



6675 Nan Gray Davis Rd.
Theodore, Al. 36582

Port City Metal Fabrication

- **Port City Metal Fabrication, LLC** was established in 2005 in Theodore, AL and currently covers over 10 acres and 50,000 square feet of indoor work area. PCMF performs CNC Machining and fabrication using different grades of Carbon, Stainless Steel and Aluminum per our customer request, and we also provide installation services per our customers' requirements. With skilled employees and determination to produce top quality products with on-time deliveries, PCMF is achieving major goals as a successful and innovative machine, fabrication, and coating supplier that strives to exceed and maintain customer satisfaction.
- **We offer services in the following Industries but are not limited to: Gas/Oil | Energy | Pulp & Paper | Maritime | Variety of Field Service Work Offered |Blasting- Indoor/Outdoor Available | Painting- Climate Control Paint Booth.**



[ISO 9001
Certification](#)

[PCMF Quality Manual](#)

HSE Quality Management System



*Safety and
Health Policies,
Procedures, &
Plans*

Completed Projects for Global Oil & Gas companies

- Occidental/ Anadarko LSDP Tieback
- Occidental/ Anadarko Tree Control Set 52 & 53
- Occidental/ Anadarko Caesar Tonga Phase II
- Occidental/ Anadarko K2
- Occidental/ Anadarko Lucius 12/13
- Occidental/ Anadarko KCPU 919 #9 Tie-Back DE
- Occidental/ Anadarko Constellation DE
- Occidental/ Anadarko GC-562
- Chevron Tahiti
- Chevron Blind Faith
- Chevron Blind Faith II
- CNOOC LIUHUA
- Subsea 7
- CNOOC LINGSHUI
- LLOG Buckskin
- LLOG Stonefly
- LLOG Nearly Headless Nick
- LLOG Red Zinger Cobrahead Weldments
- LLOG G2 Cobraheads
- Murphy Exploration & Production CO-SS7-Dalmation South Subsea Term
- Noble Leviathan
- Noble Tamar
- Shell Princess
- Shell Kaikas
- Shell Coulomb
- Shell Europa A 7
- Tullow Jubilee/Ten



