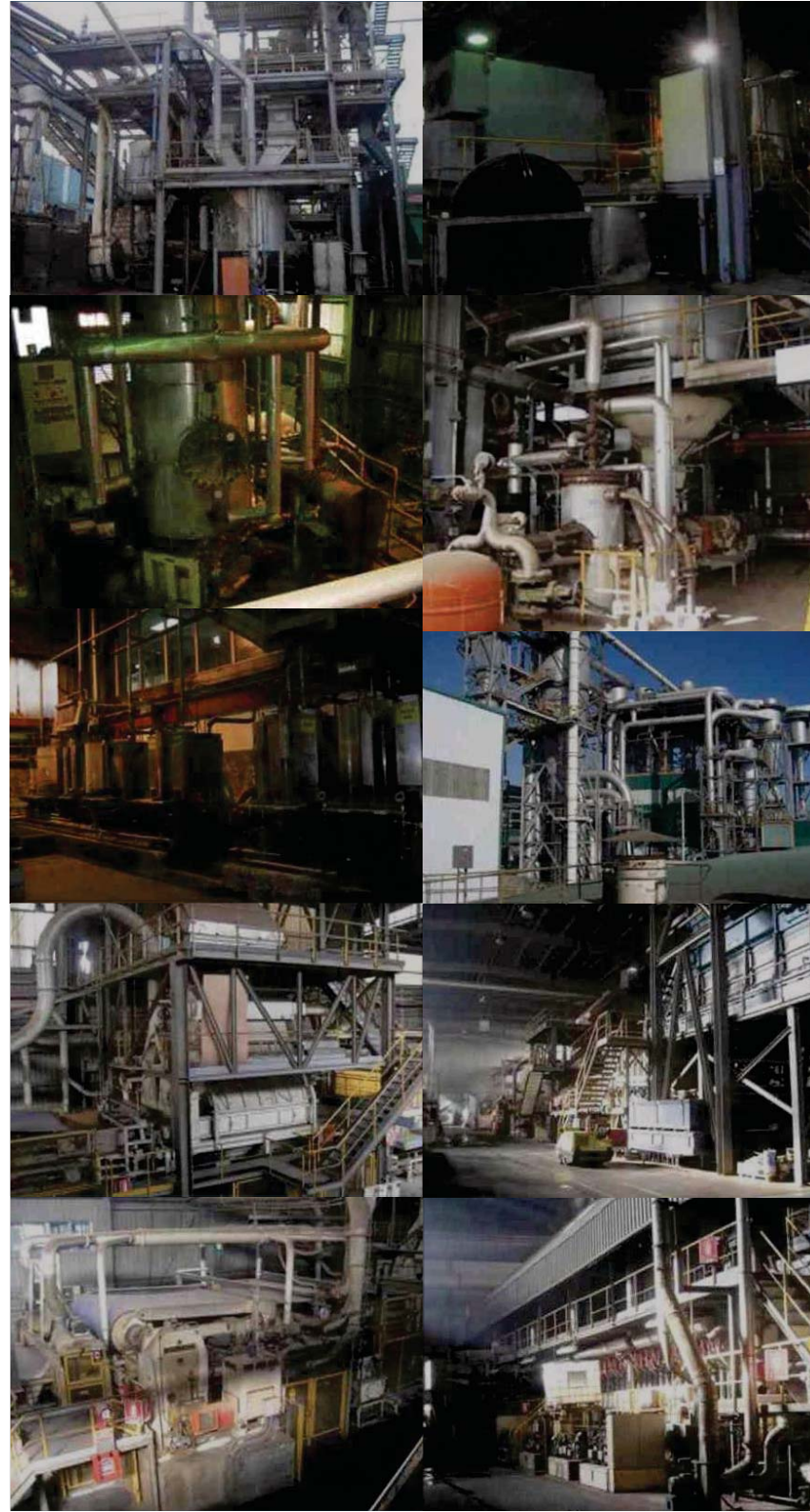


# Complete MDF Production Line



Press system:	Continuous
Major suppliers:	Sunds / Küsters
Capacity approx.:	390 m <sup>3</sup> /day @ 3 mm unsanded panel ; 260 m <sup>3</sup> /day @ 16 mm thickness
Effective working time:	23 h/day
Reference thickness:	3 - 19 mm
Heating platen length:	17200 mm
Operation speed max.:	45 m/min
Max. net board length:	4940 mm
Max. net board width:	2560 mm gross width in the press
Min. net board width:	As it is, 2440 mm in the press. Adjustable to 1830 mm changing chain configuration.
Min. board thickness:	2,5 mm unsanded panel
Max. board thickness:	20 mm
Specific pressure max.:	5 N/mm <sup>2</sup>
Electric system:	400/6000V, 50Hz, AllanBradley 5
Year of manufacture:	1989
Operated until:	2009
Modifications/ upgrades:	1997 / 2005 / 2006 / 2007

