



CAPABILITIES SURVEY ASCENSION INDUSTRIES

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1. PERSONNEL CLASSIFICATION

DEPARTMENT / CLASSIFICATION	NUMBER OF PERSONNEL
Shop Production	90
Engineers	7
Office Personnel	25
Quality Control Inspectors	5
Shop Supervisors	6

2. MANUFACTURING CAPABILITIES

2.1. Principal Products Manufactured:

PRODUCT DESCRIPTION	PRODUCTION CAPACITY
Industrial Equipment Systems	14' Wide x 16' High Length unlimited by sections
Filtration Systems	Tube Filter, Pressure Leaf, Filter Press, Dryer
Pressure Vessels	3" to 96" Diameter

2.2. Technical Drawing:

Prepare working drawings from specifications and/or outlines on the following types of equipment:

Turnkey Product Manufacturing, Skid Mounted Processing Systems,
Special Machines, Lube Oil Consoles, Separators,
Pressure Vessels, and Transfer Valves.

2.3. Code Construction :

Authority	Section	Classes
ASME	VIII, Div.1	
API	660-614-618, 6.11	
AWS	D1.1 and D1.5	
TEMA	"B", "C", "R"	

- Union Affiliation: None
- National Board Inspection Agency: Hartford Steam Boiler
- ASME Code Stamps Authorized for use: "U" & "UM"
- National Board Stamp Authorized for use: "R"
- People's Republic of China safety quality license manufacturer approval for the manufacture of stationary pressure vessels (China Code Stamp) - A2 Rating
- South Korea KGS/MOCIE Certification for Pressure Vessels and Heat Exchangers

2.4. Work Space Square Footage:

	Main Plant	Plant 2	Sweeney Plant
Total working area	82,000 sq. ft.	42,000 sq. ft.	26,000 sq. ft.
Metal Fabrication	53,300 sq. ft.	35,500 sq. ft.	20,000 sq. ft.
Machine Shop	9,200 sq. ft.		
Administration Offices	5,000 sq. ft.	4,500 sq. ft.	2,000 sq. ft.
Sheet Metal	4,500 sq. ft.		
Storage area	10,000 sq. ft.	2,000 sq. ft.	4,000 sq. ft.

2.5. Materials Handling Equipment:

11	Overhead cranes with up to 60,000 lb. maximum lift
45	Jib Cranes 1-3 ton capacities
6	Lift Trucks with up to 5 ton lift capacity (Outside Rigging Available)
1	Lift Truck with up to 20 ton lift capacity

2.6. Shipping Facilities:

Main Plant	Plant 2	Sweeney Plant
Wurlitzer: 16' High x 15'11" Wide	10' High x 10" Wide	Sweeney: 14'4" High x 13'9" Wide
5 Ton Bay: 18' High x 14' Wide	Dock: 8'10" High x 8' Wide	Bryant St.: 14'8" High x 15'7" Wide
20 Ton Bay: 15' High x 22' Wide	Dock: 8'10" High x 8' Wide	Loading Dock: 9'9" High x 9'8" Wide
Shipping Door: 14'6" High x 14' Wide	Shipping Door: 14' High x 14' Wide	

TYPE	SERVICED BY
Rail	Available - Adjacent
Truck	Many - Heavy Haul, Flatbed, Exclusive Use, LTL and Van
Water	Available - Must truck to Buffalo Port Authority
Air	Available - Buffalo Niagara International Airport via truck

Equipped to handle oversized loads.

2.7. Principal Machine Tools:

DESCRIPTION BY TYPE	QUANTITY	SIZE OR CAPACITY
Union CNC Horizontal Boring Mill	1	18' horiz. x 8' vert.
Toshiba CNC Horizontal Boring Mill	1	18' horiz. x 8' vert.
Union CNC Horizontal Boring Mill	1	63" horiz. x 49" vert.
Waida Jig Bore	1	26" x 46" x 32"
Pratt & Whitney Rotary Table Jig Bore	1	50" swing
Victor Precision Heavy Duty Lathe	1	120" ctr. to ctr. / 29" swing
Victor Engine Lathe	1	60" ctr. to ctr. / 24" swing
Dah Lih Heavy Duty Vertical Mill	1	20' x 47" travel
Sigma Horizontal Mill	1	12" x 49" capacity
Norton Surface Grinder	1	6" x 18" capacity
Okamoto Surface Grinder	1	8" x 20" capacity
Bridgeport Type Mill	1	

2.8. Principal Metal Forming and Cutting Equipment:

CNC LASER CUTTING	QUANTITY	SIZE OR CAPACITY
2000 Watt Mazak CNC Super Turbo Charged Laser	1	4' x 8' sheet / cuts to 5/8" stl / 3/8" SS / 1/8" alum
1500 Watt Mazak CNC Super Turbo Laser	1	4' x 8' sheet / cuts to 3/8" stl / 1/2" SS / 1/8" alum