Document Control



PCMF Machining Capabilities

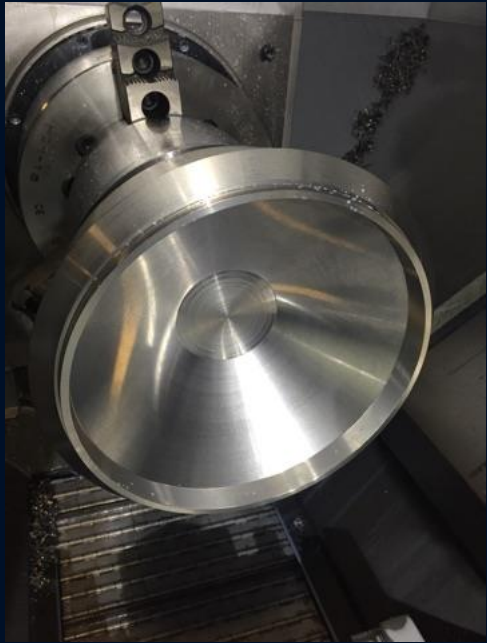
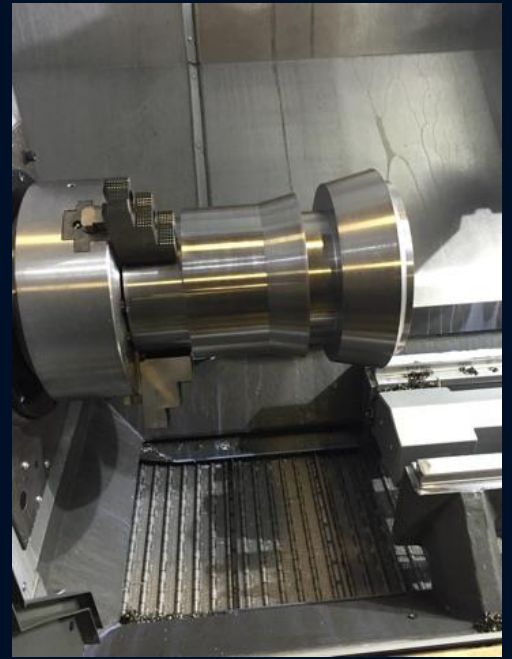
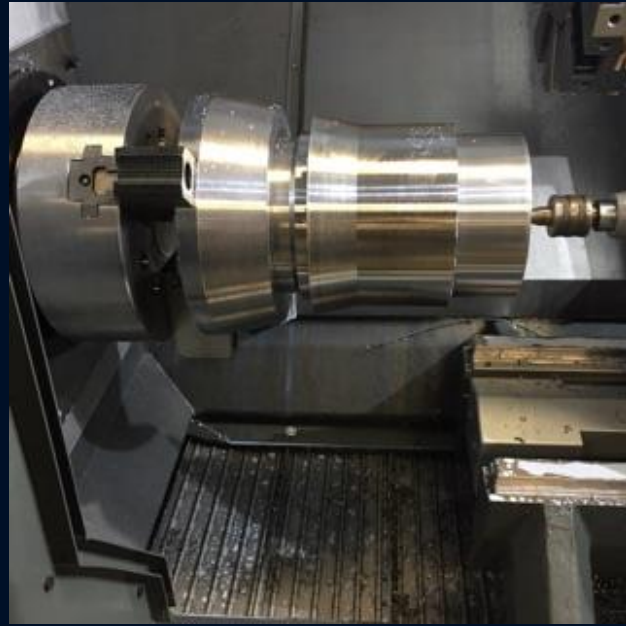
PCMF offers a wide range of machining capabilities. PCMF Machine shop is located in a 7500 square foot building that is climate controlled. It is equipped with A Quincy QGV-60 air compressor and two 5-ton overhead cranes. Please refer to the list below for more information on machines and equipment capabilities.

Within our ISO System we have written procedure for daily calibration for all measuring tools. We also have procedure for calibration of the Standards used for those daily calibrations.



- Haas ST-30
- Haas ST-40 with live tooling
- Haas EC-1600 4th axis with 5th axis capabilities
- Haas VF3yt with 4th axis capabilities
- Haas ST40L
- Haas ST 40
- DO ALL DC-460NC CNC Saw
- DO ALL DC-330NC Vertical Band Saw
- Flex Mark Part Identifier
- Sharp Manual Lathe
- Supermax Titan





Haas ST-30



The ability to turn and mill complex parts and perform multiple operations on a single machine increases throughput, reduces handling, and improves part accuracy. The Haas ST-30 Series Y-axis turning centers provide 4" of Y-axis travel (± 2 " from the centerline) for off-center milling, drilling, and tapping, and come standard with high-torque live tooling and a servo-driven C axis for versatile 4-axis capability. They are available in standard and Super Speed configurations.

Travels & Feedrates

X Axis 12.75" 12.75" 324 mm 324 mm

Y Axis ± 2.0 " ± 2.0 " ± 51 mm ± 51 mm

Z Axis 26" 26" 660 mm 660 mm

X-Axis Rapids 945 ipm 945 ipm 24.0 m/min 24.0 m/min

Y-Axis Rapids 710 ipm 710 ipm 18.0 m/min 18.0 m/min

Z-Axis Rapids 945 ipm 1200 ipm 24.0 m/min 30.5 m/min



Haas ST40 & ST-40L



Spindle	S.A.E	METRIC
Max Rating	40.0 hp	29.8 kW
Max Speed	2400 rpm	2400 rpm
Max Torque	1400 ft-lbf @ 150 rpm	1898 Nm @ 150 rpm
Spindle Bore ø	4.62 in	117.3 mm

