



On the instructions of Sean Bucknall and Graham Randall of Quantuma the joint administrators of JD Norman Lydney Limited

## Greensand Casting Foundry and Finishing Machinery for the Production of Chilled/Ductile Iron Camshaft Castings

(Subject to availability)



Foundry Building

**\*Please be aware that this is a PPE site – visitors must wear adequate PPE at all times\***

**ONLINE AUCTION:** To bid please go to [www.lsh.co.uk/mba](http://www.lsh.co.uk/mba) or

**BidSpotter.co.uk**

**AT:** JD Norman Lydney, Tutnalls St, Lydney, GL15 5PX

**ON VIEW:** Monday 28<sup>th</sup> and Tuesday 29<sup>th</sup> September 2020, 10am to 4pm

**BIDDING ENDS:** Thursday 1<sup>st</sup> October 2020 at 1pm

**CLEARANCE:** **BY APPOINTMENT ONLY** - Monday 5<sup>th</sup> to Friday 16<sup>th</sup> October 2020, 10am to 4pm (excluding weekends)

**FURTHER INFO:** Adam Marx T: +44(0) 7799 587216 E: [amarx@lsh.co.uk](mailto:amarx@lsh.co.uk)

Jason Hall T: +44(0) 7929 141863 E: [jhall@lsh.co.uk](mailto:jhall@lsh.co.uk)

**BID ENQUIRIES:** MBA Accounts T: 023 8046 1643 [mbaaccounts@lsh.co.uk](mailto:mbaaccounts@lsh.co.uk)

**OFFICE ADDRESS:** 1<sup>st</sup> Floor, Tower Wharf, Cheese Lane, Bristol, BS2 0JJ

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[www.lsh.co.uk/mba](http://www.lsh.co.uk/mba)

The property, plant and machinery specialist

## **Facility & Equipment to include:**

(Subject to Availability)

JD Norman Lydney was a leading manufacturer of semi-finished, chilled grey iron camshaft castings primarily for automotive, industrial, and motorcycle engine applications. Prior to closure the Company served a blue-chip customer base including Ford (through Linamar), Jaguar Land Rover and Volvo.

## **The Facility**

Comprising a fully equipped manufacturing facility extending to a total of 64,000 sq ft (5,948 sq m) on a site of 16.35 acres. The self-contained foundry building extends to 42,500 sq ft (3,950 sq m) with the balance of the accommodation comprising a finishing shop and administrative offices. Approximately 12.6 acres of the site is owned freehold, to include the foundry, and part leasehold which includes the finishing shop and offices. Recent Annual Net Sales for the operation were c.£21 million.

The greensand foundry was constructed in 1991 at a cost of £11.5M and has benefitted from upgrade programmes in recent years. Capacity exists to produce approximately 5 million chilled iron camshafts per annum. The large box size provides flexibility to cast a wide range of engine, transmission and driveline products. Secondary operations at the plant include fettling, end facing, and deep-hole drilling.



The Foundry Building



Aerial View of Site

The principal plant and machinery includes:

## **Foundry**

### **VIP Room**

- Inductotherm 3,000kW Power-Track Induction Furnace, complete with Transformers and Rectifiers (Year 2018) –Installed cost £520k GBP
- (2) Inductotherm 2,500kW Power-Trak Induction Furnaces, complete with Transformer and Rectifier (year circa 1992)

### **Furnace Area**

- (2) Inductotherm electric 4-tonne induction furnaces; The furnaces have a melt rate of 4,200 kg/hour



Vibratory Hopper Feeders 2-off with outfeed to furnaces



Inductotherm Powertrack Induction Furnaces, 4 tonne capacity 2,500 to 3,000Kw, 3-off (1991-2018)

## Robots

- (2) Fanuc R-2000iB 6-axis robots/chill placing robots with Eclipse Magnetics attachment with 2 x R-30iB robot controllers;
- (1) Fanuc B-J2/ Arc Mate 120i filter placing robot with Fanuc A05B-2375-B007 and (1) Fanuc R-J3 oil spray robot with robot controller;

## Moulding and Shot Blasting

- BMD Dynapulse moulding line with a mould size of 812x812x250mm and capability of moulding components with a maximum length of 760mm; The moulding line casts seven to nine camshafts per mould at a gross line speed of 160 moulds per hour
- General Kinematics (GK) shaker/ mould knock-out machine;
- Spencer & Halstead rotary shot blast machine with monorail infeed and outfeed system.

## Sand Plant

- Sand plant with (3) storage silos, (2) back storage silos; Eirich DW2914MZ9 sand mixer; UHDE DWF sand cooler

[Click here for video presentation](#)

## Finishing

The principal items of finishing machinery comprise:

- (14) Koyama automatic grinding machines (2004 to 2012);
- (3) TIBO E15-6-1000TU 6-spindle deep hole run drilling machines (2012);
- (2) TIBO/ TBT M320-6-1200 6-spindle deep hole gun drilling machines
- TIBO/TBT 2T30/320-4-630 4-spindle deep hole gun drilling machine;
- Bliss Ryder Twin Station Automatic end facing machine with 4 cutting heads;
- Mollart Sprint 2-spindle deep hole gun drilling machine;
- Mollart MD4 4-spindle deep hole gun drilling machine (1997);
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- (8) Marpol 666 double ended pedestal grinder/polisher machines;

