

BLACK BROS. CO.

Laminate Indexing Station

Increase production, decrease labor



The Black Bros. Laminate Indexing Station (LIS) offers a convenient solution to what was once a difficult, messy task — handling heavy stock that is glued on both sides. The LIS eliminates the need to manually handle panels, leading to lower labor costs and increased production rates. The LIS positions the laminate in the same spot every time, so quality is consistent and laminations are cleaner.

Advantages

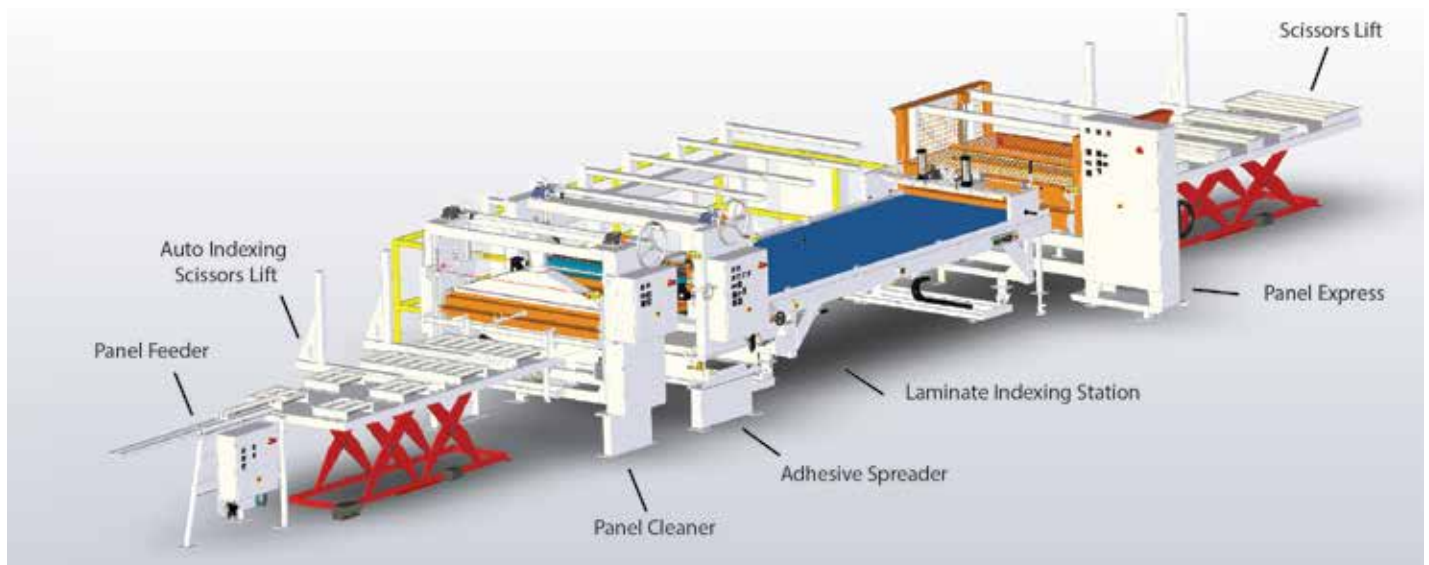
- No lifting of heavy glued panels
- Improved labor efficiency
- Reduces repetitive stress-related injuries
- Promotes cleaner laminations
- Scissors Lift or Conveyor Belt-models available
- Black Bros. heavy-duty construction

At the forefront of laminating and coating technology for more than a century

LIS Option for Single Piece Production Flow

- Consists of a belt conveyor for continuous, one-at-a-time operation, such as those found in rotary or heated rotary press applications.
- The shuttle supports the leading edge of the glued board and transports it over the backer sheet.
- Movement of the laminate rack is controlled by the operator. This moves above the glued board, making the laminate easily accessible to the operator.
- The belt type conveyor arrangement moves each assembled panel ahead one-at-a-time and into the rotary press or Panel Express. While the panel is moving into the press, the operator lays another piece of laminate on the belt so it's ready for the next board.

Panel Express Line with LIS



LIS Improvements

Many improvements to the LIS may be retrofitted to most current LIS machines. Please contact our customer service department to see if retrofits are available for your machine.

- **Mounting Hardware**

Changed mounting hardware of infeed rollers for improved operation and smoother width changes.

- **Edge Guides**

Added 3 (for a total of 6) adjustable edge guides to conveyor to help align overlay and substrate. Improved edge guides for easier adjustment without use of tools.