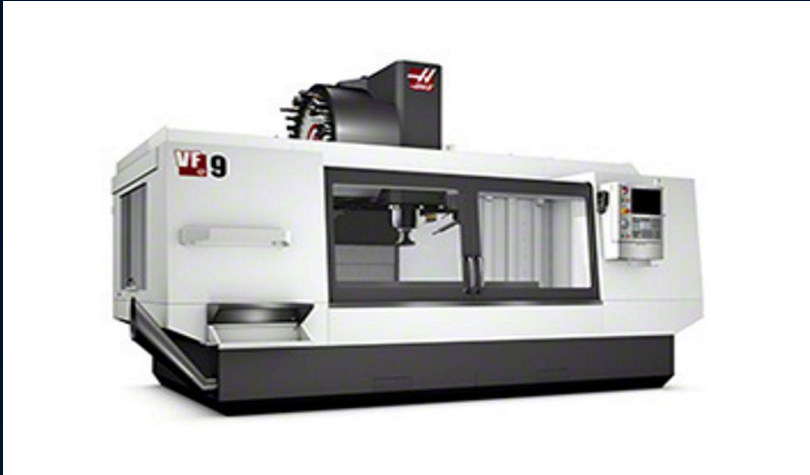
TRAVELS	S.A.E	METRIC
X Axis	17.0 in	432 mm
Z Axis	80.0 in	2032 mm

FEEDRATES	S.A.E	METRIC
Rapids on X	710 ipm	18.0 m/min
Rapids on Z	320 ipm	8.1 m/min

AXIS MOTORS	S.A.E	METRIC
Max Thrust X	5500 lbf	24465 N
Max Thrust Z	9000 lbf	40034 N



Haas VF 9



<u>TRAVELS</u>	<u>S.A.E</u>	<u>METRIC</u>
X Axis	84.0 in	2134 mm
Y Axis	40.0 in	1016 mm
Z Axis	30.0 in	762 mm
Spindle Nose to Table (~ max)	34.0 in	864 mm
Spindle Nose to Table (~ min)	4.0 in	102 mm

<u>FEEDRATES</u>	<u>S.A.E</u>	<u>METRIC</u>
Max Cutting	500 ipm	12.7 m/min
Rapids on X	600 ipm	15.2 m/min
Rapids on Y	600 ipm	15.2 m/min
Rapids on Z	600 ipm	15.2 m/min

<u>AXIS MOTORS</u>	<u>S.A.E</u>	<u>METRIC</u>
Max Thrust X	3400 lbf	15124 N
Max Thrust Y	3400 lbf	15124 N
Max Thrust Z	5600 lbf	24910 N



Haas EC-1600



TRAVELS

	<u>S.A.E</u>	<u>METRIC</u>
X Axis	64.0 in	1626 mm
Y Axis	50.0 in	1270 mm
Z Axis	32.0 in	813 mm
Spindle Centerline to Table	11.97 in	304 mm

