

Capability Self Assessment



FACTS & FIGURES

Specialty Systems (SpecSys) was founded in 1997 .

Under the umbrella of RITALKA, Inc. and headquartered in Montevideo, MN, it is a privately-held corporation that provides fast track contract engineering and volume or prototype manufacturing as well as project management, analysis, product testing and technical documentation.

The company has 3 manufacturing facilities, which are located in Minnesota and Wisconsin.

At SpecSys, we ensure your project is on time, on budget, done right and done safely.

Contact Info

121 North 1st St.
Montevideo, MN 56265
www.specsys.com
P: 320.269.3227

Company Identification

SIC codes:

- Engineering: NAICS 541330
- Manufacturing: SIC 3331

Dunn & Bradstreet ID: 041665048

CAGE code: 34PZ9

Primary Industries Served

Railroad	Construction
Agriculture	Material Handling
Government	Forestry
Oil & gas	Power generation
Utilities	

Key Clients

CAT-Paving	Geismar North America
Terex	Case/New Holland
Georgetown Rail	Schwing America
Harsco Rail	Stetco Products
Loram	Joy Global / Komatsu Mining
Taylor Group	LiuGong Norh America

250
Employees

5
Locations

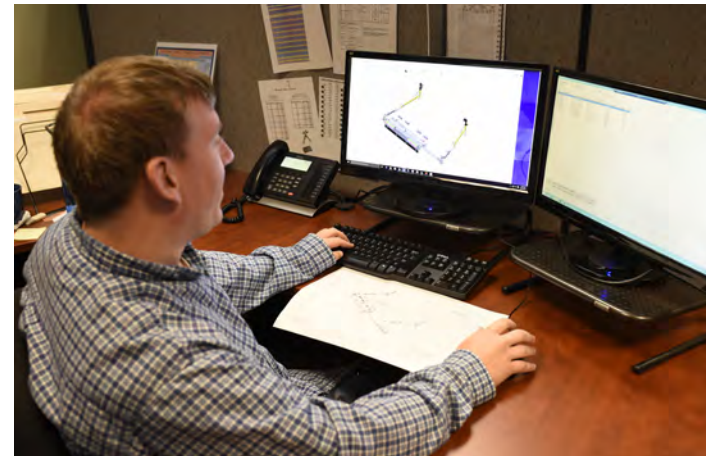
625,000
Ft² Manufacturing Space

5,000+
Hours/month Engineering Services

35,000+
Hours/month Manufacturing Services

200
Active Suppliers

70
Active Clients



DESIGN ENGINEERING

SpecSys Inc. has the staff, the experience, the tools, and the capability to take your napkin concept to a prototype build.

SpecSys Engineering staff includes B.S. and M.S. engineers and A.S. designers who produce 5,000 hours output per month. Fast-track projects are our life blood. We are contracted to bring a design along quicker than an OEM can accomplish within its own organization.

We support OEMs with market studies, pre-concept and concept design, detailed performance and configuration specifications, as well as engineering analysis.

We can provide a documentation package that includes fabrication prints, weldment prints, assembly documentation, bills of materials, vendor sourcing information, and operator/service/parts manuals.

