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(54) Method of applying a polyurethane adhesive to a substrate

Verfahren zur Anwendung eines Polyurethanhaftmittels auf ein Substrat

Procédé d'application d'un adhésif polyuréthane sur un substrat

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Description

CROSS-REFERENCE TO RELATED APPLICATIONS

- 5 **[0001]** This application is a continuation-in-part of U.S. Application No. 13/143,294 which claims the benefit of U.S. Provisional Application No. 61/305,893, filed on February 18, 2010.

FIELD

- 10 **[0002]** The present invention relates to a method of applying a polyurethane adhesive using a multi-bead applicator on a roofing substrate.

BACKGROUND

- 15 **[0003]** In many roofing applications, for example in large, flat commercial roof decks, a roofing membrane is used to seal and protect the roof deck from environmental weather conditions. The roofing membrane may be made of various materials, such as polymeric materials including EPDM (ethylene propylene diene M-rubber) or TPO (thermoplastic polyolefin). The roofing membrane is adhered overtop insulation boards or panels. The insulation boards are typically secured to the roofing substrate or roof deck via an adhesive composition. A conventional adhesive composition used to adhere the insulation boards to the roof deck includes polyurethane. The polyurethane adhesives are oftentimes applied directly onto the roof deck via an applicator system and the insulation boards are then laid onto the roof deck surface. Conventional polyurethane adhesives oftentimes include two separate parts that are mixed by an applicator just prior to being applied onto the surface of the roof deck. The two parts include an isocyanate blend and a simple polyol blend. Upon mixing, the isocyanate blend reacts or crosslinks with the simple polyol blend to form the polyurethane adhesive.

[0004] However, these conventional two-part polyurethane adhesives are sensitive to weather conditions due to the effects of temperature on the viscosity, and therefore the reaction speed, of the adhesive. Accordingly, conventional two-part polyurethane adhesives are packaged and formulated into various grades, such as Summer, Winter, and Regular, that vary the composition of the adhesive in order to account for temperature.

- 30 **[0005]** One solution to the problem of temperature effects on conventional two-part polyurethane adhesives is to use a high-viscosity adhesive. However, the applicator systems used to apply the adhesives to the roofing substrate are pump driven and oftentimes are unable to reliably pump high-viscosity two-part polyurethane adhesives. Therefore, there is room in the art for a pump driven applicator system that reliably pumps high viscosity adhesives.

- 35 **[0006]** US 2008/000928 A1 discloses a pump-driven dispenser system employing packaging modules for use with moisture sensitive materials. Each of the packaging modules comprises an outer carton and an inner bladder, which is substantially impermeable to moisture and is filled with one part of a two-part adhesive. Without being exposed to moisture in the atmosphere, the packaging modules are loaded on a mobile cart with each of the parts of the two-part adhesive being supplied to a pump or mixer to form the two-part adhesive.

- 40 **SUMMARY**

- [0007]** A pump driven applicator system is provided. The system is used to apply a two-part adhesive to a substrate. The system includes a prime mover for providing an output torque, a gearbox connected to the prime mover for receiving the output torque, a first pump connected to the gearbox for receiving the output torque from the gearbox, the first pump having an inlet and an outlet, a second pump connected to the gearbox for receiving the output torque from the gearbox, the second pump having an inlet and an outlet, a first compound in communication with the inlet of the first pump, a second compound in communication with the inlet of the second pump, a first accumulator in communication with the outlet of the first pump, a second accumulator in communication with the outlet of the second pump, a first manifold in communication with the outlet of the first pump, and a second manifold in communication with the outlet of the second pump. A plurality of applicators, is included. Each applicator has a first inlet and a second inlet in communication with the first manifold and the second manifold, respectively, for receiving the first compound and the second compound, and has an outlet, wherein the plurality of applicators mix the first compound with the second compound to form the two-part adhesive and discharging the two-part adhesive from the outlet onto the substrate.

- 55 **DRAWING DESCRIPTION**

[0008]

FIG. 1 is a front view of a device for applying a two-part adhesive;
 FIG. 2 is a front perspective view of the device;
 FIG. 3 is a schematic diagram of the device;
 FIG. 4 is a view of a portion of the device showing a prime mover and gear box connection;
 FIG. 5 is a side view of a manifold used with the device;
 FIG. 6 is a front view of a connector used with the device;
 FIG. 7 is a front view of another connector used with the device;
 FIG. 8 is an exploded side view of the connectors shown in FIGS. 6 and 7 with a removable wand;
 FIG. 9 is a side view of another embodiment of the device;
 FIG. 10 is a side view of another manifold used with the device;
 FIG. 11A is front view of a manifold used with the device;
 FIG. 11B is a front view of a portion of the manifold shown in FIG. 11A;
 FIG. 12 is a top view of connectors used with the device;
 FIG. 13 is a side view of another embodiment of the device;
 FIG. 14 is a side view of a portion of the device;
 FIG. 15 is a connection diagram of the device;
 FIG. 16 is a partial view of a connection of the device;
 FIG. 17 is a view of a portion of the device;
 FIG. 18 is a view of another portion of the device;
 FIG. 19 is a schematic diagram of a control system used with the device;
 FIG. 20 is a flow chart illustrating a method of controlling the device;
 FIG. 21 is a schematic top view of an interlocking system used with the device;
 FIG. 22 is a top view of an embodiment of the interlocking system used with the device;
 FIG. 23 is a perspective view of an embodiment of a device according to the principles of the present invention; and
 FIG. 24 is a top view of a portion of the device shown in FIG. 23.

DETAILED DESCRIPTION

[0009] The following description is merely exemplary in nature and is not intended to limit the present disclosure, application, or uses.

[0010] Referring to FIGS. 1 and 2, a device for applying a two-part fluid to a substrate is generally indicated by reference number 10. The device 10 includes a carrier or frame 12. The carrier or frame 12 is used to support the various components of the device 10 and may take many forms without departing from the scope of the present invention. In the example provided, the carrier 12 includes a rectangular base 14 with an upwardly extending portions or support columns 16. The rectangular portion includes two rotatable front wheels 18A and two spindle mounted back wheels 18B. Back wheels 18B are pivotable and rotatable allowing the device 10 to move forward as well as turn and rotate. The portion 16 supports an upper frame 20. A handle portion 24 extends out from the upper frame 20 or alternatively from the portion 16 of the frame 12. The upper frame 20 is sized to receive two parts of a two-part compound 21. These two parts are packaged separately and include an "A" side package 22A and a "B" side package 22B. Each of the packages 22A, 22B includes an outer box or container 25A, 25B that surrounds a collapsible bag 27A, 27B, respectively. The bags 27A, 27B each include an opening or nozzle 29A, 29B, respectively. This packaging system is known as CUBINATOR manufactured by Hedwin Corporation, Baltimore, MD. Each of the bags 27A, 27B preferably contain one part of a two part all weather polyurethane adhesive for use on roofing substrates. For example, the "A" side includes an isocyanate blend and the "B" side includes a polyol blend. Upon mixing, the isocyanate blend reacts or crosslinks with the polyol blend to form the polyurethane adhesive. In this example the bag 27A is fluorinated in order to prevent moisture penetration. The openings 29A, 29B are shipped and stored with removable caps (not shown). When the caps are removed, the two parts of the polyurethane adhesive are exposed to moisture in the atmosphere. To prevent the isocyanate blend from thickening due to reaction with the moisture, the isocyanate blend is preferably comprised of less than about 33% isocyanate by weight. An exemplary isocyanate blend for use with the two part adhesive includes RUBINATE M, manufactured by Huntsman. An isocyanate blend of approximately 31% isocyanate was placed under Brookfield and ran continuously for one hour at a spindle speed of 20 rpms. The following tables summarize the viscosity test results:

Table 1

Brookfield Viscosity at Ambient Conditions		
Measured After (min)	Temperature (°F)	Viscosity (cP)
1	69.5	418

(continued)

Brookfield Viscosity at Ambient Conditions		
Measured After (min)	Temperature (°F)	Viscosity (cP)
5	69.5	418
15	69.5	420
30	69.6	422
45	69.6	424
60	69.7	420

Table 2

Brookfield Viscosity at Humid Conditions		
Measured After (min)	Temperature (°F)	Viscosity (cP)
Before Being Place in Chamber	78.2	262
15	80.9	238
30	80.9	228
45	82.2	220
60	82.7	212

[0011] As can be seen in Tables 1 and 2, the isocyanate blend did not see a large increase in viscosity after exposure to the atmosphere (i.e. less than 20% change in viscosity due to exposure to atmosphere in working conditions between -17,78 degrees Celsius (0 degrees F) and 48,89 degrees Celsius (120 degrees F)). Moreover, the change in viscosity between Table 1 and Table 2 and within Table 2 over time can be attributed to the change in temperature of the material. In Table 1 and Table 2 a viscosity of 1 cP corresponds to a viscosity of 1 g/m s.

[0012] The openings 29A, 29B are connected to the device 10 after the caps are removed, as will be described in greater detail below. The upper frame 20 is designed to accommodate a particular package configuration of the A side 22A and the B side 22B. While in the example provided the A side 22A and B side 22B are illustrated as having a rectangular box packaging system, it should be appreciated that other shaped packaging systems may be supported by the upper frame 20.

[0013] Turning to FIGS. 3 and 4, the device 10 includes a prime mover 30 fixed or otherwise connected to the carrier 12. The prime mover 30 is preferably an electric motor, though it should be appreciated that the prime mover 30 may be any type of engine, such as a combustion engine, without departing from the scope of the present invention. The prime mover 30 is connected to a gear box 32 via a rotatable shaft 34. The gear box 32 is fixed or otherwise connected to the carrier 12. The gearbox 32 transfers torque from the prime mover 30 to first and second rotatable shafts 34A and 34B. The rotatable shafts 35A and 35B are coupled to a first and second pump 36A and 36B, respectively. It should be appreciated that a single pump may be employed without departing from the scope of the present invention. Each pump 36A and 36B includes an inlet 38A and 38B, respectively, and an outlet 40A and 40B, respectively. In addition, the prime mover 30 may be connected to the wheels 18B or 18A to provide a self-propelled configuration for the device 10 controlled by a throttle (not shown). Returning to FIGS. 1 and 2, and with reference to FIGS. 3 through 8, the inlet 38A is connected via a hose or other fluid passage 42A to the opening 29A of the A side package 22A of the two-part compound 21. In the example provided, the hose 42A is connected to a quarter turn connector 44A connected to the opening 29A located on a bottom of the A side package 22A. However, it should be appreciated that various other connection devices may be employed. The connector 44A extends through an opening in the bottom of the upper frame 20. Likewise, the inlet 38B is connected via a hose or other fluid passage 42B to the opening 29B in the B side package 22B of the two-part compound 21. In the example provided, the hose 42B is connected to a quarter turn connector 44B connected to the opening 29B located on a bottom of the B side package 22B. However, it should be appreciated that various other connection devices may be employed. The connector 44B extends through the opening in the bottom of the upper frame 20. The connectors 44A, 44B may be keyed connectors such that the connector 44A can only connect to the hose 42A and the connector 44B can only connect to the hose 44B, thereby preventing switching the A and B packages 22A, 22B on the device 10.

[0014] The outlet 40A of the pump 36A is connected via hose or other type of fluid passage 46A to an accumulator 50A and a manifold 52A. The accumulator 50A is an energy storage device in which a non-compressible fluid is held under pressure by an external source. In the example provided, the accumulator 50A is a gas filled type accumulator having a compressible gas that acts on a bladder within the accumulator to provide a compressive force on fluid within the accumulator 50A. However, it should be appreciated that the accumulator 50A may be of other types, such as a spring type, without departing from the scope of the present invention.

