



A Griffiths Company

## K-TEK CAROLINA

10240 INDUSTRIAL DRIVE  
CHARLOTTE, NC 28134-6517  
PHONE (704) 554-5657  
FAX: (704) 554-1866

*“Dedicated to the future with innovative ideas for an innovative world”*



SHORT RUN STAMPINGS  
FMS LASER SYSTEMS

LONG RUN STAMPINGS  
ROBOTIC WELDING

MECHANICAL ASSEMBLIES  
AMADA VIPROS 357 TURRET

*Visit our Website at [www.ktek-net.com](http://www.ktek-net.com)*

K-TEK CAROLINA, a privately held company, is a leader not only in precision fabrication, robotic welding, mechanical assemblies and laser cutting, but also in the stamping industry. K-TEK CAROLINA is a focus manufacturer that specializes in design assistance and the building of complete sub-assemblies and or finished assemblies—



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from simple parts to complex robotic weld fixtures and multiple-part weldments to final assemblies with value-added components.

**K-TEK CAROLINA is currently registered to ISO-9001:2008. This meets the requirements of the International Automotive Task Force (IATF) and QS-9000 the Automotive Industry Action Group (AIAG).**

### **K-TEK CAROLINA Supplies A Diversity Of Parts To The Manufacturers Of:**

- Major Lawn & Garden Tractors
- Off Road Recreational Vehicle (ATVs, Snowmobiles)
- Material Handling Equipment (Forklifts)
- Commercial Furniture
- Hardware
- Enclosures
- Numerous Other OEM's
- Class 8 Heavy Truck Industry

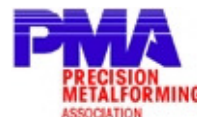
Skilled CAD/CAM programmers and toolmakers work directly from customer drawings to produce Quality Parts and Fabrications to commercially accepted tolerances. Even closer tolerances can be held, when needed. We pride ourselves in offering Solutions to our Customers from the Concept to the Completion of Each Part or Project.

### **K-TEK CAROLINA Mission Statement: "Delight all Customers"**

#### **Some of our capabilities include:**

- Presses from 20 to 400 tons
- Robotic Welding Cells
- 250 Ton Hydraulic Presses
- EDM Center
- In House Tool Design
- CNC Machining Center
- Laser Machining Centers (FMS)
- CNC Turret Center
- Full Quality Control Department
- CAD/CAM Programming Systems
- EDI, CAD, SPC, JIT, KAN-BAN

All Secondary Operations: MIG/TIG, Spotwelding, PEM-Set, Riveting, Staking, Tapping, Painting, and Plating





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K-TEK Carolina is committed to achieving excellence and attaining partnership status with our customers. We at K-TEK Carolina are committed to exceeding their expectations.

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**Quality** – Zero defects is a goal we try to achieve. We will continue to improve our processes to add more mistake proof enhancements to our manufacturing methods. It is our objective to continuously train our personnel to produce quality parts. Ownership for the quality of the parts produced will start at the heart of the manufacturing process, the individual operators.

**Delivery** – 100% on time delivery of the quantities required by our customers is critical to our success. We are committed at K-TEK Carolina to exceeding our customer's expectations by meeting their delivery requirements every time regardless of the circumstances. In order to accomplish this we are taking steps to become more flexible in our manufacturing operations. These steps include establishing standards for dies, installing a quick change die system, reducing batch sizes, and in depth production planning based on the forecasts provided to us by our customers.

**Cost Management** – It is our objective to continually improve costs through control of our indirect and fixed costs. We will also be reviewing the manufacturing processes of every part to look for cost reduction opportunities.

**Technical Support** – It is our desire to participate early in the design process providing our customers with the benefit of our manufacturing experience.

**Wavelength** – We realize that communication, responsiveness, and customer support are essential parts of any achieving excellence program. The organizational structure being adopted is designed to promote these qualities. More importantly, our management philosophy will be to promote ownership for exceeding our customer's expectations within each and every employee at K-TEK Carolina.



