



BEE LINE COMPANY

Located in Bettendorf, Iowa and owned
by the McLaughlin Group,
Bee Line is ISO 9001:2008 Certified
and puts 90 years of expertise
and advanced technology into a variety
of contract manufacturing
partnerships.



ABOUT BEE LINE

- Owns 45,000 sq ft of factory floor on nine acres of land & leases an additional 7,200 sq ft
- Over 60 employees with the flexibility to run 3 shifts and 7 days to deliver volume required
- Total P/Ns = 9500 Make = 6000 Buy = 3000
- Coordinates outside processing, such as Heat Treat, Plating, Grinding, etc.
- Balance = Assembly, rebuilds, etc.



PRODUCTION RESOURCES

Design Engineering

Solid Works software

Customer Service

Complete in-house manufacturing capabilities

Machining, Fabrication & Electronics

Assembly & Paint

Plant ERP system

Global Shop

Order entry to planning fully integrated through invoicing

Master scheduler and full time cycle counter

Shop floor data entry

Complete financial capabilities for job costing

Truck for local deliveries

Quality Lab

Purchasing – includes all certifications and properties of materials



WORK ORDERS

Typical Shop Packet – Discrete Work Orders

Includes inspection sheets

Current print at newest rev levels

Current router with work instructions

Allows tracking through completion

Parts are Stocked and Shipped

Documents are retained in a history file



STATE-OF-THE-ART EQUIPMENT



Lathes - Mills - Laser - Plasma

Processing Aluminum, Carbon Steel,
Stainless Bronze, Cast Iron, Forgings
& Plastics

Recent Equipment additions:

4000 Watt Mazak Laser

Twin table - Mori Seiki Horizontal
Machining Center

HAAS Mini Vertical Mill – Short Runs
Delivery Truck

Overhead Crane

New Mazak 3" CNC Lathe (June 2013)



FABRICATION

AKS Flame Cut machine

New 2009 - CNC
260 Amp Plasma
1 oxy fuel torch
Table size - 8' x 26'
Cut TO 3" thick steel



Time saver

Surface Finishing Machine
One side sanding & deburr
Up to 6" thick X 30"
Steel & Aluminum



FABRICATION

Weld stations

Mig capabilities

3 – miller welders

.035 wire

Smoke extraction

Welders are ASTM
certified



Wheelabrator

Roto Blast

8' Table

Steel shot



LATHES



HAAS – SL – 30 CNC

New – 2007

3" bar feed capable

30 HP – 10" chuck

Parts catcher



HAAS – SL – 20 CNC

New – 2008

2" bar feed capacity

20 HP – 8" chuck

Parts catcher

LATHES

Mazak – 200MS

New 2002 - CNC

Live milling
capability

Dual chucks – 8"

2" bar feed
capability

Parts catcher



MILLS

HAAS – CNC New 2009
Super Speed mini mill
12" X 16" table
.8 sec tool change
2400 IPM travel speeds



Mazak Nexus new 2005
40 tool spindles
20" X 40" table
30 HP



MILLS



Nexus 510 – CNC

New – 2007

50 spindle 30 HP
20" X 40" table



Nexus 510 – CNC

New – 2008

#50 spindle
Twin tables
20" X 40" 30 HP

ELECTRONICS

On site Electrical Engineer
In-house board design

Assembly & Test area
Climate controlled - clean room
/ assembly
Static controlled
Five ergonomic work areas
Movable storage
by product line



PARTS



ASSEMBLED PARTS





MILITARY PARTS - LTAS



All produced to Military
Specifications
Special tools / Material
Packaging / Inspection / Tracking



Armor plate
5 million lbs
processed

Plasma cut & cleaned



Cab parts &
Appurtenances
Over 1 Million Produced



Cab parts, Hinges, etc
Over 150,000 Produced

QUALITY

Romer
Portable CMM
New in 2009
8' measuring range
Programmable



Tesa
Height Gauges
Two available
Used daily for part
inspection



QUALITY LAB



[illegible]

UNLESS OTHERWISE SPECIFIED ALL DIMENSIONS ARE +/- .031

DATE: 6/1/07
 CHANGE RECORD: NEW
 BY: JMF

DATE: 1/25/07
 CHANGE RECORD: ADDED HOLE, AND CHAMFERS
 BY: JMF

DATE: 4/16/07
 CHANGE RECORD: ADDED TOLERANCE INFO
 BY: JMF

DATE: 3/17/09
 CHANGE RECORD: ADDED FINISH NOTE
 BY: TCE

DATE: 4/5/10
 CHANGE RECORD: added new tolerances
 BY: jmf

NOTE: REMOVE ALL BURRS & SHARP EDGES. INTERPRET DIMENSIONS & TOLERANCES PER ANSI Y14.5M-1994

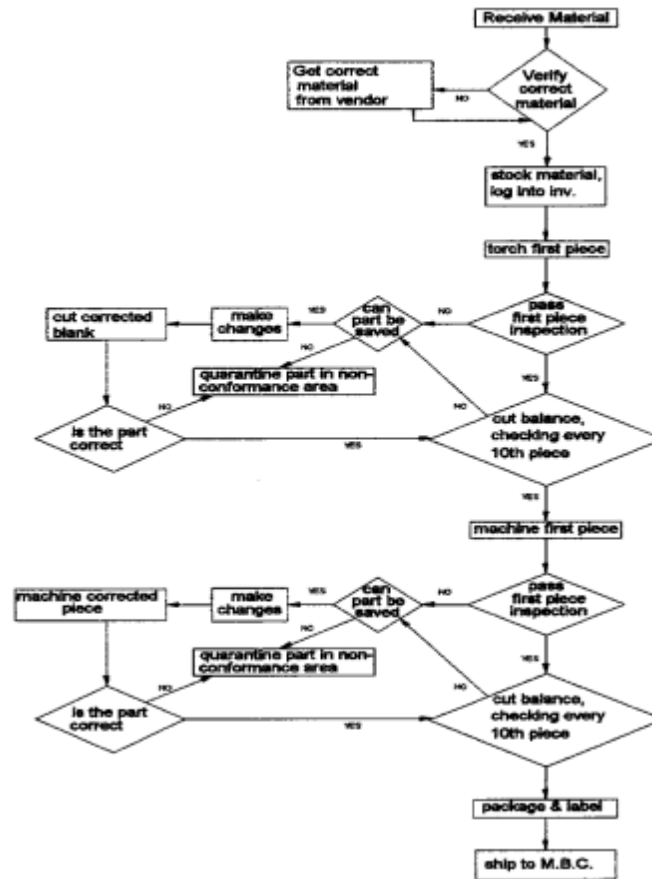
BEE LINE CO. BETTENDORF, IOWA
 A DIVISION OF MALCOLM BODY CO.
 BLOCK, FRONT CAB MOUNTING
 1 X 2.7 GR50
 206319006
 SAND & DEBURR

1/4\"/>



QUALITY

Bee Line Company
Process flow chart



OUR CUSTOMERS



THE COMPETITIVE EDGE

- Flexible – Custom Part Processing
- Low to high volume manufacturing
- Stringent quality control
- Procurement of uncommon materials
- Special tooling knowledge
- Custom packaging solutions
- 24 / 7 manufacture and service
- Engineering solutions
- Competitive pricing



www.beelinemfg.com

CONTACT – STEVE WOODWARD

swoodward@beeline-co.com

563-332-4066 x392