DIECAST DIES & INJECTION MOLDS
HELLEBUSCH Tool & Die, Inc. HTD

4 Southlink Drive
Washington, MO 63090
636.239.7543 • htdinc.com

PRECISION MACHINING & TOOLING

5-axis CNC • Large-format machining • Horizontal & Vertical CNC • EDM • Inspection

5-AXIS MACHINING

Machine	Spindle / power	Table / rated capacity	X × Y × Z travel
FIDIA DL321	15,000 RPM • 74 HP	118 × 79 in • 1,434 lb/ft^2	118 × 86.6 × 49 in
FIDIA K199	24,000 RPM • 46 HP	79 × 49 in • 15,430 lb	70 × 35.5 × 33 in
DMG DMU125P	10,000 RPM • 35 HP	39 in round • 2,200 lb	49 × 35 × 31 in
Hermle C650	16,000 RPM • 56 HP	35 × 29 in • 6,600 lb	41 × 35 × 23 in

HORIZONTAL MACHINING & BORING

Machine	Spindle	Pallet / workpiece capacity	X × Y × Z travel
OKK HM-1600	5,500 RPM • 50 HP	98.4 x 72.8 in • 25,000 lb	94.5 × 65 × 68.9 in
Giddings & Lewis PC-50	4,000 RPM • 50 HP	60 x 144 in • 25,000 lb	98.42 × 82.67 × 62 in
OKK HM-1250S	8,000 RPM • 50/40 HP	49.21 × 49.21 in • 11,000 lb	66.93 × 55.12 × 48.82 in
OKK HM-100S	12,000 RPM • 40/33.5 HP	39.4 × 39.4 in • 5,510 lb	55.12 × 43.31 × 39.37 in
Makino A77	10,000 RPM	Dual 25 × 25 in • 2,645 lb	31.5 × 29.5 × 30.3 in

VERTICAL CNC MACHINING CENTERS

Machine / qty	Spindle	Table / rated load	X × Y × Z travel
Makino V56	20,000 RPM • 25 HP	41.3 × 21.6 in • 1,763 lb	35.4 × 21.6 × 17.7 in
OKK VM5-II	20,000 RPM • 25 HP	41.34 × 22.05 in • 1,760 lb	40 × 20 × 20 in
OKK VB53	20,000 RPM	49.61 × 23.62 in • 2,646 lb	40 × 20 x 20 in
Makino SNC64	20,000 RPM • 7.5 HP	29.5 × 15.7 in • 550 lb	23 × 15.75 × 15.75 in
Makino SNC106	15,000 RPM • 5 HP	43.3 × 23.6 in • 2,205 lb	39.4 × 23.6 × 15.75 in
Makino S56	20,000 RPM • 20 HP	39.4 × 19.7 in • 1,102 lb	35.4 × 19.7 × 17.7 in
YCM NSV102A (2)	12k / 15k RPM • 30 HP	25.5 × 44 in • 2,200 lb	40 × 23.6 × 23.6 in
YCM WV108A	15,000 RPM • 30 HP	51.18 × 32.28 in • 2,645 lb	44 × 30 x 27.5 in
YCM WV108B	10,000 RPM • 30 HP	51.18 × 32.28 in • 2,645 lb	44 × 30 × 30 in
YCM NTV-158B (2)	15,000 RPM • 40 HP	64.96 × 29.92 in• 4,400 lb	60.24 × 30 × 27.56 in
Hurco VMX50	10,000 RPM • 24 HP	26 × 59 in • 3,000 lb	50 × 26 × 24 in
Hurco 4020	8,000 RPM	48 × 20 in • 1,500 lb	40 × 20 × 24 in
Hurco VMX42S (2)	10,000 RPM • 24 HP	50 × 24 in • 3,000 lb	42 × 24 × 24 in

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EDM, INSPECTION & SUPPORT

Complementary manufacturing capabilities supporting precision tooling and complex components.

ELECTRICAL DISCHARGE MACHINING

Equipment	Process	Travel / working envelope	Maximum workpiece
Mitsubishi MV4800	Wire EDM	31.5 × 23.6 × 20.1 in travel	53.1 × 43.3 × 20 in • 6,600 lb
Mitsubishi FX20K	Wire EDM	19.6 × 13.7 in travel	41.3 × 31.4 × 11.6 in • 1,760 lb
Charmilles Roboform 40 (2)	Sinker EDM	19.7 × 15.7 in • 48 × 32 in tank	39.37 × 27.55 × 14.56 in • 2,200 lb
AgieCharmilles FORM 400 (2)	Sinker EDM • 140 A	35.43 × 27.56 × 19.68 in travel	71.42 x 47.83 • 6,613 lb

TURNING, INSPECTION & DIE SPOTTING

Equipment	Key capability
Okuma Captain I370-M CNC lathe	Live tooling • 3,800 RPM • 30 HP • 13.38 in turning diameter • 19.68 in length
Zeiss Eclipse CMM	40 × 64 × 24 in measuring envelope • 3,500 lb • Renishaw PH10T
Walter Reis 100-ton spotting press	61 × 87 in platen
Walter Reis 40-ton spotting press	35 × 47 in platens • swiveling top / sliding and pivoting bottom
3-ton hydraulic spotting press	17 × 29 in through tie bars

HEAT TREATMENT & HANDLING

Equipment	Capacity / features
Electric heat-treat furnace	12 × 12 × 18 in • controlled nitrogen atmosphere
Stress-relieving furnace	30 × 30 × 48 in • 2,000 lb • 1,000°F maximum
Bridge cranes	1 × 40-ton • 2 × 20-ton • 2 × 10-ton • 1 × 6-ton • 2 × 2-ton
Hyster S150 forklift	15,300 lb capacity

ENGINEERING & SAMPLING

Capability	Equipment / software
CAD/CAM and engineering	Kubotek • SolidWorks • Unigraphics • Mastercam • WorkNC • PowerMill • Flow-3D
Plastic injection sampling	Injection molding machines in the 100–610 ton range
Extrusion sampling	Davis-Standard plastic extruder • Model 2.5 PMIV

LET'S REVIEW YOUR NEXT PROJECT

Share your drawings, models and project requirements with the HTD team to discuss machining approach, workholding, inspection and scheduling.
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