[0015] The manifold 52A is attached to a front of the upper frame 20. The manifold 52A includes an inlet port 60A that connects with the hose 46A. In one embodiment, the manifold 52A includes an inlet port 60A that communicates with a bore 62A that extends through the manifold 52A. A ball valve 64A is preferably disposed within the inlet port 60A and connects the hose 46A with the bore 62A. The bore 62A communicates with a plurality of perpendicularly extending side bores 66A. The side bores 66A each communicate with an outlet port 68A on the manifold 52A. In the example provided, there are seven side bores 66A and seven outlet ports 68A. However, it should be appreciated that any number of side bores 66A and outlet ports 68A may be employed without departing from the scope of the present invention.

[0016] Each of the outlet ports 68A may be optionally connected to one of a plurality of applicator units 70 via hoses or other fluid passages 72A. In the example provided, four applicator units 70 are illustrated with four hoses 72A connecting each of the applicator units 70 with one of the outlet ports 68A. However, it should be appreciated that the manifold 52A can accommodate up to seven applicator units 70. The manifold 52A allows each applicator unit 70 to receive a flow of "A" side fluid from the "A" side package 22A.

[0017] The outlet 40B of the pump 36B is connected via hose or other type of fluid passage 46B to an accumulator 50B and a manifold 52B. The accumulator 50B is an energy storage device in which a non-compressible fluid is held under pressure by an external source. In the example provided, the accumulator 50B is a gas filled bladder type accumulator having a compressible gas that provides a compressive force on fluid via the bladder within the accumulator 50B. However, it should be appreciated that the accumulator 50B may be of other types, such as a spring type, without departing from the scope of the present invention.

[0018] The manifold 52B is attached to a front of the frame 20. The manifold 52B includes an inlet port 60B that connects with the hose 46B. In one embodiment, the manifold 52B includes an inlet port 60B that communicates with a bore 62B that extends through the manifold 52B. A ball valve 64B is preferably disposed within the inlet port 60B and connects the hose 46B with the bore 62B. The bore 62B communicates with a plurality of perpendicularly extending side bores 66B. The side bores 66B each communicate with an outlet port 68B on the manifold 52B. In the example provided, there are seven side bores 66B and seven outlet ports 68B. However, it should be appreciated that any number of side bores 66B and outlet ports 68B may be employed without departing from the scope of the present invention.

[0019] Each of the outlet ports 68B may be optionally connected to one of a plurality of the applicator units 70 via hoses or other fluid passages 72B. In the example provided, the four applicator units 70 are illustrated with four hoses 72B connecting each of the applicator units 70 with one of the outlet ports 68B. However, it should be appreciated that the manifold 52B can accommodate up to up to seven applicator units 70. The manifold 52B allows each applicator unit 70 to receive a flow of "B" side fluid from the "B" side package 22B, separately from the fluid from the "A" side package 22A.

[0020] With specific reference to Figs 1, 2 and 5, the applicator units 70 are mounted on a front beam 71 attached to the carrier 12 and each applicator unit 70 includes a rotary valve 72, a dual manifold 74, an orifice restrictor 76, and a nozzle 78. As illustrated in FIG. 5, the rotary valve 72 includes an inlet port 80A and an inlet port 80B. The inlet port 80A is connected with the hose 72A to receive "A" side fluid and the inlet port 80B is connected with the hose 72B to receive "B" side fluid. The inlet port 80A communicates with a bore 82A and the inlet port 80B communicates with a bore 82B. The bores 82A and 82B are separate and do not communicate with one another. Each bore 82A and 82B extend through the rotary valve 72 parallel to one another. A shaft bore 84 is located in the rotary valve and perpendicularly intersects both the bores 82A and 82B. A rotatable shaft 86 is disposed within the shaft bore 84. The rotatable shaft 86 includes two spaced apart holes 88A and 88B that extend through the diameter of the shaft 86. The spaced apart holes 88A and 88B are in alignment with the bores 82A and 82B, respectively. The shaft 86 is connected to a lever 90. Alternatively, the shaft 86 may be connected via a rigid or wire connection to a lever or other device connected with the handle 24 of the carrier 12. By rotating the shaft 86, the holes 88A and 88B are simultaneously moved in and out of alignment with the bores 82A and 82B. Accordingly, the rotary valve 72 is operable to throttle the fluid flow of the "A" and "B" side fluids through the applicator unit 70. The rotary valve 72 further includes bolt channel outlet ports 92A and 92B that communicate with the bores 82A and 82B, respectively.

[0021] With specific reference to Figs. 5, 6 and 7, the dual manifold 74 includes a body portion 94 and a neck portion 96 that extends out from the body portion 94. The dual manifold 74 includes inlet ports 96A and 96B that are connected to the bolt outlet ports 92A and 92B, respectively, of the rotary valve 72. The inlet ports 96A and 96B communicate with separate channels or bores 98A and 98B, respectively, that communicate through the body portion 94 and into the neck portion 96 to outlet ports 100A and 100B, respectively.

[0022] The orifice restrictor 76 is sealingly engaged to the neck portion 96 of the dual manifold 74. The orifice restrictor 76 includes a first orifice 102A and a second orifice 102B that communicate with the outlet ports 100A and 100B,

respectively. The orifices 102A and 102B are separate and do not communicate with each other. In the example provided, the orifice restrictor 76 includes a slot 104 sized to receive a tab member 106 located on the neck portion 96 of the dual manifold 74, as shown in FIGS. 6 and 7. The tab member 106 assures that the first orifice 102A and the second orifice 102B do not communicate. The first orifice 102A has a diameter different than the second orifice 102B. For example, the first orifice 102A has a diameter that is a function of the material characteristics of the composition of the "A" side fluid. The second orifice 102B has a diameter that is a function of the material characteristics of the composition of the "B" side fluid. The orifices 102A and 102B assure that fluid does not backflow into the dual manifold 74, as will be described below. The orifices 102A, 102B allow high viscosity compound to be ported therethrough. Combined with the configuration of the pumps 36A and 36B, the device 10 is operable to pump compounds having viscosities higher than 2500 Pas, and preferably as high as about 7000 Pas.

[0023] Turning to FIG. 8, the nozzle 78 is an extended member that mixes the "A" side fluid with the "B" side fluid. The nozzle 78 is coupled to the orifice restrictor 76 and communicates with the orifices 102A and 102B. The nozzle 78 is disposable and is preferably a 36 element mixing nozzle, though it should be appreciated that other types and grades of nozzles may be employed without departing from the scope of the present invention. Once the fluids from the "A" and "B" sides are mixed, the combined fluid exits in the nozzle 78 and is dispensed in the form of elongated beads on the roofing substrate.

[0024] With combined reference to FIGS. 1-8, the operation of the device 10 will now be described. An operator of the device 10 activates the prime mover 30 which in turn drives the pumps 36A and 36B. The pumps 36A and 36B suck fluid from the "A" and "B" side packages 22A and 22B via hoses 42A and 42B, respectively. "A" side fluid exits the pump 36A via outlet port 40A and enters the hose 46A. An amount of "A" side fluid enters the accumulator 50A and charges the accumulator 50A. In the example provided, the accumulator 50A preferably stores the fluid at approximately 300psi. The remaining "A" side fluid enters the manifold 52A and is communicated through the central bore 62A to the side bores 66A. The "A" side fluid then exits the manifold 52A and communicates via hose 72A to the rotary valve 74 of the applicator unit 70. The "A" side fluid communicates through the rotary valve 74 and is throttled based on the rotational position of the shaft 86. The "A" side fluid exits the rotary valve 74, communicates through the dual manifold 76 and the orifice restrictor 76 and enters the nozzle 78 for mixing.

[0025] Likewise, "B" side fluid exits the pump 36B via outlet port 40B and enters the hose 46B. An amount of "B" side fluid enters the accumulator 50B and charges the accumulator 50B. In the example provided, the accumulator 50B preferably stores the fluid at approximately 300psi. The remaining "B" side fluid enters the manifold 52B and is communicated through the central bore 62B to the side bores 66B. The "B" side fluid then exits the manifold 52B and communicates via hose 72B to the rotary valve 74 of the applicator unit 70. The "B" side fluid communicates through the rotary valve 74 and is throttled based on the rotational position of the shaft 86. The "B" side fluid exits the rotary valve 74, communicates through the dual manifold 76 and the orifice restrictor 76 and enters the nozzle 78 for mixing with the "A" side fluid. The mixed adhesive is then dispensed from the nozzle 78 onto a substrate. By widening the distance between nozzles 78 or the number of nozzles 78, areas may be covered exceeding 40 inches in width.

[0026] While the orifice restrictor 76 and the nozzle 78 are disposable, it is desirable that the dual manifold 74 and rotary valve 76 do not become clogged with mixed and cured fluid. However, once the device 10 is deactivated, mixed fluid within the nozzle 78 may cure and expand, forcing mixed fluid back towards the orifice restrictor 76. However, as the pumps 36A and 36B are deactivated, the accumulators 50A and 50B begin to discharge, providing a positive pressure of fluid back towards the orifice restrictor 76. The back pressure provided by the accumulators 50A and 50B, in conjunction with the sizes of the orifices 102A and 102B, prevent mixed material within the nozzle 78 from entering the dual manifold 74.

[0027] Turning to FIG. 9, an alternate embodiment of the device 10 is generally indicated by reference number 200. The device 200 is similar to the device 10 described in FIGS. 1-8, and therefore like components are indicated by like reference numbers. However, the device 200 includes at least one dual channel manifold 202. The dual channel manifold or adapter base plate 202 is located on a forward support member 204 of the carrier 12.

[0028] With reference to FIGS. 10-12, the dual channel manifold 202 includes a pair of inlet ports 206A located on opposite ends of the manifold 202 and a pair of inlet ports 206B located on opposite ends of the manifold. The inlet ports 206A communicate with a first bore 208A that extends along a length of the manifold 202. The inlet ports 206B communicate with a second bore 208B that extends along the length of the manifold 202 parallel to the first bore 208A. The manifold 202 includes side bores 210A that communicate with the first bore 208A and with outlets 212A located along the length of the manifold 202. Similarly, the manifold 202 includes side bores 210B that communicate with the second bore 208B and with outlets 212B located along the length of the manifold 202. One of the inlets 206A is connected with the hose 46A while the opposite inlet 206A is plugged. One of the inlets 206B is connected with the hose 46B while the opposite inlet 206B is plugged. The outlets 212A communicate directly with the inlets 80A of the rotary valves 76 and the outlets 212B communicate directly with the inlets 80B of the rotary valves 76. Accordingly, each applicator unit 70 is fed "A" and "B" side fluids separately directly from the manifold 202.

[0029] Turning to FIG. 13, yet another alternate embodiment of the device 10 is generally indicated by reference number 300. The device 300 is similar to the device 10 described in FIGS. 1-8, and therefore like components are

indicated by like reference numbers. However, the device 300 replaces the accumulators 50A and 50B with one or more flow dividers 302 and replaces the rotary valves 72 with a plurality of diverter valves 304A and 304B, and adds an adaptor plate 306 positioned between the plurality of diverter valves 304A and 304B and the plural component or dual manifolds 74. The present invention contemplates that in other embodiments of the invention additional flow dividers 302, diverter valves 304A, 304B and adaptor plates 306 than are illustrated in the Figures are utilized.

[0030] With reference to FIGS. 13-18, the flow dividers 302 include dividers 302A and 302B to receive "A" and "B" side fluids, respectively. Flow dividers 302A, 302B have a single input port 310 and a plurality of output ports 312. The number of output ports 312 depends on the number of diverter valves 304A, 304B and mixing nozzles 78 desired. The flow dividers 302A, 302B are connected to pumps 36A, 36B via lines 46A, 46B and four port couplings 314A and 314B. The flow dividers 302A, 302B uniformly divide flow of fluid from the input port 310 to the plurality of output ports 312. Thus, each of the output ports will have the same flow rate. Since each individual divider output port flow rate is uniform, if one output is blocked the others will also stop flow in response. The present invention contemplates that flow dividers 302A, 302B have different number and sized output ports.

