

# YOUR GUIDE TO PANEL LAMINATING



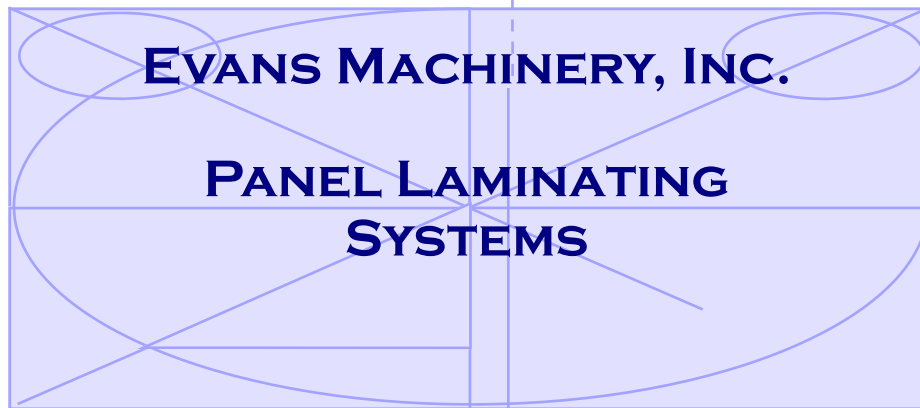
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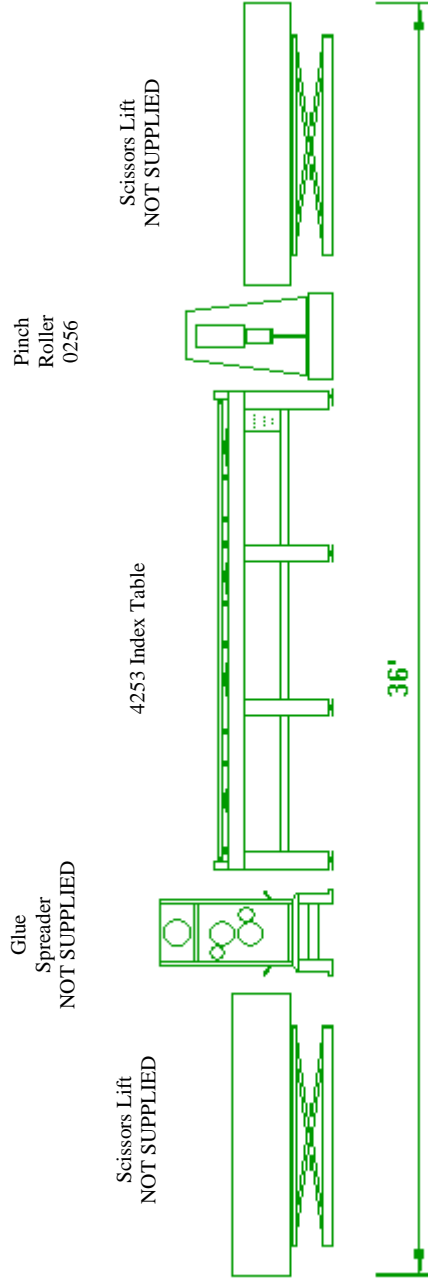
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**PVA PANEL LAMINATING**  
 DOUBLE OR SINGLE SIDED SYSTEM FOR FULL SIZE  
 SHEETS OR CUT TO SIZE PARTS.  
 Layout# 1

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Description	Model Number	Electrical	Air/Water Requirements	Application	Approx. Weight	Dimensions L X W X H	Price
Scissors Lift				Allows infeed of board to enter Glue Spreader at the correct height			NOT SUPPLIED
Glue Spreader				Applies glue to substrate Infeed fence required			NOT SUPPLIED
Index Table	4253	no electric	80 PSI	Aligns substrate to laminate	1800 LBS.	174 X 87 X 55	18,500.00
Pinch Roller with Riser Base to 40"	0256	110 Volt	80 PSI	Applies pressure to insure bond	740 LBS.	84 X 33 X 57	5,950.00 300.00
Scissors Lift				Used to stack finished product			NOT SUPPLIED

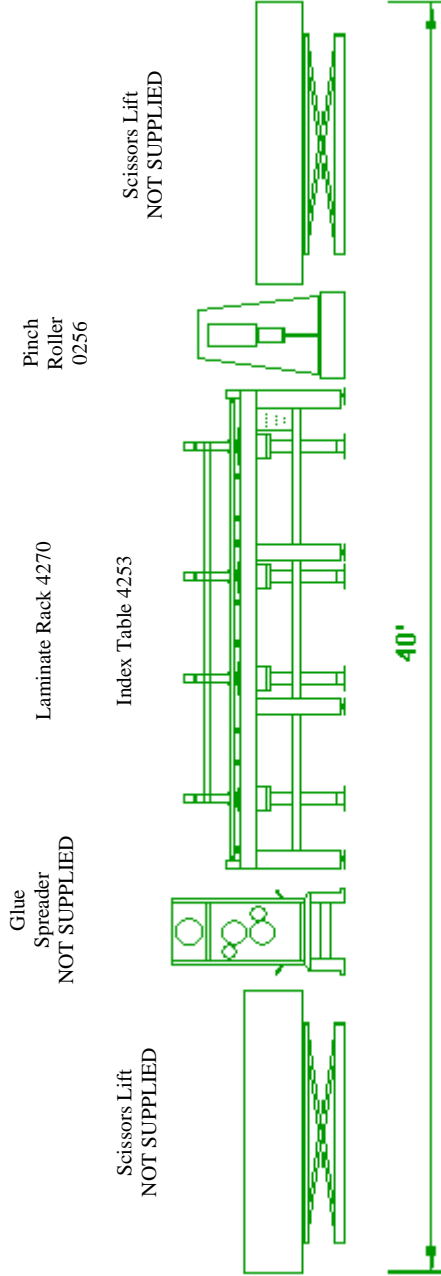
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Description	Model Number	Electrical	Air/Water Requirements	Brief Application	Approx. Weight	Dimensions L X W X H	Price
Scissors Lift				Allows infeed of board to enter Glue Spreader at the correct height			NOT SUPPLIED
Glue Spreader				Applies glue to substrate Infeed fence required			NOT SUPPLIED
Index Table	4253	no electric	80 PSI	Aligns substrate to laminate	1800 LBS.	174 X 87 X 55	18,500.00
Laminate Rack With 2nd rack	4270	None	80 PSI	Laminate storage and staging area	2000 LBS.	125 X 70 X 65	12,500.00
Pinch Roller with Riser Base to 40"	0256	110 Volt	80 PSI	Applies pressure to insure bond	740 LBS.	84 X 33 X 57	5,950.00 300.00
Scissors Lift				Used to stack finished product			NOT SUPPLIED

