.0625" Cutting, ±0.125" Squareness • >2" Thick: ± 0.0938" Cutting, ±0.25" Squareness • Up to 1.5° Edge Bevel Typical
Plate Processing	Multi-Processing Machines (2)	Plate, Sheet	Cut to Length, Part Making, Holes, Slots, Notches, Bevels (V, Y, K & X), Drilling, Tapping, Counter Boring, Milling (Slots, Profiles, Threads) & Part Marking	Drilling up to 4" Holes Tapping to 1.25" Counter Bore to 8" 12' Wide x 63' Long	HD Plasma: • <3/4" Thick: ±0.0625" Cutting, ±0.125" Squareness, 1-3° Edge Bevel Typical • >3/4" Thick: ±0.125" Cutting, ±0.25" Squareness, 2-7° Edge Bevel Typical • CNC Weld Prep Bevel – Up to 45°, ± 2° on Bevels Oxy: • <2" Thick: ±0.0625" Cutting, ±0.125" Squareness • >2" Thick: ± 0.0938" Cutting, ±0.25" Squareness • Up to 1.5° Edge Bevel Typical Drilling: ±.03125" Location, ±0.010" Too
Angles & Flats Punching & Sheering	Punch (1) Angleline (1)	Angles, Flatbar	Punched Holes & Slots, Sheared to Length	Angles from 2 x 2 x 1/8" up to 6 x 6 x 1/2" Flat Bar from 3/8 x 2 1/2" up to 1/2 x 6" 40' infeed, 20' max cut length	Length and Location Tolerances are ±0.0625"
Bending	Press Brakes (4)	Plate, Sheet	Bending with Programmable Ram Positioning & Tilting	1,100 Ton x 30' 500 Ton x 14' 350 Ton x 14' 350 Ton x 12'	±0.0625" per Dimension ±1° per Bend
Shearing	Shears (2)	Plate, Sheet	Shearing	Max Width/Length 144 1/2", Min Width/Length 1 1/2" 1/2" Thick x 12'	<.25" ±0.0625" per Dimension up to 48" >.25, <.3125" ±0.0938" per Dimension > 48" >.3125" ±0.125" per Dimension ±0.125" Squareness



Recommended Specifications for Part Processing

Processing	Good	Better	Best
Production Sawing	Hand drawing, sample part, template	Dimensioned drawing, .dwg, .dxf	
Precision Cutting	Hand drawing, sample part, template	Dimensioned drawing, .dwg, .dxf	
Structural 3D Laser Cutting	Hand drawing, sample part, template	Dimensioned drawing, .dwg, .dxf	.sldprt, .iges, .stp
Structural 3D Plasma Cutting	Hand drawing, sample part, dimensioned drawing	.dwg, .dxf, .sldprt, .iges, .stp, .step	NC 1 export per Burlington Automation configuration
Flat Laser Cutting	Hand drawing, sample part, template	Dimensioned drawing	NC 1, .dwg, .dxf, .sldprt, .iges, .stp, .step
High Def Plasma/Oxy Cutting	Hand drawing, sample part, template	Dimensioned drawing	NC 1, .dwg, .dxf, .sldprt, .iges, .stp, .step
Plate Processing	Hand drawing, sample part, template	Dimensioned drawing	.dwg, .dxf, .sldprt, .iges, .stp, .step
Angles & Flats Punching & Sheering	Hand drawing, sample part, template	Dimensioned drawing, .dwg, .dxf	
Bending	Hand drawing, sample part, template	Dimensioned drawing, .dwg, .dxf	.sldprt, .iges, .stp, .step
Shearing	Hand drawing, sample part, template	Dimensioned drawing, .dwg, .dxf	