



Shop Capabilities
177,000 Square foot facility



GK MACHINE, INC. DONALD, OREGON
503-678-5525 www.GKMachine.com

Kinetic K5000 XMC Machining , Plasma & Flame cutting



Plasma Tolerance

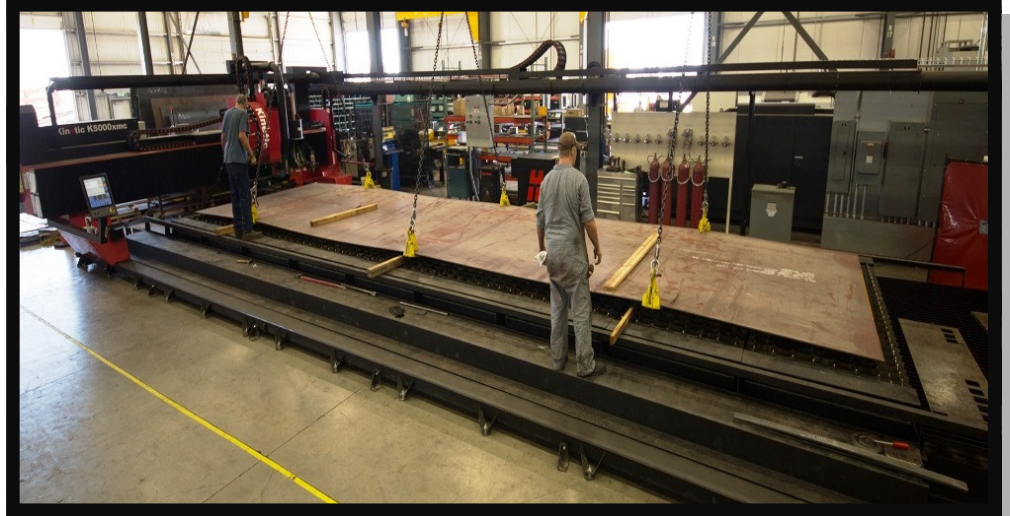
For parts 36" x 36" or smaller. For larger parts, add 0.002"/foot.

THICKNESS	TOLERANCE (In Inches)
Gauge	0.017
0.188	0.019
0.25	0.021
0.313	0.023
0.375	0.038
0.5	0.047
0.625	0.056
0.75	0.064
1	0.082
1.25	0.099
1.5	0.169
1.75	0.195
2	0.222
2.25	0.248
2.5	0.274
2.75	0.3
3	0.326

Width 10' Length 40'

24 automatic tool changer

Combination Plasma/Flame bevel, Marking Systems,
Flame cutting and multiple torch stations



Flame Tolerance

For parts 36" x 36" or smaller. For larger parts, add 0.002"/foot.

THICKNESS	TOLERANCE (IN INCHES)
$\leq 3.0"$	1/8
$> 3.0"$	1/4



Capabilities :

DRILLING	COUNTERBORING
MILLING	PLASMA CUTTING
TAPPING	FLAME CUTTING
MARKING	BEVEL CUTTING
AUTOMATIC TOOL CHANGING	

Additional Information

Max drilled hole (current tooling on hand)	1.25"
Max drilled hole (check tooling avail. 1st)	4"
Max tapped hole	1.25"
Max plasma thickness	3"
Max flame thickness	8"
Max bevel angle	45*
Max bevel "length"	3"
Max plate thickness with 45* bevel	2.0"
Bevels can be on top and bottom of parts	
10'-8" x 40'-8" cutting table size	
Min OD of a feature's profile	.125"
Min material thickness for machining	1/4"

Machining Tolerance & Capacity

Feature location:

DISTANCE BETWEEN FEATURES	TOLERANCE (IN INCHES)
$\leq 36"$	0.006 "
$> 36"$	0.006" + 0.002"/foot

Feature size:

Drilling	+/- 0.010"
Milling	+/- 0.010"

Tap sizes:

$< 1/2"$ plate	1/4 min tap size
$< 3/4"$ plate	5/16 min tap size

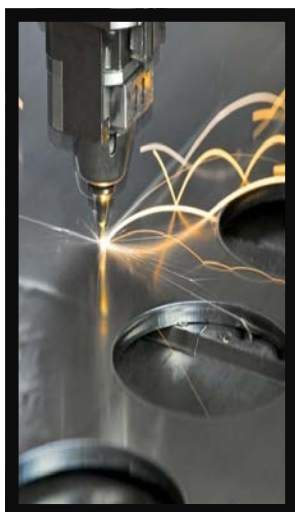
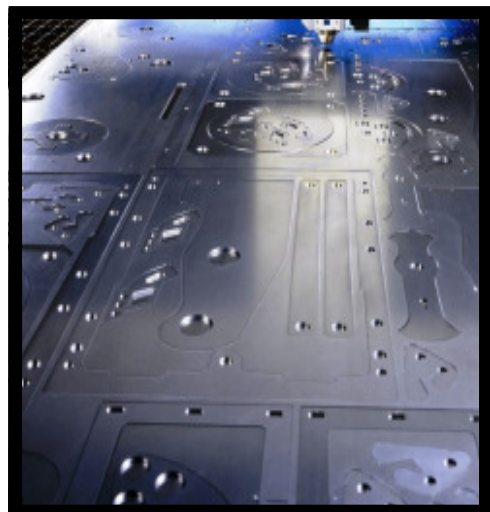
Laser Trumpf Trumatic 3030 & 3050



Facts:

- 1) .50" Max aluminum thickness
- 2) .63" Max stainless thickness
- 125-250 RMS surface finish @ cut
- 60" x 120" cutting table size, however parts must be 1/16" smaller than sheet size.

Thickness	Min Size Hole
Gauge	.85-.9x material thickness
.188-.500	= material thickness
.625-1.00	1.5x material thickness*



Laser Tolerance

For parts 36" x 36" or smaller. For larger parts, add .002"/foot. Laser Kerf angle = .5-1 degree. Chart is for

Thickness	Tolerance (In Inches)
GAUGE	0.01
0.188	0.012
0.25	0.013
0.313	0.014
0.375	0.015
0.5	0.015
0.625	0.016
0.75	0.028
1	0.031

Trumpf Liftmaster

(automatic loading & unloading)

The Liftmaster is a fast, compact loading and unloading unit. This automation solution is particularly well suited to fast sheet processing times and can handle lights out processing to increase efficiency and laser cutting production times.



Trumpf TruBend 7036 (40 T)



Bend table minimum guidelines chart is for steel (A36) up to a 90° single bend ONLY.

See below for other bends or alternate materials. Standard radius is equal to material thickness.

MATERIAL THICKNESS	8X THK	STANDARD DIE WIDTH	MINIMUM ENTITY TO BEND	MINIMUM FLANGE LENGTH	LONGEST BEND	MAX DEGREE	K FACTOR MS / SS
(.048)18 ga	0.38	0.384" (10MM)	0.281	0.317	40	35	0.156 / 0.065
(.060)16 ga	0.48	0.384" (10MM)	0.281	0.317	40	35	0.400 / 0.283
(.075)14 ga	0.60	0.472" (12MM)	0.332	0.361	40	35	0.300 / 0.225
(.105)12 ga	0.84	5/8" (16MM)	0.406	0.440	40	35	0.380 / 0.350
(.120)11 ga	0.96	5/8" (16MM)	0.406	0.440	31	35	0.315 / 0.380
(.135)10 ga	1.08	1" (30MM)	0.85	0.875	40	35	0.350 / 0.355*(16mm)
.188 Plate	1.50	1.5" (40MM)	1.17	1.173	24	35	0.415 / 0.328
.250 Plate	2.00	2" (50MM)	1.25	1.375	30.5	35	0.350 / 0.342
.313 Plate	2.50	2" (50MM)	1.25	1.375	17.5	35	0.335 / 0.328
.375 Plate	3.00	3" (70MM)	1.69	1.875	16.5	55	0.362 / 0.3145

5052 AL K factors	
Thickness	K factor
0.0478	0.135
0.063	0.5
0.08	0.41
0.1	0.485
0.125	0.5
0.188	0.415
0.25	0.345
0.313	0.328
0.375	0.3135

Notes:
Die bed is 40" and 36.7" between columns
Max interior box ID = 2.625"
Max flange at upright 16"