[0031] The number of diverters 304A and 304B are matched to the number of output ports on flow dividers 302A and 302B. Diverters 304A and 304B are three way ball valves that may be actuated to completely shut of fluid flow to a particular nozzle 78. Diverters 304A and 304B receive fluid from the outlet ports 312 of the flow dividers 302A, 302B and communicate the fluid to the adaptor plates 306 via a plurality of feed lines 308A, 308B.

[0032] The adaptor plate 306 is connectable to the dual manifold 74 described in the previous embodiments. More specifically, adapter plate 306 includes two fluid passages or bores 309A, 309B for communicating fluid from feed lines 308A, 308B to each of the bores of dual manifold 74.

[0033] In an embodiment of the present invention, a fluid by pass 316 is provided to communicate fluid from the diverters 304A, 304B to inlet 310. The redirection or bypass of fluid flow through fluid by pass 316 from the inlet 310 of the divider to the outlet 312 of the divider keeps the fluid flow through the outlet ports of the divider all uniform when an individual nozzle does not have any or the same flow rate as the other nozzles.

[0034] The present embodiment further includes a two way ball valve 320 connected to the four way ball valve 314. Valve 320 allows fluid to be diverted to a hand held gun or similar bead dispenser (not shown). The bead dispenser may be connected to the end of a length of hose and the other end of the hose connected to the valve 320. A single bead dispensed through the gun allows the operator to apply an adhesive in congested areas where the dispensing cart simply will not fit.

[0035] Preferably, the present embodiment includes a quick release mixing nozzle 78 for faster change-outs. The quick release mixer nozzle has restriction orifice 76 integrated into the nozzle. The mixer nozzle 78 is configured to be quickly releasable from dual manifold 74 by eliminating the threads and attaching the nozzle to the dual manifold 74 via a latch 330 or similar device, as shown in Fig. 19. Such a latch 330 is available from SouthCo of Concordville, PA.

[0036] The quick release mixer nozzle is an improvement over the industry standard which is a threaded attachment of the mixing nozzle to the dual manifold 74. Threaded nozzles are not preferred since they can easily get gummed up with adhesive and require cleaning.

[0037] Turning now to FIG. 19, the device 10 is illustrated schematically with either the "A" side package 22A or the "B" side package 22B. An outlet line 402 is coupled to the package 22A, 22B through which the compound within the package 22A, 22B is drawn by the pump 36A, 36B. Each individual package 22A, 22B includes an identifier 404. The identifier 404 is used to uniquely identify the particular package 22A, 22B. The identifier 404 may be located in various locations, for example on an inside or outside of the package 22A, 22B, embedded within the package 22A, 22B, located within, or attached to, a bag within the package 22A, 22B, or within the adhesive compounds themselves. The device 10 includes a reader 406. The reader 406 communicates with the identifier 404 through various methods, as will be described below. The identifier 406 in turn is in electrical communication with a controller 408. The controller 408 is preferably an electronic control device having a preprogrammed digital computer or processor, control logic, memory used to store data, and at least one I/O peripheral. The control logic includes a plurality of logic routines for monitoring, manipulating, and generating data. The controller 408 electrically communicates with various components of the device 10, such as the prime mover 30 or any manual controls indicated generally by reference number 410, and is operable to convert manual or automatic inputs into electrical signals that control the device 10.

[0038] A flow metering device 412 is connected to the outlet line 402. The flow metering device 412 is operable to detect a flow of the compound from the package 22A, 22B. A signal is communicated to the controller 408 indicative of the flow of the compound.

[0039] The identifier 404 and the reader 406 may take various forms. For example, the identifier 404 may be a radio frequency identifier (RFID) having a signal unique to the package 22A, 22B and the reader 406 may be a radio frequency receiver operable to detect the RFID from the identifier 404.

[0040] Turning to FIG. 20 and with continued reference to FIG. 19, an exemplary method of using the RFID 404 and the receiver 406 is generally indicated by reference number 500. The method 500 begins at step 502 where the receiver 406 reads or detects the RFID 404. At step 504 the controller 408 analyzes the RFID signal and determines if the RFID

signal is valid. A valid RFID signal may be one that is found in memory storage within the controller 408 (i.e. a previously stored value), one that conforms to an expected format (i.e. a certain number or digit length, etc., that is unique to the A side and B side packaging in order to prevent reversing the packaging on the device 10), and/or one that has not been previously recorded by the controller 408 and been blocked. If the detected RFID signal is not valid, the method proceeds to step 506 and the pumps 36A, 36B are shut off. This prevents incompatible compounds from being pumped through the device 10, such as compounds having low viscosities or inadvertently switching the A side with the B side. If the RFID signal is valid, the method proceeds to step 508 where the flow of the compound from the package 22A, 22B is monitored via the flow meter 412. At step 510 the controller 408 stores the RFID signal and associates the flow data with the RFID signal. The controller 408 then calculates a volume of compound that has flowed from the package 22A, 22B and compares this volume with a threshold. The threshold is equal to or greater than the expected volume of the compound within the package 22A, 22B. If the volume of compound is less than the threshold, the method proceeds to step 512 where the device 10 continues to allow pumping of the compound and monitors the flow of the compound and returns to step 510. If, however, the volume exceeds the threshold, the method proceeds to step 506 and the pumps 36A, 36B are automatically shut off. In addition, the controller 408 locks out the RFID signal such that it cannot be used again. A display device 412, such as a warning indicator or digital display screen connected to the controller 408, can indicate when the volume of the compound within the package 22A, 22B is running low, the estimated volume remaining, or any other associated information to a user of the device 10. By associating the RFID signal with the accumulated metered flow and storing these values in memory, a package 22A, 22B can be reused over time so long as the volume of the compound remains less than the threshold.

[0041] In one embodiment, the identifier 404 may be a unique bar code and the reader 406 may be a bar code scanner. The method of operating the device 10 would be the same as that described in FIG. 20. In another embodiment, the identifier 404 may be a unique number and the reader 406 may be a keypad. Again, the method of operating the device 10 would remain the same, however, the step 502 would include a user of the device 10 entering the unique identifier 404 into the keypad 406.

[0042] Turning to FIG. 21, an embodiment of the device 10 is shown having interlock features 602A and 602B. It should be appreciated that the interlock features 602A, 602B are illustrated schematically in FIG. 21. Each interlock feature 602A, 602B includes a first interlock 604A, 604B and a second interlock 606A, 606B, respectively. The first interlocks 604A, 604B are disposed on the upper frame 20 of the carrier 12 that supports the packages 22A and 22B. Interlock 604A is disposed on the side of the upper frame 20 that supports the package 22A and the interlock 604B is disposed on the side of the upper frame 20 that supports the package 22B. The second interlocks 606A, 606B are disposed on the packages 22A and 22B, respectively. The interlock 606A is configured to only interlock or mate with the interlock 604A and the interlock 606B is configured to only interlock or mate with the interlock 604B. The interlocks 602A and 602B prevent the packages 22A and 22B from being connected to the device 10 on the wrong side, thereby preventing damage to the device 10.

[0043] The interlocks 602A and 602B may take various forms without departing from the scope of the present invention. For example, the interlock 604A may be a protrusion on a side of the upper frame 20 and the interlock 604B may be a protrusion on a front of the upper frame 20. Accordingly, the interlock 606A would be a recess sized to accommodate the protrusion interlock 604A and the interlock 606A would be located on a short or long side of the package 22A. The interlock 606B would be a recess sized to accommodate the protrusion interlock 604B and the interlock 606B would be located on whichever of the short or long side of the package 22B that does not correspond with the location of the interlock 606A on the package 22A. In another embodiment, the interlocks 604A and 606B may be on the same sides of the upper frame 20 but have different sizes or shapes. Accordingly, the interlocks 606A and 606B would be on the same sides but would have shapes corresponding to the interlocks 604A and 604B, respectively.

[0044] Another example of the interlocks 602A and 602B is shown in FIG. 22. The interlock 602A includes a round receiver 610A located in the upper frame 20 and the package 22A has a round cross-section configured to fit within the round receiver 610A. The interlock 602B includes a rectangular or square receiver 610B and the package 22B has a rectangular or square cross-section configured to fit within the rectangular or square receiver 610B.

[0045] With reference to FIG. 23, an alternate embodiment of a device for applying a two-part fluid to a substrate is generally indicated by reference number 710. The device 710 includes a carrier or frame 712. The carrier or frame 712 is used to support the various components of the device 710 and may take many forms without departing from the scope of the present invention. In the example provided, the carrier 712 includes a base 714 with an upwardly extending portion or support members 716. Two rotatable front wheels 718A are coupled to a front of the base 714 and two spindle mounted back wheels 718B are coupled to brackets 718C that extend from a back and sides of the base 714. Back wheels 718B are pivotable and rotatable allowing the device 10 to move forward as well as turn and rotate. The support members 716 support an upper frame 719. The upper frame 719 in turn supports a tray 720. The tray 720 is sized to receive the two parts 22A and 22B of the two-part compound 21 (see FIG. 1). A handle portion 724A extends out from the support members 716, or alternately the tray 720 or the upper frame 719, at the back of the frame 712. A front handle portion 724B extends out from the support members 716, or alternately the upper frame 719, at the front of the frame 712. The

handle portions 724A and 724B can be used to move and steer the device 10 or to dead lift the device 10 using two or more people. A center lift hook 724C extends upwards from the tray 720 to allow the device 10 to be lifted using a crane or other machine. The center lift hook 724C may be rotated or pivotable in order to account for changes in the center of gravity of the device 710.

[0046] Turning to FIG. 24, the tray 720 includes two pairs of side walls 720A and 720B with a base or bottom wall 720C extending between the side walls 720A and 720C. A single aperture or opening 725 is formed in the base 720B. The aperture 725 extends through a midpoint of the tray 720 and is equidistant from the side walls 720A but not equidistant from the side walls 720B. The aperture 725 receives both of the openings or nozzles 44A and 44B of the packages 22A and 22B when the packages 22A and 22B are placed on the tray 720. The single aperture 725 allows for easy access to the nozzles 44A and 44B and simplifies alignment of the packages 22A and 22B with the tray 720. In one embodiment the tray 720 may include an aperture 725' that is centered on the tray 720, i.e., equidistant from the side walls 720A and 720B. The aperture 725 provides greater support to the packages 22A, 22B while the aperture 725' provides greater flexibility to allow the nozzles 29A, 29B to extend through the aperture 725' in various configurations. The single apertures 725, 725' also allow for drainage of water collected in the tray 720 near the center of the tray 720 without requiring additional drain holes through the base 720C.

[0047] In yet another embodiment, the tray 720 is a rectangular support bracket having a flange 726. The flange 726 is disposed around an inner periphery of the support bracket. The flange 726 supports the packages 22A and 22B along the edges of the packages 22A and 22B and allows non-rectilinear and non-planar shaped packages to be supported by the device 710.

[0048] Returning to FIG. 23, the device 10 includes a pumping system 730 that may include, for example, an electric motor that drives one or more pumps, as described above in reference to the device 10. The pumping system 730 pumps the two-part adhesive from the packages 22A, 22B and into a hand-held applicator unit 70, described above, or to the mixing wand or nozzle 78.

[0049] With combined reference to the FIGS. 23-24, the method of applying the two-part adhesive 21 to a substrate using the device 710 will be described. The two-part adhesive 21 is preferably stored in the packages 22A, 22B with removable caps secured to the openings 29A, 29B. The caps assure that the packages 22A, 22B are safe for shipping and do not leak. In order to apply the mixed two-part adhesive 32 to a substrate using the device 710, the caps are first removed from each of the packages 22A, 22B, thereby exposing the two parts of the two-part adhesive to the atmosphere. Due to the chemistry of the composition as described above, the exposure to the atmosphere does not substantially affect the viscosity of the adhesive (i.e. less than 20% change in viscosity over one hour of exposure). Next, the connectors 44A, 44B are connected to the openings 29A, 29B. The connectors 44A, 44B reseal the openings 29A, 29B. The packages 22A, 22B are loaded onto the device 710 such that each of the connectors 44A and 44B extend through the same aperture 725. The adhesive parts are then pumped from the packages 22A, 22B using the pumping system 730. The applicator 70 then mixes the first part with the second part to create the two-part adhesive. The parts may be mixed in ratios of less than 1 to 1 (i.e. less isocyanate blend compared to polyol blend). The applicator 70 is then used to apply the mixed two-part adhesive to the substrate.

