



**Machinery for the Woodworking, Stone,  
Glass, Plastic, and Metalworking Industries**



**Date :** 04/25/2024 - 2:51 PM \*  
**EXF # :** PB-010395  
**Category :** PLANTS & BUSINESSES  
**Brand / Model :** WASHINGTON IRON WORKS "8 TPH"  
**Machine Type :** MDF DOOR SKIN MFG. PLANT  
**Year of Mfg. :**  
**Condition :** Good Condition  
**Elect / Voltage :** 480 V, 60 Cy, 3 Ph.  
**Special Note :** Hard to Find

**FOB / Region :** MIDWEST  
**Appr. Repl. Cost. :** \$ 40,000,000  
**Price :** \$ 0 \*  
**Comment :** A great way to make MDF on a smaller scale!  
**Leasing :** Contact NCL for quote



Please ask me

**Marcus Johansson**  
800-374-5009 ext. 355  
Intl. +1 704-841-2001 ext. 355  
marcus.johansson@exfactory.com

\* Pricing is valid at the time of printing and subject to change at any time.

### **Description :**

- **MDF Manufacturing Facility designed around making thin door skins and will make board products as well.**

The plant is complete with few exceptions and boasts the following features and major components:

This plant produces MDF fiber from wood chips delivered to the site by outside vendors. Such fiber is generated by a steam pressurized "digester" and pressurized disc refiner. The refined fiber is then dried and blended with resin. The furnish fiber is subsequently vacuumed formed onto a loosely woven conveyor belt sometimes called a "wire," a means similar to that utilized in a portion of the ubiquitous Fourdrinier method paper machine. The formed mat is trimmed to a precise size to be inserted into a press where door face sized dies in the press directly press a shape into the door skins.

The plant has two WASHINGTON IRON WORKS (WIW) production lines making door skins for two different applications. The main production line has a 6-opening, nominal size 6' x 8' press. The second production line has a 2-opening 4' x 20' press. Specific press details are shown below.

The main or primary line was producing (60) press loads or (720) door skins per hour and a wood consumption rate of 4 TPH. It can be assumed that the second line produces at approximately the same curing rate although not the same number of skins per hour. However, that line was not used after the company stopped producing door skins for garage doors.

**Sales - Liquidations - Auctions - Appraisals - Consulting**

**EX-FACTORY INC.:** 1805 Sardis Road North | Charlotte, NC 28270 USA | Ph +1 704.841.2001 | Fax 704.644.8068  
**Warehouse & Showroom:** 8191 Logistic Drive, Suite E | Zeeland, MI USA | Ph +1 616.772.1520 | Fax 704.644.8328



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The refining, drying and blending systems were configured to feed either the 6-opening press line or the 2-opening press line. However, these systems were not designed to feed enough material to run both lines concurrently.

There is a pre-finish flat line for painting the door skins automatically with little oversight by a roaming operator. The line is built in a serpentine layout with powered curved 90° corner transfers. Paint is applied by means of multi or "gang" sprayers placed over the panel and spray is activated by approaching panels. Multiple ovens dry or cure paint after each application of paint. Two paint "booths" or painting apparatus sections and two ovens were removed upon closure by the previous owner.

The previous owner removed some items upon shutdown or shortly thereafter. The real estate is not part of this offer, only the machinery. The major components are as follows:

**Refining** (Subject to prior sale.)

&#9679 **SPROUT BAUER Vertical Digester.**

&#9679 Horizontal Steaming Screw Digester (long ago abandoned for use in lieu of better vertical one).

&#9679 SPROUT BAUER Plug screw feeder.

&#9679 **1992 SPROUT BAUER 42" ICP Model Refiner** (no motor- available from other sources).

&#9679 Refiner Lube system.

&#9679 Refiner Operator's Controls.

&#9679 Refiner Main Motor Starter.

**Chip Storage** (Subject to prior sale.)

&#9679 2005 27' dia. X 80' high COLUMBIAN TECTANK Chip Silo with LAIDIG Model "298" Reclaimer (unloader).