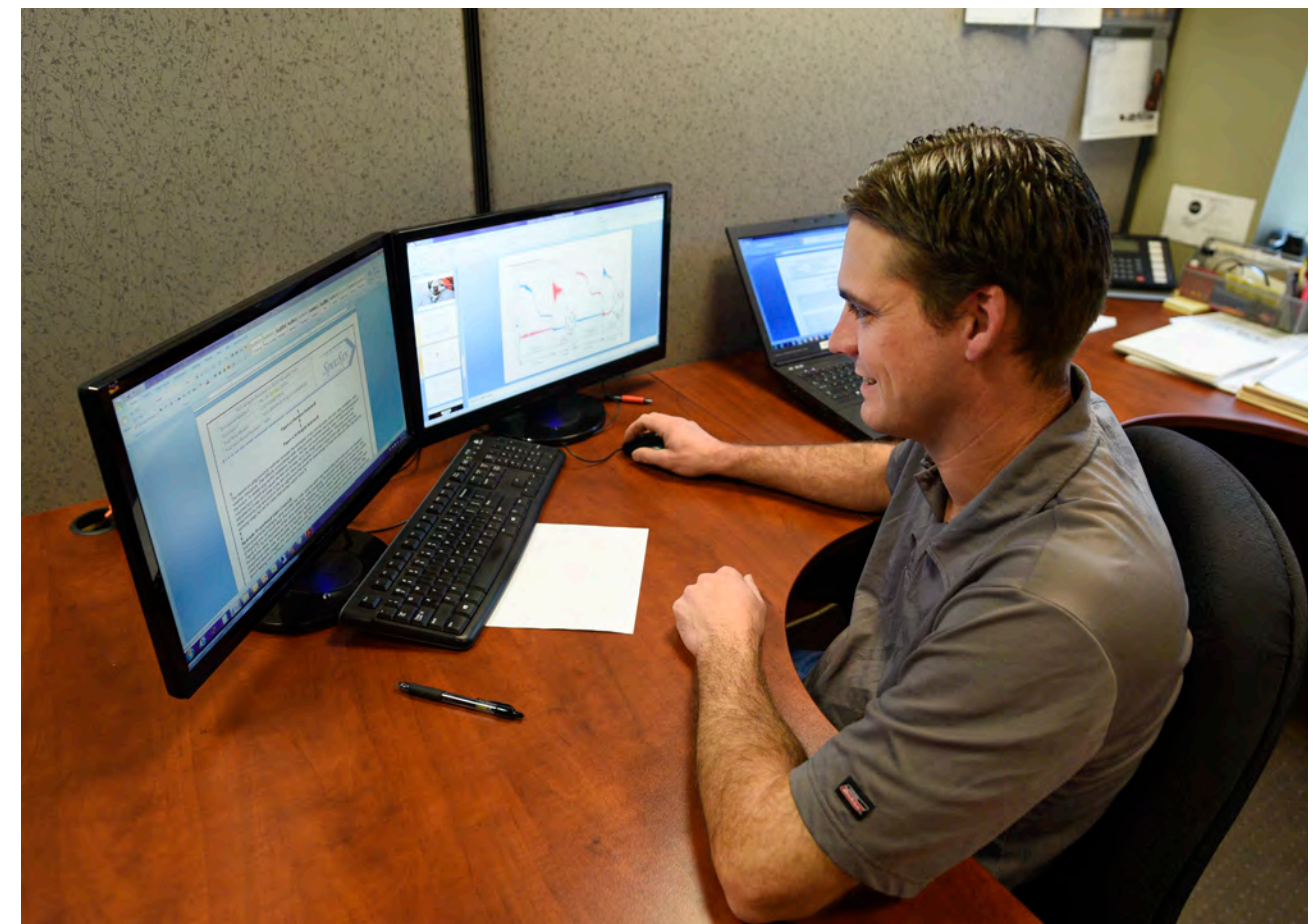
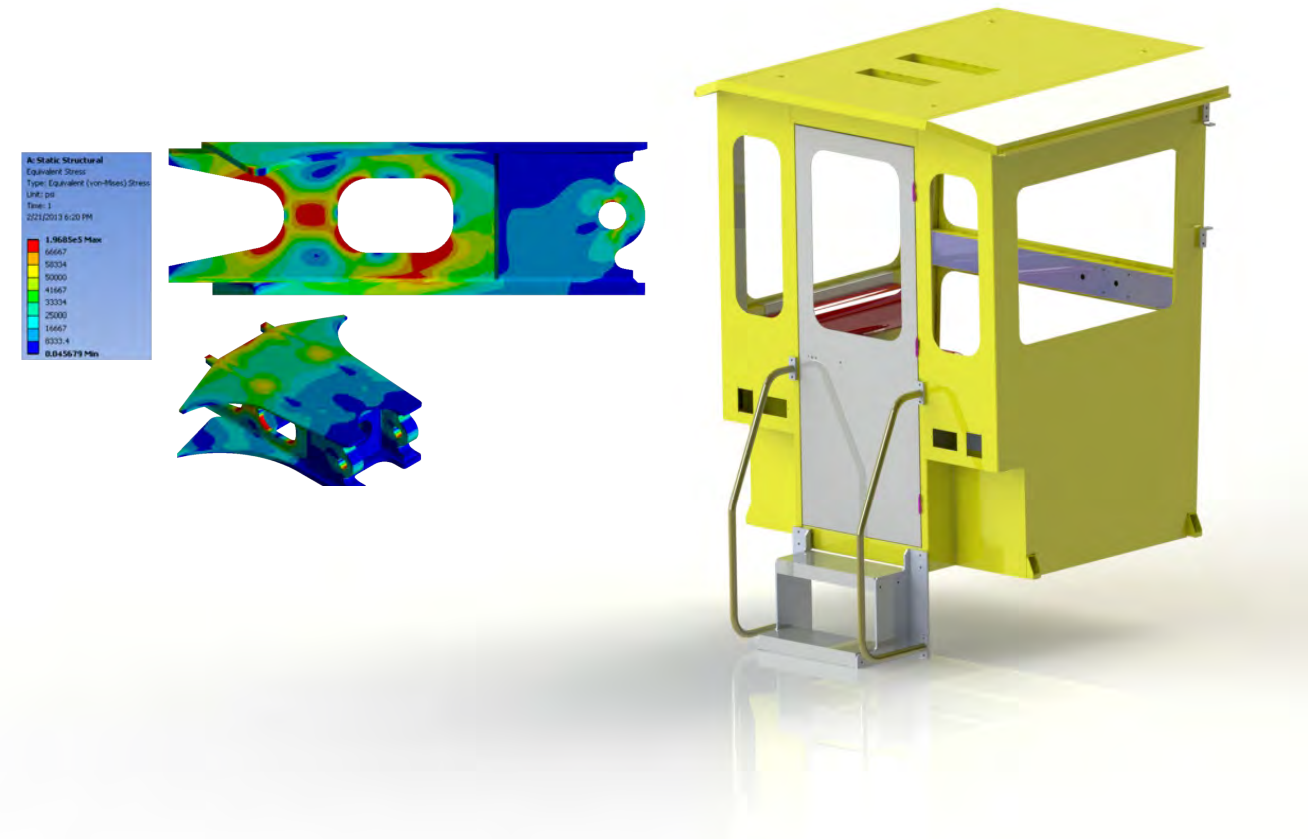
SpecSys engineers can also perform complete, turn-key testing, including life cycle testing, structural testing, systems testing and more.