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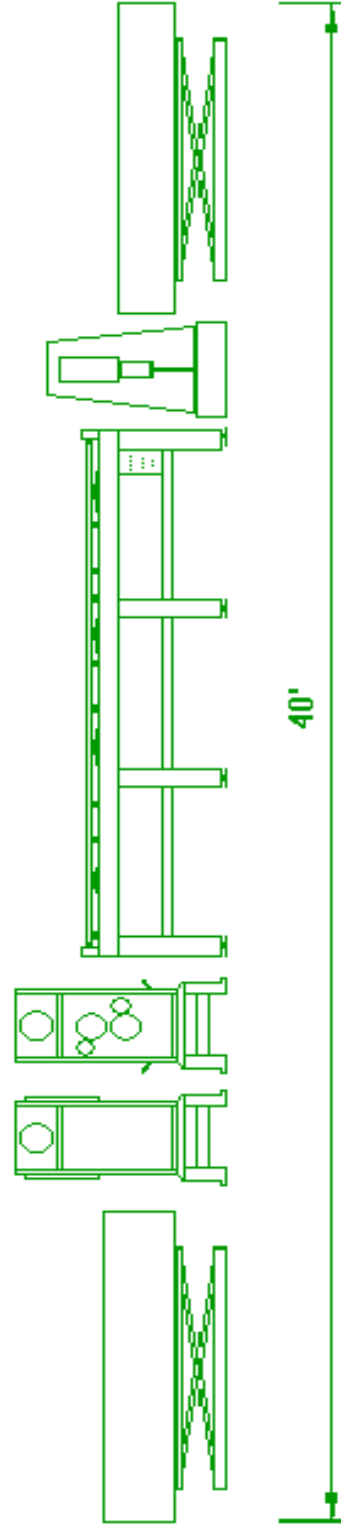


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Scissors Lift NOT SUPPLIED	Panel Cleaner 90200	Glue Spreader NOT SUPPLIED	Index Table 4253 or 4263 Laminate Rack 4270	Pinch Roller 0256	Scissors Lift NOT SUPPLIED
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Description	Model Number	Electrical	Air/Water Requirements	Brief Application	Approx. Weight	Dimensions L X W X H	Price
Scissors Lift,				Allows infeed of board to enter Glue Spreader at the correct height			NOT SUPPLIED
Panel Cleaner with Riser Base	4700	220 Volt 3 Ph	None	Cleans panel comes with infeed fence	1200 LBS.	100 X 30 X 60	19,430.00 445.00
Glue Spreader				Applies glue to substrate Infeed fence required			NOT SUPPLIED
Index Table	4253	None	80 PSI	Aligns laminate to board	1700 LBS.	174 X 87 X 55	18,500.00
Pinch Roller with Riser Base to 40"	0256	110 volt	80 PSI	Applies pressure to insure bond	740 LBS.	84 X 33 X 57	5,950.00 300.00
Scissors Lift,				Used to stack finished product			NOT SUPPLIED

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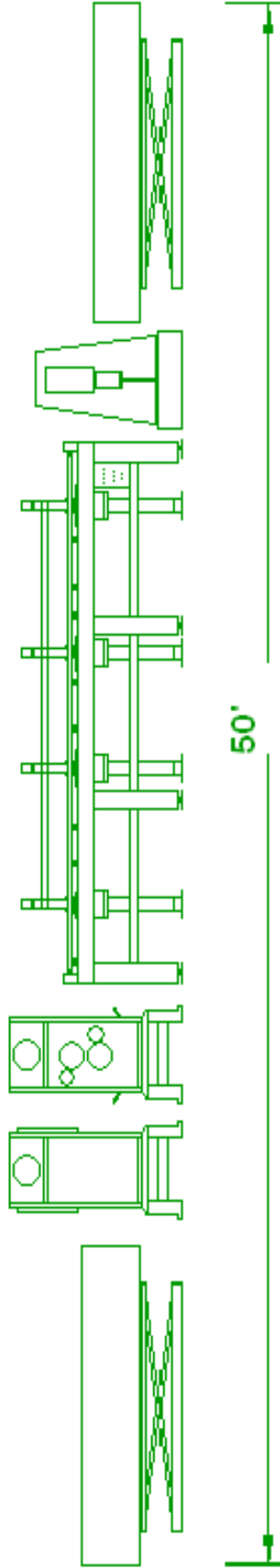


