



MACHINE SHOP CAPABILITIES

The Machine Shop is fully staffed and is operational 16 hours a day by using two shifts. This shop is divided into three groups, the Inside Machine Shop Group, the Outside Machine Shop Group and the In-Place Machine Group.

The **Inside Group** is responsible for the fabrication/machining of new parts to repair mechanical equipment including shafts, pumps, valves, reduction gears and are:

- Accustomed to working from drawings to close tolerances
- Manned by personnel with specialized training
- Proficient in the use of precision measuring instruments, testing equipment and procedures

The shipyard has more ABS approved welding procedures for various shaft repairs than any other shipyard in the United States.

Major Shop Equipment:

- 16 Lathes
- Horizontal Boring Mill capacity up to 60 ton
- Vertical Boring Mill
- Drill Presses up to 6 feet reach and 12 inch column
- Complete Valve Shop

The largest size diameter valve the Machine Shop is capable of working is 36 inches



Above: Bridgeport EZPATH III S CNC Automated Lathe.



Gray 6" Horizontal Boring Mill



Our highly skilled machine shop **Outside Group** personnel are proficient, experienced and possess the proper tooling for installation and alignment of the whole propulsion train, including engine, reduction gear, bearing, shafting, struts, stuffing boxes and propeller for both fixed blade and Controllable Propulsion (CPP) Systems . Also, tooling proficiency with in-line boring, in-position machining, skimming, soft chock forming, jacking, drilling and tapping.

Overhaul of 110 Rudders and Fins for U.S.C.G. in "gap" lathe



Additionally, the Outside Group is responsible for removal, repair, flushing, cleaning and reinstallation of shipboard valves, piping and mechanical equipment including bearings, davits, deck equipment, elevators, foundations, hoists, propellers, pumps, sea chests, shafts and winches.

The outside group is staffed by personnel with specialized training in:

- Apprenticeship training in optical alignment
- Motor/Generator School
- Lube oil, hydraulic, pneumatic and steam systems
- Shafting, propellers, valves, pumps, and other shipboard equipment
- Testing and inspection equipment and procedures