86° (90°) dies available	
Size	Length
0.3149" (8mm)	40
0.472" (12mm)	40
5/8" (16mm)	40
1.5" (40mm)	40

Radius punches available	
Size	Length
0.04 R (1mm)	40
0.16 R (4mm)	10
0.375 R	40
0.500 R	40
0.750 R	40
1.000 R	40



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Trumpf TruBend 5320 (360 T)



*Bend table minimum guidelines chart is for steel (A36) up to a 90° single bend ONLY.
See below for other bends or alternate materials. Standard radius is equal to material thickness.*

MATERIAL THICKNESS	8X THK	STANDARD DIE WIDTH	MINIMUM ENTITY TO BEND	MINIMUM LANGE LENGTH	LONGEST BEND	MAX DEGREE	K FACTOR MS / SS
(.048)18 ga	0.38	0.384" (10MM)	0.281	0.317	159	35 OR HEM	0.156 / 0.065
(.060)16 ga	0.48	0.384" (10MM)	0.281	0.317	159	35 OR HEM	0.400 / 0.283
(.075)14 ga	0.60	0.472" (12MM)	0.332	0.361	159	35 OR HEM	0.300 / 0.225
(.105)12 ga	0.84	5/8" (16MM)	0.406	0.440	159	35 OR HEM	0.380 / 0.350
(.120)11 ga	0.96	5/8" (16MM)	0.406	0.440	159	35 OR HEM	0.315 / 0.380
(.135)10 ga	1.08	1" (30MM)	0.85	0.875	172	35	0.350 / 0.355*(16mm)
.188 Plate	1.50	1.5" (40MM)	1.17	1.173	172	35	0.415 / 0.328
.250 Plate	2.00	2" (50MM)	1.25	1.375	172	35	0.350 / 0.342
.313 Plate	2.50	2" (50MM)	1.25	1.375	159	35	0.335 / 0.328
.375 Plate	3.00	3" (70MM)	1.69	1.875	159	55	0.362 / 0.3145
.500 Plate	4.00	4" (100MM)	2.25	2.500	90	55	0.300 / 0.300
.625Plate	5.00	6" (150MM)	3.25	3.750	80	85	0.285 / 0.286
.750 Plate	6.00	6" (150MM)	3.25	3.750	80	85	0.265 / 0.265
1.00 Plate	8.00	6" (150MM)	3.50	4.00	80	85	0.235 / 0.235



86° (90°) dies available

Size	Length
0.3149" (8mm)	42
0.472" (12mm)	42
5/8" (16mm)	42
1.5" (40mm)	159



5052 AL K factors

Thickness	K factor
0.0478	0.135
0.063	0.5
0.08	0.41
0.1	0.485
0.125	0.5
0.188	0.415
0.25	0.345
0.313	0.328
0.375	0.3135



Radius punches available

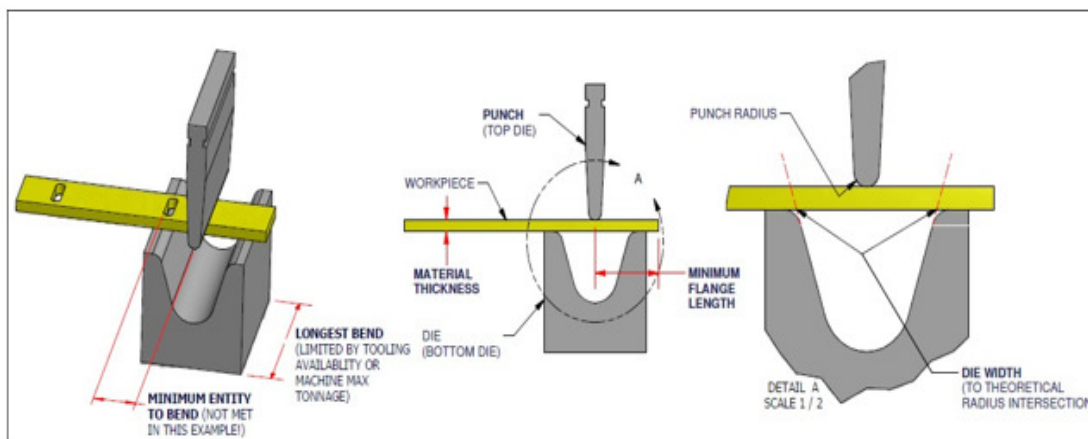
Size	Length
0.04 R (1mm)	159
0.16 R (4mm)	159
0.375 R	78.75
0.500 R	98.50
0.750 R	78.75
1.000 R	98.50
1.500 R	78.75