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**PVA PANEL LAMINATING**  
 DOUBLE OR SINGLE SIDED SYSTEM FOR FULL SIZE  
 SHEETS OR CUT TO SIZE PARTS.  
 Layout# 4

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Scissors lift NOT SUPPLIED	Panel Cleaner 90200	Glue Spreader NOT SUPPLIED	Manual Index Table 4253	Pinch Roller 0256	Scissors Lift NOT SUPPLIED
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Description	Model Number	Electrical	Air/Water Requirements	Application	Approx. Weight	Dimensions L X W X H	Price
Scissors Lift,				Allows infeed of board to enter Glue Spreader at the correct height			NOT SUPPLIED
Panel Cleaner with Riser Base	4700	220 Volt 3 Ph	None	Cleans panel comes with infeed fence	1200 LBS.	100 X 30 X 60	19,430.00 445.00
Glue Spreader				Applies glue to substrate Infeed fence required			NOT SUPPLIED
Index Table	4253	None	80 PSI	Aligns laminate to board	1700 LBS.	174 X 87 X 55	18,500.00
Laminating Rack optional second rack	4270	None	80 PSI	Laminating storage and staging area	2000 LBS.	125 X 70 X 65	12,500.00
Pinch Roller with Riser Base to 40"	0256	110 volt	80 PSI	Applies pressure to insure bond	740 LBS.	84 X 33 X 57	5,950.00 300.00
Scissors Lift,				Used to stack finished product			NOT SUPPLIED

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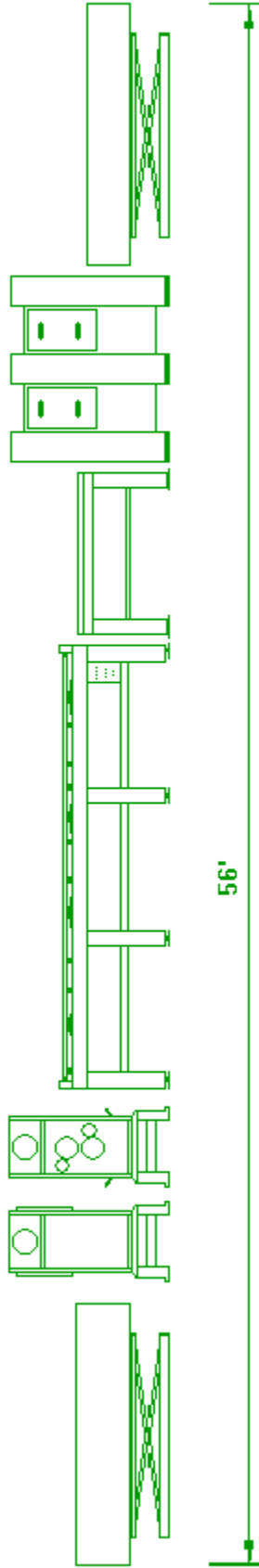


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Scissors Lift NOT SUPPLIED  
 Panel Cleaner 4700  
 Glue Spreader NOT SUPPLIED  
 Index Table 4253 or 4263  
 Conveyor 4267  
 Heat Tunnel 4603 or 4604  
 Scissors Lift NOT SUPPLIED  
 Laminate Rack



Description	Model Number	Electrical	Air/Water Requirements	Application	Approx. Weight	Dimensions L X W X H	Price
Scissors Lift,				Allows infeed of board to enter Glue Spreader at the correct height			NOT SUPPLIED
Panel Cleaner with Riser Base	4700	220 Volt 3 Ph	None	Cleans panel comes with infeed fence	1200 LBS.	100 X 30 X 60	19,430.00 445.00
Glue Spreader				Applies glue to substrate Infeed fence required			NOT SUPPLIED
Index Table Manual	4253	None	80 PSI	Aligns laminate to board	1700 LBS.	174 X 87 X 55	18,500.00
Laminate Rack optional 2nd rack	4270	None	100 PSI	Laminate storage	2000 LBS.	125 X 70 X 65	12,500.00
Conveyor	4267	None	None	Staging area	1000 LBS.	120 X 75 X 43	No longer available
Scissors Lift,				Used to stack finished product			NOT SUPPLIED

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PVA

VS.

Contact Adhesive

COMPARISON	PVA	Contact Adhesive
GLUE COST	.02 - .03 PER SQUARE FOOT	.08 -.10 PER SQUARE FOOT
SAFETY	NON-FLAMMABLE	FLAMMABLE
METHOD TO APPLY	GLUE SPREADER	SPRAY GUN
TIME TO APPLY	10 SECONDS 4 x 8 SHEET	SEVERAL MINUTES
APPLICATION	APPLY TO CORE ONLY	APPLY TO BOTH CORE AND LAMINATE
TOXICITY	NON-TOXIC	TOXIC
CLEAN UP	WATER	SOLVENT
CUSTOMER PREFERENCE	YES	NO

## BOTTOM LINE

**PVA IS LESS EXPENSIVE, SAFER TO USE, LESS LABOR INTENSIVE TO APPLY, NON-TOXIC, EASY TO CLEAN UP, OSHA APPROVED, AND YOUR CUSTOMERS WILL LIKE IT BETTER.**

# MODEL 4700 PANEL CLEANER

The 4700 Panel Cleaner is designed to clean both top and bottom of the substrate prior to the glue spreader. Without a doubt this machine will save you time and insure dimples are no longer causing you to reject parts, a common problem when processing high gloss laminates. The ten inch nylon brushes will give you years of trouble free, dependable service. The 4700 comes standard with infeed and outfeed power feed rollers equipped with cam clutch bearings to reduce excessive wear on Glue Spreader.



