By Order of the Joint Administrative Receivers
W R Tacon and A J Wolstenholme of Ernst & Young
re: Dexion Limited
(In Administrative Receivership)

FOR SALE

Phase 1 – Immediate Private Treaty Sale
Modern Roll Forming and Automatic Welding Lines, Paint Spray Plant and Equipment

Phase 2 – Live Webcast Auction Sale
Sheet Metalworking Machinery, Toolroom, Power Presses, Office & Factory Furniture and Equipment

At: Maylands Avenue, Hemel Hempstead, Hertfordshire, England
Auction to be held on: Wednesday 3rd September 2003 at 11:00am
View: Tuesday 2nd September 2003 from 9.00am to 4.30pm and on morning of sale
Immediate Private Treaty Sale - Phase One

Formit ‘Stop/Start’ Bracing Rolling Line
Atkin’CD2000-300’ Twin Decoiler,
Capacity 2 x 2t x 300mm
Atkin ‘MS58-150’ Strip Leveller,
Capacity 150mm x 3mm
Formit Hydraulic Punching Station,
Formit Rafted, 8 Stand Roll Forming Line,
BHP Hydraulic Punching Unit and Shear,
Atkin/BHP Control (1998), with Indramat CLM.
Powered Outfeed Conveyor

Proma Open Beam Rolling Line
Bradbury Twin De-Coiler – with Hydraulic Expansion,
Proma ‘RP2 1/2RR’ 15 Station Roll Forming Line with Mechanical Automatic Cut-Off Flying Shear with Indramat CLM Control.
Roll space of 410mm.
Erwin Sick Light Guards on Mill.
Mechanical End Flag over Run Out Conveyor

Arm Boxed Beam Rolling Line
Heeley Twin De-Coiler:- Mechanical Expansion,
Arm 10 Station Roll Forming Line with Mechanical Automatic Flying Shear, Boxing Unit, Take Off Table, Marpall PC Control for Mechanical End Flag.
Roll Space of 380mm

Bigwood Upright Rolling Line
Atkin CD5000L-450 Twin Decoiler,
Capacity 2 x 5t x 450mm
BHP ‘MS59-450’ Strip Leveller,
Capacity 450mm x 4mm
Atkins Photoelectric Loop Control,
Rhodes ‘S2-100-40-30’ 100-Ton Double Sided Press with BHP Servo Feeder,
Atkins Photoelectric Loop Control,
Bigwood 16 Stand Roll Forming Line, Mechanical Automatic Flying Shear and Take-Off conveyors,
Indramat CLM control, Erwin Sick light Guards on Mill.
Roll Space of 520mm

Comac Automatic Shelving Line (D38)
Coil carriage
1St x 39” Hydraulic Decoiler & Snubber,
Leveller – 13 roll,
Guillotine unit – for trimming start & end of coil
Loop control – light sensors in pit,
Safe edge rollformer,
Loop control – light sensors in pit, Unico roll feed
Pierce & blanking press – Taylor & Challen DS4 – 150 - 2000 – 1600, 100mm stroke, 60 strokes per min.
Stacker unit
Conveyors for accumulation
90-degree turnover unit, vacuum lift and feed unit
22 pass rollformer, Feed unit
Form press - Taylor & Challen DS4 – 150 - 2000 – 1600, 100mm stroke, 60 strokes per min.
Outfeed conveyor and twin pallet stacking station. (Installed 1979)
Immediate Private Treaty Sale - Phase One

Register online @ www.henrybutcher.com

Durmech 622mm X 1.625 mm Cut-To-Length Line
- Bigwood 7-Ton Coil Entry Loading Car
- Bigwood Twin Mandrel Decoiler – Hydraulic Expansion
- Durmech 13 Roll Leveller and Pinch Roll
- Looping Pit control, Durmech Measuring/Feed Rolls
- Hydraulic Punching Station(s)
- Atkin High Speed Blanking Press
- Durmech Upcut Shear and Outfeed Conveyor
- Excel blank stacking/tamping unit
- AG Designs / TOLEC PC Control

Divider Roll Forming Line – (Part & Full Height)
- Oliver ‘9FLB12Y-96’ 9 Stand Roll Forming Line,
  Parker Guillotine, side shift & 12 Stand
- Oliver Roll Former, Mitsubishi PLC Control

