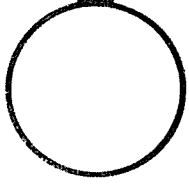


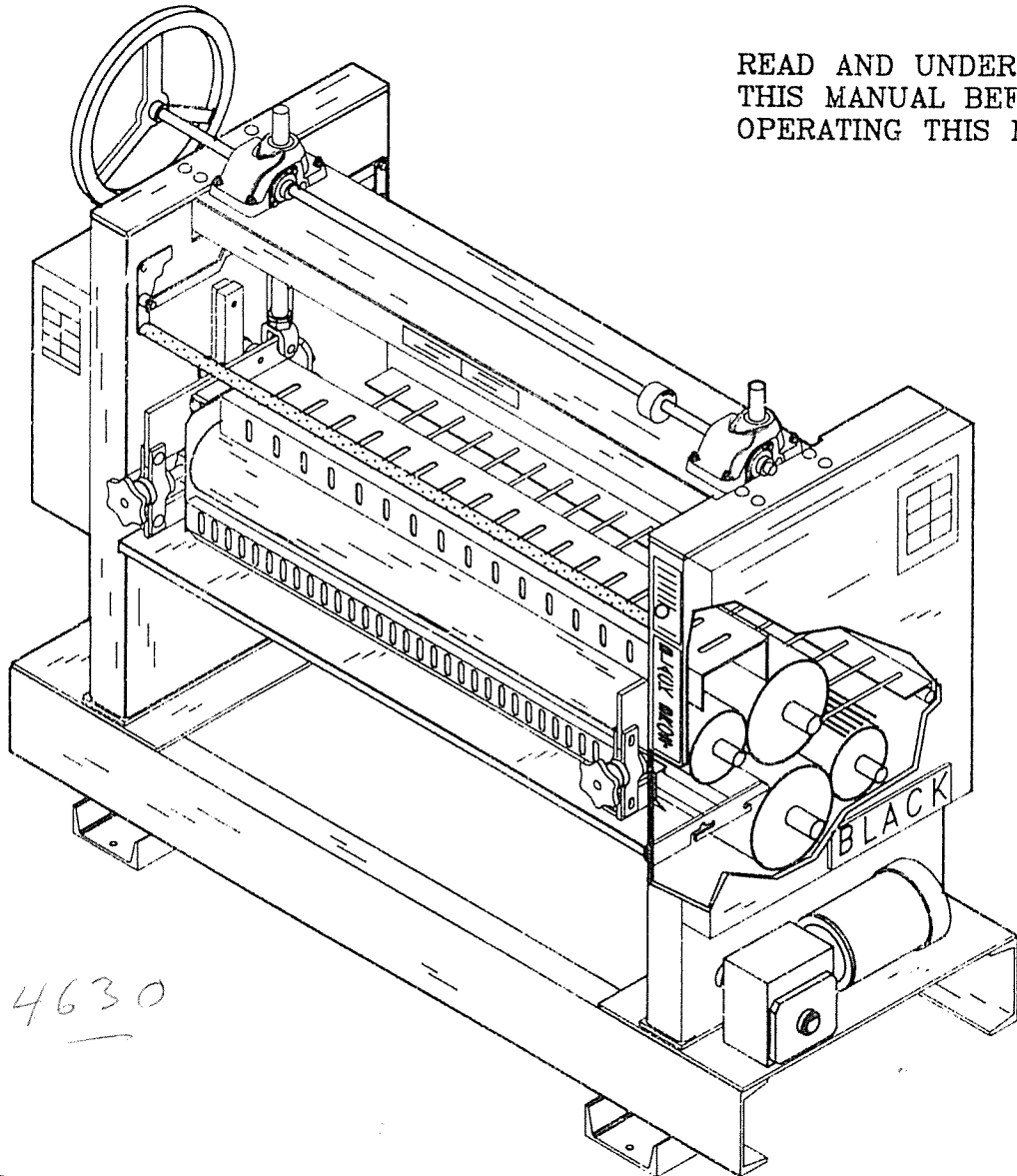
BLACK BROS. CO.