CUTTING & BURNING	QUANTITY	SIZE OR CAPACITY
10" Coping Saw	1	
18" Cut Band Saw	3	
Pak 5 Plasma Cutter	1	
Linde Shapemaker Model 48	1	straight line burning
Copicut	1	1/8" max steel
Plasma Cutter - Hobart, smooth cut	1	
Plasma Cutter - ESAB ESP 100	1	
Plasma Cutter - ESAB PCM 875	1	

SHEARING	QUANTITY	SIZE OR CAPACITY
1/4" X 10' Wysong CNC Shear	1	
3/8" x 10' Plate Shear	1	
14 Ga. x 6' Powered Shear	1	

DRILLING AND TAPPING	QUANTITY	SIZE OR CAPACITY
6' Radial Arm Drill Press	1	
Drill Presses and Mag Drills	5	
Buffalo 6 Spindle	1	
Flex Arm Hydraulic Tapping Machine	1	
M-60-FX working range, 76" reach		up to 1"

2.8. Principal Metal Forming and Cutting Equipment (continued):

PIPE BENDING AND THREADING	QUANTITY	SIZE OR CAPACITY
2" threading	1	2" Threading
2" max. sch 40 pipe (heavier available)	1	4" Threading

BENDING, ROLLING AND FORMING	QUANTITY	SIZE OR CAPACITY
175 ton x 10' Wysong CNC Press Brake	1	
250 ton 5/16" x 12' Press Brake	1	
9/16" x 8' Rolling Machine	1	
10 ton Power Turning Rolls	1	
6000 Lb Aronson Welding Positioner	1	
10 ga. x 10' Roto-die Hydraulic Bender	1	
14 ga. x 10' Chicago Leaf Brake	1	
16 ga. x 4' Box & Pan Brake	1	
Pullmax P3/3 Universal Shear & Form, 10 ga. HR	1	
Niagara #172 Edge Rolling Machine	1	
10 ga. x 4' Pexto Power Rolls	1	
Metal Munchers 13/16" dia. through 3/4" and 1-1/16" dia. through 1/2"	2	
Lockformer - 20 ga. Pittsburgh & Pipe Lock	1	
Hossfeld Bender Model #210	1	

ASSEMBLY	QUANTITY	SIZE OR CAPACITY
Auto-Sert AS-7.5 Press-Pem stud inserter	1	
Floor Plates:		
5' x 8'	3	
6' x 6'	2	
5' x 17'	1	
6' x 12'	3	
6' x 20'	1	
7' x 24'	1	
8' x 10'	3	
8' x 16'	2	
10' x 17'	2	
10' x 20'	1	
16' x 20'	2	
20' x 20'	2	

2.8. Principal Metal Forming and Cutting Equipment (continued):

ROLLS	QUANTITY	SIZE OR CAPACITY
Aronson 18" Wheels	1	18" wheels
Ircos Model # 3 -1 PWR S/N 12226-M	1	12" wheels
Joe Fuller & Co. Model # FFRD-10 S/N 98008	1	10,000 lbs. capacity
Reiner Ind. Model # PRD-10	1	18" wheels
PandJiris Piper S/N 81-2505-3	1	6,000 lbs. turning capacity and 2,000 lbs. weight capacity
Aronson Model # SPRD3 S/N 90562	1	3,000 lbs. capacity
PandJiris S/N 81-2238-5	1	6,000 lbs. turning capacity and 2,000 lbs. weight capacity
Aronson Model # PRD3 S/N 91572	1	3,000 lbs. capacity
No Tag 12" x 4" wheels	1	80" base
Reiner Ind. Model # PRD-10 S/N PRD-10	1	8" wheels

POSITIONERS	QUANTITY	SIZE OR CAPACITY
Aronson Model # HD-60A S/N 85635	1	72,000 lb. in Rotation 123,000 lb. in Tilt
Ransome	1	2 ton
Ransome Model # SW 40 E46039 S/N 9327573	1	26,000 in. lbs. Tilt torque 4,000 lbs. capacity
Ircos Model # BM100 S/N 12227	1	
Ransome hand crank tilt power rotation	1	
Atlas Model # 200 S/N 4054	1	200 lbs. capacity
Atlas Model # 200 S/N 5264	1	

2.9. Welding Equipment:

DESCRIPTION	QUANTITY	SIZE OR CAPACITY
Stud Welder	1	
Airco CV-450 Semi Automatic	3	
Miller CP 300 Mig Welder	11	Mig Welder
Miller CP 302 Mig Welder	12	Mig Welder
Miller Syncrowave 351 Tig Welder	12	Tig Welder
Hobart Tigwave 250 Tig Welder	1	Tig Welder
Miller 330 A/BF Tig/Stick/Spot Welder	1	Tig/Stick/Spot Welder
Miller Dimension 400 Boom Mig Welder	1	Mig Welder

