At Black Bros. Co. we are committed to the design and manufacture of high quality machinery, with an uncompromising attitude toward customer service.
**Panel Feeding:**
The Black Bros. Pneumatic Panel Feeder is designed to manage sheet feeding of standard units of uniform wood products, from the deck of an integrated scissors lift. Standard features include the following:

- A smooth operating stroke of 24” (610 mm), able to handle up to 250 lb (113 kg).
- Panel lengths ranging from 5’ to 9’ (1.6 - 2.8 M), or 8’ to 12’ (2.5 - 3.7 M), optional longer stroke.
- Remote activation from the operator’s station, and/or panel feeder.
- A barrier gate mounted to either the panel cleaner or glue spreader, prevents double feeding of panels.
- Dual limit switches adjust for board thickness and controls the upward travel of the scissors lift.
- Pass line heights available up to 60” (1,524 mm).

**Scissors Lifts:**
Black Bros. offers several features to make loading of standard core product more efficient:

- Pre-staging conveyor.
- Pin adjustable edge guides.
- Bump guides for initial alignment of core.

*Cold pressing is the most efficient means to laminate same-sized panels in a batch process. By integrating panel staging/feeding, panel layup, and side-shifting for alternate press loading/unloading, very high volumes may be achieved with the least amount of labor. Panel volumes may vary, but a production of 2 - 3 panels per minute is achievable with an automated system. Careful pre-staging of materials is essential.*
Automated Cold Press Systems

- Built to Perform

Board Cleaning - Adhesive Coating

Clean & Coat:
Black Bros. panel cleaners and adhesive spreaders come with options that allow for greater productivity and enhanced operator performance. Choose from the following features to assist your operator in getting the most out of the machine:

- Auto-elevator automates the roll nip adjustment on a Black Bros. cleaner and/or spreader, making it a quick adjustment to change to a new thickness.
- Centralized lubrication makes light work out of daily/weekly/monthly maintenance of the machine.
- A liquid level control provides a constant flow of adhesive to the rolls based on consumption.
- Automatic roll clean up makes the job of roll clean-up simple and hands-off.

Engineering Services Available for Custom Applications
Material Handling - Panel Layup

Air Pod Presses:
The Black Bros. Air Pod Press has been the standard in the industry for decades. Built with components that stand the test of time, the APP line of machines has been the hallmark for manufacturers across North America, and world wide. When you buy a Black Bros. press you’re buying a piece of machinery that will last decades.

Laminate Indexing Station - LIS:
Black Bros. offers the LIS to pull labor out of panel layup. The system consists of:

- Inclined framework with a roller bearing shuttle, designed to support the leading edge of the core.
- Scissors lift with a roller deck, allows the operator to build a stack of product, lowering each sheet as it is completed.
- Laminate rack to hold two sets of overlay, one for the backer, the other for the face. The rack is driven by an electric motor, for a smooth and consistent motion (push button controlled).
**System Configuration:**
In this configuration two (2) 5’x 12’ (1.6 - 3.7 M) presses with transfer carts are placed side-by-side. Other presses can be added to this system, providing the plant floor layout allows for the additional footprint. Since all of the equipment is designed to be modular, a manufacturer can elect to insert other machines at a later date.

**Material Handling Conveyors:**
Black Bros. utilizes standard conveyor stock, along with welded sub-frames, casters, and rails, to provide an economical yet robust means for transferring materials through the cold press process. Alternating presses, and keeping product moving in a linear flow, yields the highest results of any laminating system.

**Typical Cold Press System Layout - With Two 5’ X 12’ Presses**
Press Features - Specifications

Controls:
The standard control box provides (from left to right):
- The control panel reset button, power on, elevator up/down (for motorized press), master start, stop, pressure on/off, reduced pressure switch (optional) for “reduced or full” pressure, and main disconnect.

Air Pod Pressure System:
- Long-life Air Pods provide uniform pressure.
- Presses come in 10, 20, 40, 50, and 80 psi models. A 5’ x 12’ (1.6 - 3.7 M) 80 psi press can generate up to 350 tons of force in the upper platen.
- Stroke limit valves (shown at right) prevent the pods from stroking more than 5” (127 mm), they also double as a platen level detection device.

Air Loaded Roller Tracks:
- Press loading/unloading is easily accomplished with the air-activated roller tracks that elevate when platen air is off, and recess when platen air is on.
- Optional powered conveyor track for moving heavy loads in and out of the press (shown at lower left).

Motorized Press:
- Upper platen assembly available with auto-adjust. Downward movement stops automatically when the sensor on the top platen contacts the load. Ideal where loads vary in height. Standard opening is 4” to 45” (102 - 1,143 mm), with an option up to 73” (1,854 mm), or higher.

Auto Cycle Timer:
- Automatically times the press cycle and releases pressure when complete. When used with a motorized platen it will; close the press, time the cycle, release pressure, and open the press (not shown).

Zone Control:
- Individual pressure control to a series of pods, allows precise bonding of full, or smaller-than-platen size loads (ask for details).
Cold pressing offers a wide range of press configurations for various industries and numerous applications, such as:
- Solid Core Doors - Hollow Core Interior Doors - Veneered Panels - HPL Panels - Metal Skin Panels - Architectural Millwork - Honey Comb Light Weight Panels - Truck Trailer Doors - White Board - Chalk Board - SIPs ( Structural Insulated Panels ) - CLT ( Cross Laminated Timber ) - etc...
Time Proven Black Bros. Power Pod Press

Economy:
- Nothing beats the **Power Pod**! For a real press value take a serious look at the Power Pod design. Its a “no-frills” approach to sheet laminating. With a fixed opening of 28” (711 mm), and a range of platen pressure up to 40 psi.

More Compact:
- Lower profile design. A standard Power Pod press can fit into a very tight space, with very little over-head or perimeter restraints. See how the "Power Pod" press can help you change the way you bond your laminated sheet goods!

LAB Research & Development Services Available

LAB Services:
- Our customers have found fertile ground for new ideas, technologies, and approaches. And they’re comfortable with the systematic approach we suggest to solve their manufacturing problems.
- Allow Black Bros. to be your R & D partner! To schedule a LAB appointment contact us at our Mendota, IL, headquarters now!

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