We have the capability to provide the following:

- Performance specifications
- Configuration development
- Conceptual designs
- Detail design
- CAD modeling
- Styling
- BOM development
- Vendor support & supplier selection
- Technical publications
- Finite element analysis
- Systems, life cycle, and structural testing

To accommodate specific client needs, we work in most any design software, including the following:

- Creo/Pro E
- ProE Wildfire
- DesignSpace
- Solid Edge
- SolidWorks
- Xchange Works
- Autodesk Inventor
- Inventor - Routing module
- AutoCAD
- Mechanical Desktop
- Toolbox Products
- AutoSM
- DirectSoft
- ANSYS Workbench
- Cummins Advisor



MANUFACTURING SERVICES

SpecSys provides manufacturing solutions for machinery & equipment projects, simple or complex, large or small. It is one of the few firms in the country that offers true full service contract manufacturing along with engineering support. We have the experience, the staff, and the machine capability to complete a full turn-key project faster and more economically to support our OEM partners.

Differentiators

- One source, complete in-house turn-key services: fabrication, machining, welding, painting, assembly, including electrical, mechanical, hydraulic, pneumatic... all under one roof.
- Provider of fast track project management
- Custom services for client needs
- Flexibility to offer full service engineering and/or manufacturing and/or testing services
- Engineering support staff includes B.S. and M.S. engineers and A.S. designers
- Facilities, systems, and processes allow for multiple projects simultaneously

Past Performance

- Over two decades of proven client solutions
- Large complex industrial equipment designs and builds
- Continual expansion in facilities and capability to match customer needs
- Subcontractor for US government contracts
- Quality assurance driven by Process Assurance Checks (PAC)
- Project library containing information and data for historical reference

Qualifications/Awards

- ISO 9001:2015 certified company
- AWS certified weld Inspector on staff
- 2005 SW MN Entrepreneurial Business of the Year
- Governor's Certificate of Commendation
- AARM-1003 Certification



Fabrication

- Press brakes
- Band saws
- Tube benders
- Iron workers
- Laser tables
- Plasma tables
- Flame cut capabilities up to 9-in. thick

Welding

- Positioners with capacities from 500 - 40,000 lb
- Buggo/track
- Robotic and semi-robotic welding
- Spot welder, stud welder
- AWS certified welders in D1.1, D1.2, D1.6, 1G, 2G, 3G, 4G, 3F, stainless steel
- Certified weld inspector on staff



Machining

- Dual head gantry mill
- Horizontal and vertical boring mills
- Horizontal and vertical milling machines
- Horizontal and vertical machining centers
- Lathes
- Surface grinder



Paint

- Portable, commercial - grade sand blaster
- Phosphate wash room
- Phosphate weight measurement
- Pretreatment washroom
- Individual part racks
- Paint booths in four facilities
- Two-gun spray system
- Ability to meet any paint specification
- Dry film thickness, adhesion, corrosion testing and gloss measurement

Assembly

Capabilities

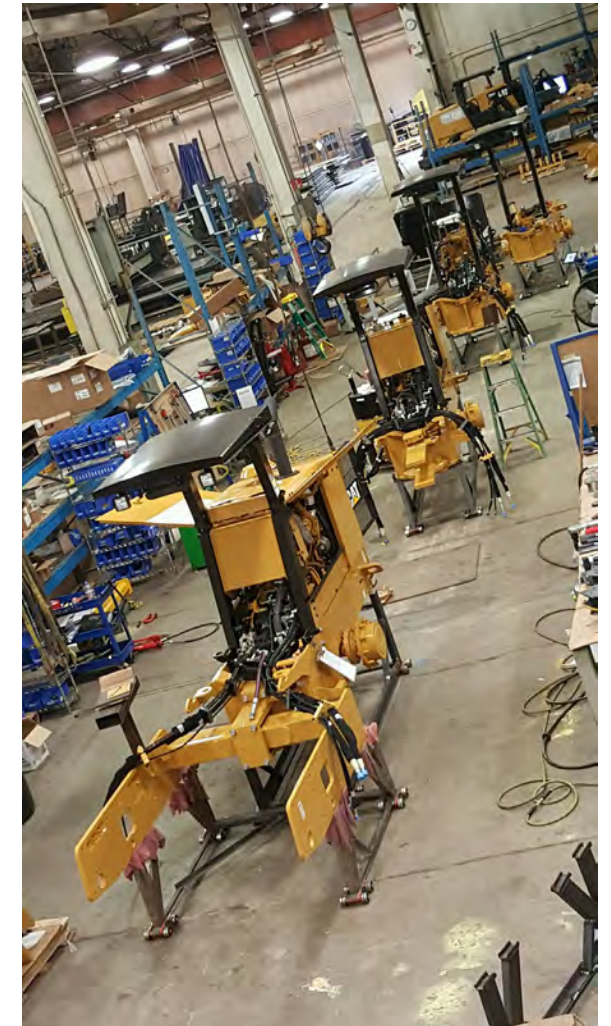
- Vehicle assembly
- Hydraulic systems
- Electrical systems
- Pneumatic systems
- Wire harness production
- Panel assembly (NEMA enclosures, DIN rail assembly, Hoffman wireways and troughs)
- Pulley and gear box assembly
- PLC programming (Siemens, Allen-Bradley, Horner, others)
- HMI design and programming
- Ability to build multiple configurations simultaneously

