

your tool for the best in steel strip and edging



Company Overview

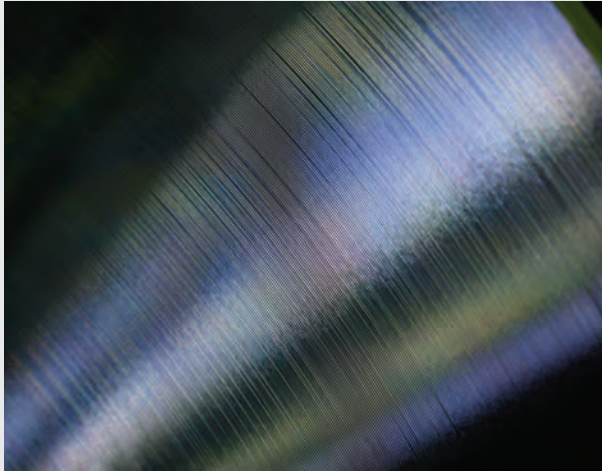
In the world of steel, there's nothing "run of the mill" about Tool King. An indispensable "tool" for metal buyers, we feature some of the finest inventories and processing capabilities in ...

- Cold Rolled Strip, Spring, and Stainless steels
- Ultra-narrow slitting and tight thickness tolerances
- Edging (skiving) in a broad array of profiles
- Oscillate (traverse) and ribbon coil winding

When it comes to quality, we're unabashedly obsessive-compulsive ... operating practices and controls often well beyond those demanded of our rigorous ISO 9001:2000 certification. During its 30-year history, Tool King has effectively supplied over 700 of the most quality, service and cost conscious customers, and their most challenging applications.

Our customer list includes a virtual "Who's Who" of QC-critical users ... Black & Decker, Federal Mogul, Franklin Electric, Hunter Douglas, Imation, ITW, Modine, Newell, Pella, Square D. And while we handle many "blue chips," we're also proud of our vital service to small OEMs, custom stampers and fabricators. Major industries served include: springs, electronics, appliance, electrical, electronic, medical, automotive, stamping, hardware, military, aerospace, lighting, utensils, and picture frames.

Tool King's processing battery includes seven slitting lines and three edging machines, with electronic-laser tolerance monitoring. We can furnish slit coil in ribbon and oscillate (traverse) wound form. Coil bundling (a.k.a. "cluster coil") is also featured, and our packaging is "rock solid." In addition to the value-added processing of our own material, we toll-process (slitting and/or edging) for end-users, mills and metal distributors.



The company's custom-tailored Just-In-Time (JIT) inventory programs are dependable and rapid – you'll gain supply assurance, accelerated inventory turnover, maximized cash flow, freed-up production space, reduced material spoilage, along with a host of other valuable benefits.

Solid, longstanding partnerships with fine and trustworthy mills – domestic and foreign – engender supply breadth and depth, dependability and cost competitiveness for us and our customers.

Based in suburban Chicago, we're strategically positioned near many domestic mills. From this central base, we service customers' plants throughout the Midwest manufacturing belt, the entire U.S., Canada, Mexico, South America and Asia.

Whether requirements call for 1000 tons or 100 pounds, you can be assured of impeccable material quality, brilliant service, expert advice, and outstanding value. Your production people will love our metal. Inventory Control will appreciate our speed and reliable deliveries. Your CFO will treasure our value.

This brochure provides an overview of our products, services, resources, benefits and mission. But we invite you to study us close-up. Discuss with us your regular usages, special specs and, especially, the really tough jobs. Give us an inquiry ... try us out with an order. Tool King will become the "tool" you always select first.