Claims

1. A method for applying a two-part adhesive to a substrate, the method comprising:

providing a first package (22A) having a first collapsible bag (27A) for storing a first part of the two-part adhesive, wherein the first collapsible bag (27A) is disposed within a first rigid container (25A), wherein the first collapsible bag (27A) has a first opening (29A) and a first cap secured to the first opening (29A);

providing a second package (22B) having a second collapsible bag (27B) for storing a second part of the two-part adhesive, wherein the second collapsible bag (27B) is disposed within a second rigid container (25B), wherein the second collapsible bag (27B) has a second opening (29B) and a second cap secured to the second opening (29B);

removing the first cap and the second cap thereby exposing the first and second parts of the two-part adhesive to air;

attaching a first connector (44A) to the first opening (29A) and attaching a second connector (44B) to the second opening (29B);

connecting the first connector (44A) to an applicator device (70) and connecting the second connector (44B) to the applicator device (70);

pumping the first part from the first package (22A) and the second part from the second package (22B);

mixing the first part with the second part; and

applying the mixed first part and second part onto the substrate.

2. The method of claim 1 further comprising placing the first package (22A) and the second package (22B) on the applicator device (70).
3. The method of claim 2 further comprising inserting the first connector (44A) through an aperture (725) in the applicator device (70) and inserting the second connector (44B) through the aperture (725) in the applicator device (70).
4. The method of claim 1 wherein attaching a first connector (44A) to the first opening (29A) includes attaching a first connector (44A) having a first valve (64A) to the first opening (29A).
5. The method of claim 4 wherein attaching a second connector (44B) to the second opening (29B) includes attaching a second connector (44B) having a second valve (64B) to the second opening (29B).
6. The method of claim 5 wherein connecting the first connector (44A) to an applicator device (70) includes opening the first valve (64A) and connecting the second connector (44B) to the applicator device (70) includes opening the second valve (64B).
7. The method of claim 1 further comprising shipping the first package (22A), wherein the first package (22A) does not leak during shipment.
8. The method of claim 1 wherein mixing the first part with the second part includes mixing the first part with the second part at a ratio of less than 1 to 1.
9. The method of claim 1, wherein the two-part adhesive is a two-part polyurethane adhesive, the method comprising:
 - providing an isocyanate blend in the first package (22A), wherein the isocyanate blend exhibits less than a 20% change in viscosity over 60 minutes when exposed to atmosphere between approximately -17,78 degrees Celsius (0 degrees F) and 48,89 degrees Celsius (120 degrees F); and
 - providing a polyol blend in the second package (22B).
10. The method of claim 9 wherein providing an isocyanate blend in the first package (22A) includes providing an isocyanate blend with less than about 33% isocyanate by weight in the first package (22A).

Patentansprüche

1. Verfahren zum Aufbringen eines Zweikomponenten-Klebstoffs auf ein Substrat, wobei das Verfahren umfasst:

Bereitstellen einer ersten Packung (22A) mit einem ersten zusammenlegbaren Beutel (27A) zum Speichern einer ersten Komponente des Zweikomponenten-Klebstoffs, wobei der erste zusammenlegbare Beutel (27A) innerhalb eines ersten starren Behälters (25A) angeordnet ist, wobei der erste zusammenlegbare Beutel (27A) eine erste Öffnung (29A) und eine an der ersten Öffnung (29A) befestigte erste Kappe aufweist;

Bereitstellen einer zweiten Packung (22B) mit einem zweiten zusammenlegbaren Beutel (27B) zum Speichern einer zweiten Komponente des Zweikomponenten-Klebstoffs, wobei der zweite zusammenlegbare Beutel (27B) innerhalb eines zweiten starren Behälters (25B) angeordnet ist, wobei der zweite zusammenlegbare Beutel (27B) eine zweite Öffnung (29B) und eine an der zweiten Öffnung (29B) befestigte zweite Kappe aufweist;

Entfernen der ersten Kappe und der zweiten Kappe, wodurch die erste und zweite Komponente des Zweikomponentenklebers der Luft ausgesetzt werden;

Anbringen eines ersten Verbinders (44A) an der ersten Öffnung (29A) und Anbringen eines zweiten Verbinders (44B) an der zweiten Öffnung (29B);

Verbinden des ersten Verbinders (44A) mit einer Applikatorvorrichtung (70) und Verbinden des zweiten Verbinders (44B) mit der Applikatorvorrichtung (70);

Pumpen der ersten Komponente aus der ersten Packung (22A) und der zweiten Komponente aus der zweiten Packung (22B);

Mischen der ersten Komponente mit der zweiten Komponente; und

Auftragen der gemischten ersten Komponente und zweiten Komponente auf das Substrat.
2. Verfahren nach Anspruch 1, ferner umfassend ein Anordnen der ersten Packung (22A) und der zweiten Packung (22B) auf der Applikatorvorrichtung (70).

3. Verfahren nach Anspruch 2, ferner umfassend ein Einführen des ersten Verbinders (44A) durch eine Durchbrechung (725) in der Applikatorvorrichtung (70) und das Einführen des zweiten Verbinders (44B) durch die Durchbrechung (725) in der Applikatorvorrichtung (70).
- 5 4. Verfahren nach Anspruch 1, wobei das Anbringen eines ersten Verbinders (44A) an der ersten Öffnung (29A) das Anbringen eines ersten Verbinders (44A) mit einem ersten Ventil (64A) an der ersten Öffnung (29A) umfasst.
5. Verfahren nach Anspruch 4, wobei das Anbringen eines zweiten Verbinders (44B) an der zweiten Öffnung (29B) das Anbringen eines zweiten Verbinders (44B) mit einem zweiten Ventil (64B) an der zweiten Öffnung (29B) umfasst.
- 10 6. Verfahren nach Anspruch 5, wobei das Verbinden des ersten Verbinders (44A) mit einer Applikatorvorrichtung (70) ein Öffnen des ersten Ventils (64A) umfasst und das Verbinden des zweiten Verbinders (44B) mit der Applikatorvorrichtung (70) ein Öffnen des zweiten Ventils (64B) umfasst.
- 15 7. Verfahren nach Anspruch 1, ferner umfassend das Versenden der ersten Packung (22A), wobei die erste Packung (22A) während des Versands nicht leckt.
8. Verfahren nach Anspruch 1, wobei das Mischen der ersten Komponente mit der zweiten Komponente das Mischen der ersten Komponente mit der zweiten Komponente in einem Verhältnis von weniger als 1 zu 1 umfasst.
- 20 9. Verfahren nach Anspruch 1, wobei der Zweikomponenten-Klebstoff ein Zweikomponenten-Polyurethan-Klebstoff ist, wobei das Verfahren umfasst:

Bereitstellen einer Isocyanatmischung in der ersten Packung (22A), wobei die Isocyanatmischung weniger als
25 eine 20%ige Änderung der Viskosität über 60 Minuten zeigt, wenn sie einer Atmosphäre zwischen ungefähr -17,78 Grad Celsius (0 Grad F) und 48,89 Grad Celsius (120 Grad F) ausgesetzt ist; und
Bereitstellung einer Polyolmischung in der zweiten Packung (22B).
- 30 10. Verfahren nach Anspruch 9, wobei das Bereitstellen einer Isocyanatmischung in der ersten Packung (22A) das Bereitstellen einer Isocyanatmischung mit weniger als etwa 33 Gew.-% Isocyanat in der ersten Packung (22A) umfasst.

Revendications

- 35 1. Procédé pour appliquer un adhésif en deux parties sur un substrat, le procédé comprenant les étapes consistant à :

fournir un premier emballage (22A) présentant un premier sac souple (27A) pour stocker une première partie
40 de l'adhésif en deux parties, dans lequel le premier sac souple (27A) est disposé à l'intérieur d'un premier
conteneur rigide (25A), dans lequel le premier sac souple (27A) possède un premier orifice (29A) et un premier
bouchon fixé au premier orifice (29A) ;
fournir un second emballage (22B) présentant un second sac souple (27B) pour stocker une seconde partie
de l'adhésif en deux parties, dans lequel le second sac souple (27B) est disposé à l'intérieur d'un second
45 conteneur rigide (25B), dans lequel le second sac souple (27B) possède un second orifice (29B) et un second
bouchon fixé au second orifice (29B) ;
retirer le premier bouchon et le second bouchon de manière à exposer à l'air les première et seconde parties
de l'adhésif en deux parties ;
fixer un premier connecteur (44A) au premier orifice (29A) et fixer un second connecteur (44B) au second orifice
50 (29B) ;
relier le premier connecteur (44A) à un dispositif applicateur (70) et relier le second connecteur (44B) au dispositif
applicateur (70) ;
pomper la première partie à partir du premier emballage (22A) et la seconde partie à partir du second emballage
(22B) ;
mélanger la première partie avec la seconde partie ; et
55 appliquer la première partie et la seconde partie mélangées sur le substrat.
2. Procédé selon la revendication 1, comprenant en outre l'étape consistant à placer le premier emballage (22A) et le
second emballage (22B) sur le dispositif applicateur (70).

3. Procédé selon la revendication 2, comprenant en outre l'étape consistant à insérer le premier connecteur (44A) à travers une ouverture (725) dans le dispositif applicateur (70) et à insérer le second connecteur (44B) à travers l'ouverture (725) dans le dispositif applicateur (70).
- 5 4. Procédé selon la revendication 1, dans lequel l'étape consistant à fixer un premier connecteur (44A) au premier orifice (29A) consiste à fixer un premier connecteur (44A) présentant une première vanne (64A) au premier orifice (29A).
- 10 5. Procédé selon la revendication 4, dans lequel l'étape consistant à fixer un second connecteur (44B) au second orifice (29B) consiste à fixer un second connecteur (44B) présentant une seconde vanne (64B) au second orifice (29B).
- 15 6. Procédé selon la revendication 5, dans lequel l'étape consistant à relier le premier connecteur (44A) à un dispositif applicateur (70) consiste à ouvrir la première vanne (64A) et l'étape consistant à relier le second connecteur (44B) au dispositif applicateur (70) consiste à ouvrir la seconde vanne (64B).
7. Procédé selon la revendication 1, comprenant en outre l'étape consistant à expédier le premier emballage (22A), le premier emballage (22A) ne fuyant pas pendant l'expédition.
- 20 8. Procédé selon la revendication 1, dans lequel l'étape consistant à mélanger la première partie avec la seconde partie consiste à mélanger la première partie avec la seconde partie dans un rapport inférieur à 1 pour 1.
9. Procédé selon la revendication 1, dans lequel l'adhésif en deux parties est un adhésif polyuréthane en deux parties, le procédé comprenant les étapes consistant à :
- 25 fournir un mélange d'isocyanate dans le premier emballage (22A), le mélange d'isocyanate présentant un changement de viscosité inférieur à 20 % sur 60 minutes lorsqu'il est exposé à une atmosphère comprise entre environ -17,78 degrés Celsius (0 degré F) et 48,89 degrés Celsius (120 degrés F) ; et
- 30 fournir un mélange de polyol dans le second emballage (22B).
10. Procédé selon la revendication 9, dans lequel l'étape consistant à fournir un mélange d'isocyanate dans le premier emballage (22A) consiste à fournir un mélange d'isocyanate ayant moins d'environ 33 % d'isocyanate en poids dans le premier emballage (22A).

