

Title (en)  
PROCESS FOR THE CONTINUOUS PRODUCTION OF CHIP, FIBRE OR SIMILAR BOARDS

Publication  
**EP 0220701 B1 19900808 (DE)**

Application  
**EP 86114843 A 19861025**

Priority  
DE 3538531 A 19851030

Abstract (en)  
1. Method of continuously producing chip boards, fibre boards and like boards, with which a fleece formed on a support and consisting of lignocellulose and/or cellulose-containing chips, fibres and the like, mixed with at least one bonding agent, is pressed while being heated in a calander press with a heated pressurising drum embraced over a part of its circumference by a steel band running over guide rollers and pressurising rollers and is discharged in the form of a continuous length of board, the fleece being compressed at the leading end of the pressing gap and then being heated while enclosed between heated pressurising drums and steel band and while being simultaneously advanced and is brought to the necessary hardening temperature, an additional application of pressure being applied to the steel strip, at least at one further circumferential position of the heated pressurising drum and thus to the fleece, which is under the radial holding pressure of the steel band, and thereafter the fleece is cured to form a finally compressed length of board, characterised in that the additional application of pressure only takes place after a time when the particles are heated to a temperature at which they are fully transformed into their yieldable state, and which corresponds substantially to the final hardening temperature of the bonding agent being used.

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