master coils receiving bay



stainless on slitter uncoiler



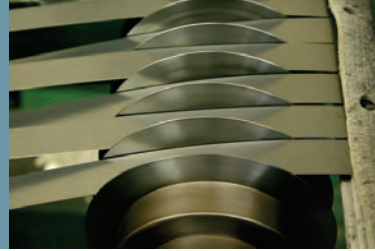
blue polished first-stage edging

PRODUCTS PORTFOLIO

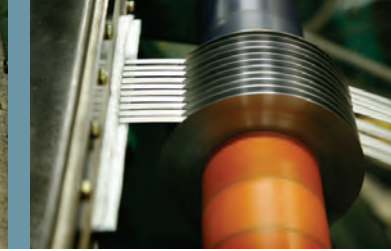
Product	Grades	Tempers	Finishes	Coatings	Thickness Range
Cold Rolled Strip Spring Steels	C1050, C1070 C1075, C1095	Soft Annealed	#2	--	.008" - .125"
	C1095 "Clock Spring"	Tempered (Rock. C 48-51)	Blue Polished	--	.002" - .062"
	C1074/C1075	Oil Tempered (Rock. C 44-47)	Scaleless	--	.008" - .062"
	D6A	Annealed or Hard Rolled	#2	--	.010" - .075"
Cold Rolled Strip Low Carbon	C1006 - C1020	#1, #2 #3, #4, #5	Matte Bright	--	.008" - .125"
Cold Rolled Sheet Low Carbon	C1006 - C1020	Commercial, Drawing, Quarter, Half, Full Hard	Light Matte Regular Matte Bright	Mill Finish Prepainted	.008" - .125"
Stainless	301, 302, 304, 304L, 316, 316L, 321	Annealed 1/4, 1/2, 3/4 Hard Full Hard	#1, #2, #3, #4 Bright Anneal	--	.005" - .125"
Galvanized Galvannealed Electroalvanized Aluminized Galvalume	--	Commercial, LFQ, Forming, High Strength, Structural, Drawing	various	various	various
Tinplate & Blackplate	Single Reduced Double Reduced	T2 - T5	--	--	.005" - .015"
Aluminum	1100, 3003 5005, 5052 6061, 2024, 7075	various	mill	--	.015" - .130"
Copper & Brass	various	various	--	--	various



.031" x 0.250" brass slit coil



spring steel slit coil through separators & tension stand



stainless slit coil entering recoiler



.012" x 0.276" cold rolled awaiting oscillate winding

Slitting Services

Tool King is widely admired for superb ultra-narrow, tight-tolerance slitting. Beyond cutting our own material, we're pleased to perform toll-slitting for OEMs, mills and distributors.

SLITTER CAPACITIES

Line/Capacity	36"	24"	24"	18"	18"	12"	8"
Width max.	37"	24"	24"	18"	18"	12"	8"
Width min.	0.500"	0.375"	0.250"	0.150"	0.187"	0.312"	.060"
Thickness – Carbon	.015" - .130"	.020" - .125"	.010" - .050"	.008" - .090"	.003" - .030"	.010" - .050"	.003" - .028"
Thickness– Stainless	.015" - .130"	.020" - .090"	.010" - .040"	.008" - .080"	.003" - .025"	.010" - .040"	.003" - .025"
Width Tol. +/-	.005"	.005"	.003"	.003"	.003"	.003"	.003"
Coil Weight max.	15000#	7000#	6000#	6000#	5000#	4000#	3500#
ID incoming	16" - 24"	16" - 20"	16" - 20"	16" - 20"	16" - 20"	16" - 20"	16" - 20"
OD max. incoming	62"	62"	58"	58"	58"	60"	58"
ID outgoing	16" - 20"	16"	16"	16"	16"	12"/16"	6"/16"
Trim min. required	0.312"	0.250"	0.187"	0.187"	0.125"	0.187"	0.125"
Cuts – max. number	14	14	14	12	14	12	12
Special Features	--	--	--	--	looping pit	--	looping pit
Line No.	9	1	2	4	6	3	5



blue polished entering #7 edging line



sparks and fire during edging

Tool King's "edge-ucation"

Tool King is practically unique in its abilities to produce a wide variety of edge shapes, and across so broad of a gauge range. Edging/skiving offers a number of significant benefits ...

- faster, easier die feed-thru enhancing productivity
- increased formability, especially for hard steels
- tighter width tolerances (+/- .001")
- helps prevent edge cracks
- extended spring cycle-life
- improved customer safety and reduced product liability exposure
- increased worker safety and morale, with decreased attendant medical claims

Tool King can produce coil with edge profiles shown below ...

