

Manufacturing & Production Facilities

CNC MILLING

High Speed, Multi-Axis, Multi-Pallett Production Milling & Jig Boring

Machine Type	Number of Machines	Max Machining Capabilities X Y Z
Yasda H40i (Horizontal Machining Center, 5 Axis, twin pallet, 60 tools - 20,000 RPM)	1	34" x 29" x 27"
Yasda PX30i (5 Axis Precision Center, 33 pallet, 323 tools - 20,000 RPM)	2	26"x15"x19"
Fanuc Robodrill Haeberle (5 Axis Vertical CNC, 48 pallets, 88 tools - 20,000 RPM)	1	6.00" x 4.30" x 2.50"
Fanuc Robodrill Haeberle (5 Axis Vertical CNC, 60 pallets, 64 tools- 20,000 RPM)	2	6.00" x 4.30" x 2.50"
Mitsui-Seiki HT3 (CNC Horizontal twin pallet, 4 Axis - 13,000 RPM)	3	21.6" x 22" x 19"
Mitsui-Seiki HT4 (CNC Horizontal twin pallet, 4 Axis - 13,000 RPM)	1	28" x 23" x 21.5"
Supermax fv56a (Vertical CNC YCI)	1	22" x 16" x 17"
Mori-Seiki NH40 dcg 00 (High Speed Horizontal twin pallet, 4 Axis)	3	22" x 22" x 24"
Matsuura H plus-300 11 (High Speed Horizontal with 11 pallet changer - 20,000 RPM)	1	19.6" x 22" x 19.6"
Fanuc Robodrills-t21ie (High Speed twin pallet - 24,000 RPM)	5	27.5" x 15" x 13"
Matsuura es-800 (High Speed Vertical with twin pallet)	1	31.5" x 21.6" x 19.7"
Fryer MC60 (Vertical CNC 5 Axis index table - 12,000 RPM)	1	60" x 30" x 28"
Fryer MC60 (Vertical CNC with Glass Scales - 12,000 RPM)	1	60" x 30" x 28"
Kiwa KH-45 (4 axis, 6 pallet - 15,000 RPM)	1	25" x 24" x 27"
Feeler VPM-580 (CNC Vertical Mill twin pallet - 10,000 RPM)	1	22.8" x 16.5" x 6"

Kenlee Precision Corporation - 1701 Inverness Avenue - Baltimore, Maryland 21230 - Phone: 410-525-3800, Fax: 410-646-3278

Turning CNC Centers High Speed, Multi-Spindle Production Turning

Machine Type	Number of Machines	Max Machining Capabilities X Y Z
Tsugami Swiss Turn BZ18 Live Tooling w/sub spindle	1	7 tools for main spindle are on a slide 3 live tools for main spindle 3 tools for sub spindle 5/8" thru the spindle for bar work Max. spindle speed for main spindle 8000RPM Max. spindle speed for sub spindle 4000RPM
Tsugami Swiss Turn SX20B Live Tooling w/sub spindle	2	7 tools for main spindle are on a slide 3 live tools for main spindle 3 tools for sub spindle 3/4" dia. thru the spindle for bar work Max. spindle speed for main spindle 6000RPM Max. spindle speed for sub spindle 4000RPM
Tsugami Swiss Turn SX20C Live Tooling w/sub spindle – super precision w/ 5 place programming and offsets	1	7 tools for main spindle are on a slide 3 live tools for main spindle 8 tools for sub spindle – 3 for live tooling 3/4" dia. thru the spindle for bar work Max. main spindle speed 6000 RPM Max. sub spindle speed 4000 RPM
Hardinge Conquest 425P Super Precision Machine with 5 place programming and offsets	2	12 station turret 1-5/8" dia. thru the spindle for bar work 6.0" chuck 16C collet Max. turned diameter 9.0" Max bored diameter 7.0" Max. length between centers (collet 10.0"/chuck 6.0") Max. spindle speed 4500 RPM
Nakamura WT150 Live Tooling and sub-spindle can work at the same time	1	2 twelve station turrets (upper and lower) all w/live tooling 2 - 6" chucks/ S20 collet 2" dia. Thru the spindle w/6" chucks Max. turned dia. w/chucks 6" Max. turned dia. w/collets 2" Max. spindle speed both spindles 5000 RPM
Doosan Puma 240 w/Live Tooling w/Gantry Loader to load/unload parts - can also be bar fed	1	12 station turret w/live tooling 2.625" dia. thru the spindle bar work 8" chuck Max. turned dia. 12" Max. bored dia. 9" Max. length of part for gantry loader 5" Max. spindle speed 3500 RPM
Hyundai WIA HD2600Y with Live Tooling	1	12 station turret 2.6" diameter thru the spindle for bar work 10.0" chuck Max. turned diameter 15.0" Max. bored diameter 9.0" maximum length between centers 17.3" Programmable tail stock Max. spindle speed 4000RPM Max. Live Tooling speed 6000RPM
Hyundai WIA HD2200Y with Live Tooling	3	12 station turret 2.6" diameter thru the spindle for bar work 8.0" chuck Max. turned diameter 11.8" Max. bored diameter 6.8" Max. length between centers 25.6" Programmable tail stock Max. spindle speed 4000RPM Max Live Tooling speed 6000RPM

