Rolls to Fit Most Industry Needs
A variety of resilient covered, steel, and chrome plated rolls are available to meet most any customer need. Steel or plate rolls are matched to the specific application. Resilient compounds are available to meet desired chemical resistance and in various hardness ranges. Over three hundred different groovings are available to apply adhesive in virtually microscopic amounts up to heavy beads 1/4” to 1/8” (6 mm to 3 mm) apart. Typical groovings are helical, but also available with compounds grooves; length of roll. Contact Black Bros. Co. for all your new, reconditioned, standard, or specialized roll needs.

Roll Coaters and Adhesive Spreaders for Cut-to-Size Sheets
Standard roll arrangements are commonly used to apply liquid materials to particleboard, hardboard, plywood, chipboard, paperboard, steel blanks, plastic panels, rigid and flexible foam, circuit boards, and other cut-to-size stock of uniform thickness.

Roll Arrangements
Roll arrangements, sizes, and coverings vary according to specific operations. Machines are available for direct roll coating, reverse roll coating, web coating, glue spreading, edge coating, filling, hot melt coating, printing, and more.

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Roll Groovings
- Modified “V” Pattern
- Buttress Grooving
- Roll Groovings

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Standard Machine Specifications

<table>
<thead>
<tr>
<th>Model</th>
<th>22D</th>
</tr>
</thead>
<tbody>
<tr>
<td>Series</td>
<td>200</td>
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<tr>
<td>Applicator Roll Diameter</td>
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<tr>
<td>Roll Widths Available</td>
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Models shown may not reflect latest configuration.
Innovative engineering, quality manufacturing, and dedicated support for over 125 years.
Established in 1882, Black Bros. has become an international leader in the manufacture of high quality gluing, coating, and laminating equipment. Our exceptional machines are the result of many years of design, engineering, and manufacturing experience, combined with an extensive and ongoing research and development program.

Black Bros. testing and research laboratory has always played a key role in the development of advanced machine technology. This facility is also instrumental in evaluating the various materials and methods proposed for the customer’s operation prior to machine order placement. Many equipment and application improvements can be attributed to our close cooperation with customers and material suppliers.

Black Bros. Roll Coaters and Adhesive Spreaders easily adjust to deliver a uniform coating at the precise thickness recommended by the supplier.

**Model 22-D**

The 22-D is a proven, popular model with a reputation for durability, production, efficiency, and profitability. Exceptional accuracy delivers consistent quality, reduces material waste, fewer rejects with maximum production output, and reduces downtime. Variable speed ranges (from less than 10 to over 300 FPM (13-91m)) meet most requirements. Full-length operating control bars on both sides offer convenient machine control and emergency stops. The 22-D’s heavy-duty construction means long machine life and low maintenance. Includes time-savings and easy adjustment for substrate sizes and coating thickness.
Model 775

Built for durability and longevity, the Series 775 provides a compact and economical approach to adhesive spreading. The efficient design – with fewer components than other models – makes the 775 easy to maintain and increases uptime. This adhesive spreader is a popular choice for companies who need an efficient method of applying adhesive, but cannot justify the larger, higher production adhesive spreaders. Available in sizes ranging from 32” (812 mm) through 74” (1880 mm) with numerous standard features and options.

With Black Bros. equipment you can apply:

Almost any coating:
Paints - lacquers - enamels - latex - sealers - sizings - metal lubricants - oils - resins - stains - inks - clear or gloss coats - toners - insulative or conductive coatings - emulsions - waxes - varnishes - polyesters - photo-polymers - EB and UV curable - acrylics - elastomers - base coats - drawing compounds - polyurethane - diazos - fillers - silicones - rust inhibitors … 100% solids, water borne, flammable and nonflammable solvent reducibles, etc.

Common wood glues including:

To almost any flat substrate:

Models and Sizes
Black Bros. Roll Coaters and Adhesive Spreaders are available in a wide range of sizes and models for coating stock as narrow as 8” (200 mm) and as wide as 15’ (4572 mm), up to 121/2” (317 mm) thick. The customer’s requirements determine the model, size, roll specifications, and options.
775 Hot Melt Spreader
This spreader is built to handle the increasing market demands for reactive hot melt polyurethane (RHW/PUR) adhesive application. The RHM-775 Adhesive Spreader is equipped with the necessary features to handle RHM/PUR materials: drive components on one end – heat connections on the opposite end, easy access to the roll ends for maintenance, easy roll change, tempered glass for visibility, and vent or port for vapor control/exhaust. The oil heating unit mounts on the same base as the machine. All controls are wired into a single control box for installation and operating ease. Standard units are available from 32” (812 mm) through 74” (1880 mm) capacity. In units up to 110” (2794 mm), special arrangements can be designed and manufactured to customer specifications. *Bulk melting units and/or arrangements for connecting the hot melt product supply and liquid level sensing control are also available.