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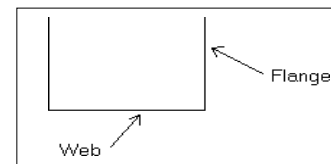
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Trumpf TruBend 7036 / 5320

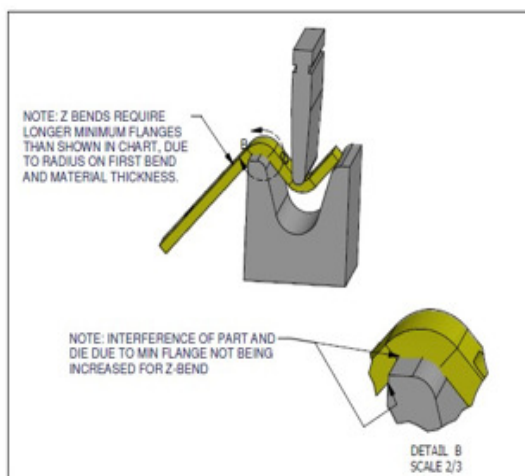
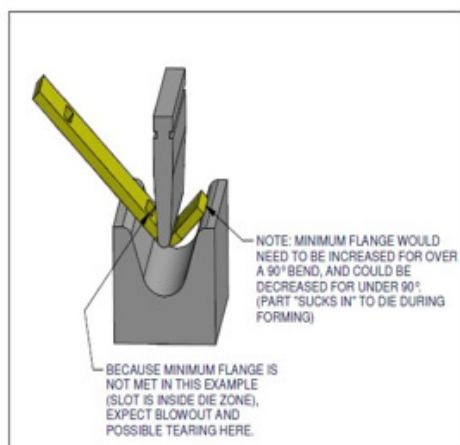


All dimensions measured to inside of bends



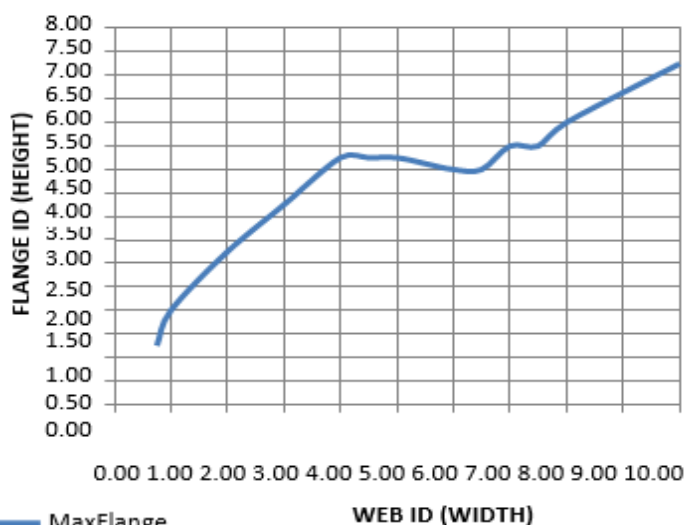
Maximum Flange Lengths typical for all material thicknesses.

Extreme



Web	Max Flange
0.75	1.25
1	2
2	3.25
3	4.25
4	5.25
4.5	5.25
5	5.25
5.5	5.13
6	5
6.5	5
7	5.5
7.5	5.5
8	6
10	7.25
12	9.25
15	12.2
18	15.2
21	18.2
24	21.2
30	27.2
36	33.2

MAX FLANGE HEIGHT FOR <10" WEB



Forming Tolerance

Thickness	+/-
18 ga - 10ga	1/32
3/16 - 1/2	1/16
5/8 +	3/32
Angular = +/- 1 deg.	