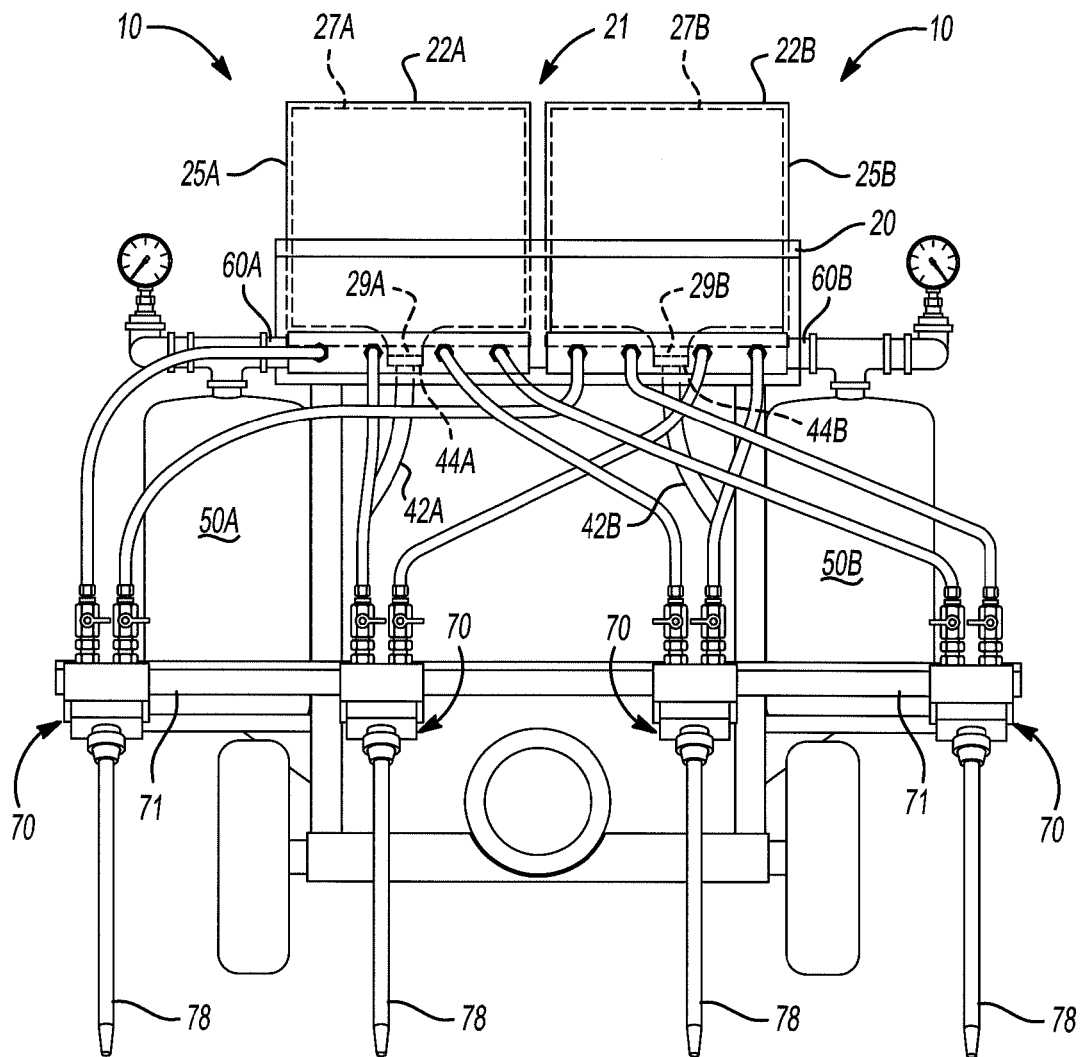


Fig-1

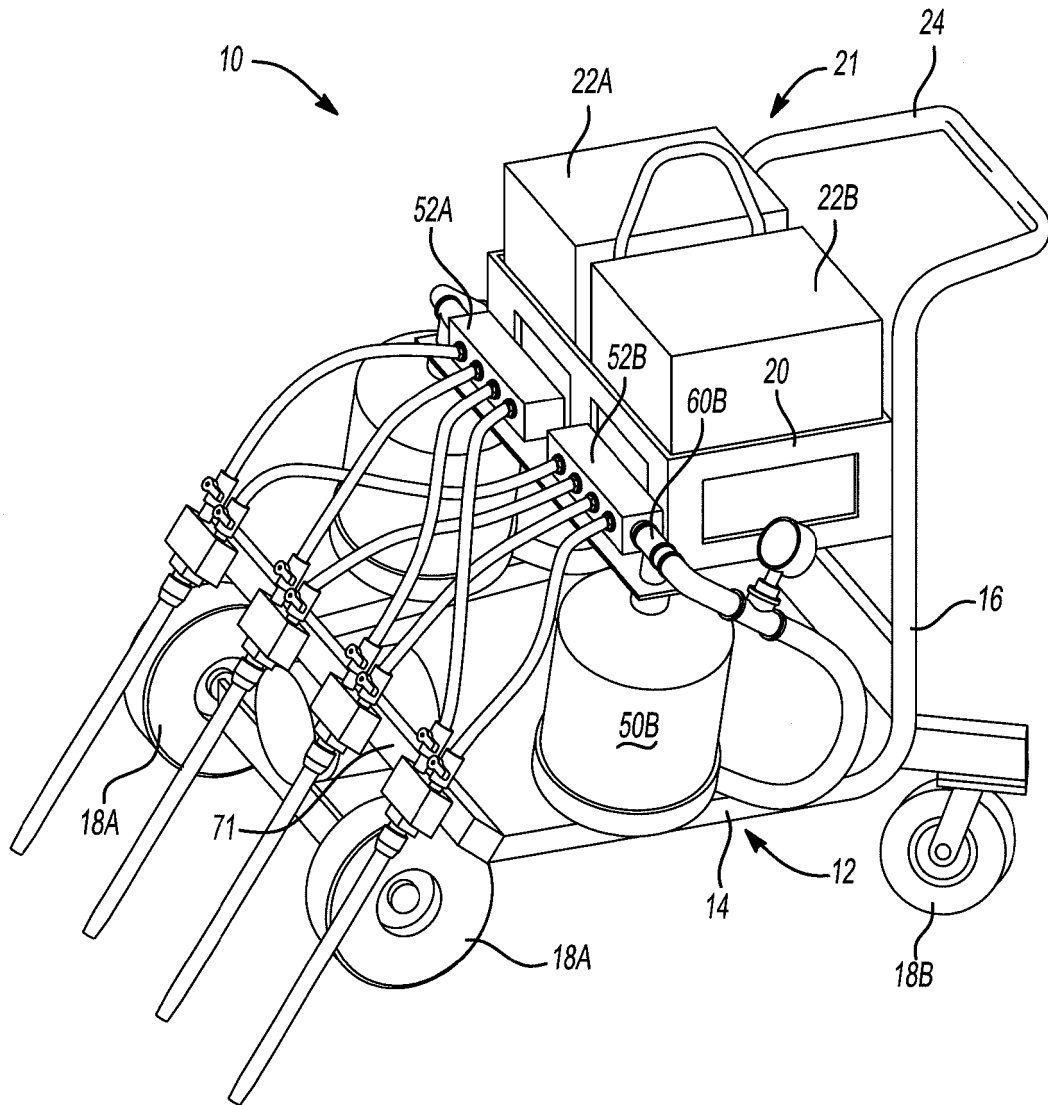


Fig-2

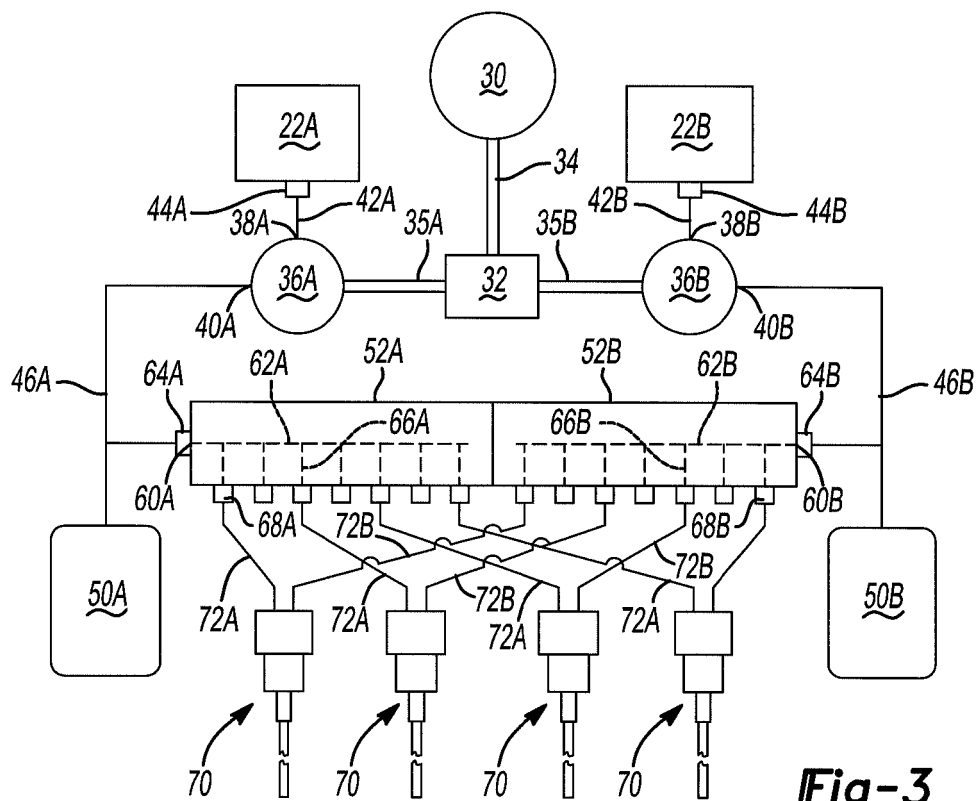


Fig-3

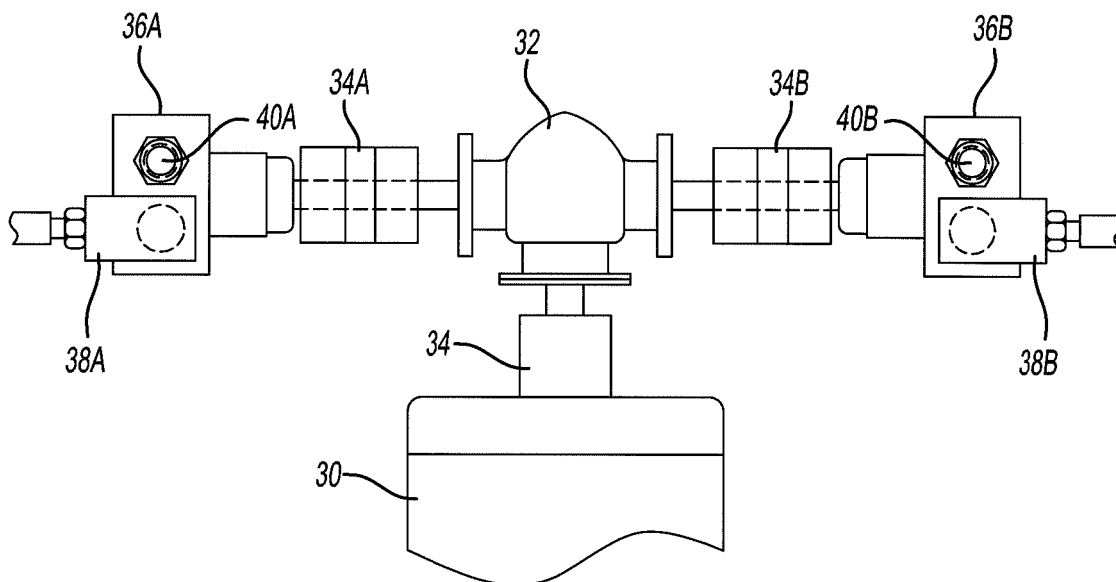
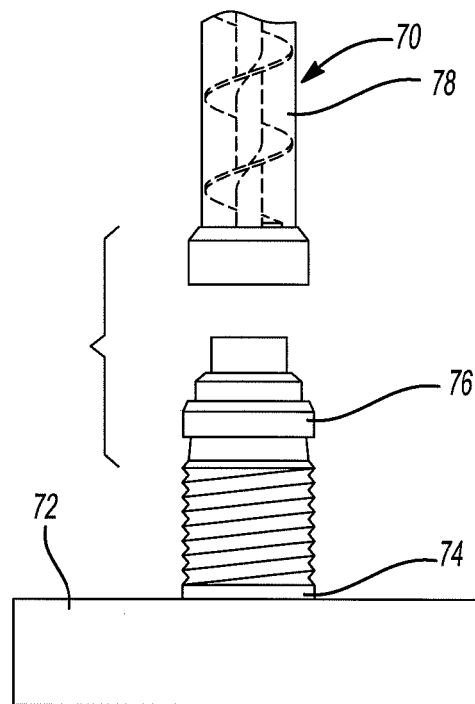
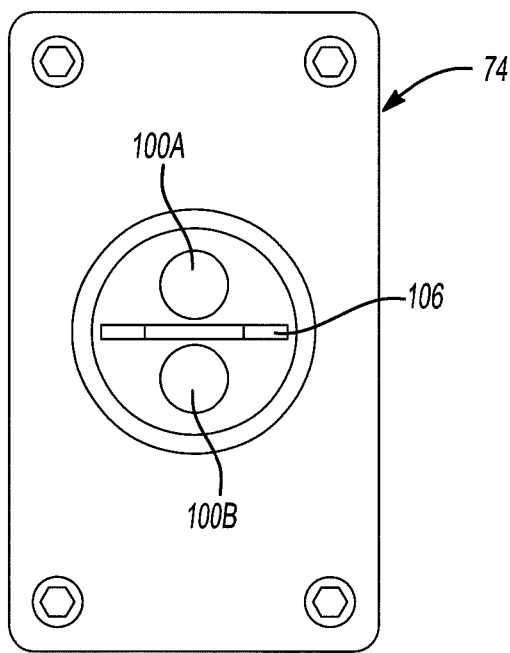
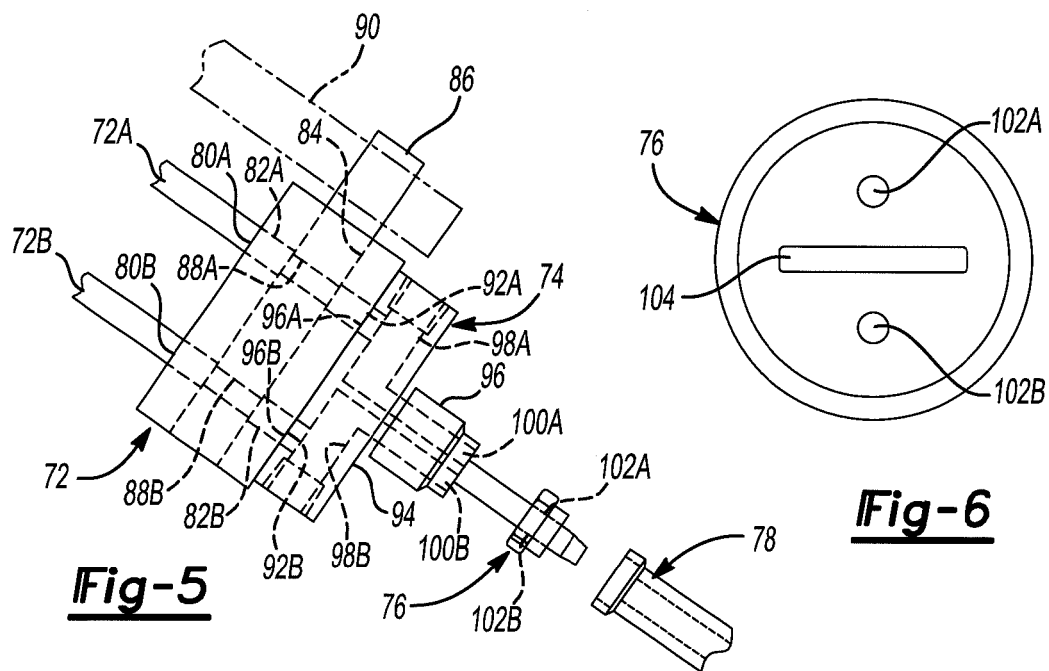


