

From handling loose stock  
to final stack, Black Bros.  
sets the standards in  
complete panel laminating  
systems. Besides our  
industry-leading glue  
spreading and laminating  
equipment, Black Bros. Co.  
offers a wide range  
of auxiliary equipment to  
facilitate the typical panel  
manufacturing process.

**Infeed and Outfeed Scissors Lifts** – either plain or with roller deck – are required for each lay-up station. Incorporating a gravity roll conveyor on the lift deck provides easier stack movement. This arrangement is equipped with a brake to keep the rollers from turning, enabling a stack of panels to be assembled on a caul board placed on the conveyor. A foot control allows the operator to lower the lift as the stack is being assembled, then raise the load to place it on the transfer cart. The entire arrangement may be recessed into a floor pit to maintain a convenient working height for the operators.



**Minimum Contact Conveyors** with freewheeling sprockets support glued panels as they exit the adhesive spreader and minimize disturbance to the glue line. Panels can then be handled at the operator's convenience.

**Pivoting Corner and Side Guides** are unique devices that help the operators align a stack on the scissors lift. Provision is made for centering various panel sizes on the lift. The corner guide pivots out of the way to allow the stack to be readily moved to the transfer cart.





**Heavy-Duty Laminate Racks** are designed to support a stack of high pressure laminate sheets prior to lay-up. Wide spaced legs allow sufficient clearance to transfer load to cart.

**Transfer Carts with Floor Tracks** are specially built gravity roll conveyors designed to easily transfer a stack of panels from the scissors lift to the press. Each cart is supported on four rigid casters that ride on floor-mounted steel tracks. Two casters are "V" grooved and ride on an inverted angle iron track to keep the loads properly aligned with the presses. A side-mounted handle allows the operator to move the load without disturbing the stack. "Pockets" are provided to allow the stack to be lifted off with a fork truck, if desired.



**Outfeed Roller Conveyors** provide support for glued or finished panels as they exit the spreader, coater, or laminating station. Freewheeling rollers allow easy panel movement.

*Ask for details on other optional machine designs:*

- *Panel Feeders*
- *Panel Cleaners*
- *Laminate Indexing Stations*



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