

Masa GmbH, 56626 Andernach, Germany

# Regal Plant in a Majestic Setting

Already a well-positioned supplier in the Western United States, Oldcastle APG, through its subsidiary Central Pre-Mix Concrete Products, found itself in strong need of a new production facility in the Northwest. The geographic focus narrowed to the rapidly growing Seattle Metro area. The concept was to develop a state of the art facility, in both volume and quality criterion, for a full range of hardscape products. Fredrickson, WA became the 28 acre (11.3 hectare) site to build a combined facility for optimized and comprehensive production. The plant was up and running in early 2017.

The Oldcastle project team selected Masa as its big board sized production machinery manufacturer. It is interesting that these two companies share a common time line and 40 year anniversaries at the time of this project's execution. In 1977 CRH crossed the Atlantic in search of expansion opportunities. The following year Oldcastle, Inc. was incorporated and its first US acquisition was made with the purchase of Amcor in the West. Meanwhile during those same years, Masa sold and delivered its first big board to the United States.

In addition, this project utilized Haarup to supply the mixing and aggregate batching facilities to feed both the Masa machinery as well as a reconditioned Besser V3-12 moved from an existing Oldcastle facility. Egan provided controls for the mixing and batching to integrate with both production lines.



*The 105,000 sq. ft. (9700 sq. m) building during construction*

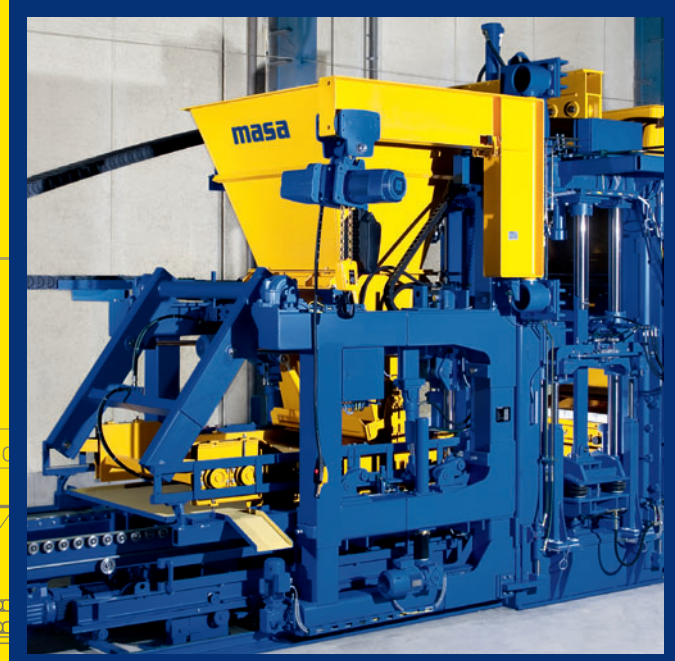


*With majestic Mt. Rainier hovering in the background the new plant rises in the foreground*

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One dump station fills all the bins for both plants and there are supplemental covered aggregate storage areas



The large patio storage includes area to efficiently and quickly load product

### Building a Dual Facility

The project's foundation begins with the building laid out for adequate space to operate both production lines simultaneously. A total of approximately 105,000 sq. ft. (9700 sq. m.) under one roof houses both operations. The mixers are centrally located sharing a large vertical platform to feed both plants. Likewise, one aggregate dump feeds the eight aggregate bins, capable of holding 1200 tons of raw materials. There are four large covered storage areas outside which provide supplemental capacity. Four cement silos, one each of 200, 115, and two each with 100-ton capacity, store different cementitious materials to round out the raw materials storage capability.

Two mixers, one sized at 3750/2500 liter to feed the Masa plant and one of 2250/1500 liter size to feed the Besser plant are mounted high up for ease of operation. Feeding belts run to each facility to provide a continuous mix allowing for multiple color blends.