MAX FLANGE HEIGHT FOR >10" WEB

$$\text{FLANGE} = \text{WEB} - 2.8$$



Trumpf 260-T Punch



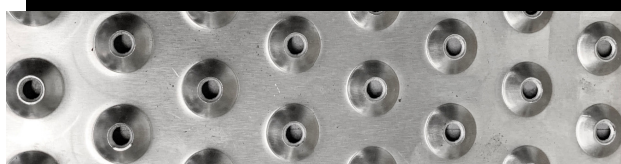
Capabilities

Tonnage	27 T
Max. Hits per Minute	500 HPM
Min. Width ¹	22 5/8
Max Width	100" (without Reposition)
Max Thickness	1/4"
Min. Edge to Punch Center Line ^{3,4}	4 1/16
Tool Stations	25
Min. Center to Center	1.5"

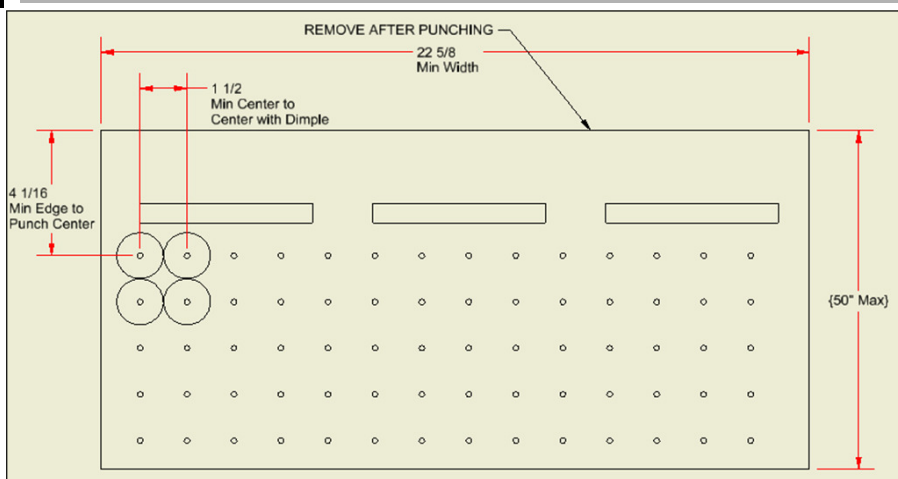
Minimum distance to center of a punched "dimple" can be from a bend line is 1.75" (1/4" max for dimples)

Available Punch Shapes

Circle	.039" - 2"
Oval	.142" - 1.0"; L 0.203" - 2.0"
Square	0.2" x 0.2"
Rectangle	0.125" x 0.5" - 1" x 2.5"
Dimple	1.5"



Many intermediate sizes and other shapes are available. Star, Hexagon, Obround, Special, etc. Check with manufacturing for availability.



DAVI 4 MCA 3022 Roller



ROLLER CAPABILITIES:

MAX ROLL WIDTH (FT)	10'
MAX ROLL THICKNESS (IN)	3/8"
MAX PREBENDING THICKNESS (IN)	1/4"
TOP ROLL DIAMETER (IN)	8.5"
BOTTOM CLAMPING ROLL DIAMETER (IN)	8"
Maximum Dia.	N/A
Minimum Dia.	10"
Minimum Width	30"
ELECTRIC POWER (HP)	12

POSSIBLE SHAPES:	PIPES/TUBES, CONES, OVALS.
TYPICAL SIZES	10" - 108" DIAMETER



MISC. Rollers

ROLLER CAPABILITIES:

MAX ROLL WIDTH (FT)	*6'
MAX ROLL THICKNESS (IN)	*TBD
Maximum Dia.	N/A
Minimum Dia.	*4"
Minimum Width	0"

Small Lip Roller:

- ◆ 16" - 64" DIA MAX
- ◆ 18 GA - 10 GA
- ◆ 3/4" - 1" LIP



LARGE Lip Roller:

- ◆ 64" - 108" DIA MAX
- ◆ 3/16" - 1/4" THICK
- ◆ 1" - 2" LIP



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Machining



DMG MORI NT5400/1800SY PRODUCTION MILLING MACHINE
5 axis mill-turn with lower turret
X: 40.9"/1,040mm Y: 10"/255mm Z: 76.4"/1,940mm