Fig-4



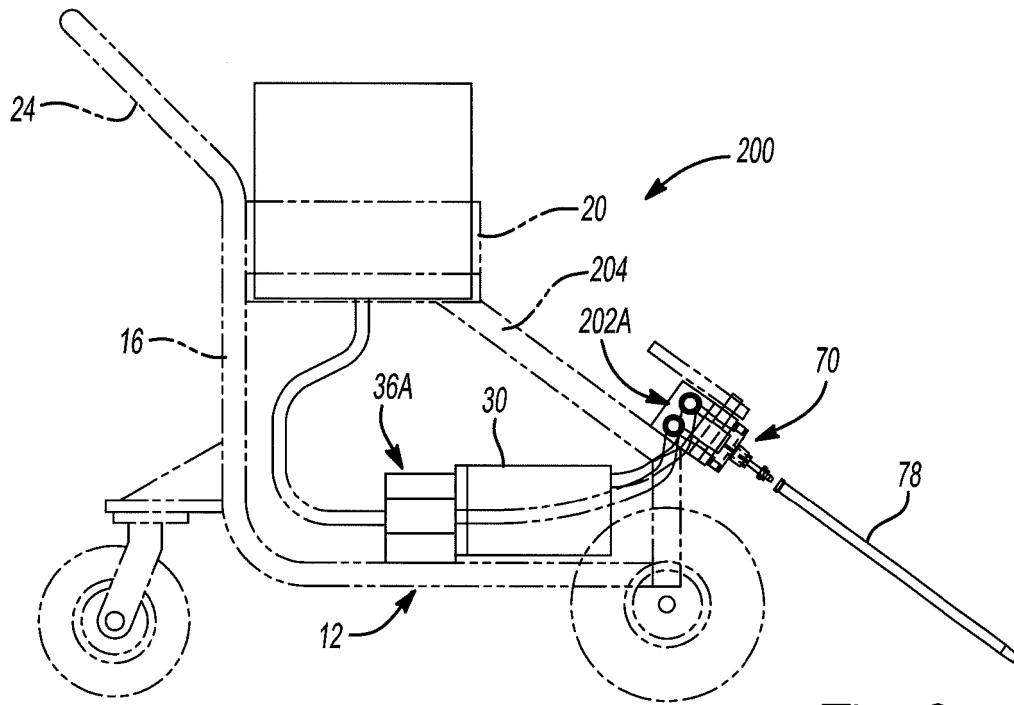


Fig-9

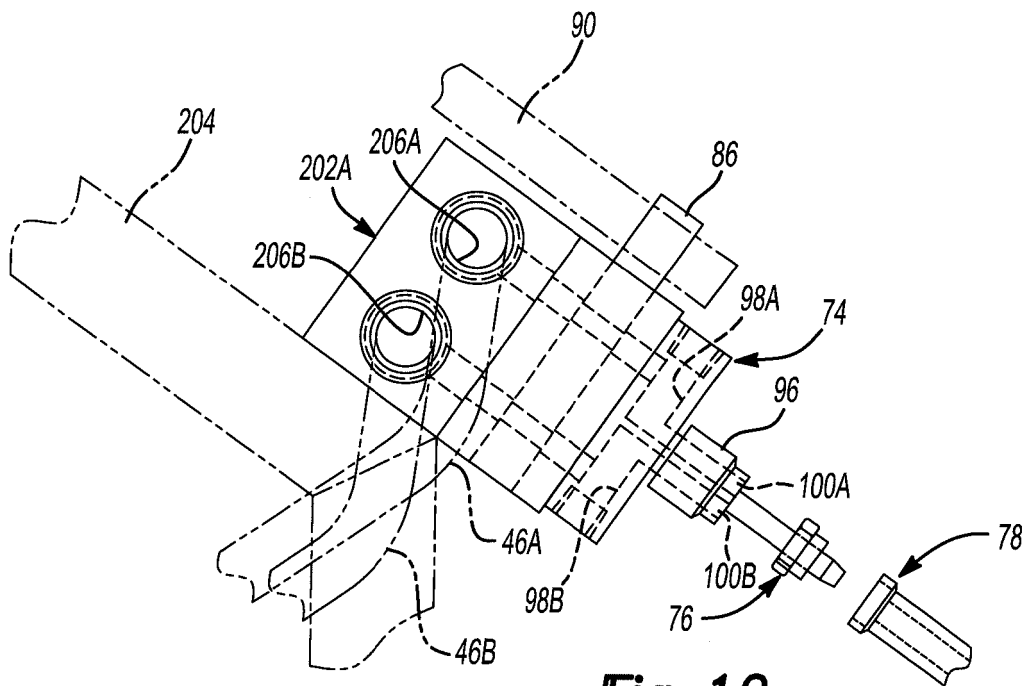
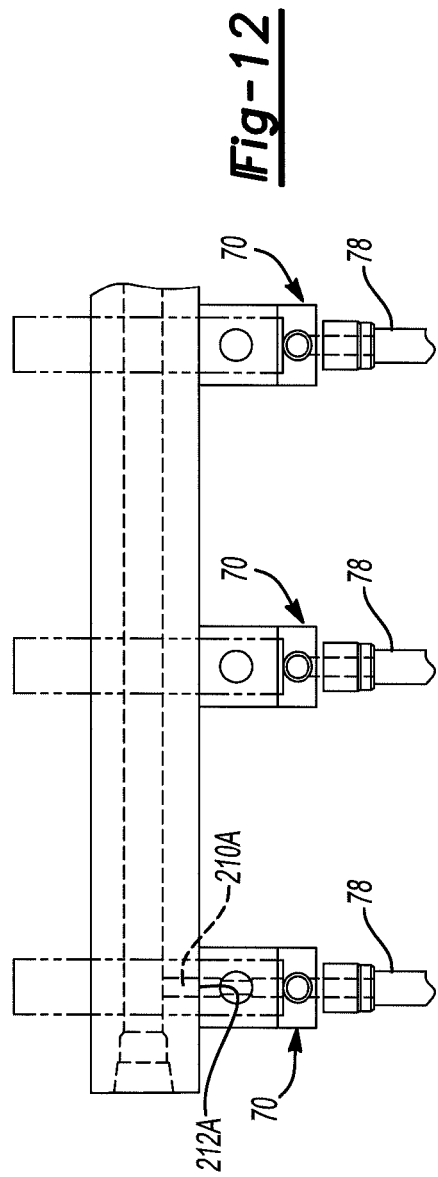
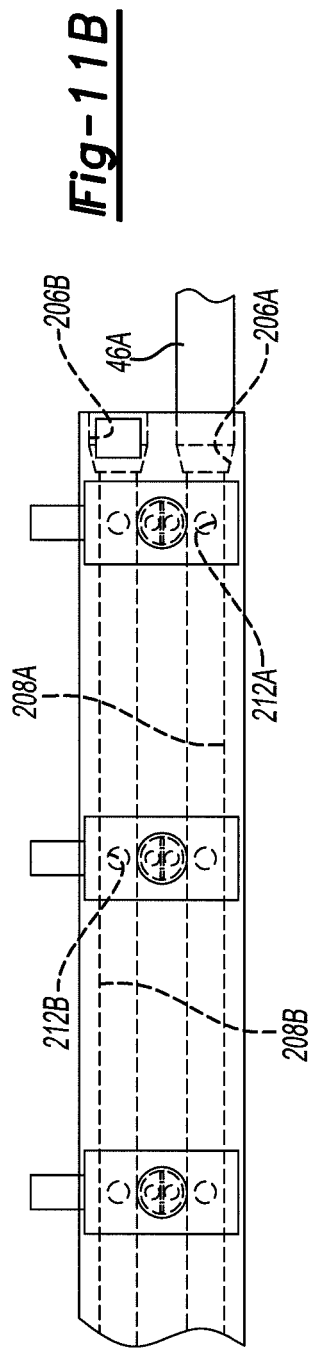
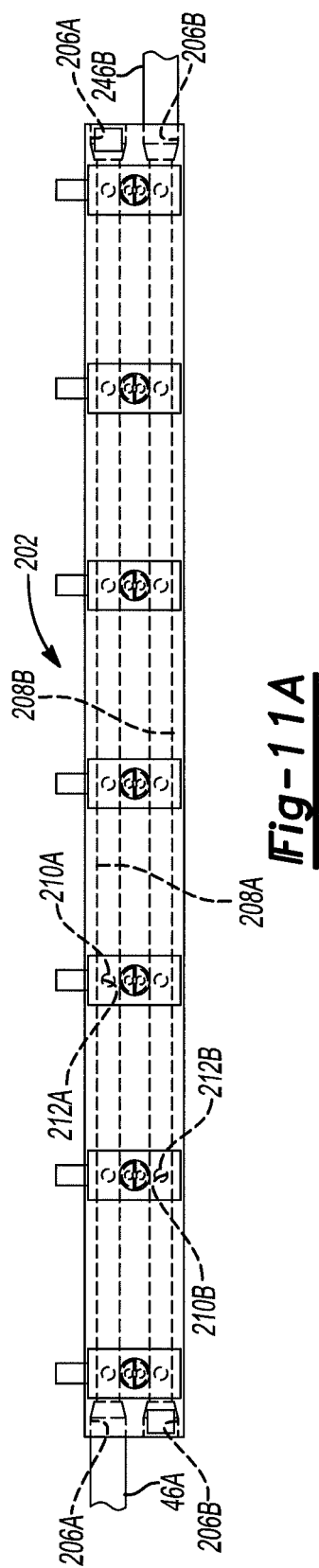