OPERATING, MAINTENANCE
AND
SAFETY INSTRUCTIONS
775 ADHESIVE SPREADER

Serial No. 192918

READ AND UNDERSTAND
THIS MANUAL BEFORE
OPERATING THIS MACHINE



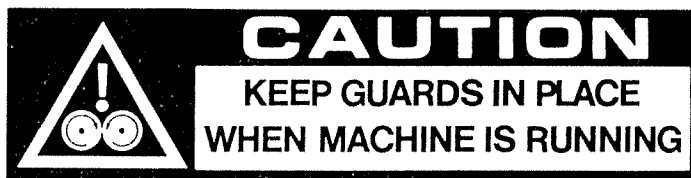
219 269 4630

9/1/92

BLACK BROS. CO. / 501 NINTH AVENUE / MENDOTA, ILLINOIS 61342
PHONE: (815) 539-7451 / FAX: (815) 538-2451

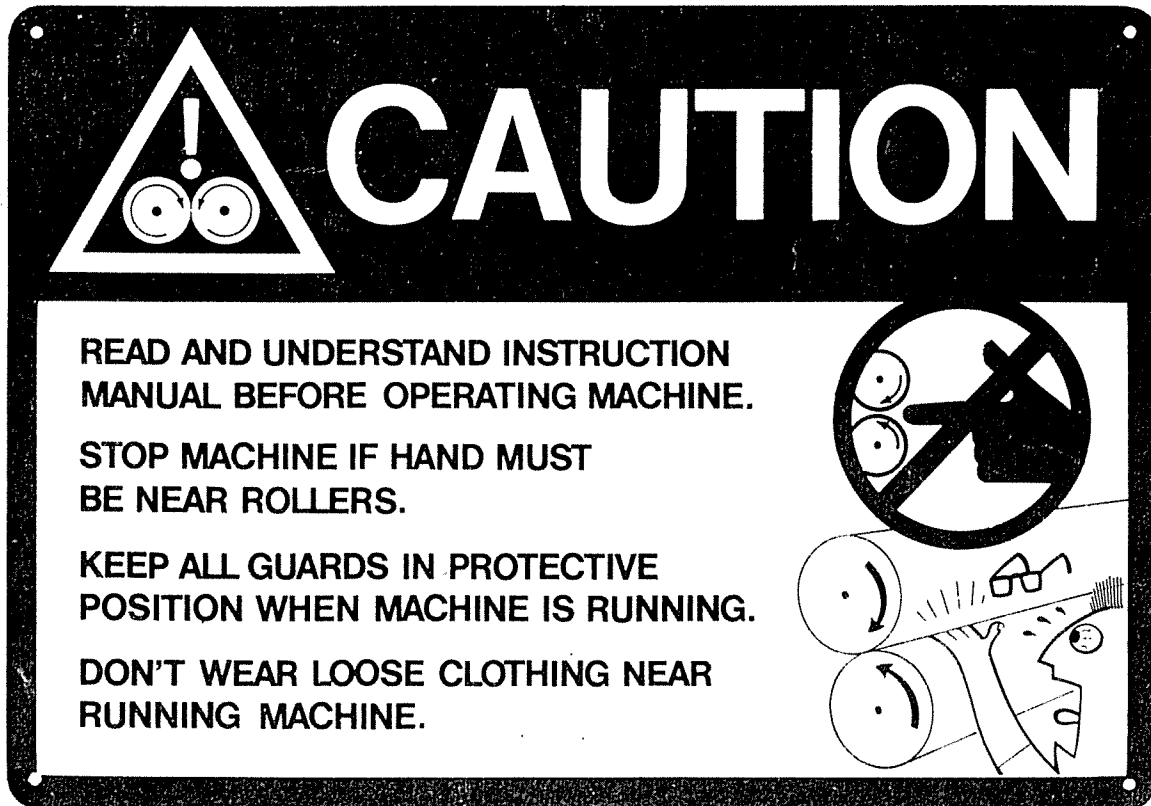
Sharing Advances in Applied-Roll-Engineering