DMG MORI DURAVERICAL 5100 PRODUCTION MILLING MACHINE
3 Axis vertical
X: 17.7"/450mm Y: 3.94"/100mm Z: 51.2"/1,301mm



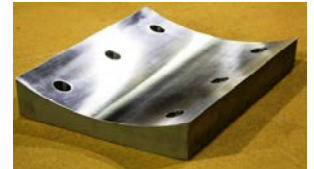
DMG MORI NHX6300 PRODUCTION MILLING MACHINE
4 axis horizontal machining center
X: 41.3"/1,050mm Y: 35.4"/900 mm Z: 40.6"/1,030mm



DMG MORI NLX 2500/700SY PRODUCTION MILL TURN
4 axis machining center and 48" bar feeder
X: 10.2"/260mm Y: 31.3"/795mm Z: 28.6"/728mm



DMG MORI CTX BETA 1250TC MILL TURN
5 axis and 60" bar feeder
X: 17.7"/450mm Y: 3.94"/100mm Z: 51.2"/1,301mm



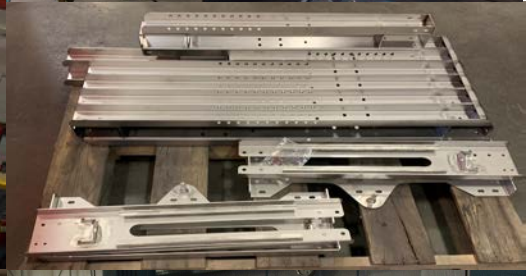
Machining Capabilities			Max travel			Through spindle		Raw material		Barfeed / max L ¹	Removable side
			X	Y	Z	Main	Sub	Max L	Max D		
M1001	Mill, 3 ax.	OKK 40	36.0	25.0	12.0						Yes
M1003	Lathe, 2 ax.	Takasawa TC4	15.9		37.5	3.25		48.0	24.0		
M1004	Turn/mill, 5 ax.	CTX 1250TC	17.7	7.8	51.2	3.00	2.00	47.0	15.4	Yes / 60"	
M1005	Mill, 4 ax.	NHX6300	41.3	35.4	40.6			51.1	41.3		
M1006	Turn/mill, 4 ax.	NLX2500	10.2	3.9	31.3	3.00	1.9 ⁵	28.6	3.00	Yes / 48"	
M1007	Mill, 3 ax.	DV 5100	41.5	20.9	20.1						Yes
M1008	Turn/mill, 5 ax.	NT5400	40.9	10.0	76.4	4.20	4.20	75.6	36.2		
M1009	Mill, 3 ax.	SMV1370	53.0	27.0	24.0						Yes
Manual lathe						4.00		120.0	36.0		
Simplon Mill			48.0	16.0	16.0						
Manual mill			37.0	27.0	24.0						
Turret drill			20.0	12.5	24.0						

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Welding & Fabrication



UL Certified
Aluminum Certified Structural Welders
Welding in all positions
150 years of experience in our shop
Specialize in fabrication and repair

Mechanical/Electrical Assembly:
(98) JIB Cranes
(5) Milwaukee Bridge (5 TON)
(2) Milwaukee Bridge (10 TON)
(1) Milwaukee Bridge (20 TON)

Fabrication:
(30) Dual Feed MIG Welders
(5) Dual Feed TIG Welders
Dual Feed Track Welders

Specialize in all grades of finish work
Specialize in various alloys and materials
- Stainless - Aluminum - Thin gage - Brass - Hardox
- T1 Hardened plate - Mild steel - Structural steel

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Powder Coat & Paint



Standard Colors

Powder Coat: * Additional Colors Available

Color	Name	Stock Code
Black	Gloss SRSF 10108	POWD100
Blue	Powder Blue Streak	POWD113
Gray	SNO-CAT	POWD118
Green	John Deere	POWD125
Green	Reiter	POWD136
Orange	New Orange #10091336	POWD102
Red	International	POWD154
White	Gloss PFW51059	POWD104
Yellow	GK / Cat Yellow	POWD120

