

Title (en)

Method for continuous manufacturing of fiberboards from wood

Title (de)

Verfahren zur kontinuierlichen Herstellung von Holzwerkstoffplatten

Title (fr)

Procédé pour la fabrication en continu de panneaux en fibres lignocellulosiques

Publication

EP 1688230 B1 20080528 (DE)

Application

EP 06010284 A 20021220

Priority

- EP 02028550 A 20021220
- DE 10163090 A 20011220

Abstract (en)

[origin: EP1323509A1] Continuous production of woodchip or woodfiber panels, involves application of adhesive to boiled wood fibers and compression of a mat of scattered and wetted fibers on a conveyer belt. <??>Woodchips are boiled at NOTLESS 12bar, preferably NOTLESS 16bar for NOTLESS 3min. $\leq 5\%$ of phenolic based adhesive is then applied to the chips in a blowing tube and/or in a mixer and the chips scattered(2) onto a conveyer belt(7) to form a mat(8). The mat, with a moisture content of $\leq 15\%$ just prior entering a continuously working heated press, is sprayed(3) with 5-80g/sq m water on the upper side while being steamed(10) on the lower side. Initial pressure on the mat in the press(6) is 2.5-5m/sq mm so that the mat is compressed to form a panel(11) with densified faces on both sides. <??>An Independent claim is made for a the process plant which comprises a woodchip boiler, an adhesive applicator with blowing tube and/or mixer, a water spray unit(1), chip scattering machine(2) to form a mat on a conveyer belt(7), a water spray unit(3) for wetting the upper side of the mat, precompressor and preheater(4), a steamer(5) with or without a filter ribbon, a steamer(10) and circulating filter ribbon(9) on the mat lower side and a continuously working press(6).

IPC 8 full level

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