<u>Edge No./Name</u>	<u>Typical Cross-section View</u>	<u>Corner Description</u>
#1 Round*		full round, $R = 1/2 t$
#1 Square*		square edge, very accurate width, all slitter break removed
#2 Mill*		edge (unprocessed) as normal mill-rolled, some burr
#3 Slit*		standard slit edge – minimal burr
#4 Rounded*		a.k.a. safety edge, semi-round corners (less radius than #1 Round)
#5 Deburred*		a.k.a. "skived" – all burr removed; almost-square profile
#6 Approx. Square*		semi-square (more radius than #1 Square)
#7 Round/Square**		1 side #1 round; 1 side #1 square (Tool King custom)
#8 Bevel**		tapered both sides (Tool King custom)
#9 Custom***		your custom-engineered/proprietary profiles

Notes:

* consistent with ASTM A505-00 (2005)

** per Tool King existing profiles

***per consultation with and approval of Tool King



edge-width laser monitor



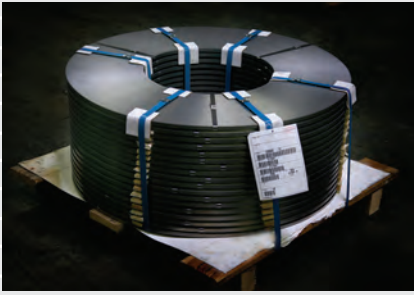
cold rolled being square edged



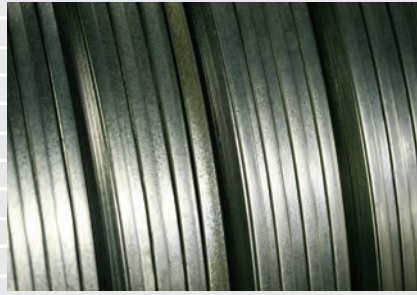
coils being banded on turnstyle

EDGING/SKIVING CAPACITIES

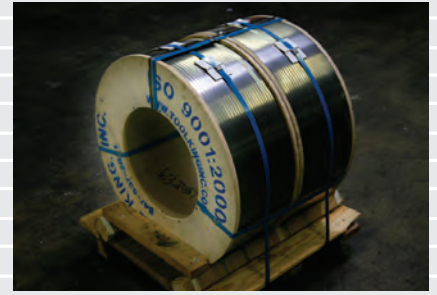
Line/Capacity	4"	3.5"	2.5"
Width max.	4.00"	3.50"	2.50"
Width min.	0.250"	0.150" (ribbon) 0.188" (oscillate)	0.150" (ribbon) 0.188" (oscillate)
Thickness – Carbon	.008" - .125"	.008" - .125"	.008" - .125"
Thickness – Stainless	.008" - .125"	.008" - .125"	.008" - .125"
Width Tol. +/-	.003"	.001"	.001"
Coil Weight max.	1100#	1100#	2200#
ID incoming	16" - 20"	16" - 20"	16" - 20"
OD max. incoming	64"	65"	65"
ID outgoing	16"	5"/16"	5"/12"/16"
Trim min. required	n/a	n/a	n/a
Cuts - max. number	1	1	1
Special Features	--	laser width micrometer	laser width micrometer
Line No.	7	8	10



slit coil (ribbon wound) on skid



galvanized coil bundles awaiting skidding



oscillate wound coil on spool with skid

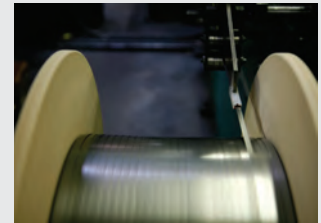
Packaging Options

Beyond standard ("ribbon") coil packaging designs, we offer enhanced capabilities and benefits including ...

Oscillate (a.k.a. Traverse) Winding

In this method, slit coil is stagger-wound (similar to cloth thread or fishing line) over a wider spool. This is in contrast to the conventional ribbon-winding process, in which the coil is wound "edge flush." Oscillate winding enables a much longer strip (est. 7x-15x) to fit onto an inside diameter (ID), thus reducing coil-changeover downtime, and increasing production runs. Our customers realize large gains in terms of:

- productivity rise exceeding 15% typically
- increased coil yields (i.e., far less head and tail loss)
- reduced scrap (fewer dollars wasted)
- reduced labor (fewer operators needed for coil mountings)
- reduced tool fatigue and increased tool life
- reduced injury risk and attendant health care savings



oscillate/traverse winding

Coil Bundles (a.k.a. "Cluster Coils")

Beyond traditional individual slit coil "pancake" bundling, Tool King offers coil bundling. In this method, 8-10 mults are ribbon-wound recoiled on a fiber core, then banded as a single unit. The core can be loaded either "eye-to-sky" or "eye-to-side," depending upon customer preference. This package construction offers significant customer benefits ...