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## *Equipment & Capabilities*



K-TEK Carolina's 2 FMS Laser systems include 6-shelf material towers, Mazak 2000 and Mazak 2500 watt super-charged lasers, rail mounted load/unload systems, and line controllers that coordinate all of the material handling equipment.

K-TEK Carolina's AMADA VIPROS 357 Queen turret press is ideal for low to medium quantity production runs without the cost and lead time associated with special tooling.



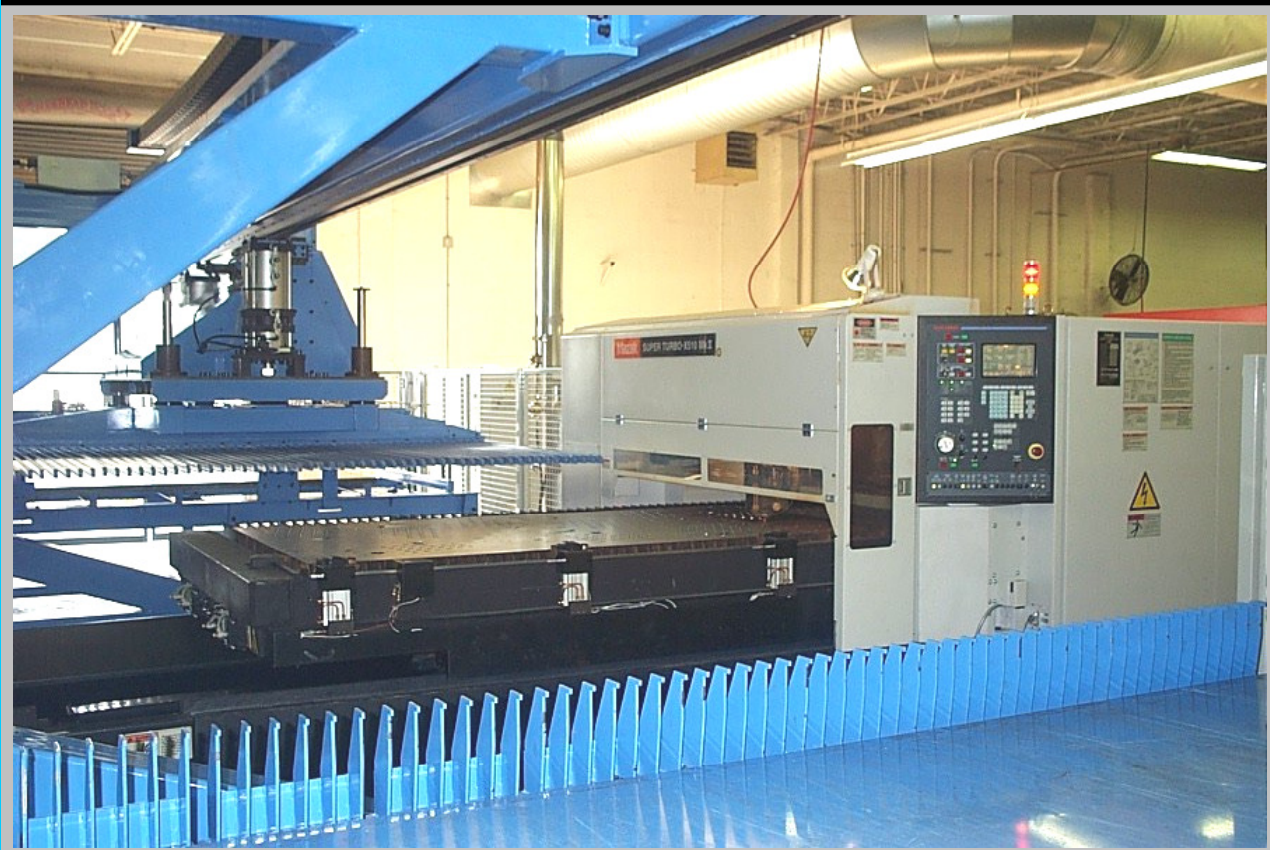


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Our Mazak Super Turbo X510 MKII 4000 Watt  
Laser is capable of cutting up to 1" material.



