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Since 1949 ACE Clearwater Enterprises has been building complex formed and welded assemblies for the aerospace and power generation industries. Operating from three facilities within a 10 sq. mile radius in Southern California, our employees are the best problem solving team in the business. ACE is the place for Engineering, Tool Design, Forming, Bending, Welding, Machining, Waterjet and Assembly. We have over 400,000 square feet of pure manufacturing agility and people with the experience to make it happen.

Core Competencies

Engineering

Tool Design & Reverse Engineering

Welding

Tube Bending

Assembly

5-Axis & 3-Axis Machining

5-Axis Waterjet

5-Axis Laser Cutting

Drop Hammer Forming

Hydraulic Press Forming

Hydro Forming

Metal Spinning

Foundry

NDT (Penetrant & X-Ray)

Pressure Test

CMM Inspection

Approvals

Nadcap - Welding & NDT

Lockheed Martin

Sikorsky

Northrop Grumman

Honeywell

SpaceX

Boeing

Bell

GE

Bombardier

MD Helicopters

United Launch Alliance

New Capabilities

In 2019, a new CNC Tube Bender and 5-Axis Waterjet were installed to address capacity issues at our Torrance Facility.

In 2020, a new 5-Axis CNC Machine and 3-Axis waterjet were installed to support increased demands from our valued customers.

EQUIPMENT LIST

Welding Department

- 22) Miller Digital (Inverter) Dynasty TIG 350 AMP
 - 1) Lincoln Square Wave TIG 350 Amp
 - 1) Lincoln Precision TIG 375 AMP
 - 2) 1,000 Lb. Ransome Welding Turntables
- 10) Aircrafter Welding Turntables
 - 1) Sciaky Spot Welder 100 KVA
 - 1) Janda Resistance Seam Welder 250 KVA
 - 1) Janda Spot Welder 175 KVA (Inverter)
 - 1) Uinter Precision Spot-Poke-Tack Welder
 - 1) Cress Pro 24" X 36" Pre / Post Heat Oven
 - 4) Ton Arbor Press
 - 3) Power Expanders
 - 4) Band Saws
 - 2) Drill Presses
 - 3) 48" x 48" Sandblasting Chambers

Machine Shop

- 1) YCM 5-Axis DCV2018A-5AX 86.6" x 126" x 165.3" 17,637 lb. Capacity
- 1) YCM 3-Axis Vertical Mill 80" x 40" x 40" 15,000 lb. Capacity
- 1) Johnford DMC-2600 SH 102" x 70" x 42" 22,000 lb. Capacity
- 1) Femco BMC 110R2 CNC 4-Axis Boring Mill 78" x 71" x 67"
- 1) OKK HM 1000S Dual Table HS Machining Center 55" x 43" x 40"
- 1) Kafo/Femco VMC-137 CNC 4-Axis Vertical Mill 51" x 27"
- 1) Mazak Slant 50 CNC 2-Axis Horizontal Lathe, 50 HP 26" Cut
- 1) Mazak Quickturn 20N CNC Horizontal Lathe 16" Cut
- 1) Sharp SVG-4323 CNC, 43" x 23" x 25" travel, 8,000 rpm, CAT 40, 20 HP
- 1) Sharp SVG-6335A CNC, 63" x 35" x 27" travel, 8,000 rpm, CAT 50, 35 HP
- 1) Kingston Horizontal Lathe 40" Swing
- 1) LeBlonde Horizontal Lathe 40" Swing
- 2) Mori Seiki Horizontal Lathe 24" Swing
- 3) Mori Seiki Horizontal Lathe 18" Swing
- 9) Bridgeport Vertical Mills
- 1) WARDJet 5-Axis Waterjet 8' X 13' Bed
- 1) Flow 5-Axis Waterjet 6' X 10' Bed
- 1) OMAX 3-Axis Waterjet 5' x 5' Bed
- 1) NTC TLM610 3.3K 5-Axis Laser Bed 75"x122" 4,000 lb. Capacity

Drop Hammer / Hydroforming

- 1) 5-Ton Rope Hammer 48" X 84"
 - 3) 3-Ton Rope Hammers 48" X 60"
 - 2) 2-Ton Rope Hammers 48" X 48"
 - 2) 1-Ton Rope Hammers 40" X 60"
 - 2) 1-Ton Rope Hammers 36" X 34"
 - 1) 1-Ton Ceco Stamp 24" X 30"
 - 2) 3-Ton Ceco Stamp 36" X 48"
 - 3) 3-Ton Ceco Stamp 48" X 48"
 - 1) 4-Ton Ceco Stamp 66" X 68"
 - 1) 7-Ton Ceco Stamp 60" X 96"
 - 1) 7-Ton Ceco Stamp 60" X 100"
 - 1) 12", 23", 26" Cincinnati Hydroform Presses
 - 1) 400-Ton Lien Chieh Press
 - 1) 250-Ton Verson Draw Press 42" X 42"
 - 1) 10-Ton Arbor Press
 - 5) Metal Spinning Lathes 72" Maximum
 - 2) Melting Pots & Furnaces
 - 3) 3,500 lb. Bull Ladles
 - 2) Air Tamping Hammers
 - 1) Steel Casting Platform
- Plaster Pattern/Form Tooling Department
Planishing, Clean Line, Processing, Heat Treat,
De Greaser, Annealing/Stress Relieve Ovens

Tube Bending Department

- 1) Vectorbend 65 ELEC CNC Rotary Draw Bender
 - 2) #4 Pines 4" Benders (1 Modified to 5")
 - 3) #2 Pines 2"
 - 1) Leonard Model 412 1"
 - 1) Leonard Model 62 1 6"
 - 5) Leonard & Conrac Hand Benders
 - 5) Leonard Beading & Flaring Machines
 - 2) Peak, Stow & Wilcox Beading Machines
 - 1) Fenn Reducer
 - 2) Bridgeport Tooling Machines
 - 2) Moriellci Conventional Lathes
 - 1) Custom Pull-Out Machine
- Complete Set of Bend Tooling 1/2" - 5"
Titanium Bend Tools 1/2" - 3"

Sheet Metal Department

- 1) Di-Arco 15-Ton 4' Press Brake
- 1) Chicago 30-Ton 6' Press Brake
- 1) Wysong 90-Ton 12' press Brake
- 1) Amada Vela II Punch Press
- 1) Amada 16' Shear
- 1) Amada Power Notcher
- 3) Manual Rollers 18"-48"
- 2) Bridgeport Milling Machines
- 1) Behringer Automatic Horizontal Bandsaw

Inspection/Quality

- 1) NDT Pressure Testing Department
- 1) Dedicated Dye Penetrant Line
- 1) In-House Level II
 - 360 Kv X-Ray Room
 - 180 Kv X-Ray Booth
- 3) 9 Ft. Faro Arm Portable CMM for In-Place Dimensional Inspection