



无锡市任源科技有限公司

Wuxi Renyuan Technology Co., Ltd.

聚氨酯夹芯板生产浇注洒杆说明书

v2.0(中英文版)

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Specification of spraying bar for PU sandwich panel production

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一、 概述和适用范围

Summary and scope of application

聚氨酯夹芯板在生产过程中浇注布料非常关键,直接影响到聚氨酯夹芯板的质量。In the production process of PU sandwich panel, the material spraying is very key, which directly affects the quality of PU sandwich panel.

目前一般采用往复横扫浇注方式,面材再以一定速度连续向前移动,往复横扫浇注头将聚氨酯料不停来回洒到面材上。其缺点是两边浇注的聚氨酯料重复,较多。浇注时前后迭加容易夹杂着大量气泡。产品中存在气泡、芯材密度分布不一和因浇注不均匀而填充不满等缺陷。现根据多年生产经验、反复调整生产工艺研发出本浇注洒杆,采用固定浇注方式。改善传统布料浇注发泡中的缺陷,提高夹芯板品质。

At present, the method of reciprocating sweeping pouring is generally adopted, the surface material moves forward continuously at a certain speed, and the reciprocating sweeping pouring head continuously sprinkles the PU material on the surface material. Its disadvantage is that the PU material pours on both sides repeatedly and wastefully. It is easy to mix a lot of bubbles during pouring. There are some defects in the product, such as bubble, different density distribution of core material and insufficient filling due to uneven pouring. According to years' production experience and repeated adjustment of production process, this spraying bar is developed by adopting fixed pouring method. By improving the defects of traditional foam spraying, the quality of sandwich panel can also be greatly improved.

1.1. 适用范围 **scope of application:**

- ★ 聚氨酯连续线定点浇注发泡 continuous PU fixed spraying foaming;
- ★ 间歇式聚氨酯夹芯板浇注 discontinuous PU sandwich spraying;
- ★ 聚氨酯宽幅制品浇注 PU wide spraying;

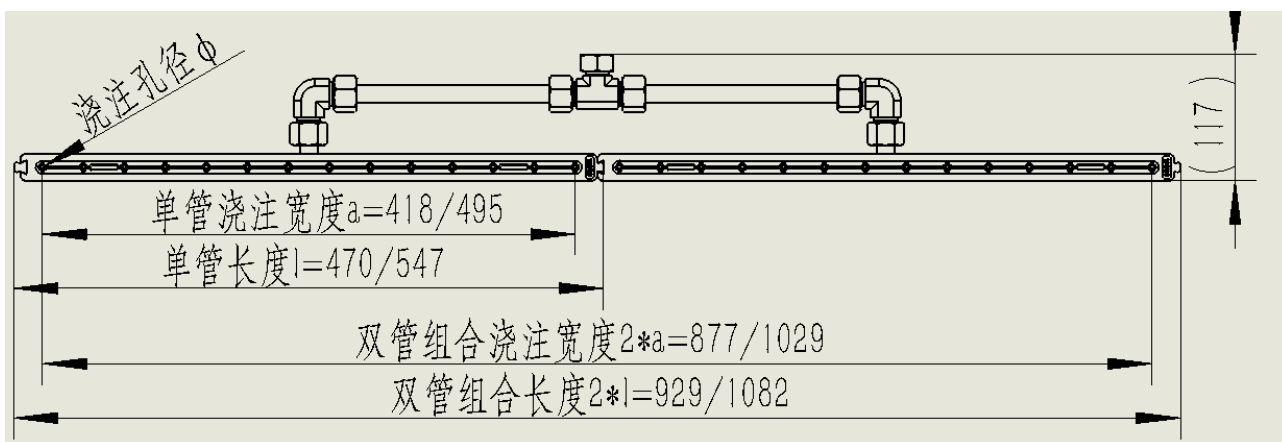


二、 组成部件结构 components





三、规格说明 specification



a (浇注宽度)					φ (浇注孔径 spraying hole diameter) mm
定型规格 fixed size	规格 size	实际浇注孔宽度 mm (Actual spraying hole width)	适用浇注范围 Mm (Scope of spraying)	浇注孔数量 Qty of spraying holes	1120 常规规格 normal size: 2.0、2.5、3.0、 1000 常规规格 normal size : 2.0、3.0、 可以定制 Customizable: 1.8、2.5、3.5、4.0、
	1000/浇注孔径 spraying aperture	877	930-1000	24	
	1120/浇注孔径 spraying aperture	1029	1120-1200	28	