KEEP WARNING PLATES ON YOUR MACHINE IN CLEAR VIEW AT ALL TIMES



OPERATING CAUTION	CAUTION	CLEANING CAUTION
<p>READ AND UNDERSTAND OPERATING INSTRUCTIONS BEFORE RUNNING THIS MACHINE</p> <p>KEEP ALL GUARDS IN PROTECTIVE POSITION WHENEVER MACHINE IS RUNNING</p>	 <p>KEEP AWAY FROM REVOLVING ROLLS</p> <p><small>© BLACK BROTHERS CO.</small></p>	<ol style="list-style-type: none"> 1. SEPARATE TOP FROM BOTTOM ROLLS AT LEAST 3 INCHES 2. ADJUST TO SLOW SPEED (IF ADJUSTABLE) 3. DO NOT REMOVE TABLE, GUARDS, ETC., FROM RUNNING MACHINE 4. KEEP ONE HAND ON OPERATING CONTROL BAR WHILE CLEANING 5. STOP MACHINE BEFORE CLEANING TABLE, PAN, OR WIPING ROLLS (WIPE-JOG, WIPE-JOG)

Replacement Plates Supplied by Black Brothers at No Charge



3 Color 7" x 10" Metal Sign Replacements at Nominal Cost

INTRODUCTION

Throughout the world Black Brothers machines are meeting today's demands for faster, more accurate, and more economical production.

More than a century of experience has given Black Brothers a thorough understanding of the wants and needs in practically every segment of the finishing and laminating industry. As a result, Black Brothers machines are of the most advanced design for speed, accuracy, safety, cleanliness and economy.

This instruction manual is intended for maintenance personnel. It should be kept available for immediate reference so that maintenance can be performed with maximum efficiency and satisfaction.

For additional information regarding machine function and operation, see "Operating, Servicing and Safety Instruction Manual."

ZELLERBACH DIVISION-MEAD

Machine # **775 - 68" Top and Bottom Adhesive Spreader**

Serial No. **192918**

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775 Adhesive Spreader

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Automatic Clean-Up Bulletin		Bul. ACU
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		A-3574-0211
Parts List	Cat. No.6012G,STRS(10/88)	Pages 104 & 105

SD-235	Preventive Maintenance Check Sheet	
SD-236.1	When Changes Occur	
SD-238	Old Worn Out Rollers Return	
PES	Non Metallic End Seals	
	Black Bros. Co. Bulletin	# 775

M-N.9	Safety Information Envelope Containing:			
	Letter	TSW	P2	P11.3
	DS1.4	VHS	P9	P8.6
	PIT	P1.1	P3	S4-E

MACHINE PURPOSE

To uniformly, economically, and precisely apply a wide variety of liquid materials to flat stock or panels.

This is accomplished by the proper combination of roll surface, hardness, pressure, and the interrelationship of rolls.

HOW YOUR MACHINE FUNCTIONS

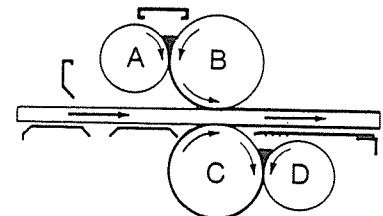
Coating material in the crotch type reservoir is metered by the doctor roll (A or D) onto the applicator roll (B or C) which applies it to stock passing through the machine. (See Fig. 2)

Adjustment for stock thickness is set with the large handwheel (G). The amount of coating material to be deposited is determined by the doctor roll adjustment. (H) (See Illustration - Sec. III, Pg. 6)

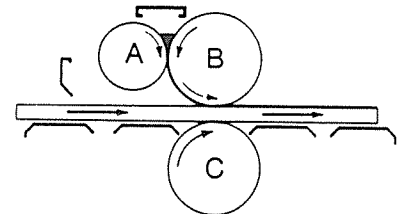
Coating material is fed to the reservoir by pumping system, gravity tank, or pouring from containers. Reservoir ends are closed with "end seals" or dams (I).