- reduces material handling for increased efficiency
- enhanced worker safety – reducing injury and medical claims
- increases plant space



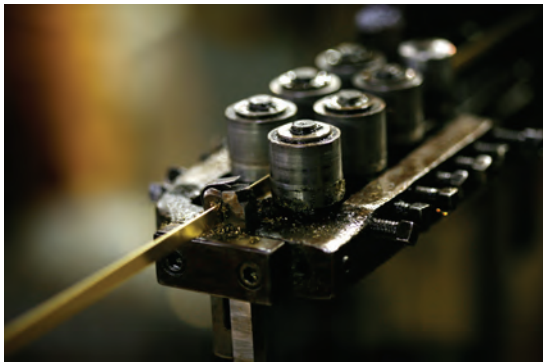
oscillate wound coil on spools with plastic shrouding

Product Marking & Tagging

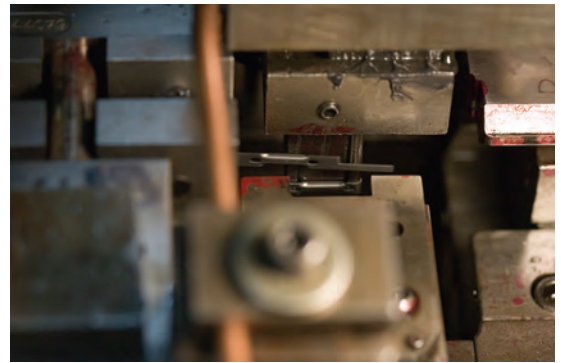
We feature bar coding with full data input capability including: customer name, PO Number, release number, plant/ship to, part number, product, grade, thickness, width, weight, coil number, heat number.

Customer Applications

Below are some examples of our metals applications, as seen in the precise, sophisticated stamping (i.e., four-slide) and finished parts of our loyal customers ...



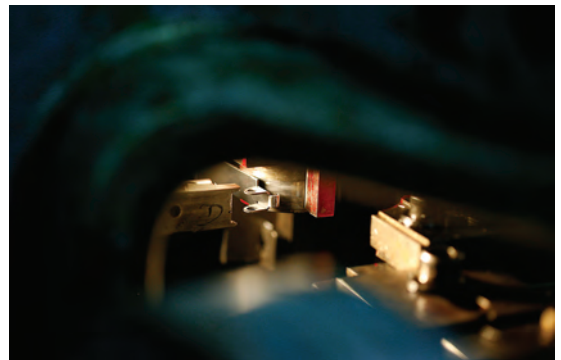
0.250" wide brass feeding into four-slide



spring steel thru multi-slide



ultra-precise tolerances



peering into four-slide



clamp – cold rolled #6 semi-square edged



brass terminal for electronics

Other Resources & Features

Corporate Quality Policy

Tool King is committed to supplying the finest products and services. We strive to fulfill and, to the extent practicable, surpass all of our customers' quality requirements and standards. Accordingly, we proactively and continuously improve our knowledge, skills, materials, processes, equipment, technologies and other resources.

Metallurgical Facilities

With our ISO 9000:2001 and other rigorous quality control protocols, we furnish material certification to quality standards including ASTM, AMS, SAE, MIL-S and A2LA. In-house metallurgical instrumentation includes:

- Spectrometer – chemistry
- Rockwell Testers – hardness
- Ball Punch Deformation Tester – ductility
- Profilometer – surface smoothness
- Ultrasonic Micrometer – thickness
- Magnetic Coating Thickness Gauge – zinc density
- Optical Comparator – dimensional examination

Plant

40,000 sq. ft.

Crane capacity – 17,000# max.

Heat & humidity controlled

Docks: 3 recessed, 1 ground; 40-foot trailer accommodation

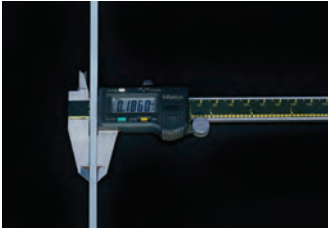
Brick construction; built 1984

Technology Architecture

Microsoft Windows® servers and applications, Enmark metal service center management software.