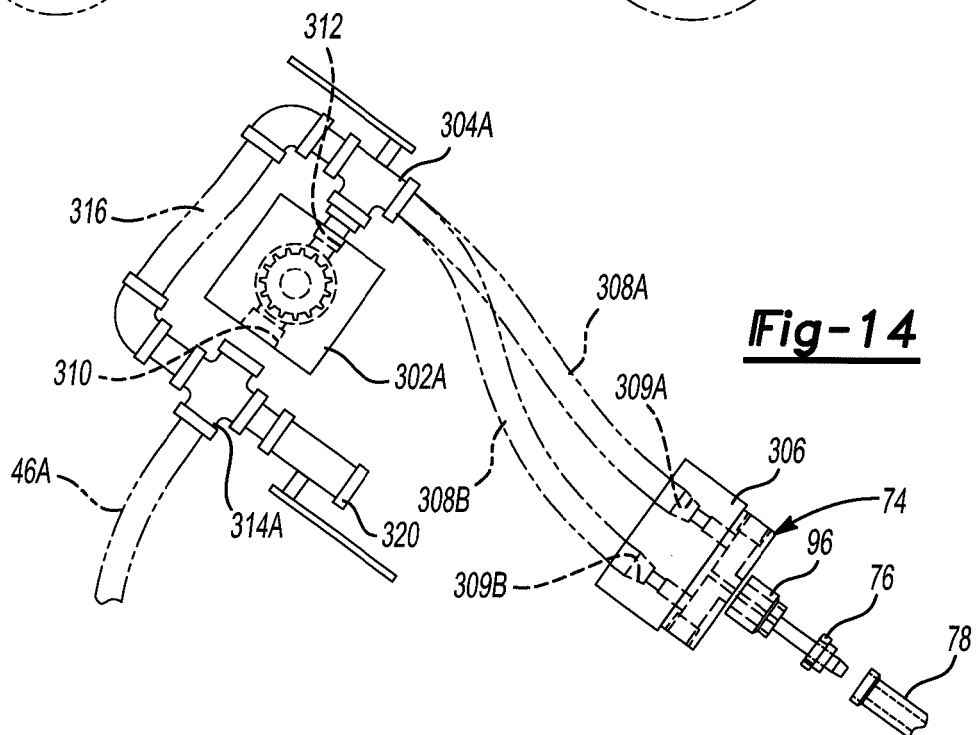
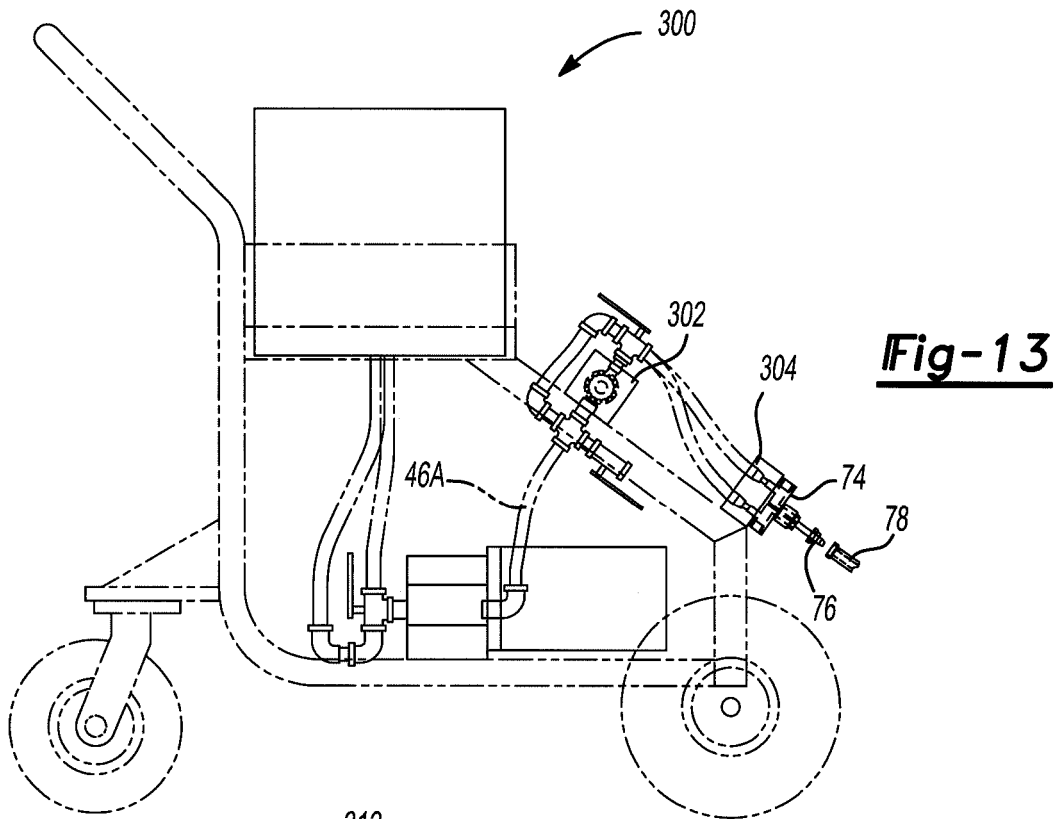
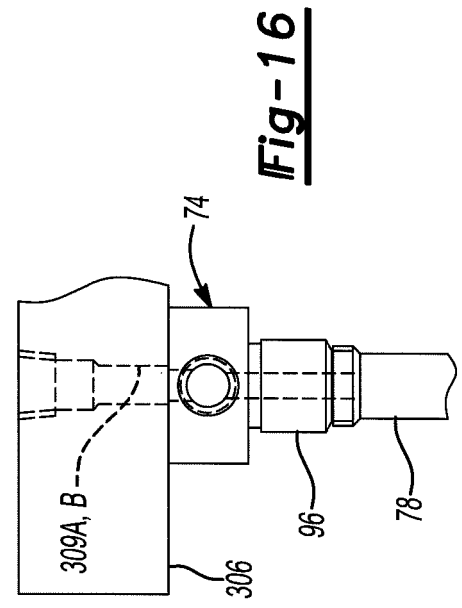
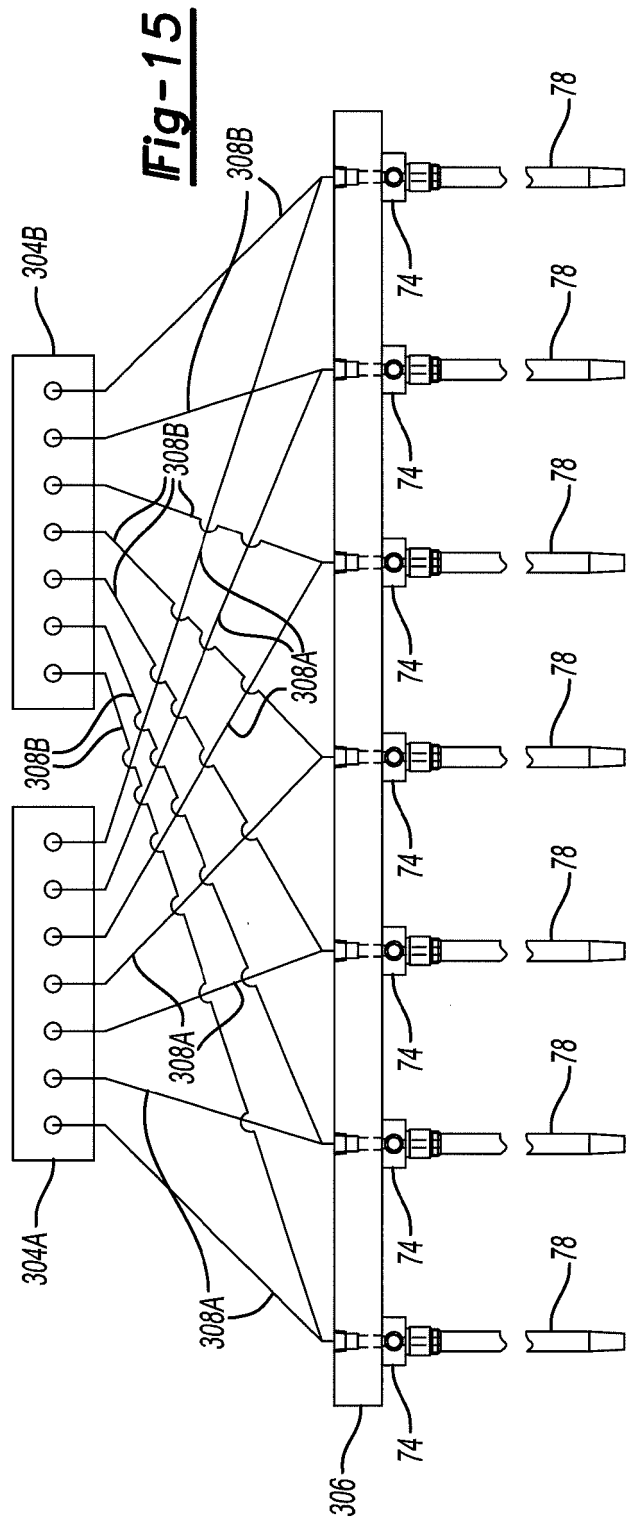
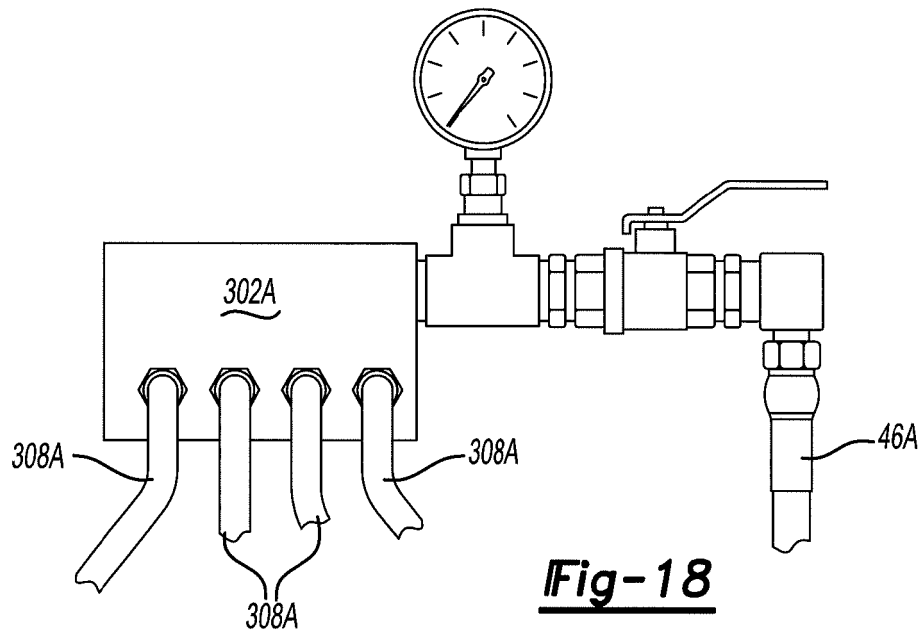
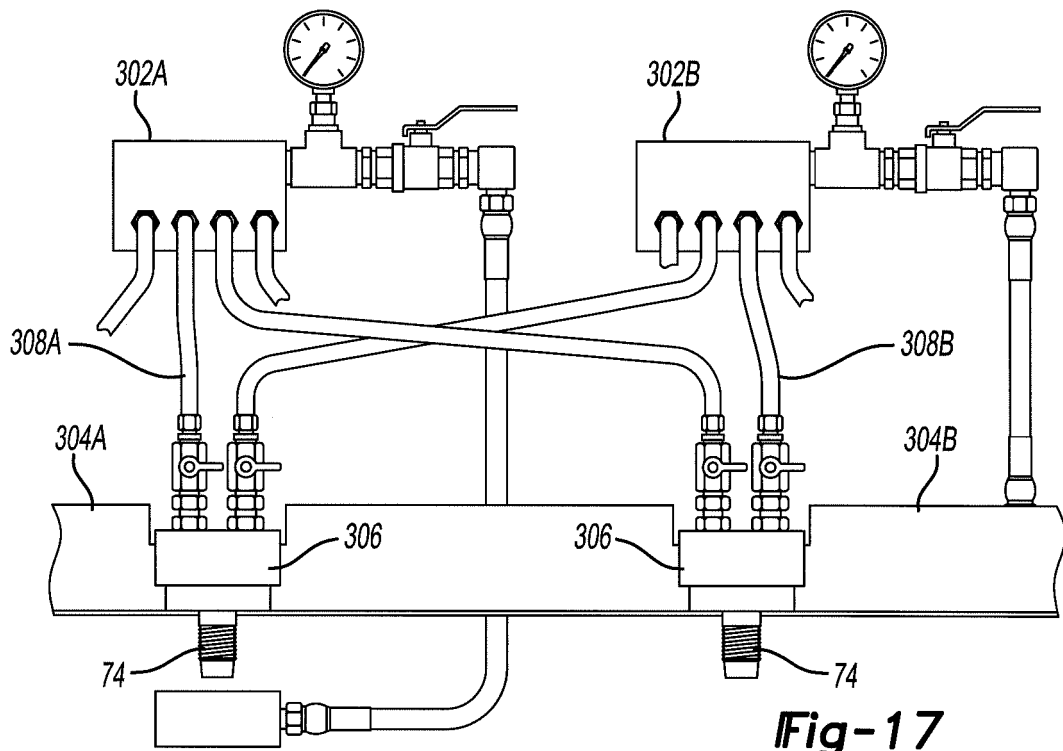


