MESQUITE RIDGE METAL WORKS
Plant 1 | Cedar Flats, Texas

Plant 1 floor notes for the twin

From Ray Tillman, plant manager. Friday, Nov 20, 2026. Numbers from Luis Ramos where marked.

What we want to know

Will the open orders ship on time through Dec 18? Walt wants to buy a second HMC (quote: $420,000 installed). Hector thinks one more machinist on nights would fix it. We keep arguing. Let's count first.

Machines (only the ones these orders touch)

- 1 band saw (cuts bar, plate and tube)
- 1 four-axis horizontal mill, HMC-1
- 2 three-axis vertical mills, VMC-1 and VMC-2
- 1 lathe, L-1
- 2 weld cells, W-1 and W-2
- 1 deburr and wash bench
- 1 shipping dock

Plant 1 has 14 CNC machines. The other 8 run other work and are not part of this.

People and shifts

- Machinists: 4 on each shift. Any machinist runs the saw, the mills or the lathe.
- Welders: 2 on each shift.
- Finisher (deburr and wash): 1 on each shift.
- Shifts: 1st 6:00 am to 2:00 pm, 2nd 2:00 pm to 10:00 pm, Monday to Friday.
- Shipping: one clerk, 7:00 am to 3:30 pm, Monday to Friday. Nothing ships on 2nd shift.
- Closed Thursday Nov 26 (Thanksgiving) and Friday Nov 27.

How work moves

- Steps and times for each part are in the routing export (plant1-routings.xlsx).
- Jobs run in the order the travelers hit the rack: first come, first served.
- Gearbox housing castings come from Plant 2, ready to machine. Bar, plate and tube are always on the rack.
- Powder coat goes out to Blue Heron Coatings on the daily truck. 2 days door to door, no limit on how many.
- A setup on HMC-1 takes about 2.5 hours: swap the fixture, load tools, check the first piece.

Money (from Luis)

- A late order costs us about $1,800 on average: expedited freight, overtime and scorecard hits.
- Quick-change fixture plates for HMC-1: $14,000 one time. Cuts an HMC-1 setup to about 1 hour 15 minutes.
- A Saturday day shift for the 4 machinists (6:00 am to 2:00 pm): about $1,900 each Saturday in overtime.
- One more machinist: about $78,000 a year with benefits.
- Second HMC: $420,000 installed.

Price and late cost by part (for the shop file)

Part	Price	Unit cost	Late cost a day	Main customer
MR-1010	$640	$260	$900	Anchor Point Machinery
MR-1020	$385	$150	$1,200	Prairie Wheel Equipment (strict scorecard)
MR-1015	$120	$48	$400	Prairie Wheel Equipment
MR-1002	$46	$17	$150	Tri-County Implement
MR-1030	$780	$330	$300	Tri-County Implement
MR-1031	$4,200	$1,900	$1,500	Bayou Drilling Supply