## Technical Specifications:

MACHINE LENGTH	26 inches
MACHINE WIDTH	90 inches
MACHINE HEIGHT	55 inches
ELECTRICAL	220 volt 3 phase
MOTORS	1 1/2 hp Brushes 1/2 hp Drive
CFM REQUIREMENT	2600



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# 4700 PANEL CLEANER DOUBLE SIDED BY EVANS MACHINERY, INC.

4700 Double Sided Panel Cleaner. Left to right hand feed.  
220 volt 3 phase

19,430.00

Standard Features:

- 1 1/2 hp brush motor
- 1/2 hp drive motor
- 62" width capacity
- Feed rate 60 fpm.
- Working height 30"
- Cam clutch on Infeed drive roll to allow use of panel cleaner coupled with a Glue Spreader
- Two 10" nylon brushes
- Infeed fence with extension to glue spreader to help insure proper alignment.
- Convenient elevator hand wheel with built in roll opening indicator.
- Custom design hold down rollers move with upper brush assembly
- 4 each 6" dust collection outlets
- Power Infeed and outfeed rollers
- Start and stop buttons, on/off indicator lamp,
- Magnetic starter with overload protection.
- Emergency stop device located on both Infeed and out feed sides.

The Model 4700 is newest addition to the Evans Machinery family of laminating systems. The Panel Cleaner is designed to clean the top and bottom of the substrate prior to the glue spreader. The use of a panel cleaner will eliminate the manual process of cleaning your panel and ultimately result in a high quality bond. The model 4700 requires minimal floor space and is equipped with a efficient airflow system for maximum dust pickup. Built for durability and longevity, the 4700 provides a compact and economical approach to removing debris from your panels. The system requires a minimum 2600 CFM dust collector.

For right to left hand feed or working height other than 30" call for quotation.



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# EVANS MODEL 4253

## SEMI-AUTOMATIC LAMINATING INDEX TABLE

PROVEN A PERFECT FIT WITH  
ALL PVA LAMINATING SYSTEMS



ALSO AVAILABLE FOR COLD  
PRESS OPERATIONS

With over 40 years of proven reliability, the Evans Machinery Model 4253 Index Table is a great addition to any continuous laminating system. The 4253 provides for a single sheet of substrate to be laminated on both sides, and no one touches the glue line. The unique design conveys the board from the glue spreader and automatically positions and drops it on the bottom sheet of laminate with a minimal amount of effort by the operator. The operator then places the top sheet on the board. Custom design stops index the laminate to the board every time.

This economical system is sure to score big with your laminating department. Let this workhorse go to work for you today and see an instant improvement in quality, and production.

A great addition to the 4253 is the 4270 Laminate Rack. Be sure to ask for more information on this labor and time saving device.

The 4253 can be custom fit to your specifications, so rather your using a Hot Press, Cold Press, or a continuous laminating system the Evans Index Table can go to work for you.

## TECHNICAL SPECIFICATIONS

Air Requirement	100 PSI	Maximum Board Size	61" X 145"
Working height In-Feed	43"	Working Height Out-Feed	40"
Foot print	177" x 87"	Weight (crated)	1200 LBS



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## 4253 SEMI-AUTOMATIC INDEX TABLE



- 4253 Automated Index Table. Left to right hand feed. \$ 18,500.00  
 80 PSI Required.  
 Max. Board size, 61" X 145"  
 Min. Board size, 11" X 48"  
 Infeed height 43"  
 Outfeed height 40".  
 Center conveyors supplied.  
 18" extensions on infeed side.  
 Hand crank for width adjustment, one revolution equals 7".  
 Adjustable guides for board positioning.  
 Width opening indicator- scale with pointer  
 Width opening locking device, pneumatic break  
 Heavy duty steel construction  
 Leveling feet.  
 Foot print, 87" X 169" plus 18" extensions

### Application:

To assist in assembling a sheet of single or double sided PVA laminated board.

The 4253 receives board with adhesive applied from glue spreader using custom design transfer rollers without disturbing the glue line. When the board is transferred to the outfeed end, the board will automatically fall and index to the pre-applied backer or laminate. Then the top sheet is applied and indexed to the board. With the board laminated on both top and bottom the transfer to the Evans Heat Tunnel or Hot press can now take place. This operation requires minimal effort from the operator.

Right to left hand feed add \$2,895.00. Working over 43" add \$235.00



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# MODEL 4270 LAMINATE RACK



4253 Index Table **not** included with 4270

The Model 4270 Tilting Laminate Rack is by far the most innovative addition to the Evans line of laminating equipment to date. The unique design allows the laminate to be handled and properly indexed to the substrate with only one operator. So if you ever wondered if one man could easily handle a 5 X 12 sheet of laminate in your laminating line than wonder no more.

The 4270 is capable of handling up to 80 sheets of 5 X 12 standard grade laminate or 1600 pounds collated backer and laminate. The tilting arms represent a safe and sensible alternative to handling your laminate. The 4270 is sold as a retrofit for 4200 series Index tables already in service or ordered as part of a new system.