Methods

- Bay build or line build
- Digital work instructions that are available real time via tablets or screens
- Kanban, point-of-use, and kits for efficient production
- Demand flow
- Part specific rigging
- Tool boards in assembly
- Training programs for manufacturing staff

Testing

- Inputs: analog, digital, CAN Bus, synchronous video
- Heat cycle testing
- Measuring capability: torque, strain, temperature, pressure, flow, fluid levels, voltage, current, acceleration and more
- Machine functions
- Time trials
- Extended machine run time tests
- Wi-fi control
- Emissions tier qualification



QUALITY PROVIDER

On Time

We understand that delivering projects on time is important not only for our success but for the success of our clients. To ensure that design or manufacturing projects are proceeding as planned, each is assigned a project manager, and a time line is made.

- The project is integrated within the company's daily/weekly planning schedule and is included in capacity reviews.
- An MRP system keeps track of all requirements. Facilities, systems and process allow for multiple projects simultaneously.
- SpecSys is capable of designing and manufacturing its own tooling.
- A formal maintenance management program helps to reduce equipment downtime.
- When it comes time for your hardware to hit the road, SpecSys has access to rail and truck transport near its multiple locations.

On Budget

- To ensure that the project is completed within the defined budget, SpecSys uses a contract review process with a documented checklist.
- Forecast reviews, cost roll ups, and supplier cost reduction programs help us source parts and raw materials at best cost.
- Engineering changes are recorded and tracked.

Done Right

At SpecSys, having built-in procedures is a quality focus. We have been ISO-9001 certified since 2001 and recently were certified to the ISO-9001:2015 standard. Components in our quality system include the following:

- Floating quality gate checks with constant modifications to ensure quality throughout the manufacturing process
- DXF files if not provided by the customer
- Detailed, visual work instructions to consistently maintain specifications
- Production machines that are rigorously checked for any defects to improve quality and detect reoccurring issues
- Product-specific verification processes
- Templates and go/no-go gauges to gain consistency and quick part verification
- A portable coordinate measuring machine (CMM) and Faro arm to provide multiple measuring capabilities
- PDI / PDA (Pre-delivery inspection and audit)
- Audits performed on completed product before shipping
- Root cause analyses on all findings that come out of the quality system



MANAGEMENT SYSTEM CERTIFICATE

Certificate no.:
CERT-07148-2006-AQ-HOU-ANAB

Initial certification date:
19 September, 2007

Valid:
02 November, 2022 – 10 September, 2025

This is to certify that the management system of
RVI, Inc. / SpecSys/ Integral DX Inc.

121 North First Street, Montevideo, MN, 56265, USA

and the sites as mentioned in the appendix accompanying this certificate

has been found to conform to the Quality Management System standard:

ISO 9001:2015

This certificate is valid for the following scope:

Provide Services to Clients that include: Contract Manufacturing, Design Engineering, Fabrication, Machining, Welding, Assembly, Painting, Repair & Renewal of Electronic Products, Test development & testing of Electronic Products, Battery Management, Wire Harness & Control Box manufacturing & Assembly as well as Intelligent Inventory Management

Place and date:
Katy, TX, 02 November, 2022



For the issuing office:
DNV - Business Assurance
1400 Ravello Drive, Katy, TX, 77449-5164, USA

Sherif Mekkawy
Management Representative

Lack of fulfilment of conditions as set out in the Certification Agreement may render this Certificate invalid.
ACCREDITED UNIT: DNV Business Assurance USA Inc., 1400 Ravello Drive, Katy, TX, 77449, USA - TEL: +1 281-396-1000. www.dnv.com

