



DAVID REEKIE & SONS LTD

INCHINNAN BUSINESS PARK

RENFREW, PA4 9RL

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Machine Shop Plant List 2020

CNC machining and conventional machining is available from our 1850 m² subcontract machining facility adjacent to Glasgow Airport. Our machine shop offers quick turnarounds on components from a range of materials in various quantities, from reverse engineering and one-offs to batch runs. If your component is out with our capacity our insitu machining service may be an option, please contact one of our project engineers.

CNC LATHES				
Machine	Max Turning Diameter	Max Turning Length	Max Swing Cross Slide	Max Dia Through Spindle
Eagle 100 fitted with bar feeder	200mm	300mm	-	40mm
Takisawa Ex 110	370mm	800mm	-	80mm
Daewoo Puma 12L fitted with bar feeder	480mm	1020mm	-	77mm
Broadbent Stanley BS 25120 (Max 1.7T)	630mm	2810mm	400mm	85mm

CENTRE LATHES					
Machine	Max Turning Diameter	Max Turning Length	Max Swing Cross Slide	Max Dia Thro' Spindle	Threading
Colchester Student	330mm	650mm	200mm	40mm	Metric & Imperial
Gate – Eclipse Model 8460-C (with digital readout)	400mm	1500mm	280mm	80mm	Metric
Colchester Mascott	460mm	1400mm	260mm	75mm	Imperial
Colchester Magnum	635mm	4000mm	390mm	119mm	Metric & Imperial
Dean Smith & Grace fitted with digital readout	820mm	3660mm	500mm	100mm	Imperial

VERTICAL BORERS					
Machine	Max Turning Dia	Max Turning Length	Taper turning	Max weight of work piece	Notes
Webster Bennet fitted with digital readout	1220mm	585mm	Yes		Table size: 1220mm (4 foot)
GLF 5ft CNC VB	1524mm	1500mm	Yes		Table size: 1524mm (5 foot)
Broadbent (Double Column) fitted with digital readout	2642mm	1270mm	Yes	8 Tonnes	Table size: 2463mm (8 foot)

HORIZONTAL BORERS				
Machine	Working Envelope (Travel)			Table Dimensions
	X	Y	Z	
Giddings Lewis fitted with digital readout	2100mm	1400mm	1590mm	1220 x 2500mm Rotary table: W920 x L1520 x H330mm Spindle: BT50, Facing head: 660mm

5-AXIS MACHINING CENTRE				
Doosan DNM 350-5AX	Working Envelope (Travel)			Control: Fanuc i , Spindle: BT40 Max spindle speed: 12000 rev/min Max work piece size: Ø400 x 355
	X	Y	Z	
	400mm	655mm	500mm	
	A axis (Table Tilt)		C axis (Rotary)	



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	150° (+30° / -120°)	360°	
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VERTICAL MACHINING CENTRES				
Machine	Working Envelope (Travel)			Notes
	X	Y	Z	
Hardinge VMC 600II	500mm	500mm	500mm	Control: Fanuc OTC, Spindle: BT40 Table: 750 x 510mm Spindle Speed: 8000 rev/min
Haas TM1	762mm	305mm	406mm	Control: Haas, Spindle: BT40 Max Spindle Speed: 4000 RPM Table: L1213 x W267
DMC 103V	1000mm	600mm	600mm	Control: Heidenhain, NC426/430 Spindle: SK40 Spindle Speed: 8000 rev/min Table: 1200 x 600mm
Sorulace TA-25	2500mm	1000mm	1000mm	Control: Heidenhain iTNC 530 Spindle: BT 50 Max Spindle Speed: 3000 RPM Accessories: 4 th Axis with 620 Dia chuck c/w 250 Dia Spindle Bore
Dugard Eagle SDV - 3219	3200mm	1900mm	1000mm	Control: Fanuc 21i, Spindle: BT50 Max Spindle Speed: 4000 rev/min Table: 3000 x 1700mm Accessories: Right Angle Head (reduces Z-axis envelope to 700mm)