Pricing FOB Glendale, Arizona, is as follows:

Evans Tilting Laminate Rack Two Levels

100 PSI no electric

4270 Laminate Rack

\$ 12,500.00

4270 Retrofit Laminate Rack

\$ 12,500.00

## Technical Specifications:

MACHINE LENGTH	135 inches
MACHINE WIDTH	85 inches
MACHINE HEIGHT	60 inches
AIR REQUIREMENT	100 PSI



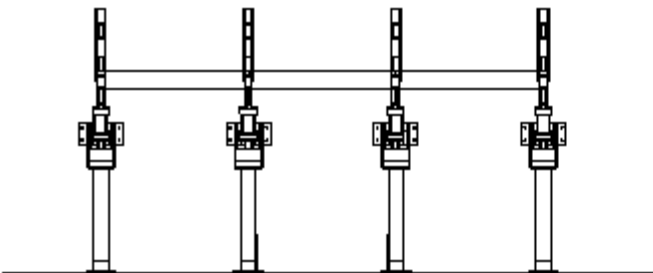
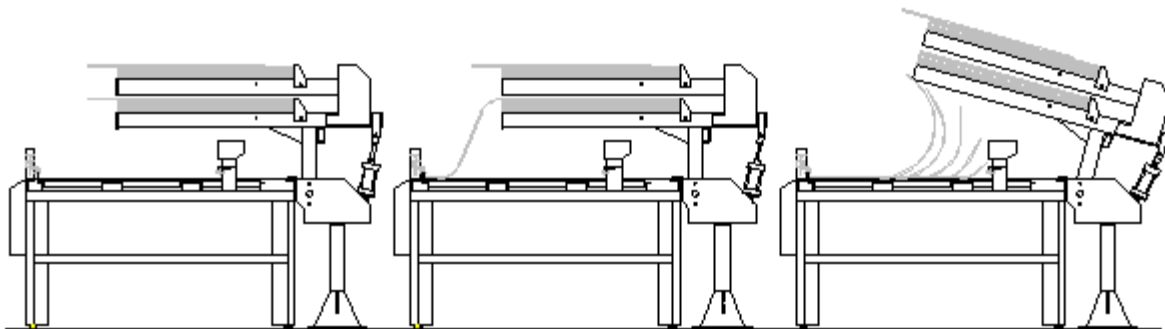
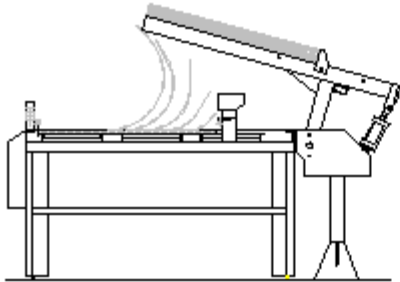
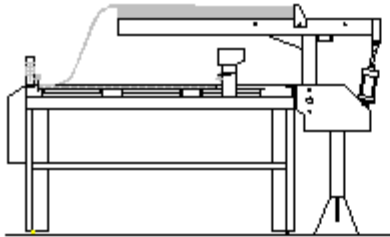
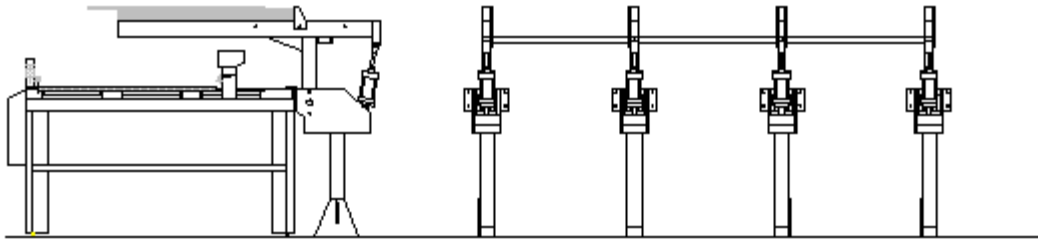
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The Evans Machinery Inc. Model 0256 Pinch Roller is a key asset for laminating shops both large and small. The top roller is easily adjustable to the thickness of the work being laminated. Simply insert the provided spacers 1/8, 1/4, 1/2, and 3/4. You can use any combination to acquire the desired thickness.

The 0256 is specifically designed to laminate using either contact adhesives or the fast bond PVA's. The Evans unique design of the pressure roller allows for uniformed and even bonding of the laminate to the substrate.

Compare the features and performance. You too will make the same choice professionals all over the world have been making for over 35 years. Evans Machinery still the number one choice.

## MODEL 0206/0256 PINCH ROLLER



0206 61" Segmented Bottom Roller For  
Countertop Fabrication

0256 61" Solid Bottom Roller (shown)

### Technical Specifications:

Electrical	110 VOLT
Air	100 PSI
Working Height	30"
L X W X H	61"X28"X48"
Drive Motor	1/2 HP
Feed Rate	50 FPM
Maximum Material Width	61"

- Bonds at 50 Feet Per Minute
- Safety Gate Helps Prevents Bodily Injury
- Fast, Accurate Thickness Adjustment
- Bottom Roller Segmented Available for Working With a Buildup.
- Heavy Duty Construction



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**0206/0256  
PINCH ROLLER  
BY  
EVANS MACHINERY, INC.**