To meet the requirements of ISO-9001:2015, the following documented work instructions and policies are in place:

- Quality Assurance Manual QA-11, rev K (3/28/11)
- Contract Review SAL-26
- Design review ENG-08
- Document Control SOP 2.01
- Nonconformity Control SOP 6.09
- Corrective/Preventative Action SOP 8.02 (non-conforming material is segregated or tagged for disposition)
- Management Reviews SOP 1.01
- Training SOP 3.01
 - Formal employee orientation process
 - Training effectiveness evaluated
- Supplier Evaluation SOP 4.07
- Special Process Validation SAL-28
 - Certified weld inspector on staff
 - Welders qualified to AWS D1.1
- Calibration SOP 7.01
 - In-house and outsourced
 - Traceable to NIST
- Quality Record Control SOP 2.03
- Internal Audits SOP 8.03
 - External audit each year
 - Internal processes internally audited on a 3-year cycle
- Record retention plan (7 years for shipping documents, 5 years for inspection records)

Acme Co: Tractor 685

Engine Sub Assembly

Engine harness

Step 16

Tools required

Open end wrench 5/16" 1/2"

Socket 7 MM

P/N	Description	Qty.

a. Connect the harness to the alternator.

1) Top: Red large cable

2) Middle: Black small cable

3) Bottom: Yellow small cable

Note: The grey cable connects to the air conditioning unit below.

16 Rev: D

SpecSys

Engineering and Manufacturing

Done Safely

At SpecSys we take safety very seriously. Not only is it our duty to our employees and visitors, we know that without a safe work environment, meeting our clients’ needs would be difficult. Therefore, we have the following safety initiatives:

- AWAIR Program
- Weekly “tool” box talks
- TRIR metrics
- PPE Requirements (company provided):
 - Eye protection
 - Fall protection
 - FRC
 - Hand protection
 - Hard hats (if required)
 - Hearing protection
 - Safety shoes
- Respiratory protection program
- Hearing conservation program
- Forklift/truck safety program
- Permit-required confined space entry program
- Lockout/Tagout program
- Hazard communication (Right-to-Know) program
- Material safety data sheets
- Emergency action plan
- Fire prevention plan
- Portable fire extinguisher program
- Weapons prohibited policy
- Substance abuse policy (includes pre-employment screening, cause screening, post accident screening and random screening)
- Training
 - First aid/CPR/AED
 - Blood borne pathogens
 - Hazard communication
 - Electrical safety
 - PPE
 - Lockout/Tagout
 - Fall protection
 - Forklift certification
 - Lifting safety
 - Rigging safety

OUR LOCATIONS

Address	Area (sq. ft)	Employees
121 North 1st St. Montevideo, MN 56265	29,000 (HQ, office)	30
2120 Broadway N New Ulm, MN 56073	65,000 (mfg.)	50
1123 Hwy. 212 W Granite Falls, MN 56241	125,000 (mfg.)	45
474 Birch Street Prentice, WI 54556	210,000 (mfg.)	67
3535 Plymouth Blvd Unit 211 Plymouth, MN 55447	6,000 (office)	6





Headquartered in Montevideo, MN, RVI, Inc. has over 25 years of experience as a full service provider of custom electrical wire harness production, test, and custom cable box production.

Our humble beginnings started with OEMs and system integrators, servicing electrical type products; power supplies, communication cards, network switches, disk drives, automatic test equipment, audio, digital projection equipment, and more.

Learn more at www.rvi-inc.com.



RITALKA, Inc. is a business holding company based in Montevideo, Minnesota. It is 100 percent owned by Kevin R. Wald.

The company in turn owns and provides human resource, IT, finance and facilities management services for several subsidiaries, including SpecSys, RVI and Integral dx.