Stock is fed to the machine and removed by conveyor or by hand.

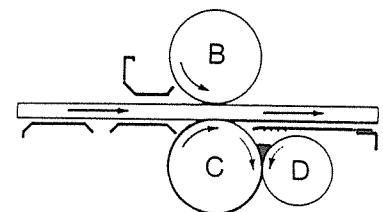
ROLL ARRANGEMENT:



Top and Bottom Coating



Top Coating



Bottom Coating

Fig. 2



BLACK BROS. CO.

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PAGE

1

501 NINTH AVENUE
 P.O. BOX 410
 MENDOTA, ILLINOIS 61342-0410
 PHONE: 815-539-7451
 FAX: 815-538-2451

ORDER NUMBER: 192918

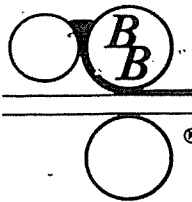
SOLD TO 0569400
 EDWARD B MUELLER CO INC
 101 E BENSON ST
 CINCINNATI, OH 45215-3899

SHIP TO 0900530
 ZELLERBACH DIVISION-MEAD
 1000 E GRANT ST
 HARTFORD CITY, IN 47348

Machine Specifications

ORDER DATE:		CUSTOMER ORDER:		SALES REPRESENTATIVE:		
08/28/95		33623		BLACK BROS CO		
			F.O.B.	SHIP VIA:		
			MENDOTA, IL (DGJ)	HOLLAND		
LINE #	QUANTITY	UM	ITEM	DESCRIPTION	UNIT PRICE	EXTENDED PRICE
10	1.00	EA	#775	ADHESIVE SPREADER		
20				TOP & BOTTOM SPREADER 68" NOMINAL LENGTH APPLICATION: APPLY PSA TO NON- WOVEN FABRIC, THIN FOAM AND FILM IN WEB FORM		
30				MECHANICAL ELEVATOR, 0 - 4-1/2" OPENING HANDWHEEL ON RIGHT END PASS LINE HEIGHT, 30"		
40	2.00	EA	4-9811-0068EF	COATING ROLL, 7-3/4" O.D., EPT 40 DURO, GROUND SMOOTH PER A2321		
50	2.00	EA	4-9821-0068EF	DOCTOR ROLL, 6-7/8" O.D., EPT 90 DURO, GROUND SMOOTH PER A2320		
60				SINGLE HANDWHEEL DOCTOR ROLL ADJUSTMENT WITH INDICATOR HANDWHEEL ON RIGHT END		
70				VARIABLE SPEED DRIVE - MECHANICAL ADJUSTABLE 1-1/2 H.P., 30 TO 150 FPM ON LEFT END		
80				PIVOTING INFEED TABLE		

Acceptance of this order is expressly made conditional on buyer's assent to the terms and conditions on the reverse side of this order acknowledgment. Such terms and conditions shall become part of this contract of sale.



BLACK BROS. CO.