- |                                                                                                                                                                                                                                                                                                                                                                                                                    |                    |
|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------|
| <p>0206 Pinch Roller, 62"<br/>Segmented bottom rollers<br/>115 Volt, 1 Phase, 100 PSI required<br/>50 lineal feet per minute<br/>30" working height<br/>Forward and reverse drive roller<br/>Safety gates on both infeed and outfeed sides<br/>(Automatically raises top roller)<br/>Positive top roller adjustment<br/>Roll opening to 4"<br/>35 pounds per lineal inch at 100 PSI (48" material)<br/>740 LB.</p> | <p>\$ 6,050.00</p> |
| <p>0256 Pinch Roller, 62"<br/>Solid bottom roller<br/>115 volt 1 phase, 100 PSI<br/>50 lineal feet per minute<br/>30" working height<br/>Forward and reverse drive roller<br/>Safety gates on both infeed and outfeed sides<br/>(Automatically raises top roller)<br/>Positive top roller adjustment<br/>Roll opening to 4"<br/>35 pounds per lineal inch at 100 PSI (48" material)</p>                            | <p>\$ 5,950.00</p> |

**Both machines are ideal for use with high solid PVA adhesive or contact glue**

Call for quote on working height over 30"



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# MODEL 4604 HEATED ROLLER PRESS

The Evans Machinery Model 4604 Heat Tunnel provides an efficient, compact method of laminating high pressure laminate to a substrate using an environmentally safe, non-flammable, water soluble PVA adhesive. Operates in less than half of the space of a cold or hot press.

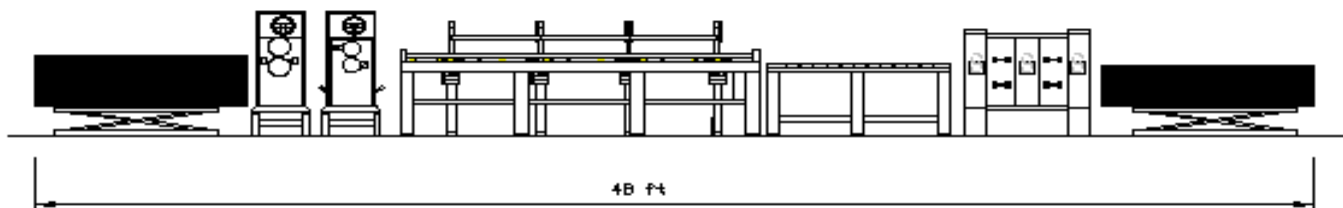
The Heat Tunnel uses radiant heaters and silicone nip rollers for a continuous cure and a consistent quality bond. With simplicity and economy in mind, the model 4604 is available by itself or as part of a complete system. Also available as a single sided model.

### Technical Specifications:

Electrical	440 VOLT 3 Phase
Air	100 PSI
Working Height	40"
L X W X H	52"X80"X58"
Drive Motor	3/4
Feed Rate	1-15 FPM
Maximum Material Width	61"
Minimum Length	24'



4700 PANEL CLEANER    4800 GLUE SPREADER    4270 LAMINATE RACK    4252 INDEX TABLE    CONVEYOR    4604 HEAT TUNNEL



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## 4604 HEATED ROLLER PRESS BY EVANS MACHINERY, INC.

4604 Evans Double Sided Heat Tunnel  
440 volt 3 phase, 100 PSI req.  
1-12 FT. per min.  
Max. width 61"  
Max. length unlimited, min. length 24"  
50 amp service  
3 sets nip rollers with quick change thickness adjustment  
Foot print 60" X 72" wide  
40" working height

NO LONGER AVAILABLE

Advantages of continuous feed roller press:

The ability to work the part within minutes.

The freedom to run 1 part without the burden of using fillers to complete mandatory stack height with cold press operation.

Allows you to run hundreds without creating a stopgap on large runs.

Allows you to laminate various length and width parts on a continuous basis

The ability to use less glue thus eliminating squeeze out that results in boards bonded together and damaging the surface of the laminate. The use of excessive glue is required in cold press operations to eliminate precure of glue.

Reduces material handling and material handling equipment required with cold press or hot press.

The Evans 4600 series Continuous press requires less floor space than a cold press or hot press operation.

Application:

Accepts substrate pre-glued with laminate applied through first set of nip rollers. The product is then heated before entering the 2nd set of nip rollers greatly expediting the curing process. The feed rate will depend on the desired tack of the laminate to the substrate. Below is an example of an operation where machining the product within minutes is desired.

Board: 3/4" Particle board.

Glue: WilsonArt WA3000 adhesive at 5-6 wet mills per side.

Laminate: Standard grade laminate on top side.

Oven temperature setting: 800 degrees (surface temperature of heater)

Feed Rate: 8 to 10 feet per minute. Exit temperature of part to be 125-135 degrees Fahrenheit.