Rollsec Shelf Panel Roll Forming Line
- Rollsec ‘RSD 9082D’ 20 Stand Duplex Panel Forming Line with Vacuum Sheet
  Lift/Feeder, Infeed Conveyor and Two Folding Stations, Outfeed Conveyor. (1996)
- Mitsubishi PLC Control

Stam Longspan Rolling Line
- Maskin ‘M-300-2’ Strip Leveller
- Maskin ‘MV750-300-2’ Strip Feeder
- PMB ‘EPF-54’, 60-Ton Eccentric Blanking Press, 90 SPM – with SMV Control
- Stam 16 Stand Duplex Roll Forming Line
- Stam Hydraulic Flying Shears and Take-Off with SMV Indramat CMT Control
  (Refurbished 2000)

Perkins Upright Rolling Line
- BHP 1676 x 250mm x 3t Twin De-Coiler – Mechanical Expansion
- BHP Strip Leveller
- K&T CVA 50t Dieing Machine with Mechanical Strip Feeder
- Perkins 14 Stand Roll Former with Flying Saw and Cut-To-Length
- Roll Space of 370mm
- Erwin Sick light Guards on Mill

Pro/Eco Rafted Upright Rolling Line
- Pro/eco 10-Ton Coil Entry Loading Car.
- Pro/eco ‘SHH20T220’ 10 Ton Hydraulic Decoiler
- Pro/eco Peeler Table and Snubby, Pro/eco Strip Leveller
- Atkins Photoelectric Loop Control in Pit,
  Blow Press 300-Ton Double Sided Power Press with BHP Roll Feed using Indramat CLM Control
- Atkins Photoelectric Loop Control in Pit,
  Pro/eco Rafted Roll Forming Line with 4 Sets of Rafts
- Pro/eco Mechanical Automatic Flying Shear.
- Indramat CLM Control
- Run Out Conveyors
Immediate Private Treaty Sale - Phase One

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Stam Longspan Rolling Line

Perkins Upright Rolling Line

Semi-Automatic Robotic Welding Line

Cold Reduction Rolling Mill
Robertson 4 High, Single Stand Cold Reduction Mill with Coil Entry
Twin coil mandrel
Coil car
Decoiler
Edge deburr unit
Reduction mill - 4 high single pass, non reversing, 40m/min max speed
100 Tonne capacity, 13” (330.2mm) max. strip width
Automatic gauge control – flying micrometer
Main drive motor – Bull 180 HP
Re-coil unit
Coil car & outfeed chutes
Spare work & backup rolls
Coolant system
Controller – Control Techniques

Elctropaint / Itw Powder Coating Plant(S)
Twin line electrostatic powder coating facility including:

Specification:

Line 1 – Suited to long, thin stick products, max length of 3750mm
Line 2 – Used for panel and stick products, max length of 3100mm
Pre-treatment – Twin line four stage force spray type
Dry off oven – Gas Fired, common for both lines
Natural cool – Run off conveyor for cooling
Forced cool – Fan assisted
Powder coating equipment –
(4 off) RORO booths, (2 off) CRS, (2 off) MRS – one with windows for manual application. Manufactured by ITW Gema, 97% powder utilisation on the CRS booths, 95% powder utilisation on the MRS booths
Fully automatic reciprocator system x 2 per Booth, 32 guns per reciprocator
Two spare cartridge assemblies for CRS booths

Powder curing ovens – Multi pass conveyed floor mounted gas fired
Natural cool – High level conveyor
Offload Line 1 – Two off ABB ‘Rex’ IR2400 handling robots with accumulation and conveyors
Offload Line 2 – Manual offload
Gas fired Hook burn off unit – For removal of powder on Line 1 hooks
Overhead Conveyor – supplied by Jade, type - 50K

Conveyor Speeds – Line 1: 3.1m/min, Line 2: 5m/min – line is configured to run 25% faster

Robertson Cold Reduction Rolling Mill
Immediate Private Treaty Sale - Phase One

Register online @ www.henrybutcher.com

High Speed Gantry Welding Line

Infeed conveyor, Automatic pick and place, Two welding positions (i.e. 1 beam welded complete per stroke)
(8) Welding Heads with Murex 4HD Transmatic Wire Feed Units
(8) ESAB Lag 315 welding sets
Automatic Beam Eject
Erwin Sick Light Guarding
Allen Bradley PLC and Panel Views
Torit Extraction equipment (x2)
(Refurbished in 2001 – mechanical & electrical)
Beam cycle time of approx. 30 seconds