## MACHINERY LIST

### Fibre Production

- |                            |                              |
|----------------------------|------------------------------|
| 1 Chip washing plant       |                              |
| Sunds Defibrator           |                              |
| Type:                      | FT 80 single                 |
| Capacity:                  | 80 m <sup>3</sup> /h (chips) |
| 1 Wood refining equipment, |                              |
| Sunds Defibrator           |                              |
| Type:                      | L 44, modified to 46"        |
| Capacity:                  | 13 t/h b.d.                  |
| Main motor:                | 3.150 kW                     |
| 1 Glue blending,           |                              |
| IMAL                       |                              |
| System:                    | volumetric                   |
| 1 Blow-line system         |                              |
| Make:                      | Sunds Defibrator             |

### Fibre drying, sifting, dosing

- |                         |  |
|-------------------------|--|
| 1 Two stage fibre dryer |  |
| Fläckt                  |  |
| Capacity:               | 15.000 kg/h atro, 14600 kg/h water evaporation |
| Dryer duct length I:    | 28 m   |
| Dryer duct length II:   | 75 m   |
| 1 Fibre sifter          |  |
| Sunds Defibrator        |  |
| Capacity:               | 19.000 kg/h                                    |
| Type:                   | Z-sifter                                       |
| 1 Fiber bin             |  |
| Sunds Defibrator        |  |
| Volume:                 | 50 m <sup>3</sup>                              |





## Forming and press line

### 1 Mat forming station (Option 1)

Sunds Defibrator

System: mechanical  
 Width adjustment: 2100 – 2700 mm (adjusted by shave-off saws)  
 Dosing Bin: 20 m<sup>3</sup>  
 Year: 1997

### 1 Scalper

### 1 Weight scale

Sunds Defibrator

Year: 1997

### 1 Pendistor forming head (Option 2 and preferred)

Sunds Defibrator

System: Air  
 Forming Width: 2700 mm (adjusted by shave-off saws)  
 Year: 1989

### 1 Continuous pre-press

Sunds Defibrator

Belt speed: 45 m/min  
 Infeed opening: 100 – 700 mm  
 1 Hydraulic unit for pre-press

### 1 Oscillating density gauge

Sunds Defibrator (to be discussed because of radioactivity source).

### 3 RF Units (dismantled)

### 1 Reject mat hopper

Sunds Defibrator



1 Continuous hot press

Küsters

Press width: 2.560 mm

Heating plate length: 17.200 mm

Max. press speed: 45 m/min

Including hydraulic unit

Secondary heating circuits

1 Double diagonal saw

Sunds Defibrator

1 Thickness measuring device

IMAL

1 Board blister detector

IMAL

Roller conveyors to board turners

Raumatic

2 Destacking stations

Raumatic

2 Board cooling turners each 64 pockets

Raumatic

Belt transport conveyors

Raumatic

1 Raw board destacking station

Raumatic

Stack transport conveyor

Raumatic



## Sanding and Saw Line

1 Mechanical board handling line  
Raumatic

1 Sanding machine  
IMEAS  
Number of heads: 4 (2K/2K)

1 Sanding machine  
IMEAS  
Number of heads: 2 (2K)

1 Sanding machine  
IMEAS  
Number of heads: 4 (2FS/"FS asym.)

3 Destacking stations  
Raumatic

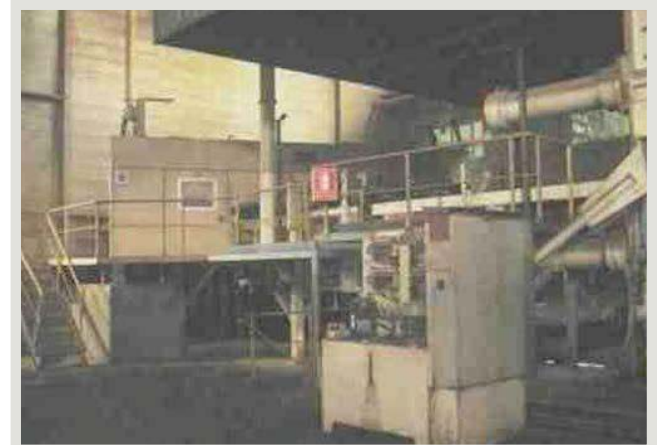
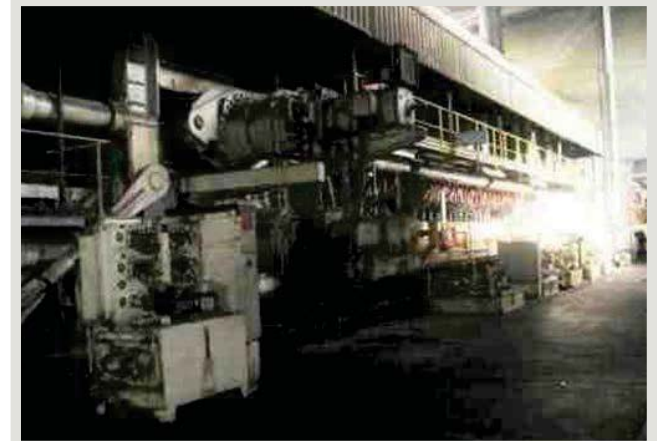
1 Cut to size saw  
Raumatic  
Max intake size: 2530 x 4940 mm  
Min. cutting size: 600 x 900 mm