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PHONE 623-934-7294 FAX 623-934-7384

**PVA adhesives for  
0256 Pinch Roller  
or  
4600 Heated Roller Press**

Manufacture	Product number	Cold Pinch	Heated Roller Press	Sprayable grade available	Glue spreader application
Wilsonart <small>When more open time is needed use LW3001</small>	LW3000	yes	yes	yes	yes
	LW3001	yes	yes	yes	yes
National Casein	50-22-9	yes	no	yes	yes
	CL1809HV	no	yes	no	yes
Franklin Adhesives	Quickset 2000	yes	yes	yes	yes
SEACO	Protact	yes	yes	no	yes
	Protact 2	yes	yes	yes	yes
Imperial	7709T	yes	yes	yes	yes
HB Fuller	RK3394-225	yes	yes	yes	yes

**CONSULT THE GLUE MANUFACTURER FOR ALL APPLICATIONS AND PRICES**

**Glue manufacturers information**

WilsonArt International	254-207-6701
National Casein	773-846-7300
Franklin Adhesives	800-487-4583
SEACO	800-359-1880
Imperial	513-351-1300
HB Fuller	651-236-5300



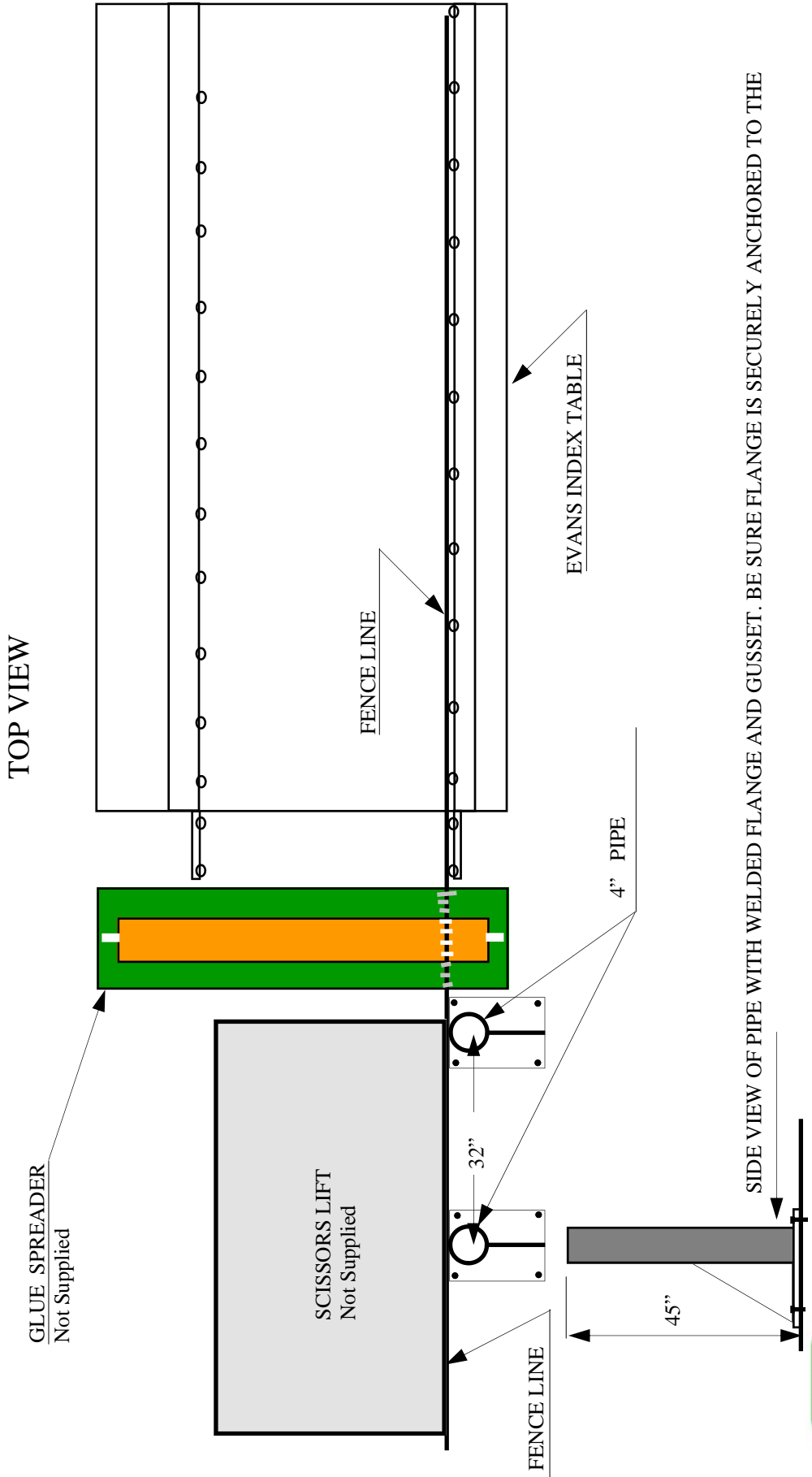
**Evans Machinery, Inc.**

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Web Address [www.evansmachineryinc.com](http://www.evansmachineryinc.com) e-mail [sales@evansmachineryinc.com](mailto:sales@evansmachineryinc.com)

The glues listed above were compiled using information provided by the glue manufacturer.  
Evans Machinery, Inc. makes no claims regarding the products performance.

POSSIBLE FENCE SET UP FOR LAMINATING LINE.  
FENCE SHOWN IS ONLY ONE OF MANY POSSIBILITIES AND IS ONLY SUPPLIED AS A GUIDE.  
CARE SHOULD BE TAKEN IN DECIDING A FENCE SYSTEM FOR YOUR APPLICATION.

DIMENSIONS SHOWN ARE TYPICAL, AND SHOULD BE CHANGED TO FIT YOUR NEEDS.