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PAGE 2

501 NINTH AVENUE
 P.O. BOX 410
 MENDOTA, ILLINOIS 61342-0410
 PHONE: 815-539-7451
 FAX: 815-538-2451

ORDER NUMBER: 192918

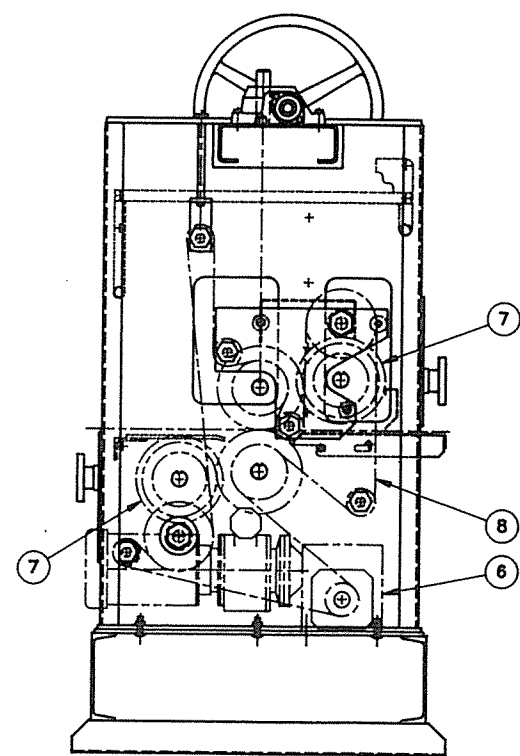
0569400
 SOLD TO EDWARD B MUELLER CO INC
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0900530
 SHIP TO ZELLERBACH DIVISION-MEAD
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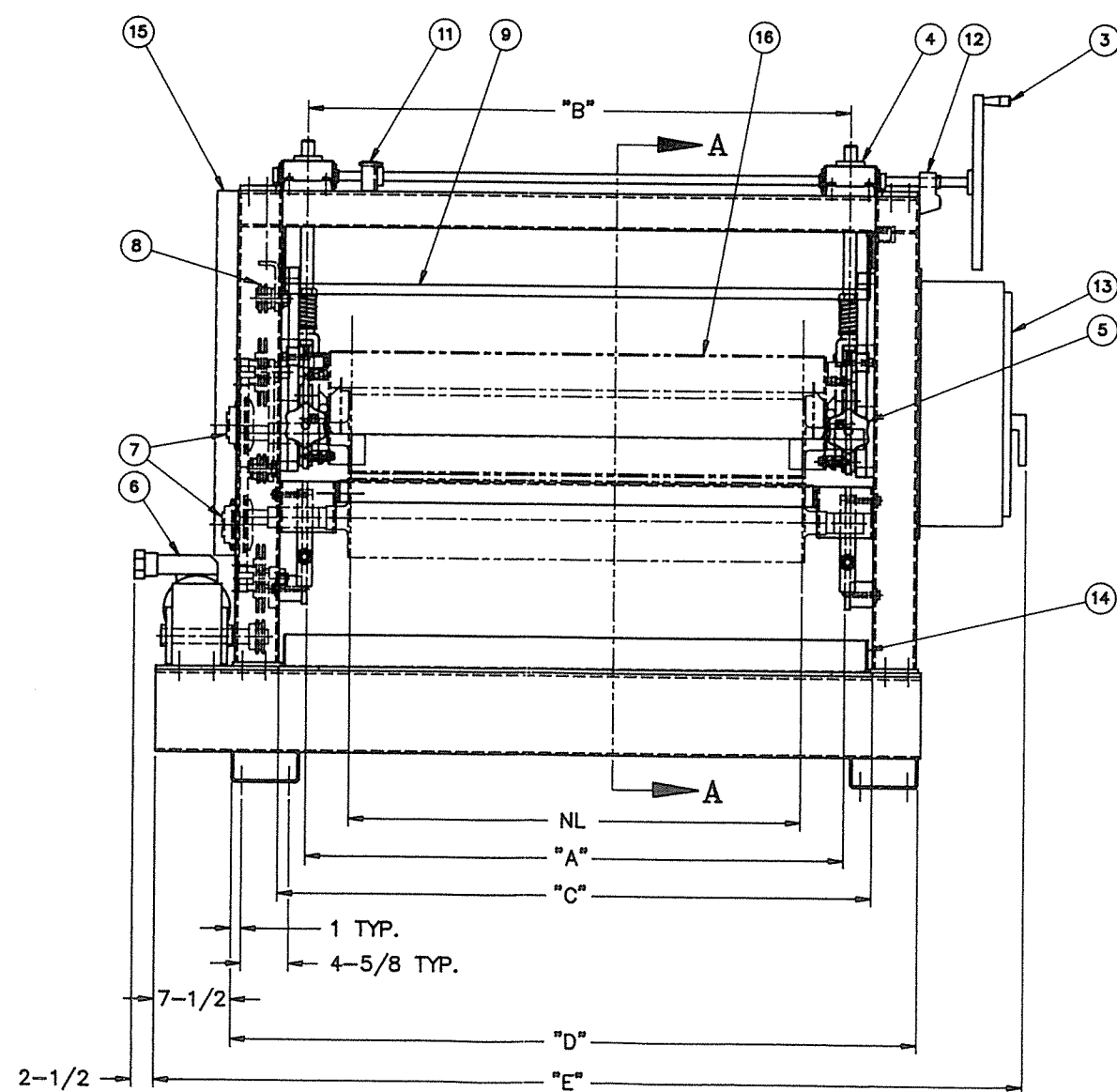
ORDER DATE: 08/28/95	CUSTOMER ORDER: 33623	SALES REPRESENTATIVE: BLACK BROS CO
	F.O.B. MENDOTA, IL (DGJ)	SHIP VIA: HOLLAND