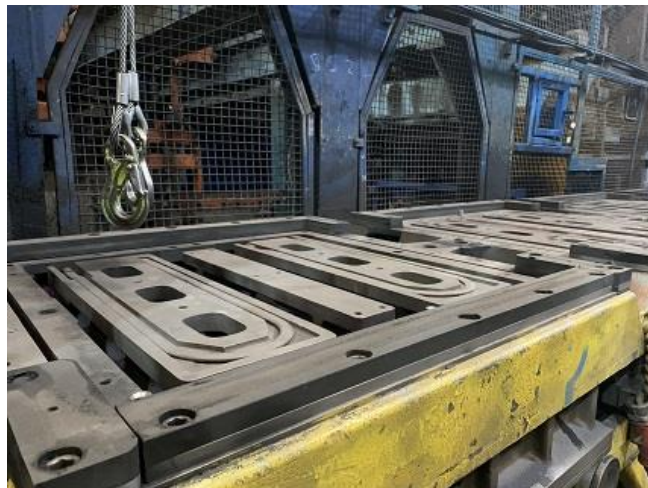
## Vehicles

- Barford SX6000 6T Dumper Truck (Year 2006)
- CASE JX80 Tractor with Q35 Bucket Attachment (Year 2006)
- AW Engineering 7T S&R Twin Axle Trailer (Year 2005)
- ABBEY 2-wheeled Bowser (Year 2007)
- Citroen Relay Drop-side van (Year 2012)

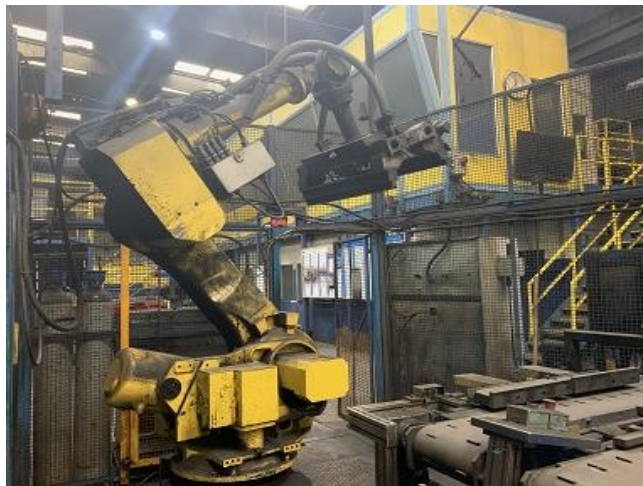
Circa £500,000 (at cost) of Spares, Laboratories, Workshops, Quality Control, Standby Generator, Air Handling and Internal Craneage Throughout.



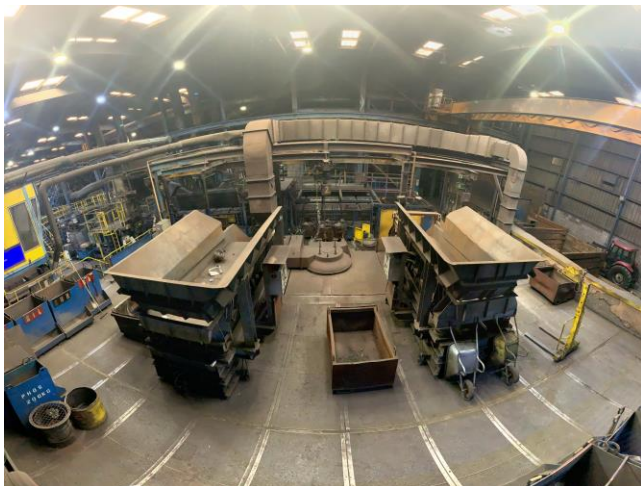
Internal view of inside Foundry



BMD Dynapuls automated conveyor moulding plant



Fanuc R-200ib multi axis loading insert robots



Vibratory Hopper Feeders 2-off with outfeed to furnaces



Vibratory Hopper Feeders 2-off with outfeed to furnaces



Inductotherm Powertrack Induction Furnaces, 4 tonne capacity 2,500 to 3,000Kw, 3-off (1991-2018)



Spencer & Halstead rotary 4 compartment shot blast machine



Spencer & Halstead rotary 4 compartment shot blast machine



Spencer and Halstead rotary shot blast machine with monorail infeed and outfeed system



Sand Plant Air Handling systems



Tibo multi spindle gun drills, 6-off 2001 - 2012



Tibo multi spindle gun drills, 6-off 2001 - 2012



Tibo multi spindle gun drills, 6-off 2001 – 2012



Tibo multi spindle gun drills, 6-off 2001 – 2012



Koyama Barinder 400 auto grinders, 14-off 2004 – 2012



Mollart multi spindle gun drills, 3-off (1970'2 to 1997)



Bliss Ryder end face miller (1970's)



Cast cam shaft product examples



Compressors by Atlas Copco and Air solutions, 6 off



Case IH JX80 tractor (2006)



Citroen Relay 35 dropside lorry (2012)



Abbey twin axle bowser (2006)



AW Trailers twin axle trailer (2005)



Barford SX6000 dumper (2005)