SPINDLE

S.A.E

METRIC

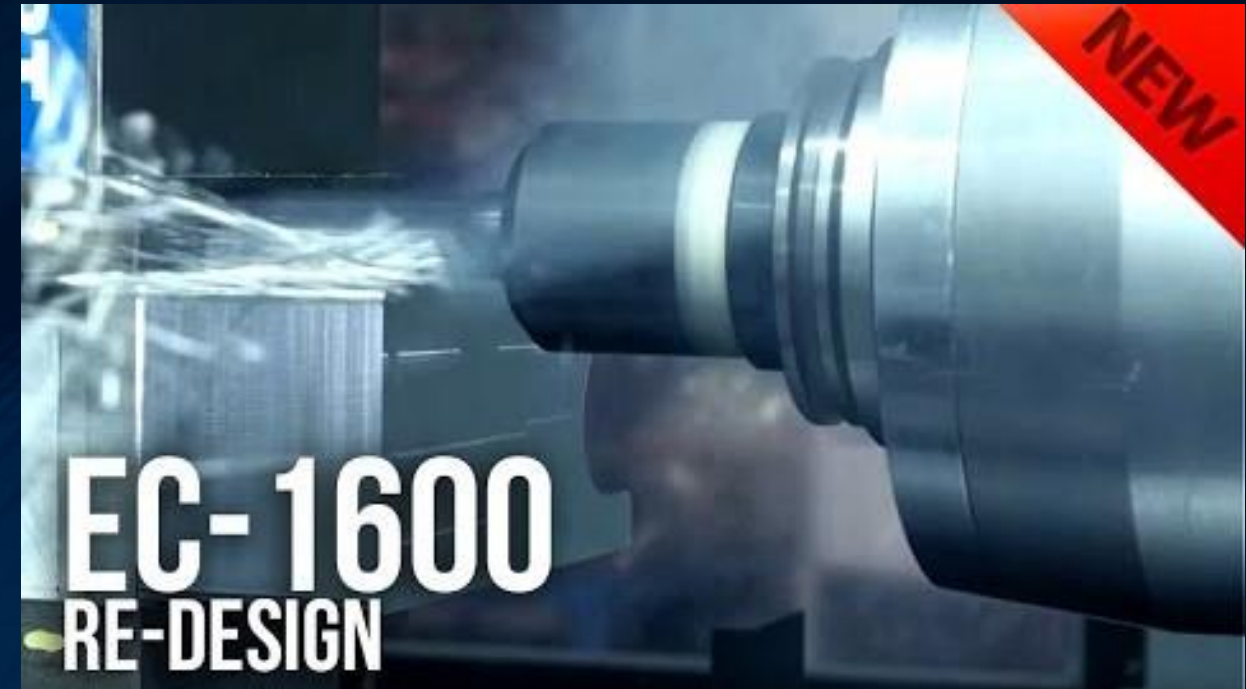
Max Rating	30.0 hp	22.4 kW
Max Speed	7500 rpm	7500 rpm
Max Torque	340 ft-lbf @ 700 rpm	460 Nm @ 700 rpm
Drive System	2-Speed Gearbox	2-Speed Gearbox
Taper	CT or BT 50	CT or BT 50

FEEDRATES

S.A.E

METRIC

Max Cutting	500 ipm	12.7 m/min
Rapids on X	600 ipm	15.2 m/min
Rapids on Y	600 ipm	15.2 m/min
Rapids on Z	600 ipm	15.2 m/min



Haas VF 3yt



TRAVELS

	<u>S.A.E</u>	<u>METRIC</u>
X Axis	40.0 in	1016 mm
Y Axis	26.0 in	660 mm
Z Axis	25.0 in	635 mm
Spindle Nose to Table (~ max)	29.2 in	742 mm
Spindle Nose to Table (~ min)	4.2 in	107 mm

AXIS MOTORS

	<u>S.A.E</u>	<u>METRIC</u>
Max Thrust X	2550 lbf	11343 N
Max Thrust Y	4100 lbf	18238 N
Max Thrust Z	4100 lbf	18238 N

FEEDRATES

	<u>S.A.E</u>	<u>METRIC</u>
Max Cutting	500 ipm	12.7 m/min
Rapids on X	710 ipm	18.0 m/min
Rapids on Y	710 ipm	18.0 m/min
Rapids on Z	710 ipm	18.0 m/min





PCMF Blasting & Coating

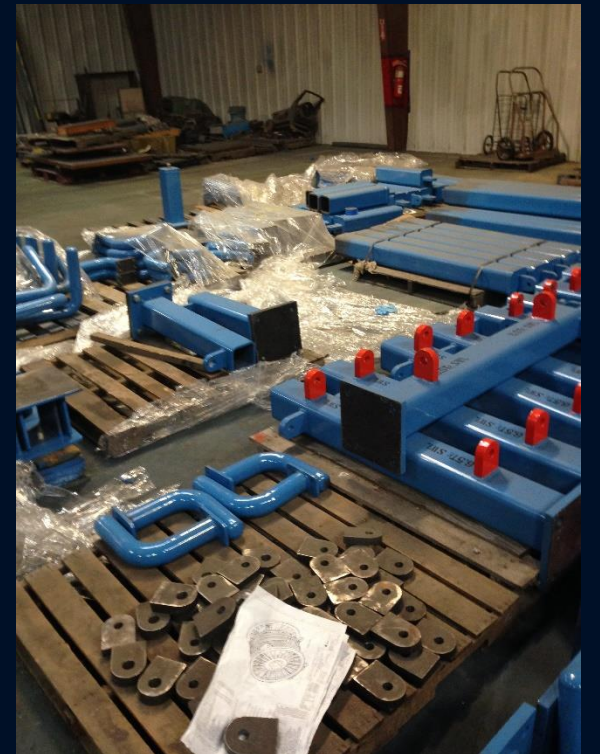
PCMF Painting and Coating facility sits under a 15,000 square foot building with two climate-controlled paint rooms.