LINE #	QUANTITY	UM	ITEM	DESCRIPTION	UNIT PRICE	EXTENDED PRICE
90				OPERATING CONTROL BARS		
100				ROLL OPENING INDICATOR ON RIGHT END		
110				ELECTRICAL INTERLOCK ON NIP GUARD (TOP AND BOTTOM)		
120				NEMA 12 ELECTRICAL ENCLOSURE WITH 115 VOLT CONTROL & FUSE DISCONNECT SWITCH 230 VOLT, 3 PHASE, 60 HERTZ ON RIGHT END		
130				AUTOMATIC ROLL CLEANING SYSTEM INTERLOCKED SO ROLLS MUST BE SEPARATED 3" FOR CLEAN-UP MODE		
140				STANDARD PAINT - HAMMERTONE BLUE		
150	1.00	EA		7-7924-2890 CLEAN-UP VIDEO MACHINE SERIAL NO. 192918		

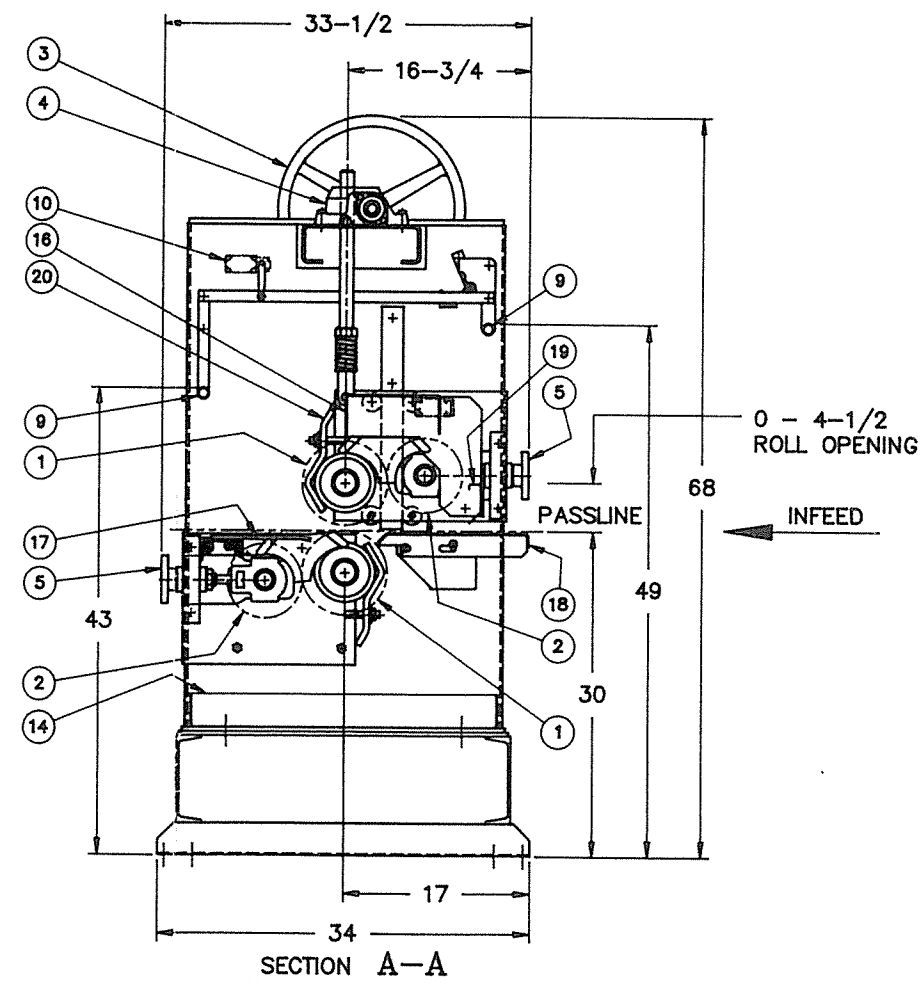
- | NO. | DESCRIPTION |
|-----|---|
| 1 | 7-3/4 DIA. RESILIENT COVERED COATING ROLL |
| 2 | 6-7/8 DIA. RESILIENT COVERED DOCTOR ROLL |
| 3 | ROLL OPENING ADJUSTMENT HAND WHEEL |
| 4 | ROLL OPENING ADJUSTMENT GEARBOX |
| 5 | INDIVIDUAL DOCTOR ROLL OPENING ADJUSTMENT HANDWHEEL |
| 6 | VARIABLE SPEED DRIVE, ___HP, ___TO___FPM |
| 7 | 5:1 DOCTOR ROLL GEAR DRIVE WITH TORQUE LIMITER |