SIDE VIEW OF PIPE WITH WELDED FLANGE AND GUSSET. BE SURE FLANGE IS SECURELY ANCHORED TO THE

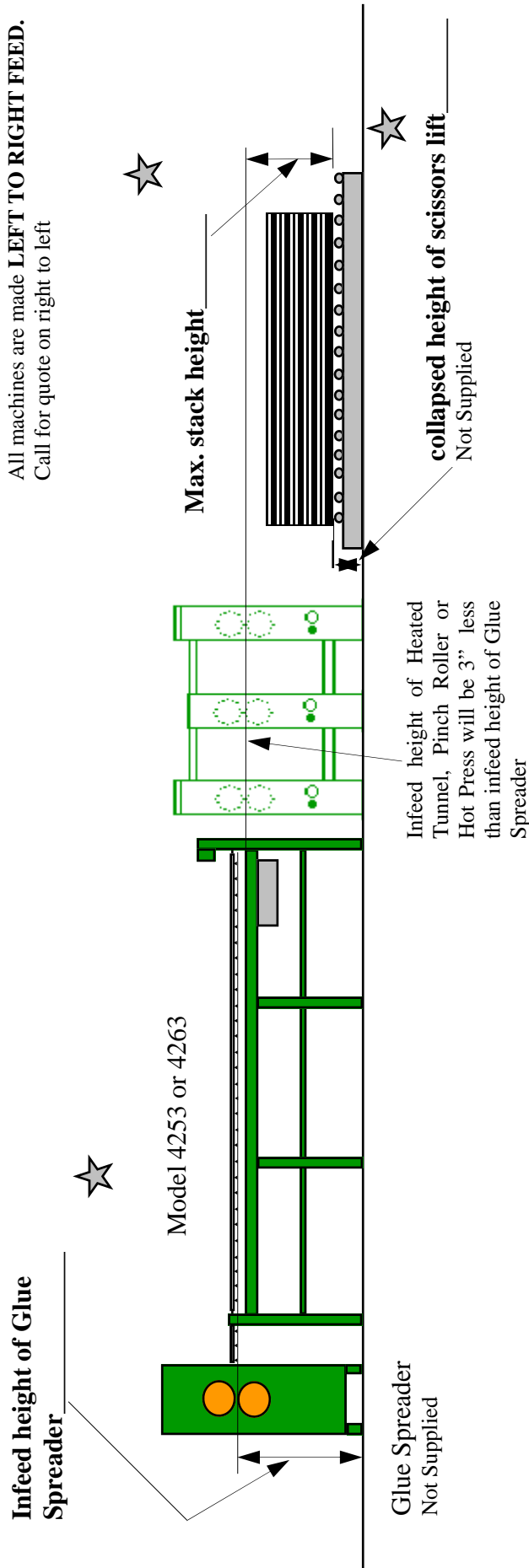


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FAX 623-934-7384

Please complete the required dimensions so that we can build the Index Table to your specification and make you aware of any changes or further requirements. ★

Below is an **example** to calculate maximum stack height. Glue Spreader infeed height 43" Once in Index Table board drops to 40" as it indexes to laminate., The collapsed height of scissors lift is 10". 40" minus 10" = 30" max. stack height. If you need maximum. stack height of 31" infeed of Glue Spreader needs to be 44". Please call for quotation on any machine other than standard working height or see price list for details.



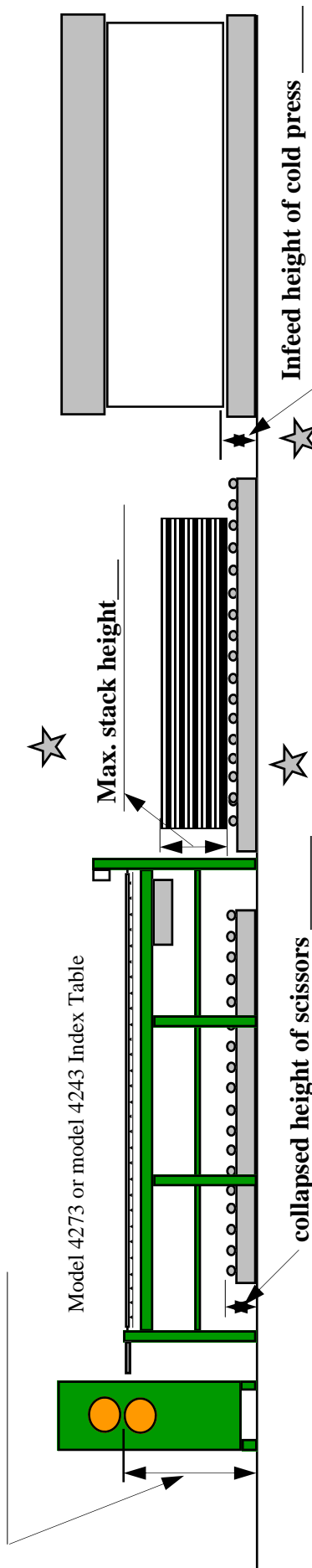
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Please complete the required dimensions so that we can build the Index Table to your specification and make you aware of any changes or further requirements. ★

Below is an **example** to calculate max. stack height.  
 Glue Spreader infeed height 43"  
 Board drops to 40", collapsed height of scissors lift is 10".  
 40" minus 12" = 30 max. stack height. If you need max. stack height of 31" infeed of Glue Spreader needs to be 44". Cold press must be same height or higher than collapsed height of scissors lift. Please call or check price list for other than standard working height.

infeed height of Glue Spreader \_\_\_\_\_ ★

All machines are made **LEFT TO RIGHT FEED.**  
 Call for quote on right to left



Glue Spreader  
 Not Supplied

Index Table with scissors lift  
 and conveyor

optional conveyor  
 Not Supplied

Cold press  
 Not Supplied



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