PCMF is able to perform airless and conventional painting. PCM is equipped with Graco Mark V airless sprayers and Binks 2100 pressure Conventional Pots.

When required, we use a Positec 6000 & or Tinker / Rasnor Holiday Testor to meet customer requirements for specific blast profiles or paint thicknesses.

PCMF has 2 600Lb. Blast pots with and Indoor and outdoor sand hopper and a covered blast area.



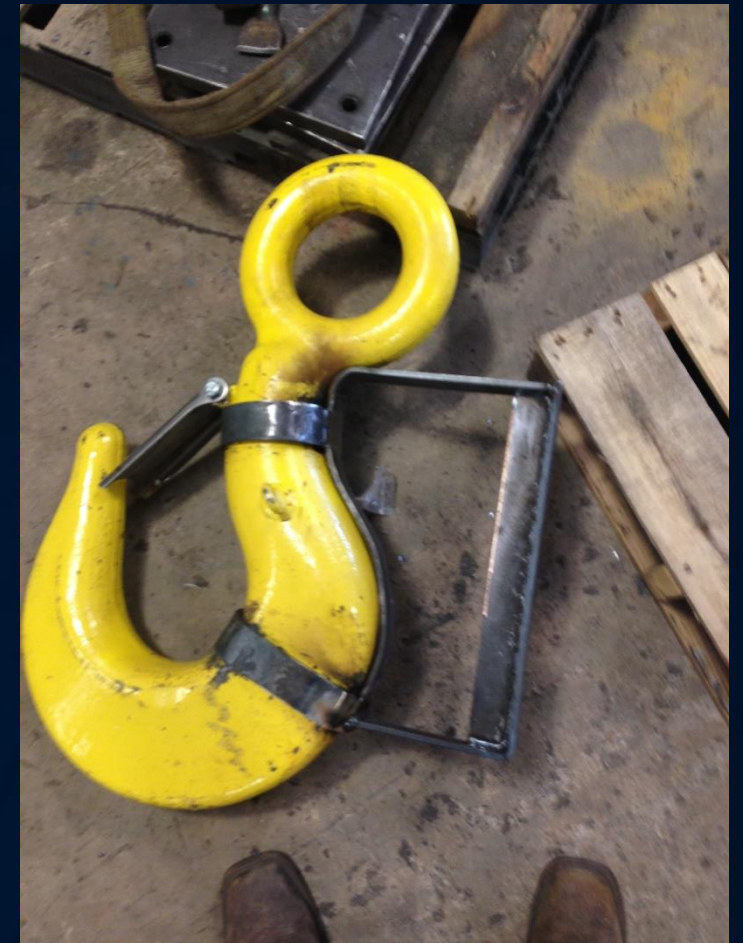


PCMF Fabrication

Port city Metal fabrication and welding facility is located under 20,000 square foot metal building with offices Infront. It is equipped with four 5 ton over head cranes. Equipment and capabilities are listed below.