Our mission:

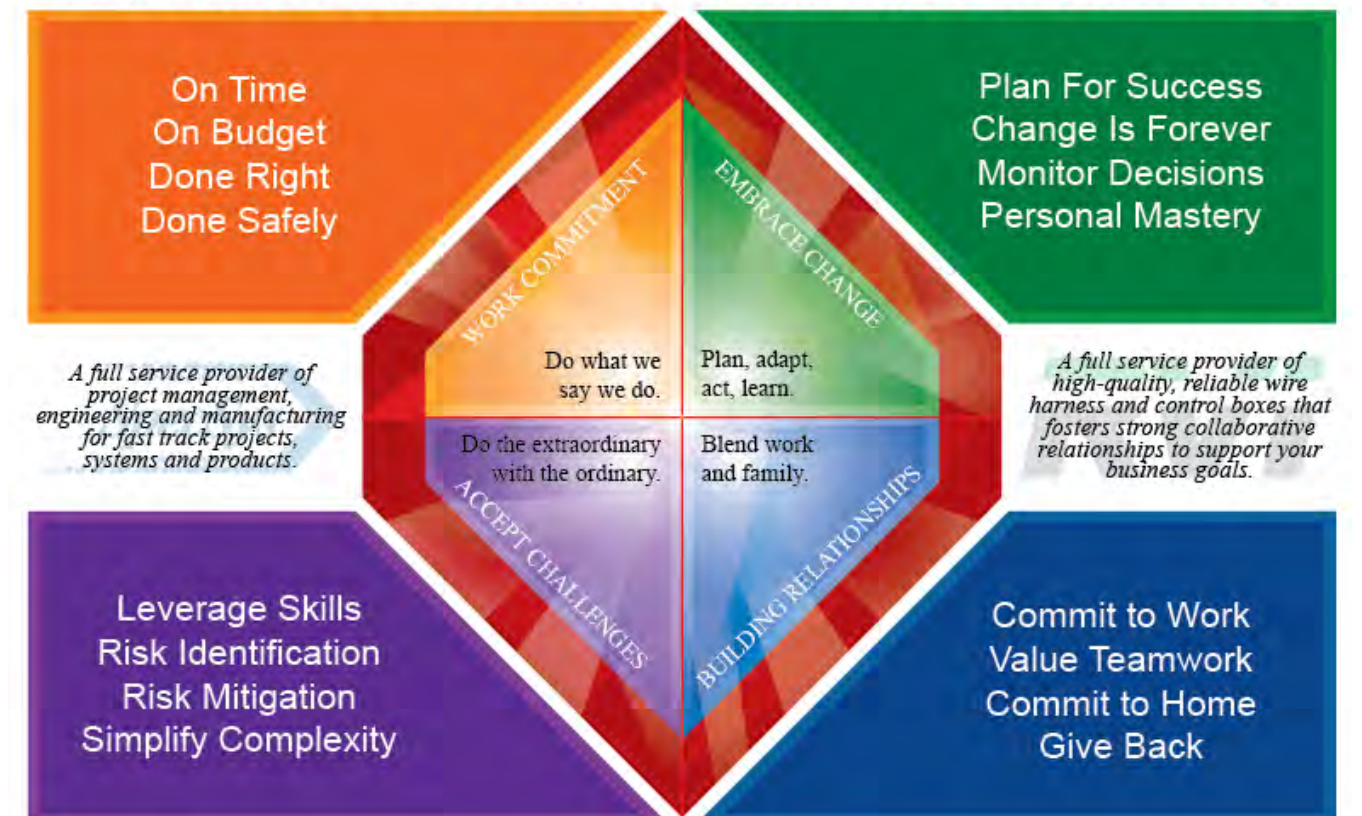
To be a full service provider of project management, engineering and manufacturing for fast track projects, systems and products.

Our vision:

Embrace those who respect, honor and value relationships.



Vision Statement: Embrace those who respect, honor, and value relationships.



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