Kenlee Precision Corporation - 1701 Inverness Avenue - Baltimore, Maryland 21230 - Phone: 410-525-3800, Fax: 410-646-3278

Electrical Discharge Machining (EDM)

Machine Type	Number of Machines
Eltree Pulisitron (RAM EDM)	1
Mitsubishi CX20 (CNC 4 Axis Wire EDM)	1
Makino Sinker (EDM)	1

Quality Assurance Systems ISO 9001:2015 Certified Facility

Equipment

2x- Zeiss CNC Coordinate Measuring Machines	2X - Optical Comparators
Pratt & Whitney Super Micrometers	2X - ASNT SNT-TC-1A Welding Inspectors
Rockwell Hardness Testers	Profilometers/Scienscope (20X to 90X)
Mantis stereo scopes	Mechanical inspection gauging
ASQ Certified Mechanical Inspector and Quality Technician	Keyence IM-7501 Vision System

Support Systems

Epicor's VANTAGE® Enterprise Resource System (ERP)	Conversion Capabilities • DWG • DXF • IGES/PDF • Parasolid • STP/STEP
Unigraphics NX12 CAD/CAM on Nutanix Hyperconverged Infrastructure	
Unigraphics CAD SOLID EDGE	
MASTERCAM 2024	
CATIA Version 4 and 5	
AUTOCAD LT/CADKEY CAD	
CGTECH VERICUT	
VIRTUAL GIBBS CAM/Lathe/Mill/Solid Modeling	
Metalsoft's FABRIWIN CAD/CAM for Amada (Fabrication)	
Pro-E WILDFIRE 5.0	
Custom DIGITAL PRODUCTION BOARD for Real Time production, quality and shipping efficiency controls	

Kenlee Precision Corporation - 1701 Inverness Avenue - Baltimore, Maryland 21230 - Phone: 410-525-3800, Fax: 410-646-3278

Manual Equipment Grinding & Manual Lathes

Harig Manual Surface Grinder 6" x 18"	2 Tool & Cutter Grinders
Hardinge Tool Room Lathe	2 Bridgeport Vertical Mills with Digital Readout
Sunnen Hone Machine	

Saw Capabilities

Vertical Do - All with Hydraulic power Feed	
2 Cosen Horizontal Saws	

Paint Capabilities (Military and Commercial Standards) Military & Commercial Certified Painting & Detailing

Wet Painting	500 Degree (F) Oven 6' x 7' x 12'
Nordson Versa-Spray Powder Coating System	Bonding Oven 24" x 48" x 48"
Gloss Meter	

Assembly Electrical, Mechanical & Manual Component Assembly

Electrical Assembly	Testing and Concurrent Engineering
Mechanical Assembly	Laminaire Flow Booth, Class 1000
2 Haeger Presses, one w/auto feed	

Finishing & Special Processing Certified Finishing Facilities, Deburring, Cleaning & Brazing Systems

MIL-DTL-55411 Type 1 Cert. Chromate Line	Certified Welding
Silk Screening	Spot Welders
Pressure Test Equipment and Gages	Extrude Honing
Induction Brazing (25 KW Level)	Bead Blasting (Glass & Sand)
Critical Deburring and Tumble Deburring	CFC Free Crest Ultra-Sonic Cleaning System

Kenlee Precision Corporation - 1701 Inverness Avenue - Baltimore, Maryland 21230 - Phone: 410-525-3800, Fax: 410-646-3278

Other Information

Facility Size	50,000 sq. ft
Number of Employees	60
Certification	ISO 9001:2015
US Dept. of State - Defense Trade Controls Compliance	M20216
Dunn & Bradstreet	04 - 857 - 362
Federal Tax ID #	52 - 0894524
NAICS Code	332710
Standard Industry Code	3599 - 03
Cage Code	63924
Established	Aug-69

Kenlee Precision Corporation - 1701 Inverness Avenue - Baltimore, Maryland 21230 - Phone: 410-525-3800, Fax: 410-646-3278