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Our new Hass VF-5B/XT40 5-axis CNC machining center has 60" x 26" x 25" travel and can be used for 2-D and 3-D machined parts and tooling.



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Our new Cordax Sheffield RS-150 CMM has a 7' x 4' bed and a 36" measuring height for checking dimensional accuracy for both very small and very large parts to very close tolerances. It can also be programmed to quickly and accurately repeat part checking sequences automatically.



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The ROBOFIL 510F EDM Machine provides quicker turnaround time for your die and other tool cutting needs



Our 3 Amada RG-100 Press Brakes provide computer-controlled slide travel, precision guides, and multi-station forming capability for precise dimensional control and efficient production.

Our Accurpress "Advantage" Press Brakes provides computer-controlled slide travel, precision guides, and multi-station forming capability for precise dimensional control and efficient production.





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Presses from 25 to 400 tons provide the capability to handle any size job. The larger presses are well-suited for high-tonnage blanking and deep drawing.



Our robotic welders result in greater economy on parts that require precise dimensional control.





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### FACILITY LIST

December, 2011

#### LASER AND SHEAR

2000 Watt Mazak Laser FMS System  
2500 Watt Mazak Laser FMS System  
4000 Watt Mazak Laser with 5000lb. skid loader

AccurShear Hydraulic Shear – 1/4" x 10'  
AccurShear Hydraulic Shear – 3/8" x 10'  
Niagara Power Squaring Shear – 1/4"

#### TURRET, BRAKE, AND OBI PRESSES

Amada Vipros 357 Queen Turret Punch Press  
Muratec Turret w/ 5' x 10' sheet loader  
3x 110 Ton Amada CNC Brake 10'  
400 Ton Bliss Press W/Feed and Air Cushion  
300 Ton Bliss Press W/Feed  
250 Ton Cincinnati Hydraulic Press  
200 Ton Niagara Press

300 ton Bliss w/ Air Cushion  
2x 200 Ton Bliss Presses W/Feed  
110 Ton Bliss OBI Press  
4x 60 ton Bliss OBI Press  
175 Ton AccurPress Brake 12'  
80 Ton Stamtec OBI Press  
5 Ton Pemsrter

#### WELDING AND FABRICATION

Panasonic PerformARC 350 Robotic Welder  
3x Miller MRV-6 Robotic Welders  
Motoman Arc World 6000 Robotic Welder  
150 KVA 3-Phase Spotwelder  
300 KVA Spotwelder  
2x 100 KVA Spotwelder

3x Miller Shopmaster MIG Welders  
4x CP 300 Miller MIG Welder  
2x Miller Syncrowave 350 TIG Welder  
1/8" Plasma Cutter  
Roll Former

#### TOOLING AND MACHINING

Charmilles Robofil 510F High Speed Wire EDM  
4x Alliance Milling Machines W/Digital Readout  
2x Alliance Milling Machines W/DR and Servo Feeds  
Haas VF-5B/40XT 5-Axis Vertical Machining Center with  
60"x26"x25" travels  
Cincinnati Brickford Radial Drill  
Johnson Horizontal Band Saw  
2x Surface Grinder (Okamoto 12"x24", Boyer Schultz 5"x10")

Grob Band Saw  
8x Clausing Drill Presses  
14" Cut-Off Saw  
2x Sentry Heat Treat Furnace  
1/3 HP Bench Grinder  
1/3 HP Drill Grinder  
2x Hoist (1 A-Frame, 1 H-Frame)

#### FINISHING

Timesaver Vibratory Finisher W/Conveyor  
2x Corn Cob Media Mixer  
2x Roto Finish Vibrator

Timesaver Speedbelt Sander  
2x Dual Barrel Finisher

#### QUALITY CONTROL

RS150 Cordax DCC CMM  
DoAll Set Gauge Blocks  
5x Height Gages  
4x Surface Plates  
0.011-1.00 Plug Gage Set