Titan Spreader
The Titan Spreader is a new series of Hot Melt Adhesive Spreaders. This machine is loaded with many operator convenience features and will deliver quality panels using flexible PUR adhesives for years to come in your laminating line. Titan Spreaders are durable machines that are available in widths up to two meters wide. The doctor roll assembly is mounted on precision ground linear bearings and energized pneumatically to simplify set-up and ensure reliable and repeatable coating weights. The Titan Spreader offers independent variable speed drives for the coating rolls and doctor rolls that are built-in to allow fast and easy roll adjustments. The Titan Roll Coater is also available unheated and can perform high speed precise coating applications in web or sheet environments.

*applicable to Titan Spreader and 775 Model Spreader
Differential Direct Roll Coater
The Differential Direct Roll Coater (DDRC), an advanced design of our popular Roll Coaters, is flexible enough to handle a variety of jobs at a competitive price. Independent variable speed drives mounted on coating roll, direct or reverse rotating doctor roll, and conveyor belt greatly increase the machine’s versatility. These coaters are ideal for UV applications and solvent and water borne coatings (including stains, tints, colors, and protective coats) when coating wood, metal, plastics, aluminum, and other surfaces. It is capable of producing extremely smooth finishes with light to heavy viscosity materials. The DDRC offers belt conveyor, easy installation, simple setup, fast roll changes, a low profile, and a wide range of capabilities. It is available in widths for 3’, 4’, and 5’ (910 mm, 1210 mm, 1520 mm) stock.
**Standard Features**

**Easy and Efficient Clean-up**
The roll reversing feature of the coaters and spreaders makes them almost self-cleaning with no need to touch rotating rolls. Step-by-step cleaning instructions appear on a decal at each end of machine.

**Heavy Frame Construction**
Heavy welded steel frame construction (as much as 30% heavier than competing units) assures rigid roll alignment for precise coating action, extended coverage rates and unsurpassed longevity.

**Machine Guarding**
Guards at key locations help protect operators and/or cleanup crew from nip points on upper and lower coating and doctor rolls. Electrical interlocks (standard) shut off machine when any guard is pivoted away from protective position.

![Upper roll nip guard](image)

**Micrometer Scale Doctor Roll Adjustment**
Convenient handwheel adjusts doctor roll to control coating material thickness for maximum economy and minimum waste. Easy-to-read scale calibrated in .001” (.025 mm) increments to allow exact repeat settings.

![Micrometer scale doctor roll adjustment](image)

**Electrical Equipment**
All machines are pre-tested and ready to operate, complete with drive motor and electrical controls, including NEMA 12 enclosure with fused disconnect, wired to meet customer’s requirements.

**Lubrication**
Grease fittings for pressure lubrication of bearings and other moving parts to protect against corrosion, dirt, and moisture for long life with minimum maintenance.

![Roll Opening Indicator](image)

**Roll Opening Indicator**
Provides digital readout in .001” (.025 mm) increments. Extremely helpful in setting stock thickness. Also available with metric readout.

**Variable Speed Drive**
For cleaning or to synchronize with other machines in-line. Match machine speed to various production requirements, stock sizes, etc.
Optional Features

Pump, Fluid Handling and Recirculation Equipment
To suit almost any supply or recirculating requirement. Component “Packages” to provide supply lines, special manifolds, recirculating overflow systems, etc. for use with customer-supplied pumps or supply lines.

Single Handwheel Doctor Roll Adjustment
Provides doctor roll to coating roll adjustment from one end of machine with digital read-out. Ideal for in-line operations.

Automatic Roll Clean Up System for Water Soluble Materials
With the push of a button, Black Bros. automatic water-wash cleaning system spray-cleans rolls during a preset series of forward/reverse roll rotation cycles.

Minimum Contact Outfeed Finger Assembly
Supports stock with minimum contact wheels to assist in Off-loading of panels with little to no glue line disturbance.

Air Lift on Top Rolls
When actuated by operating control bar push button, top roll assembly quickly raises 3” (76 mm) above bottom roll. Ideal for roll cleanup or when operation is stopped for a period of time. Push button also returns top rolls to proper coating position.

Automatic Liquid Level Control
Liquid level sensing unit insures a constant coating material level in the coating reservoir. Automatic viscosity control units are also available to maintain proper viscosity of fast evaporating and other critical-to-control liquids.

Automatic Elevator
Auto-Elevator mechanizes the roll nip adjustment on Black Bros. Spreaders and Coaters, and comes standard with a touch screen interface. The motorized adjustment system replaces the large handwheel with a power adjust button. Touch screen entry allows the operator to input the desired nip measurement on the screen and the machine will automatically advance to that position.

Other Optional Equipment Includes:
• Special paint to meet customer preference
• Riser base to increase pass line height for in-line operation
• Sheet metal hoods
• First revolution scraper blade
• Power driven infeed and outfeed rolls
• Divided top rolls
• Cooled or heated rolls
• Protective plating of critical parts
• ‘Non-stick’ coated parts
• Segmented bottom rolls
• Load cells
• Centralized lubrication systems

Standard Machine Specifications

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