推荐流量范围表 recommended flow scope

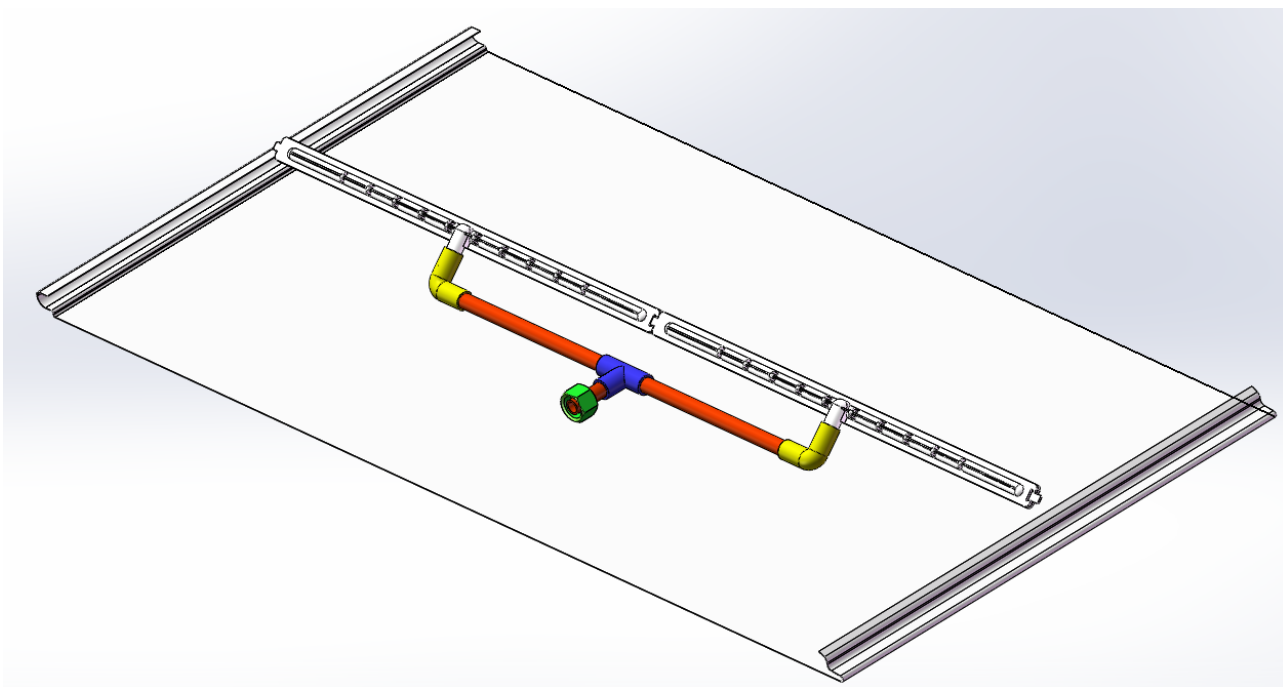
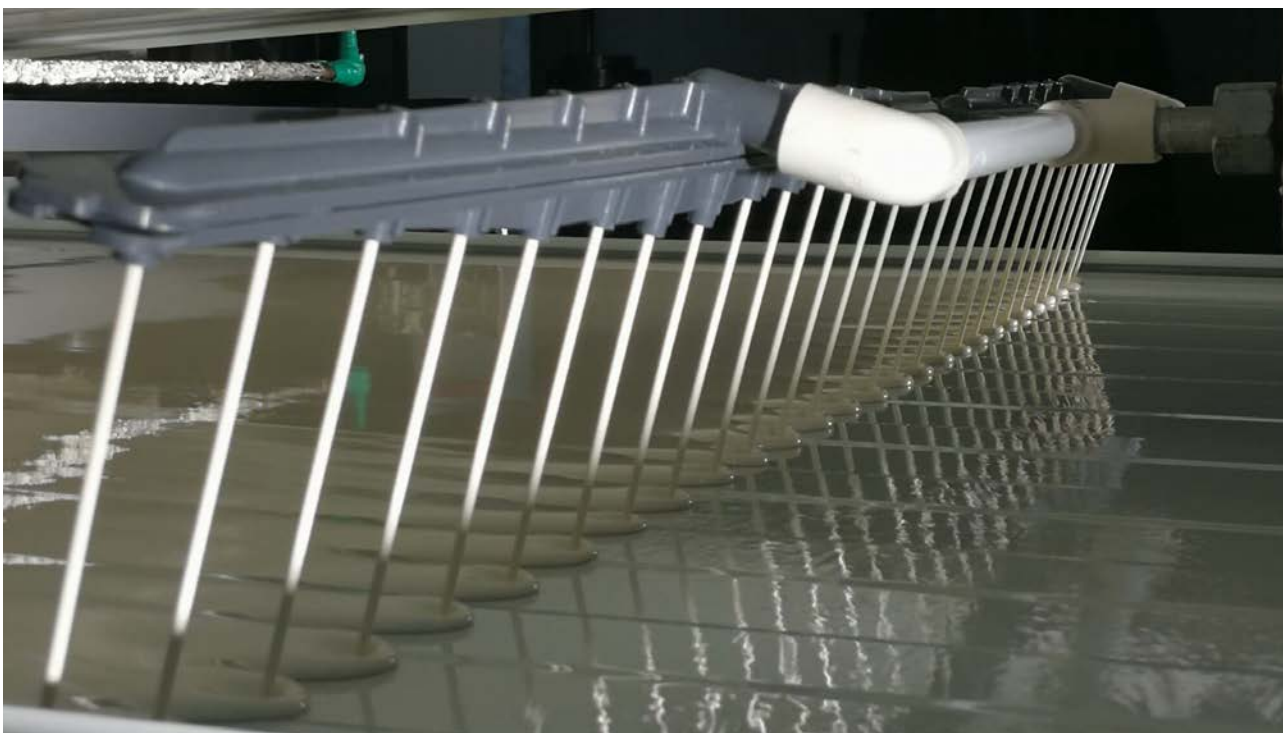
型号 fixed size	1000/2	1000/2.5	1000/3	1120/2	1120/2.5	1120/3
recommended flow 流量 kg/min	10-16	16-23	23-28	12-19	19-27	27-38
recommended flow 流量 g/s	170-270	270-380	380-470	200-310	310-450	450-630
备注	两节 two sections					



每支规格型号标识 size mark

四、 使用和更换 usage and change

按图组装好后，各个管件接缝处用 502 胶水涂粘。用压缩空气气枪吹干净。接到发泡机混合头上，将布料料孔向下前方，建议孔和下钢板成 45 度左右（如下图）。调整好左右位置可以开始布料浇注。Fix the components according to the following pictures , use 502 glue to connect every joints. Use compressed air gun to blow it dry. Connect it to foaming mixer, make spraying hole face down front, make hole and down panel 45 angel as the following picture. It can start to spray once adjusted.



五、 特别说明 special instruction

本洒杆根据因流量、温度、黏度、反应时间不同，使用效果不同，建议拉丝时间控制在 35s 以上。在使用过程中会有部分孔会堵塞属正常现象。如发现不能满足生产工艺要求，或满足不了制品质量时，请立即处理或更换。



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According to different flow rate, temperature, viscosity and reaction time, the effect is different. It is suggested that the drawing time is over 35S. It is normal that some holes will be blocked during use. If you find it can not meet the production process requirements or product quality, please handle or replace it immediately.