Trade Organization Memberships and/or Certifications

ISO 9001:2000 (ISO-certified since 1999), Tooling & Manufacturing Assn., Precision Metalforming Assn., Spring Manufacturers Institute, Metal Service Center Institute.



caliper measuring 0.186" wide slit electrogalvanized



spectrometer



Tool King plant – exterior view



west bay – slitting area 1



northeast bay – finished goods



east bay – finished goods

Company Insight

Company History

Tool King was founded in 1976 by Bjorn and Peter Hestad. Earlier, Bjorn had been in charge of purchasing for a prominent electronics manufacturer, and sourcing very narrow slit steel coil was daunting. Meanwhile, Peter had worked as a slitter operator for several Chicago-area metals distributors.



slit coil banding

With Bjorn's and Peter's complementary steel experience, they began supplying manufacturers and job shops with tool and flat-rolled steels (thus, the name "Tool King"). In 1980 they purchased their first slitting line, satisfying their customers' burgeoning needs for thin, narrow coil. In the ensuing years, the firm evolved from its initial footing in tool steels and expanded into today's full range of ferrous and nonferrous capabilities. Yet all the while, the company has stayed true to its initial mission of providing customers with unique and vital metals supply. It remains, heart and soul, a "family" business.

Corporate Mission Statement

Tool King is a business committed to the utmost performance, value and integrity of its people, products, services, processes, technologies and brand.

People

At the core of Tool King's strength lie its talented and dedicated people. The company's President, along with its General Manager, have a combined 70+ years' experience in the supply and processing of metals. They're "hands-on," fully engaged, literally and figuratively. The organization is modern and streamlined, yet with an "old school" work ethic, to ensure maximum customer responsiveness.



positioning slit coil on skid

The Account Managers are very knowledgeable about products, processing, and the metal market; fully aware of order status and delivery timeframes; courteous, friendly, responsive and genuine. All administrative and quality personnel are similarly "in sync."

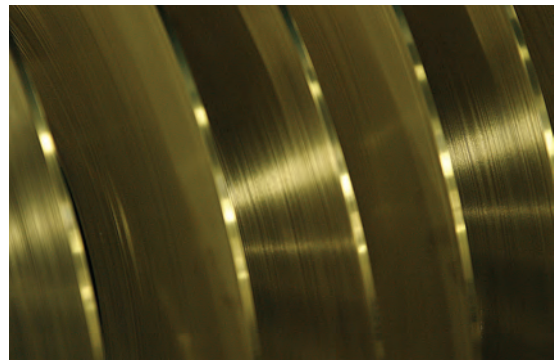
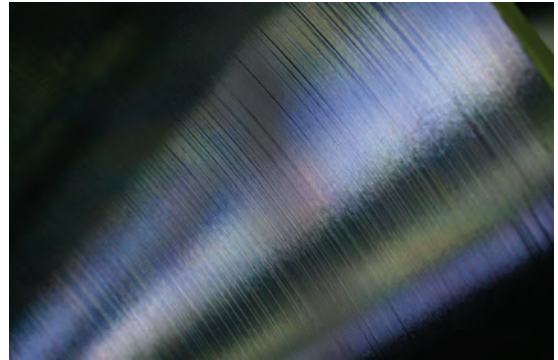
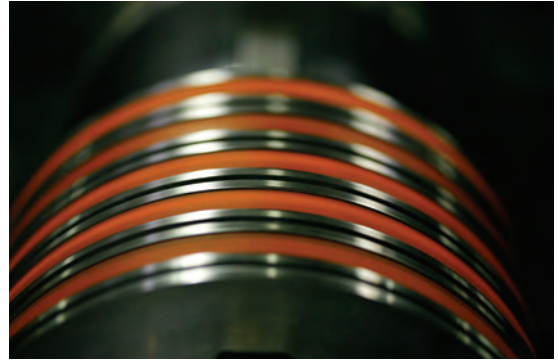
Tool King's production personnel approach their jobs with extraordinary skill, dedication, and justifiable pride. Many have 15-25 years' tenure with the company - they're "masters" of machinery, operations, and quality protocols. They fervently share the firm's mission and customer focus. Their great passion is evident in our fine steel products.

A Word from the President & Owner ...

On behalf of the Tool King family, we deeply appreciate your interest, trust and patronage. We're pledged to fulfill, and prove to you, now and always, the true "steel" of our company Mission Statement, Quality Policy and motto ... *your tool for the best in steel strip and edging.*



Peter Hestad, President, Tool King



your tool for the best in steel strip and edging

275 Larkin Drive ▪ Wheeling, IL 60090 USA
tel. 847.537.2881 ▪ fax. 847.537.6937
toolkinginc.com
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