- **Angled Descending Rollers**

Changed angles of rollers to get substrate closer to the laminate before the trailing edge drops.

- **Carriage Sensors**

Added carriage sensors so laminate rack cannot move until the carriage is in the proper location (at 8' or 12').

Laminate Indexing Station

LIS Improvements

Soft-drop Trailing Edge



Air cylinders added to conveyor to more accurately align lower substrate to the laminate.

Soft-drop Leading Edge

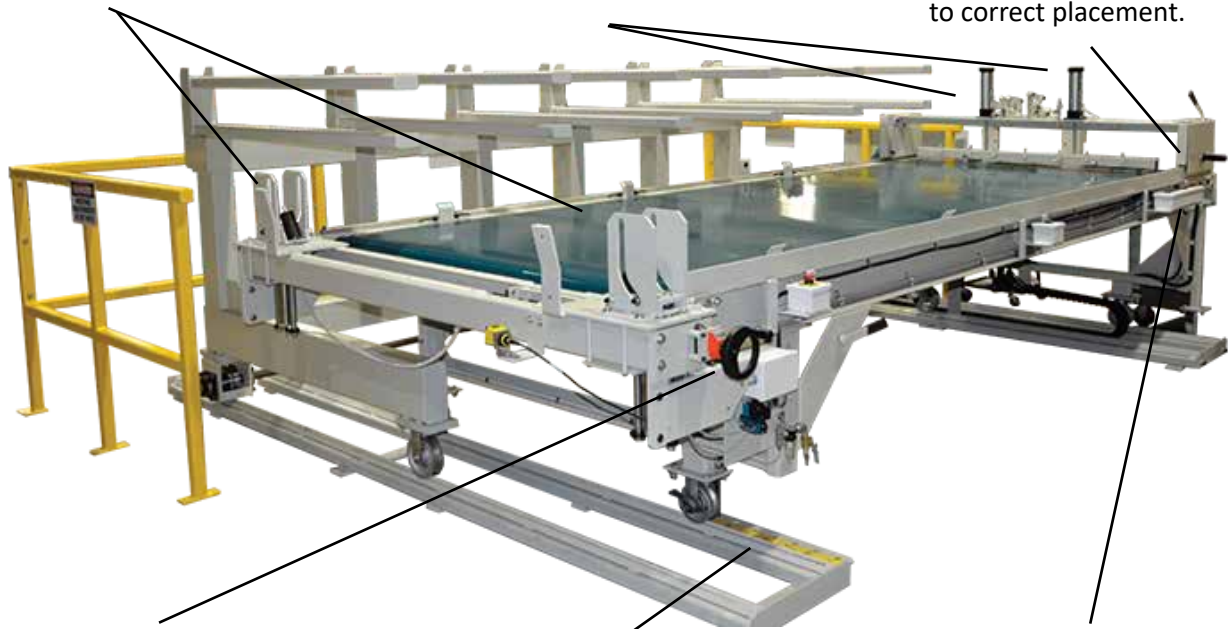


Air cylinders added to carriage to more accurately align lower substrate to the laminate.

Linear Bearings



Changed carriage casters to linear bearing. This stabilized the carriage so it would better guide board to correct placement.

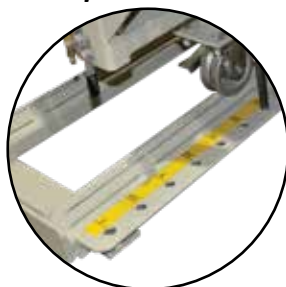


Hand Wheel



Added hand wheel with dial indicator for easier board width adjustment.

Tape Measure



Added tape measure to conveyor to help operator more easily determine the conveyor position for various width boards.

Operator Controls



Added reset button to operators' side of conveyor for ease of resetting machine.

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Additional Model Available

Laminate Indexing Station for batch processes — for stack laminating and includes a scissors lift for cold press applications.

- The operator pulls the top sheet for one panel along with the backer sheet for the next panel at the same time.
- On a scissors lift model, a sensor lowers the lift as the stack is assembled, preparing it to accept the next board.
- A conveyor is provided to move stacks or batches to a transfer cart or directly to a Black Bros. Air Pod Press.



Specifications (Approximate)

Models	Length	Width	Height	Weight
LIS	200" (5080 mm)	166" (4216 mm)	62" (1575 mm)	4500 lbs. (2041 kg)

For more details, contact your nearest Sales/Service Division:

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