Semi-Automatic Robotic Welding Line

(2) Robotic Welding Lines each with (3) Welding Cells, Beam End Connector
Magazines, Infeed system, spine conveyors and exit conveyors
Each Cell Includes:-
(2) ABB ‘IRB1400’ M98 Robotic Welders with ‘A134’ Wire Feed Units
(1) ABB ‘IR2400’ Handling Robots
Line control via Allen Bradley PLC’s and Panel Views
Beam cycle time of approx. 26 seconds/cell/line

<table>
<thead>
<tr>
<th>Line</th>
<th>Manufacturer / model</th>
<th>Product made</th>
<th>Min gauge</th>
<th>Max gauge</th>
<th>Max width</th>
<th>Theoretical max gauge</th>
<th>Passes</th>
<th>Roll shaft Dia</th>
<th>Vertical ctrs</th>
<th>Horizontal ctrs</th>
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<tr>
<td>Open beam line (Proma - No2 line)</td>
<td>Proma</td>
<td>Open beams</td>
<td>1.7</td>
<td>2.5</td>
<td>263</td>
<td>3</td>
<td>15</td>
<td>76.2</td>
<td>114-267</td>
<td>457</td>
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<tr>
<td>Boxed beam line (ARM)</td>
<td>ARM</td>
<td>Boxed beams</td>
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<td>2</td>
<td>251</td>
<td>3.5</td>
<td>10</td>
<td>76.2</td>
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<td>Bigwood</td>
<td>Uprights</td>
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<td>3.1</td>
<td>261</td>
<td>4</td>
<td>16</td>
<td>76.2</td>
<td>165-330</td>
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<tr>
<td>Upright line (No3 line Pro eco)</td>
<td>Pro-eco</td>
<td>Uprights</td>
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<td>4</td>
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<td>4.5</td>
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<td>Uprights</td>
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<td>2</td>
<td>8</td>
<td>76.2</td>
<td>TBA</td>
<td>TBA</td>
</tr>
</tbody>
</table>

The above lines have previously been used in the manufacture of the above listed products

For further details please contact:-

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ABB Handling Robots
CNC and Conventional Press Brakes

Amada ‘ITP1030’ 100 Ton x 3m CNC with Sick Light Guards and EMA CNC Control (1988)
Promecam ‘RG65.30’ 65 Ton x 3m CNC with Sick Light Guards and Hurco ‘Autobend’ CNC Control
Promecam ‘ITP2’ 100 Ton x 3m CNC with Sick Light Guards and EMA CNC Control
Promecam ‘RG5020’ 50 Ton x 2m Hydraulic with Sick Light Guards
Bronx 110 Ton x 10ft Hydraulic Upstroke with Light Guards
Bronx 60 Ton x 8ft Mechanical with Light Guards (Qty 2)
Bronx 40 Ton x 6ft Mechanical with Light Guards

CNC Turret Punch Presses

Shape Omega ‘Index Rota’ CNC with Siemens Shumerik System 3 CNC Control, 20 Ton Turret, 2 Auto Index Stations (Qty 2 1988 & 1984)
Versatile ‘PG-8’ Universal Die and Punch Grinder

Guillotine, Metalworkers and Folder

Elga ‘Hydrashear’ 6ft x ¼” Hydraulic Guillotine
Mubea ‘KBL11N’ Universal Metalworker
Mubea ‘Junior BF10’ Universal Metalworker
Edwards ‘618’ 6ft x 18 swg Box and Pan Folder
Fenco 8” x 8” Hydraulic Corner Notcher

UNABLE TO ATTEND
Bid live online with

www.henrybutcher.com
Welders and Ancillary Equipment

ESAB ‘LAN400’ 400amp Mig with Fine Wire Feed
ESAB ‘LAN315’ 315amp Mig with Fine Wire Feed (Qty 3)
Kemppi ‘RA450’ 450amp Mig with Fine Wire Feed
PW ‘SP30’ 30kva Spot Welder (2000)
Cebora ‘PROF 36M’ plasma Welder
Maxarc and Oxford Arc Welding Sets (Qty 3)
Sangre and Nederman Portable Welding Fume Extractors (Qty 3)