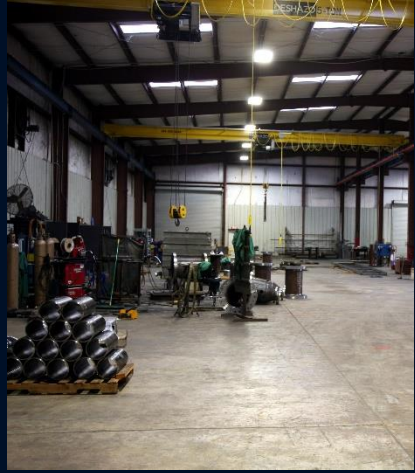
Within our ISO system we have daily, weekly and annual checks and calibrations for equipment. These are documented.

- 2 Hydmech s-20p series 3 Band Saw
- 10 ft. .25" Hydraulic Sheer
- 12ft. 220-ton Press Break
- 3 Pipe Bully's
- Geka 80-ton Ironworker
- 5Ft 1/2in plate roll
- 4 Miller Trailblazers 302
- 1 Lincoln Classic 300HE
- Hypertherm 10ft x 20 ft Plasma Table
- 5000# Rice Lake Scale
- Power Team 50T Padeye Puller



PCM

Port City Metal
CNC MACHINING-FABRICATION-COATING



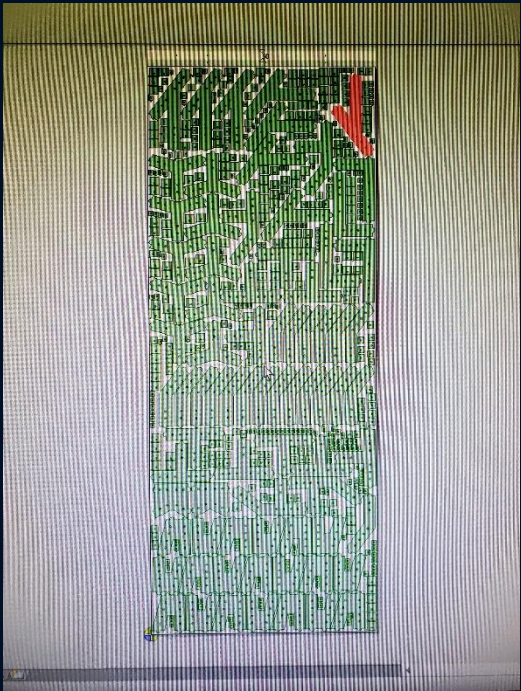
Hydmech S-20 Band Saw



Capacity	Rectangular (h x w)	Round
90°	13" x 18"	13"
45°	13" x 10 3/4"	12"
30°	13" x 7 3/4"	8 1/2"
Blade Size	1" x 14' 10"	
Blade Drive	3 HP VFD	
Machine Voltage	208, 240, 480, or 575 v	
Blade Speed	45-330 SFM	
Coolant Tank Capacity	6 Gallons	
Work Load	5,000 lbs.	
Machine Weight	2,200 lbs.	
Table Height	31"	
Dimensions (w x l x h)	92" x 75" x 52"	

Hypertherm Edge Pro:

This is a 260 Amp Plasma Cutting Machine. It can cut up to 1.5" thick carbon and stainless steel. It can also cut using Oxygen / Acetylene and can up to 9" Carbon Steel. The bed can hold 10' x 20' plate. We use Pro Nest and Draft Sight for programming and nesting.



Within our fabrication shop we perform some load tests in house. Here you can see a fabricated basket, using concrete as resistance. We also use 3rd party suppliers Locally and out of state.



Subcontracted Vendors

Marine & Industrial



Load Testing

Holloway Houston



Load Testing

FMS



NDE

NVI



NDE

AFT

Automated Finishing Technology

Coating (Xylan / Zinc Plating)

PV

Pinson Valley Heat Treating

Metal Treating



PCM has various capabilities for lifting, moving, and delivering a vast range of parts and the capabilities to perform off-site work with the following.

- Genie 15,000 lb extended reach forklift.
- (2) 24ft 14,000 lb trailers.
- (2) 20ft Gooseneck 10 ton trailers.
- Enclosed work trailer.
- 6,000 lb Forklift.

Previous Work Portfolio