Set Go No-Go Tread Gages (Inches & Metric)  
Gold Series Faro Arm # 1148  
18" Mitutoyo Calipers # 1025  
Set Gauge Blocks 31pcs. # 1096  
Miscellaneous Micrometers, Vernier Calipers

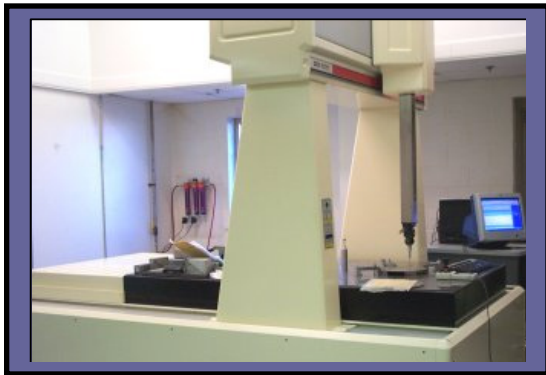
# K-TEK Carolina Quality

*K-TEK CAROLINA QUALITY IS*

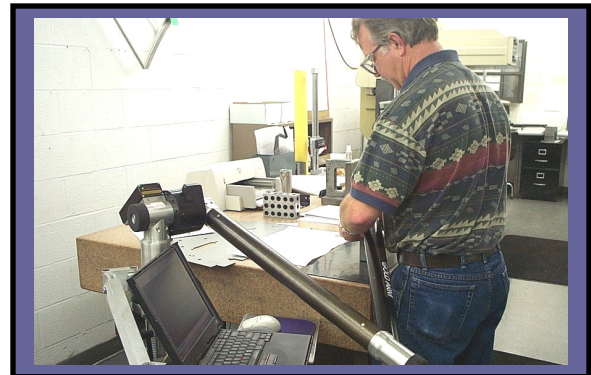


*LOOKING TO THE FUTURE*

K-TEK Carolina has the capability of generating any documentation that is required by our customers from capability studies to full PPAP's using the Current Edition from the QS-9000:1998 Automotive Industry Action Group (AIAG) and ISO/TS-16949:2002 International Automotive Task Force (IATF).



*RS150 DCC CMM*



*Gold Series Faro Arm*



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**STANDARD TOLERANCES**

<b><u>HOLE SIZE</u></b>	0.062 - 0.499 +/- .002 0.500 - 1.500 +/- .003 (OK TO 10 GA.) 1.501 - 2.000 +/- .005
	LARGER HOLES 1/3 MAT. THICKNESS
<b><u>LOCATION</u></b>	+/- .005 HELD ON PUNCH SIDE ONLY
<b><u>CONCENTRICITY</u></b>	+/- .005 (NORMAL)
<b><u>BLANK SIZE</u></b>	+/- .005 (NORMAL)
<b><u>DRAWS</u></b>	+/- .010 (NORMAL)
<b><u>LINEAL</u></b>	+/- .005 (NORMAL)
<b><u>FORMED ANGLE</u></b>	+/- 1 DEGREE
<b><u>BLANK ANGLE</u></b>	+/- ½ DEGREE
<b><u>PERPENDICULAR</u></b>	+/- .016 PER DEGREE PER 1 INCH
<b><u>FLAT</u></b>	+/- .003 PER 1 INCH
<b><u>BREAK OUT</u></b>	30% LAND (OK) THE REST ABOUT 60% IS BREAK OUT. (ALUMINUM IS SLIGHTLY MORE)
<b><u>RADIUS</u></b>	
<b><u>PERIPHERY</u></b>	.010 - .015
<b><u>INSIDE</u></b>	.015 MINIMUM (SHOULD BE SAME AS MATERIAL THICKNESS)
<b><u>OUTSIDE</u></b>	NONE SHOULD ALWAYS REFERENCE INSIDE RADIUS
<b><u>EDGE</u></b>	STANDARD EDGE CONDITION 125 MICRO FINISH