&#9679 High Pressure transfer system from TECTANK.

**Auxiliary Systems**

&#9679 36 inch Hog. (Subject to prior sale.)

&#9679 CLARKES Fire Suppression System.

&#9679 GRECON Plugged Alert System.

**Blending**

&#9679 Blender Fiber Feed Bin.

&#9679 THAYER Scale at Blender infeed.

&#9679 DRAIS WERKE Chip and Resin Mixer, paddle type Blender. (Previous owner removed two attrition Blenders upon shutdown - Paddle Blender remains.)

&#9679 Blender Discharge Fan.

**Primary or Main Forming and Press Line**

&#9679 1992 WIW Mat Forming Machine with Vacuum Felting & Low Pressure Former Fan.

&#9679 1992 WIW Mat Shaver with Shave-off & Recycle Fan.

&#9679 1992 WIW Mat Former Shave-off Baghouse Air Filtration Unit with Airlock Discharge.

&#9679 1992 WIW Mat Trim and Mat Reject Recycle System.

&#9679 1992 WIW Mat Pre-Compressor.

&#9679 1992 WIW Mat Side Trim Saws.

&#9679 1992 WIW Mat Cut-off Saw.

&#9679 1992 Mat Metal Detector.

&#9679 1992 WIW Forming Line Conveyor System with Mat Reject Tipple and Mat Speed-up Belts.

&#9679 1992 WIW 6-Deck Traybelt Type Press Loader.

&#9679 1992 WIW with 7'-11"W X 96"L platens, 3900 Ton Capacity, Steam Heated, 6-Opening Press, with (12) 36-inch Die capacity and Spring-Loaded simultaneous.

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&#9679 Closing Arms. (hardboard mfg. pressure)  
&#9679 1992 WIW Press Die Loader with Elevator.  
&#9679 1992 WIW Press Unloader with Powered Ribbon Belt Conveyors.

**NOTE:** Press Dies not included.

**Controls**

&#9679 WONDERWARE HMI Control System with Integrated Software.  
&#9679 Multiple MCC Rooms of Motor Controls.  
&#9679 GE Variable Speed Drives.  
&#9679 Press Oil Cooling Coils and Fans.  
&#9679 Press Counter Cooling Coils and Fans.  
&#9679 40 kV Power Distribution and Control Panels.

**Sizing Line**

&#9679 JENKINS Door Skin Sizer with Skinner and Equalizer Saw Systems plus Wide Belt Conveying and Dust Suction.

**SECOND DOOR SKIN PRODUCTION LINE**

&#9679 Fiber Feed Bin (older than the main part of the line).  
&#9679 2007 WIW MDF Mat Forming Machine, 54 inches wide with Mat Fiber Suction beneath the forming belt.  
&#9679 2007 Low pressure Suction Fans.  
&#9679 2007 WIW Mat Shaver.  
&#9679 2007 WIW Belt Type Mat Pre-Compressor.  
&#9679 2007 WIW Mat Side Trim Saws.  
&#9679 2007 WIW Mat Cut-off Saw.  
&#9679 GORING CORNING TEK, Model "21", Mat Metal Detector.  
&#9679 2007 WIW Forming Line Conveyor System with Mat Reject Tipple and Mat Speed-up Belts.  
&#9679 2007 WIW 2-Deck Traybelt Type Press Loader.  
&#9679 1964 Reconditioned/Repurposed WIW 2-Opening Press having 54" x 20 Ft. platens, Steam Heated, with (4) 24-inch Die capacity and Chain Operated  
&#9679 Simultaneous Closing, Top Down Cylinder Arrangement with Hydraulic Pumping System located on top.  
&#9679 2007 WIW Press Unloader with Powered Ribbon Belt Conveyor.  
&#9679 WONDERWARE HMI Control.

**NOTE:** Press Dies not included.

**A small plant with lots of *great machinery* !**

**Available for inspection. Call to arrange an appointment.**

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