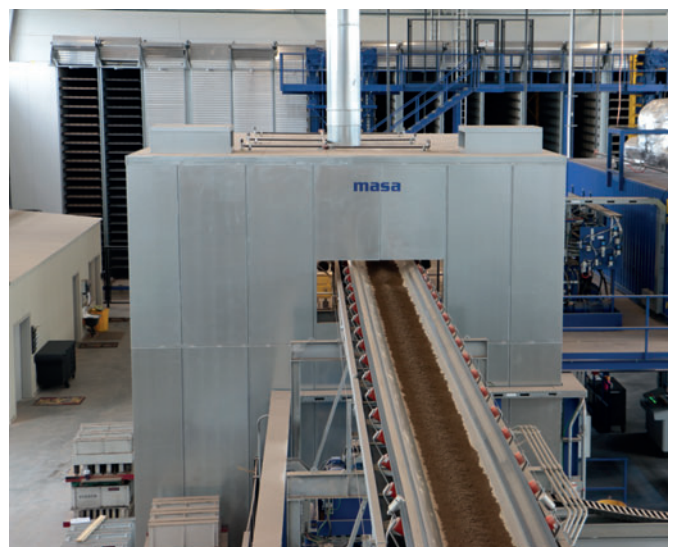
### The Masa Plant

The Masa production facility revolves around the 1400 mm x 1100 mm steel pallet size. The Masa XL 9.1 machine, consisting of three parts: the main feed section, the massive vibration unit, and the front mix section which would allow a future face mix option if desired, is the starting point to form the wide variety of residential and commercial hardscape products required for this production facility. A fully automatic rapid mold change, combined with an XY-axis moveable crane inside the sound cabin completes the set up. Masa Servo vibration, with state of the art features and unique visualization controls provide the means to achieve demanding quality specifications and reliable, consistent output volumes.

The rotating finger car, elevator, lowerator, intermediate finger car and curing racks are based around a 22 floors high x 6,000 pallet capacity curing storage. An active temperature and humidity controlled curing system supplied by CDS with individual door type kilns finishes the curing area.



A central raised platform holds the entire mixer operation for both plants



Feeding belt going to the back of the Masa machine



An operator utilizing the Masa visualization control panel

A pallet buffer system with capacity for 2016 pallets provides flexibility for system changes on both the wet and dry side. The pallet buffer consists of a rack storage with a small finger car to transport the pallets to/from either side and insert/remove from the rack storage.

The dry side conveyors consist of belted conveyors for maximum speed feeding the cubing components made up of a centering device, doubler, and servo driven, energy efficient cuber to create the cubes.



