

From handling loose stock
to final stack, Black Bros.
sets the standards in
complete door 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 door
manufacturing process.

Stock Support Tables are often used to hold loose door components at the infeed of an adhesive spreader. Leg length can be adjusted for optimum operator convenience based on the size of pieces being handled.



Inclined Outfeed Tables are constructed of a rigid sheet of UHMW polyethylene mounted on a metal frame equipped with adjustable legs. This allows the table to slope upward about 10" (254 mm) from front to back. As material exits the adhesive spreader, the leading edge travels up the table without disturbing the glue on the bottom of the piece.

Scissors Lifts are required for each lay-up station. A gravity roll conveyor on the lift deck provides easy stack movement. This arrangement is equipped with a brake to keep the rollers from turning, enabling a stack of doors 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 is recessed into a floor pit to maintain a convenient working height for the operators.

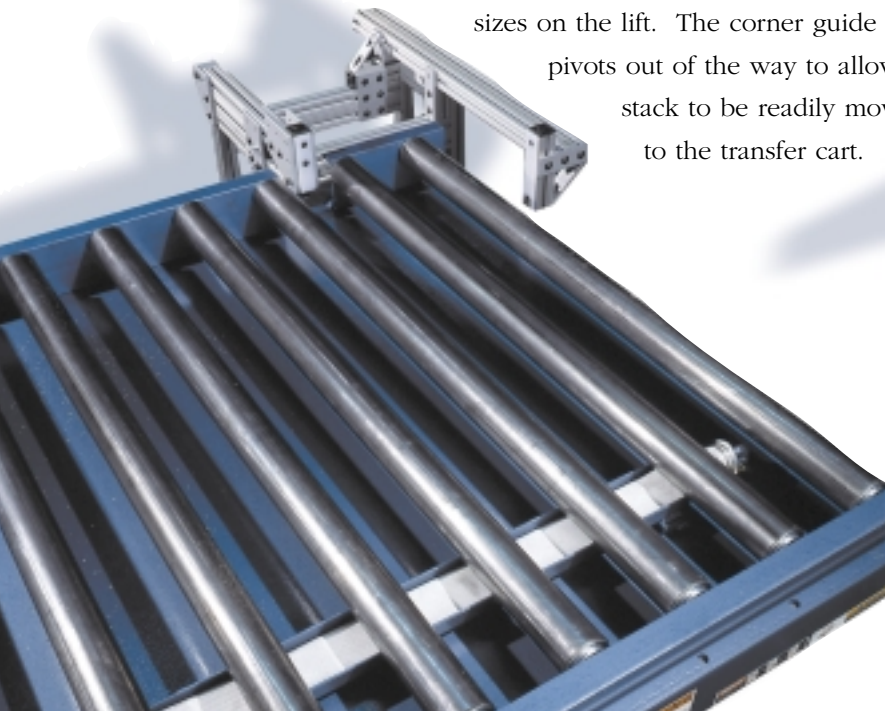


Transfer Carts with Floor Tracks are specially built gravity roll conveyors designed to easily transfer a stack of doors from the scissors lift to the press. Each cart is supported on four rigid casters that roll on floor-mounted steel tracks. Two casters are "V" grooved and ride on an inverted angle 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.



Pivoting Corner and Side Guides are unique devices that help the operators build a door stack on the scissors lift.

Provision is made for centering various door sizes on the lift. The corner guide pivots out of the way to allow the stack to be readily moved to the transfer cart.



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