DESCRIPTION	QUANTITY	SIZE OR CAPACITY
Miller Deltaweld 451 Mig Welder	7	Mig/Tig Welder
Lincoln Pulsed Power 500 Tig/Mig Welder	1	Mig/Tig Welder
Miller Pulse XMT300 Pulse CC/CU	2	Mig/Tig/Stick/Spot Welder
Airco 300 amp Heliwelder	1	Mig/Tig/Stick/Spot Welder
Lincoln Idealarc 250 Welder	1	Tig/Stick Welder
Hobart Excel-Arc 8065 CV Sub Arc	1	Sub Arc Welder
Airco 300 amp Mig Welder Heliwelder	1	Mig Welder
Lincoln Invertec Surface Tension Transfer	6	Mig Welder
Lincoln Invertec Surface Tension Transfer II	6	Mig Welder
Thermal Dynamic Thermal Arc 300 CTSW	1	Tig/Stick Welder
Airco 300 amp Heliwelder	1	Mig/Tig/Stick/Spot Welder

With this equipment we can weld using the following processes:

Gas Metal Arc Welding	GMAW (MIG)
Gas Tungsten Arc Welding	GTAW (TIG)
Flux Core Arc Welding	FCAW (MIG)
Shield Metal Arc Welding	SMAW (STICK)
Submerge Arc Welding	SAW (Sub-Arc)

We are coded and/or can weld the following materials:

Carbon Steel	Cast Iron
Stainless Steel	Copper Alloys
Aluminum	Nickel Alloys
Steel Alloys	

2.10. Melting and Heat Treating Furnaces:

HEAT TREATING SUB-CONTRACTOR:

B & W Heat Treating
 2780 Kenmore Avenue
 Tonawanda, NY 14150
 Inside Furnace Dimensions - Various
 Reading - Time and Temperature
 Automatic / Manual - Both

2.11. Material scope for items able to fabricate:

NOTE: Indoors is limited to 20 ton bay door. Outdoors is unlimited

Material	Thickness Maximum	Thickness Minimum	Outside Dia. Min.
Carbon Steel	Unlimited	1/16"	13'
Straight Chrome Stainless	Unlimited	1/16"	13'
Clad Nickel Copper	Unlimited	1/16"	13'
Silicone Bronze	Unlimited	1/16"	13'

2.12. Finishing:

Conventional and airless spray, surface etch and sandblasting. Anodizing is available.

2.13. Computer Aided Design:

HP A/E Plotter - Autocad Release 2006 & 2007, Solidworks 2000
Intergraph - Smart Plant Review, Smart Sketch
Striker CAD/CAM System with Program Assist
Compress

2.14. Manufacturing System:

Epicor's Vantage 8.0 integrated enterprise software solution. Provides dynamic total project management traceability from quote to ship. Current modules: CRM; Production Control which includes: Purchasing - vendor tracking, approved vendors; Scheduling - integrates with MS Project; Quality Control - lot tracking, serialization, conformance reporting; Accounting - AR, AP, GL; Warranty Tracking; and Field Service.

3. QUALITY CONTROL DATA

Quality Assurance / Quality Control Manager reports directly to the Plant Superintendents

3.1. SNT-TC-1A Certified Non-Destructive Examination Personnel:

METHOD	LEVEL 1
RT	None
MT	None
PT	6 (ASME VIII APP.8)
AWS CWI	4

3.2. In-House Non-Destructive Testing Equipment:

METHOD	EQUIPMENT DESCRIPTION
Radiography	Sub-Contracted
Gamma Ray	Sub-Contracted
Magnetic Particle	Sub-Contracted
Liquid Penetrant	D-70 Met-L-Chek
Ultrasonic (3rd party)	Sub-Contracted
Ultrasonic (used for in-house testing)	(1) Krautramer Branson USN menu driven, ultrasonic flaw detector (1) Stresstel T-Mike II ultrasonic digital thickness gauge

3.3. In-House Pressure and Leak Tightness Testing Equipment:

1. Hydrostatic testing to 10,000 psig
2. Pneumatic testing to 160 psig maximum

Halogen leak testing able to be done by outside source.

Impact testing able to be done by outside source.

Tensile testing able to be done by outside source.

3.4. Other Principal Testing and Inspection Equipment:

1. Portable Rockwell Hardness Meter
2. 450 gpm Oil Cooler Flushing System

3.5. Capable of working to SI and Metric in rating of heat exchangers

3.6. Quality Assurance / Quality Control Program Manual:

TITLE: 3rd Edition Quality Control Manual for the fabrication, repair and alteration of pressure vessels to ASME Code, Section VIII, Div. 1 and National Board Inspection Code for the above location and field sites.

4. SUB-CONTRACTORS:

TEI Analytical Services Inc.
220 John Glenn Drive
Amherst, NY 14228

Quality Inspection Services, Inc.
Cathedral Park Tower
37 Franklin St. Suite #400
Buffalo, NY 14202

(paint)
Hillcrest Coatings Inc.
1176 Minkel Road
Strykersville, NY 14145

(heat treat)
B & W Heat Treat
2780 Kenmore Ave
Tonawanda, NY 14150