| 8 | #D40 ROLLER CHAIN DRIVE |
| 9 | OPERATING CONTROL BAR |
| 10 | OPERATING CONTROL BAR NEUTRAL POSITION LIMIT SWITCH |
| 11 | DIFFERENTIAL COUPLING TO PARALLEL ROLLS |
| 12 | ROLL OPENING INDICATOR |
| 13 | NEMA 12 ELECTRICAL ENCLOSURE |
| 14 | DRIP PAN |
| 15 | GEAR AND CHAIN COVER |
| 16 | PIVOTING ROLL NIP GUARD |
| 17 | PIVOTING FINGERS |
| 18 | PIVOTING INFEED TABLE |
| 19 | BARRIER GUARD |
| 20 | COATING ROLL RETAINER |



LEFT END VIEW



INFEED VIEW



SECTION A-A

DIMENSION CHART

	NL		
SYM.	44"	56"	68"
"A"	52-1/2	64-1/2	76-1/2
"B"	53	65	77
"C"	58	70	82
"D"	67	79	91
"E"	84-3/4	96-3/4	108-3/4

NOTICE	
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SERIAL NUMBER	
DWG NUMBER REF	
DISK NUMBER	A-1-D19
DATE	6/17/93
DRAWN BY	A.P.
CHECKED BY	

BLACK BROS. CO.		
MENDOTA, IL		
#775 ADHESIVE SPREADER TOP AND BOTTOM W/ VARIABLE SPEED DRIVE		
SCALE	SHEET	DRAWING NUMBER
NONE	1 OF 1	4-1249-0100