The rotating finger car loading the individual door kilns



The finger car moving freshly-produced products to the curing racks

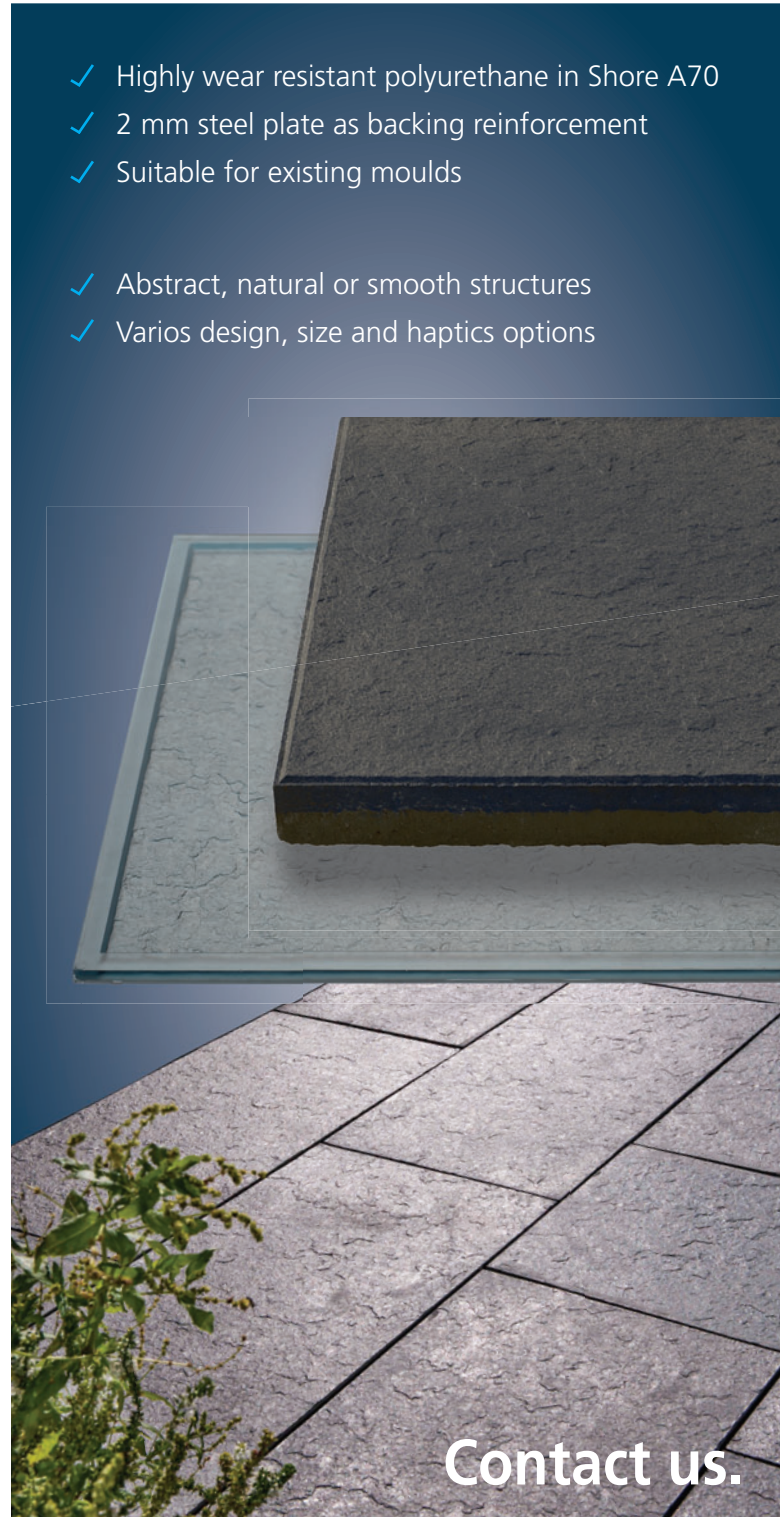
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*The 2016 capacity ballet buffer with finger car transport system*

**“We are very pleased at having met the challenge.”**

“There were several important goals with building this plant,” said Brian Austin, President of Oldcastle APG, West Coast. “Most critical was the need for high quality and consistent output from day one. We focused on hitting the ground running, while making good product and Masa allowed us that outcome. We are very pleased at having met the challenge.”

“In addition to the physical equipment, we are also pleased with the level of service and support that Masa has supplied to us. One of our corporate manifests is to work with our suppliers as partners as much as possible and in this case we can say with certainty that is a reality,” added Brian.

**Results of 40 years**

Since the first acquisition, Oldcastle has expanded its operations to become a quite diverse family of companies of materials and products, with operations in 38 US states, 5 Canadian provinces, and South America with over 350 locations in the western hemisphere.

Masa has expanded in its own way, with having placed 85+ plants in the Americas with more being added each year. To that end, it established a subsidiary, Masa USA to assist its customers to provide same time zone service.

Realizing that locally available parts were going to be a necessity for purchasers of the equipment, in 1991 the first warehouse of spares began, along with service technicians located in North America. In 2001, Masa-USA was formally created and expanded further in its capacity to improve the relationship and support between Masa and its customers. Based on its success, it became the blueprint for other Masa parts and service subsidiaries now located in Middle East, China, Russia, and India to allow the realization of regional time zone service centers’ across the world.

Since this milestone in Masa’s history, both existing and new customers can more readily obtain information and take advantage of a large warehouse in Green Bay to ensure a steady supply of spare parts already available in the American market.

Fortunately, a robust building materials market continues today to allow both of these companies the opportunity to expand on their core applications and ability to serve their customers. No doubt this project is a visual and solid testament of such competencies. ■



*Small retaining wall are just one of the many diverse products made at the plant*



SKU's of finished product await shipment under the watchful eye of Mt. Rainier



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