CNC MILLING				
Machine	Working Envelope			Notes
	X	Y	Z	
XYZ 4000 Bed Mill	1000mm	500mm	640mm	Control: Prototrak Spindle: BT40 with drawbar
Butler Elga Mill fitted with 4 th Axis table	3000mm	1140mm	1000mm	Control: Fagor, Spindle: BT50 Accessories: 810mm Rotary Table (4 th -axis)

CONVENTIONAL MILLING				
Machine	Working Envelope			Notes
	X	Y	Z	
Bridgeport Turret Mill	730mm	400mm	280mm	
Huron fitted with digital readout	1470mm	670mm	480mm	Table size: 460 x 2000mm Spindle: BT40 with drawbar

RADIAL DRILLS				
Kitchen & Walker	Working Envelope			Table size
	X	Y	Z	
	1450mm	Radial	1385mm	780 x 1220mm



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SPARK EROSION				
Machine	Working Envelope			
	X	Y	Z	
SM25 Sparcatron	300mm	600mm	350mm	

SURFACE GRINDING				
Machine	Working Envelope			
	X	Y	Z	
Jones & Shipman Model 540	200mm	150mm	460mm	
Churchill	1100mm	300mm	300mm	

CYLINDRICAL GRINDING				
Machine	Working Envelope			
	Max Turning Dia	Max Turning Length		
Jones & Shipman Model 1300	340mm	740mm		

Cutter and Tool Grinding				
Machine	Working Envelope			
	Work piece travel	Grinding wheel travel		
Jones & Shipman Model 310	150mm	200mm		

VERTICAL SLOTTER				
Machine	Working Envelope			Table Size:
	Stroke	X	Y	
Butler Slotter	406mm	990mm	990mm	990 x 990mm

HONING	
Delapena Autostroker vertical honing machine, model 276/P	Capable of honing diameters from 25.4 to 600mm with a 868mm stroke



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CMM capability				
Machine	Working Envelope			Volumetric accuracy
	X	Y	Z	
Aberlink Axiom 600	640mm	600mm	500mm	TP20 (2.4um + 0.4L/100um)
Faro Prime 8 foot Arm	Measurement Range	Repeatability		Accuracy
	2.4m	0.024mm		+/-0.034mm
Faro Vantage Tracker	Horizontal Scale Bar Measurement (2.3m wide)			
	Range (m)	2	20	80
	Maximum Permissible Error (mm)	0.044	0.170	0.594
	Typical (mm)	0.022	0.085	0.297

Welding / Fabrication	
BW3000 DC Orbital Welder	Materials Stainless / Alloy 600 / Hardox / Carbon Steel
Miller Synchrowave 300 TIG and Stick Welder	Materials Aluminium / Stainless / Alloy 600 / Hardox / Carbon Steel
Kemppi 2200 TIG and Stick Welder	Materials Stainless / Alloy 600 / Hardox / Carbon Steel
TECARC 186 DC TIG Welder	Materials Stainless / Alloy 600 / Hardox / Carbon Steel
Transmig 500	Materials Aluminium / Stainless / Alloy 600 / Hardox / Carbon Steel

Forklift	
Linde 8T Forklift	Fork capacity 8000kg Boom Capacity; 4000kg at 1400mm, 3000kg at 1800mm, 2000kg at 2200mm, 1500kg at 2600mm
Clark 2T Forklift	Fork capacity 2000kg Boom capacity 2032kg at 300mm, 2032kg at 500mm, 1850kg at 914mm, 1510kg at 1219mm
Hyster 1T Forklift	Fork capacity 1000kg Boom capacity 907kg at 350mm, 771kg at 500mm, 626kg at 650mm, 544kg at 800mm 404kg at 1160mm

Fitting	
Time Served Fitters	Part Assembly Work

Loading	
Main Door	Width 4.77m, Height 4.15m
Crane Hook Height	4.1m

Part Cleaning	
Vixen Aqua Blast	Width 915mm, Depth 720mm, Height 873mm

Hydraulic Press	
Slingsby	25 tonne capacity