Roll and Lock Formers

Bulldog SMC 6 Station Heavy Duty Roll Former
Oliver ‘W14977’, ‘OMBP178W79’ and ‘L124LD95’ Lockformers (Qty 3)

Power Presses

Rhodes ‘S2-100-40-30’ 100 Ton Double Sided Mechanical
Rhodes ‘S2-150-60-36’ 150 Ton Double Sided Mechanical
Cincinnati Milacron ‘G100’ 100 Ton O.B.Fixed, Adjustable Stroke, Udal Guards
Cincinnati Milacron ‘G55’ 55 Ton O.B.I, Adjustable Stroke, Udal Guards (1975)
Cowlishaw Walker 80 Ton Double Sided Power Press

Ancillary Press Equipment

Atkin BHP ‘MS59-150X’ Strip Leveller and Decoiler (1999)
BHP ‘16DSCH’ 2 Ton x 400mm De-Coiler and Strip Leveller
BHP 250 x 3.2mm and 4mm Strip Levellers (Qty 2)
BHP 150 x 4.8mm De-Coiler and Strip Leveller (Qty 2)
Atkin ‘SP150’ De-Coiler and Strip Leveller (Qty 3)
Atkin ‘SCD’ 2000-300 Twin De-Coiler (Qty 2)
Atkin BHP ‘MS59-150X’ Strip Leveller (1999)

Toolroom Machinery

Colchester ‘Mastiff’ 1400 x 72” SS & SC Gap Bed Lathe with Ainjest Threading
Harrison ‘190’ x 50” SS & SC Gap Bed Lathe
Colchester ‘Student’ SS & SC Gap Bed Lathe
Sajo ‘300’ Swivel Head Vertical Milling Machine with Table 330 x 1500mm and 2 Axis DRO
Sajo ‘VF54M’ Swivel Head Vertical Milling Machine with Table 330 x
1500mm and 2 Axis DRO
Stefor ‘RV1000’ Vertical Wet Table
Segmented Wheel Surface Grinder
Jones and Shipman ‘1311’ 10” x 21”
Universal Cylindrical Grinder with Internal Grinding Attachment
Jones and Shipman ‘540’ 6 x 18”
Surface Grinders (Qty 3)
Elliott Burdett ‘Rapidgrind’ 12 x 24”
Surface Grinder
Guyson ‘DBH 140’ Bead Blaster with Dust Unit
50 Ton Manual Hydraulic Workshop Press, Mandrel and Fly Presses (Qty 5)
Pollard Corona ‘15AY’ Pedestal Drill (Qty 2)
Elliott Heavy Duty Pillar Drill
Meddings ‘MB4’ Bench Drill, Bench and Cabinet Grinders and Linishers
Desoutter / Dexion 4 Spindle Pneumatic In-Line Drill

**Sawing Machines**
Kaltenbach ‘KKS400’ Cut-Off Saw with Cut-to-Length (Qty 2)
Speedax 18” Vertical Bandsaw
Thomas ‘Flash 2’ 150mm Horizontal Bandsaw
Elu, Mod & Dewalt Cut-Off Saws (Qty 4)

**Plate Glass Washer**
Contract Development and Project ‘1-3 Empire’ Plate Glass Washing Machine with Inspection and Deionising Vacuum Plate Glass Lifting Units (Qty 2)

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Contract Developments and Projects ‘1-3 Empire’ Plate Glass Washer

SMC 6 Station Roll Former

Rhodes’S2100-40-30’ Mechanical Power Press

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**September Auction Sale - Phase Two**

Webcast Available @ www.henrybutcher.com
CNC Router
Rye ‘MG2400’ CNC Four Head with Table 1280 x 2440mm, Bosch ‘Alpha CRT’ CNC Control and Dust Collection Unit, Trunking and Fittings (1988)

Compressors
HPC ‘DS140’ Totally Enclosed Rotary Screw (Qty 2 1997 & 1994)
HPC ‘CS76’ Totally Enclosed Rotary Screw (Qty 2 1997)
Hiross ‘Polestar’ and ‘Drystar’ Air Dryers (Qty 2 1997 & 1994)
Welded Steel Air Receivers (Qty 2)