Liquid: * Additional Colors Available

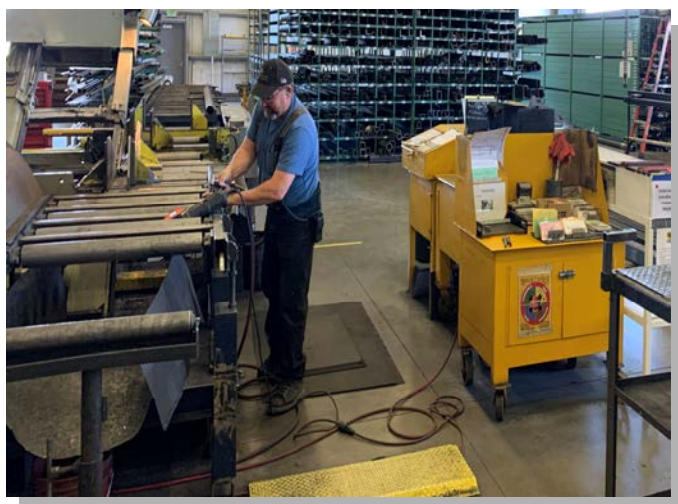
Color	Name	Stock Code
Black	Imron High Gloss 1640	DUPO803
Blue	Global	DUPO843
Gray	42P-3714 Imron Volve-GM	DUPO500
Green	John Deere Imron	DUPO828
Orange	GK	DUPO101
Red	International	DUPO848
White	Imron Urethane Bright	DUPO804
Yellow	GK / Tracker Urethane	DUPO300

Booth sizes:	L	W	H	DW	DH
Blast	70'	20'	17'	20'	16'
Chemical wash	14'	9'	7'	9'	7'
Powder	35'	14'	16'	14'	16'
Liquid	70'	20'	17'	20'	16'



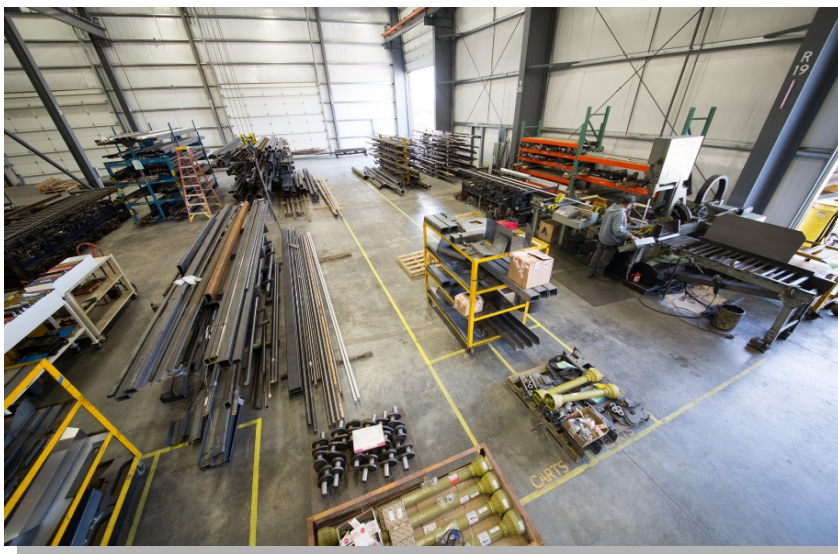
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503-678-5525 www.GKPaintandpowder.com

Saw Cutting



Tolerances	
Length:	+/- 1/16"
Angle:	+/- 1°

Note: Standard tolerances no longer apply due to lack of control over this clamp style



Capacities	
Max angle with standard clamping	60°
Max angle with shimming / pre-cambering.	70°
No cut can exceed linear travel	20"
Max material height (between jaws)	18"
Max material width (table to blade)	20"
Max length	60'

Shearing



- ♦ 12' max width
- ♦ 1/2" max thickness

Parts & Hydraulic Sales



GK Machine is your location for Parts & Hydraulics for your equipment. GK carries a large selection of:

- ◆ Hydraulic fittings & adaptors
- ◆ Hydraulics
- ◆ Pumps, valves, couplings & fittings
- ◆ Spray nozzles & Spraying systems parts
- ◆ Gearboxes and performance differentials
- ◆ Hydraulic custom manifolds
- ◆ Tank accessories
- ◆ Filtration systems
- ◆ Filters & tank accessories
- ◆ Farm and tractor parts
- ◆ Chemical sprayers
- ◆ Fertilizer
- ◆ GPS systems
- ◆ Implements
- ◆ Field computers
- ◆ Pneumatic actuators
- ◆ Differentials
- ◆ Liquid handling systems
- ◆ Application & Boom controls
- ◆ Accessories
- ◆ Spray applications
- ◆ Flow indicators
- ◆ Caps and adaptors
- ◆ Tubes and fittings



Our technical experts, with over 40 years of experience, will help you find the part or supplies you need to keep your operation moving.

