Colonial Tool Group Divisions

Colonial Tool Group Inc. – HQ & Broach Division
1691 Walker Road, Windsor Ontario
Building Size: 45,000 SF (1942)

Advanced Cutting Tool Systems
4811 Malden Road, Windsor Ontario
Building Size: 20,000 SF (1979)

Colonial RAS Spindle
12344 Delta Drive, Taylor Michigan.
Facility: 28,300 SF (1998)

Colonial Tool Mexico
Saltillo-Monterrey Highway,
C.P. 25207 Saltillo, Coahuila.
Building Size: 5400SF (2010)
Corporate History

• Established in 1930 as a subsidiary of the Michigan Tool Company

• 1954 Ex-Cell-O purchased the Michigan Tool Company (Ex-Cell-O Colonial Tool)

• 1986- Textron purchased Ex-Cell-O North America and we became Colonial Tool Textron

• 1993- Colonial Tool purchased from Textron now privately held as Colonial Tool Group Inc.

• 1998- Acquired Val-U-Tool (Fixture and Gage Manufacturing)

• 2007- Acquired Advanced Cutting Tool Systems

• 2010- Established Colonial Tool de Mexico
Major Customer Base

NAG Powertrain
Cross Hüller - Ex-Cell-O - Lamb

NAVISTAR

Pratt & Whitney
A United Technologies Company

Cummins
Chrysler
CAT

Motor
Harley-Davidson
Company

GM

Allison Transmission

Ford

PACCAR

Magna

MAGELLAN
Aerospace Corporation

LUK

Northstar Aerospace

Dana

Caterpillar

John Deere

Detroit Diesel

Colonial
Sales Volume

Year

Total Employees: 100
Colonial Tool Group - Spindle Division

Spindles
• CNC Spindles
• Motorized Spindles
• Gear Driven Spindles
• Belt Driven Spindles
• Replaceable Cartridges
• Cluster Spindles
• Special Spindles
• Turret Spindle Index
• Hydro-Static Spindles
• Rotary Tables
• Indexing Heads
Colonial Tool Group - Broach Division

Colonial Tool has the ability to offer full machining, assembly, mechanical design, controls engineering, qualification, PPAP, and commissioning capabilities.

Broaches
- Spline Broaches
- Helical Broaches
- Round Broaches
- Surface Broaches
- Keyway Broaches
- Special Broaches

Spline Rolling & Cold Forming

Broach Machines
- Table Up Broaching Machines
- "Pot"-Broach Machine
- Surface Broaching Machines
- CNC Broaching Machines
- Chain Broaching Machines
Advanced Cutting Tool Systems

Over 40 years of design and build of special indexable cutting tool systems for the auto/truck powertrain industry

**Boring, Facing and Grooving**
- Cross-Facing
- Finish Bore with Size Compensation
- Internal Bore Grooving
- Internal Bore Undercutting
- Multi-Feature Machining

**Milling Cutters**
- Surface Machining
- Slotting
- Form/Stepped Face
- Peripheral and Face Milling
- Circular Interpolating
- Straddle Milling

**Boring Tools**
- Multi-Feature Hole Machining
- Stepped Bores
- Chamfers
- Counter Bores
- Rough, Semi-Finish and Finish
- Cylinder Block Main Bearing Bores and Cam Bores
- Cylinder Head Cam Bores
Collaboration Opportunities for Advanced Cutting Tool Systems and Colonial Tool Group

- Access to advanced metal cutting machinery and process IP for broaching and motion tool technology
- Access to precision tooling and machinery manufacturing capability
- Access to Turn-Key design & build partner for pallet fixtures, special cutter bodies, and motion tools
- Access to advanced spindle technology essential for MQL, Nitrogen and CO2 green manufacturing technologies
Questions, Discussion & Next Steps

Thank You!

Toll Free 888-865-6701
infoacts@colonialtool.com
www.ColonialTool.Com
FULL SIDE STEP MILL
(20) TEETH RH, EQUALLY SPACED
(10) EFFECTIVE
(20) TEETH LH, EQUALLY SPACED
(10) EFFECTIVE

INSERT LNMU150812T-F27T
WKP25
(40) REQ'D.
FINISH CYLINDER BORING NOSE
ACTS QUICK-CHANGE MOUNT
(4) SEMI-FINISH INSERTS
(4) COMPENSATED FINISH INSERTS
THE ACTS ADVANTAGE

2.7L, OP150, Finish Cylinder Bore
2.7L, OP150, Finish Cylinder Bore
Ø18mm HEAD DECK SPOT FACE AND DE-BURR TOOL

(4) INSERTS, KENNAMETAL #SPHX060204R21
Ø37mm HEAD DECK SPOT FACE AND DE-BURR TOOL

(3) INSERTS, KENNAMETAL #SPHX120404R21
(1) INSERT, KENNAMETAL #SPHX060204R21
MILL FUEL PUMP MTG. SURFACE

(18) INSERTS LNMU150812T-F27T  WKP25
(6) EFFECTIVE TEETH
(6) TEETH – STAGGERED
(3) EFFECTIVE
MODULAR BORING BAR TO SEMI-FINISH LIFTER BORE

HSK-100A
THROUGH COOLANT

WALTER STANDARD ADAPTER
AK530.H100A.T36.120
MODULAR BORING BAR TO SEMI-FINISH LIFTER BORE

WALTER INSERT
#SCMT 09T308-PM5
GRADE WAK20

(3+2) EFFECTIVE TEETH – THROUGH COOLANT
BALL MILL TO ROUGH MILL CRANK BORE JOURNALS
OP40, 2\textsuperscript{nd} PASS

- **SCMT 3(2.5)2**
  - 3/8 I.C. SQUARE, .156” THICK  R.03” Corners
  - 0° AXIAL RAKE, 0° RADIAL RAKE
  - (4) EDGES, (1) REQ’D.

- **CDE 323R05**
  - 3/8 X 1/2 X 3/16  R.03” Corners
  - 7° AXIAL RAKE, 0° RADIAL RAKE
  - (2) EDGES, (2) REQ’D.

- **LNE 324-05**
  - 3/8 X 5/8 X 1/4  .03” X 45° Corners
  - -5° AXIAL RAKE, -9° RADIAL RAKE
  - (8) EDGES, (2) REQ’D.
OP #70 ROUGH BORE CUP PLUG HOLES 44301, 44302, 44303
(4) INSERTS SCMX 09T308, (2) INSERTS CDE 323L05
THE ACTS ADVANTAGE

MODULAR BORING BAR TO SPOTFACE SIDE BOSSES

HSK-100A
THROUGH COOLANT

WALTER STANDARD ADAPTER
AK530.H100A.T36.120
THE ACTS ADVANTAGE

MODULAR BORING BAR TO SPOTFACE SIDE BOSSES

WALTER INSERT
#SCMT 120412-PM5
GRADE WAK20

(2) EFFECTIVE TEETH – THROUGH COOLANT