Internal Handling
Yale ‘ERC 40 AKE V3785’ 4000kg Electric Long Mast Fork Lift Truck with Side Shift (1995)
Yale ‘ERC 30 AGEE 2110’ 3000kg Electric Triple Mast Fork Lift Truck (Qty 2 1992)
Henley 15 Ton Diesel Fork Lift Truck
Manual Hydraulic Pallet Trucks (Qty 7)
5, 14 and 15 Ton Coil Crane Carriers (Qty 4)

Shrinkwrap Machines
Vacuum Pump ‘AM80N’ Film and Shrinkwrap Tunnel with Packseal Band Strapper (2001)
Vacuum Pump ‘AM160N’ Film and Shrinkwrap Tunnel with Conveyor etc (2001)
Vacuum Pump Portable Shrinkwrap Tunnel (2001)

UNABLE TO ATTEND
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Rhodes ‘S2-150-60-36’ Mechanical Power Press
HPC ‘DS140’ & ‘CS76’ Rotary Screw Compressors
DCE ‘Unimaster G8’ Unit Dust Collection Unit

Register for the Catalogue Online @ www.henrybutcher.com
September Auction Sale - Phase Two

Miscellaneous Equipment
Gate 1½” Manual Hydraulic Hose Crimper
Pakseal Twin Pallet Carousel Film Wrapper (1997)
Hymo 10’ x 4’ Hydraulic Scissor Lift
Megamat ‘130/300/26’ and ‘132-342-30’ Paternoster Storage Units
(Qty 4 to 1986)

Engineers Loose Tools and Equipment
Including Taps, Dies, Milling Cutters, Twist Drills, Reamers, Punches, Files, G Clamps, Nuts, Bolts, Cap Screws, Angle and Bench Grinders, Micrometers, Surface Plates, Height Gauges, Stilsons, Single Beak Anvil, Brazing Torch and Hearth, Abwood Machine Vices, Rotary Tables, Pipe Vice, Brothers, Slings, Plate Clamps, Eye Bolts, Transformers, etc.

Mezzanine Floors
Dexion Mezzanine 50ft x 25ft with 2 Access Stairways and Guard Rails
Dexion Mezzanine 55ft x 45ft with 2 Access Stairways and Guard Rails

Factory Equipment
Including, Extensive Dexion Speedlock Pallet Racking and 9 high carousel Component Systems, Dexion Benches and Multi Drawer Tool Cabinets, Lin Bins, Strapping Machines, Trollies, Stillages, Glass Racks, Sip ‘Pneumatic’ Parts Washer, Oxy Bottle Trollies, Eli Lift Hydraulic Platforms, Personal Lockers, Nilfisk Vacuum Cleaners, DCE Unimaster ‘G5’ and ‘G1’ Dust Collection Units, Steel Cased Twin Section Dust Extraction Unit, Access Warehouse Steps, etc.
OHET Cranes and Swing Jibs
Street 7.5 Tonne Single Beam 40ft Span with Pendant Control
Morris 5 Ton Single Beam 35ft Span with Pendant Control
Allen 5 Ton Single Beam 35ft Span (Qty 2)
125kg Free Standing Swing Jibs (Qty 2)
125kg Single Beam 15ft Span with Vacuum Plate Lifting Unit

Office Furniture and Equipment
Extensive Oak and Grey Laminate Desks, Laminate and Glass Topped Tables, Double and Single Door Cupboards, Filing Cabinets, Reception Chairs, Extensive Computers and Business Machines, etc.

Canteen Equipment
Falcon and Bartlett Stainless Steel Gas Ovens, Steakhouse Grill, Chip Fryer Stainless Steel dishwasher, Microwave, Mixers, Bain Maries, Sadia Upright Refrigerators, Preparation Tables, Racking, Pots, Pans etc
Directions
From M1 leave at junction 8 signposted Hemel Hempstead A414. Proceed over 1st roundabout and take 3rd exit at second roundabout. Over two sets of traffic lights and the works are about 1/4 mile on right hand side.

Important Notice
Although information has been obtained from sources deemed reliable, Henry Butcher make no warranty or guarantee, expressed or implied, as to the accuracy of the information contained herein.

Clearance
All lots must be cleared without fail by Friday 18th September 2003.

Conditions of Sale
All goods will be sold in accordance with the auctioneers standard conditions of sale which will be detailed in the sale catalogue. Further information will be available on request.

Buyers Premium
A Buyers Premium of 10% + VAT is charged to the Purchaser. An additional 3.5% will be charged to Webcast Purchasers.

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