Banjo Pipe Fittings - Liquid handling solutions for agricultural and industrial applications; valves, pumps, couplings, fittings; glass injected polypropylene or stainless steel

KZCO - Flow management solutions for systems through motorized valve capabilities

Pentair Hypro-Shurflo - Air Blast Spray Nozzles, Banding & Directed Spray Nozzles, Broadcast Spray Nozzles, Centrifugal Pumps, Clean-load Chemical Systems, Diaphragm Pumps, Express Boom Assembly and Fertilizer Spray Nozzles

TeeJet Technologies - Spray application and precision farming technology including spray nozzles, valves, control systems, and GPS guidance systems

Raven Precision - Field computers, guidance and steering systems, application controls, boom controls, and harvest controls.

Parker Hannifin - Motion and control technologies for a wide variety of mobile and industrial markets: aerospace, climate control, electromechanical, filtration, fluid and gas handling, hydraulics, pneumatics, process control, sealing and shielding.

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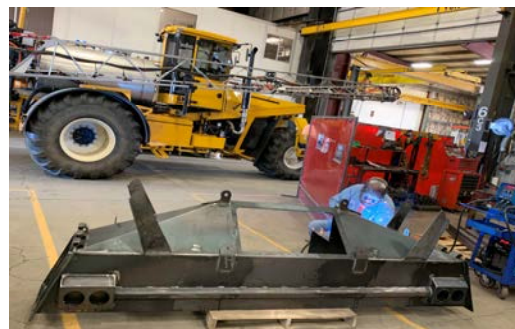
Service Department



GK provides maintenance and repair services for almost all brands of agricultural machines, engines and components. We offer specialized repair services for Ag machines, components and hydraulics. GK Machine has the experts to troubleshoot and diagnose your repair issue in our shop or at your job site.

GK Machine repairs hydraulic cylinders, motors and pumps. GK maintains a large in-house inventory of finished parts and raw material to handle quick turn projects and special modifications to your equipment. Here's just a sample of the things we do:

- Ag equipment Service and repair
- In-shop parts, repair and installation
- Hydraulic Hoses
- Custom Machining
- Implement Repairs
- Raven/Teejet trouble shooting & repair
- Equipment Cleaning
- Hydraulic Systems Diagnostic & Repair
- Re-Engineered Parts
- Custom Fabrication and Welding
- Fuel Systems and repairs



On-site repair services

We have fully equipped field service trucks with experienced technicians to travel to your site and repair your equipment.

GK MACHINE, INC. DONALD, OREGON
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GK Machine Inc. Sales Team



Gary Grossen
Owner / Outside Sales



Connie Lindsay
Marketing



Julia Thompson
Outside Sales



Mike Mader
Equipment Sales



Brent Selna
Equipment Sales



Derrick Bratton
Greenhouse Sales



Dave Hetrick
Manufacturing Sales



Charissa Stephens
Sales Assistant



Adam Berreth
Paint Sales

GK Machine Inc. provides full service custom contract metal fabrication for a variety of industries.

We specialize in OEM component parts, sub-assemblies and finished products; laser cutting, CNC punching, forming, welding, stamping, integrated assembly, washing and finishing.

Whether you need parts and pieces or even large production runs, we have the capacity and capabilities for your next manufacturing project.

Call one of our Sales Specialists at **(503) 678-5525** or [email us](#) for more information and quote for your next project.

Industries and markets include:

agriculture, industrial food harvesting, transportation, electrical enclosures, aluminum structures, alternative fuel heating equipment, commercial, military and institutional industries.

Parts/Hydraulic Sales / Service & Repair



Will Crawford
Parts Counter



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Gage Charpilloz
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Justin Stephenson
Service Department



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