1 Strapping line  
Itipack

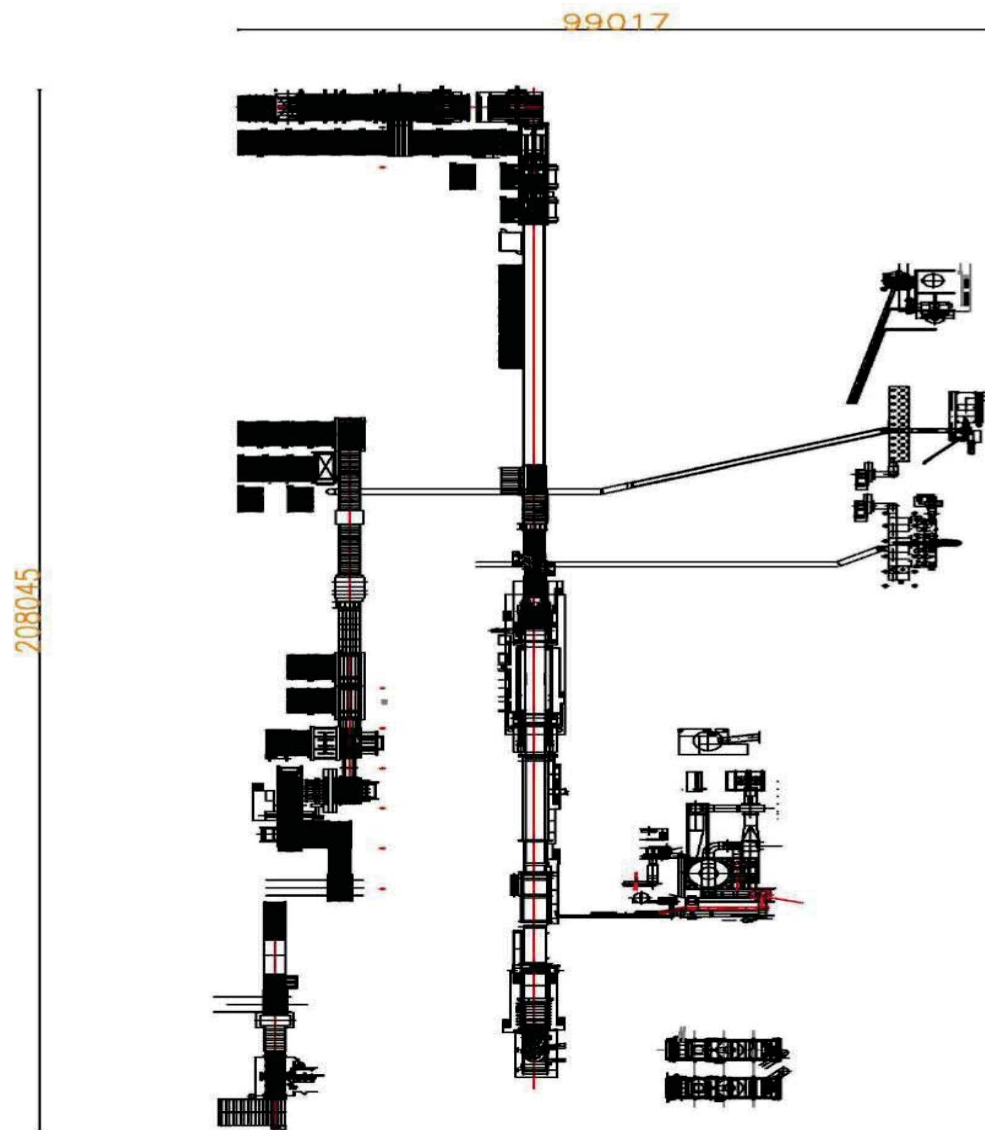
### Suction systems, filters for above machinery

#### Electric control:

Allan Bradley PLC 5  
Year: 2006







NOTE: TO BE CONSIDERED JUST FOR LAY-OUT PROPOSES  
NOT AS A DETAILED SCOPE OF SUPPLY