Fig-10









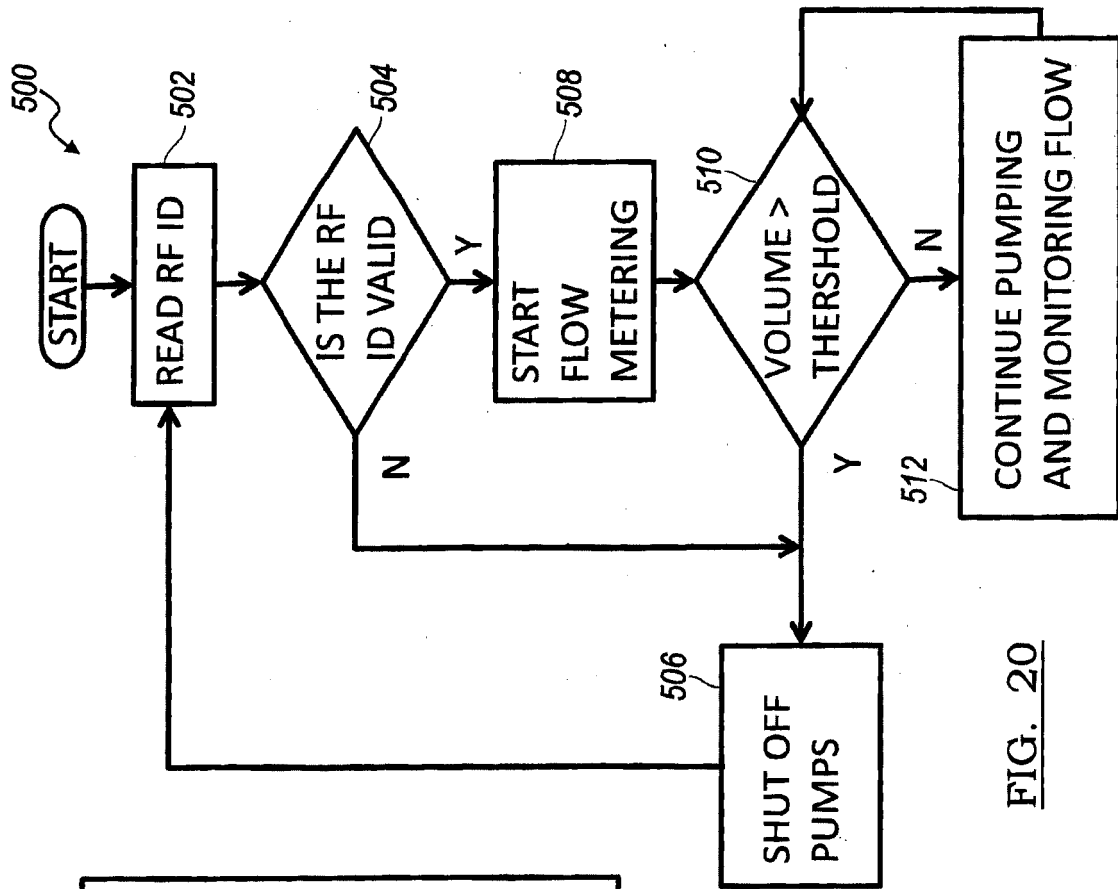


FIG. 20

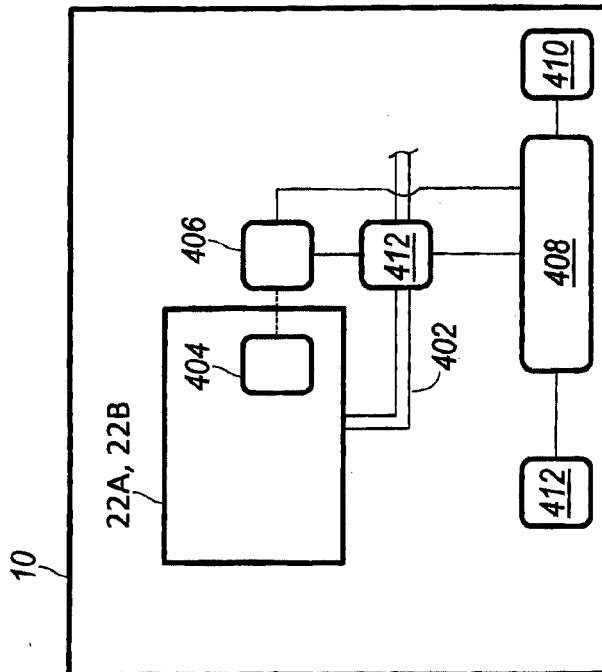


FIG. 19

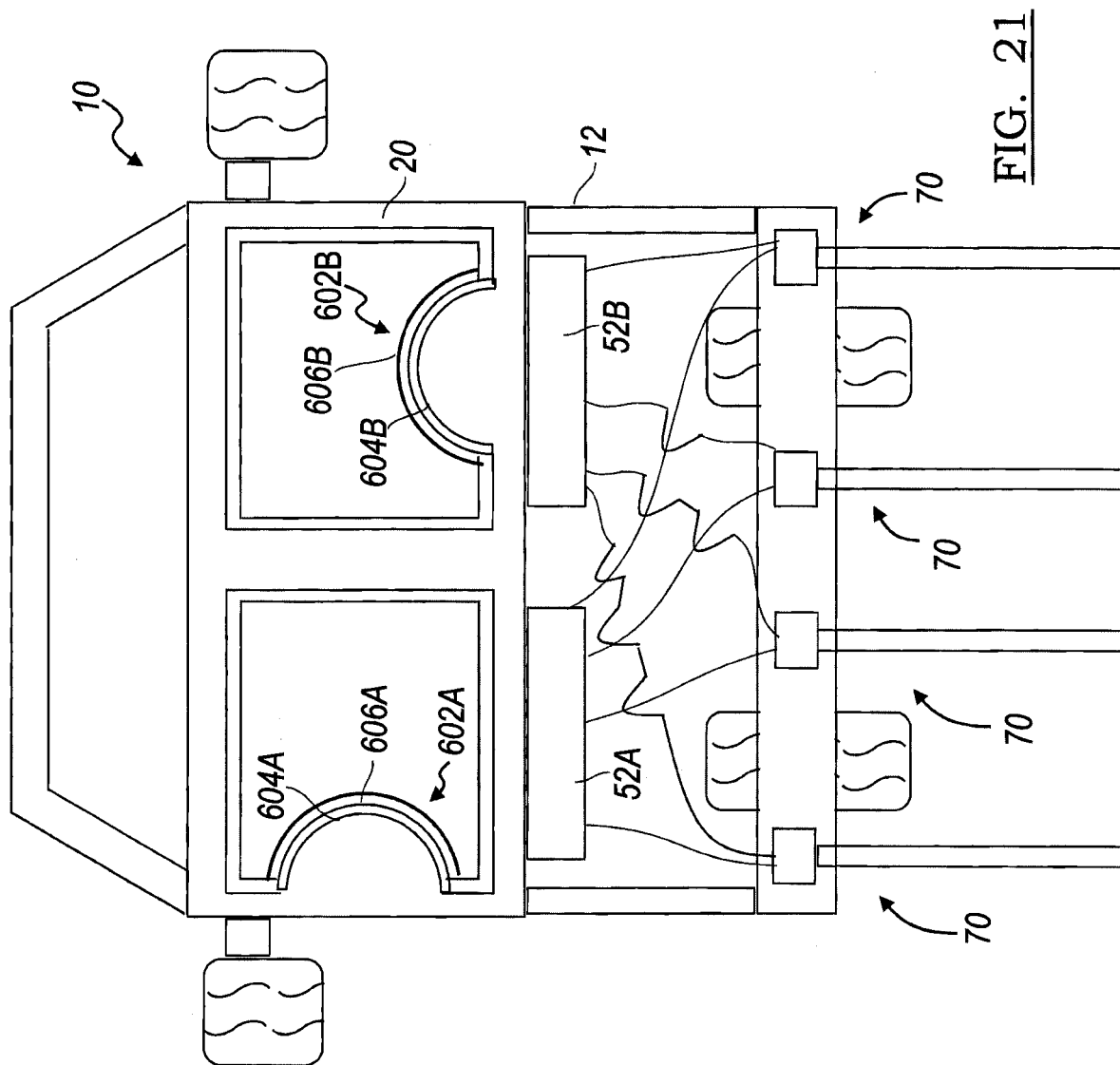


FIG. 21

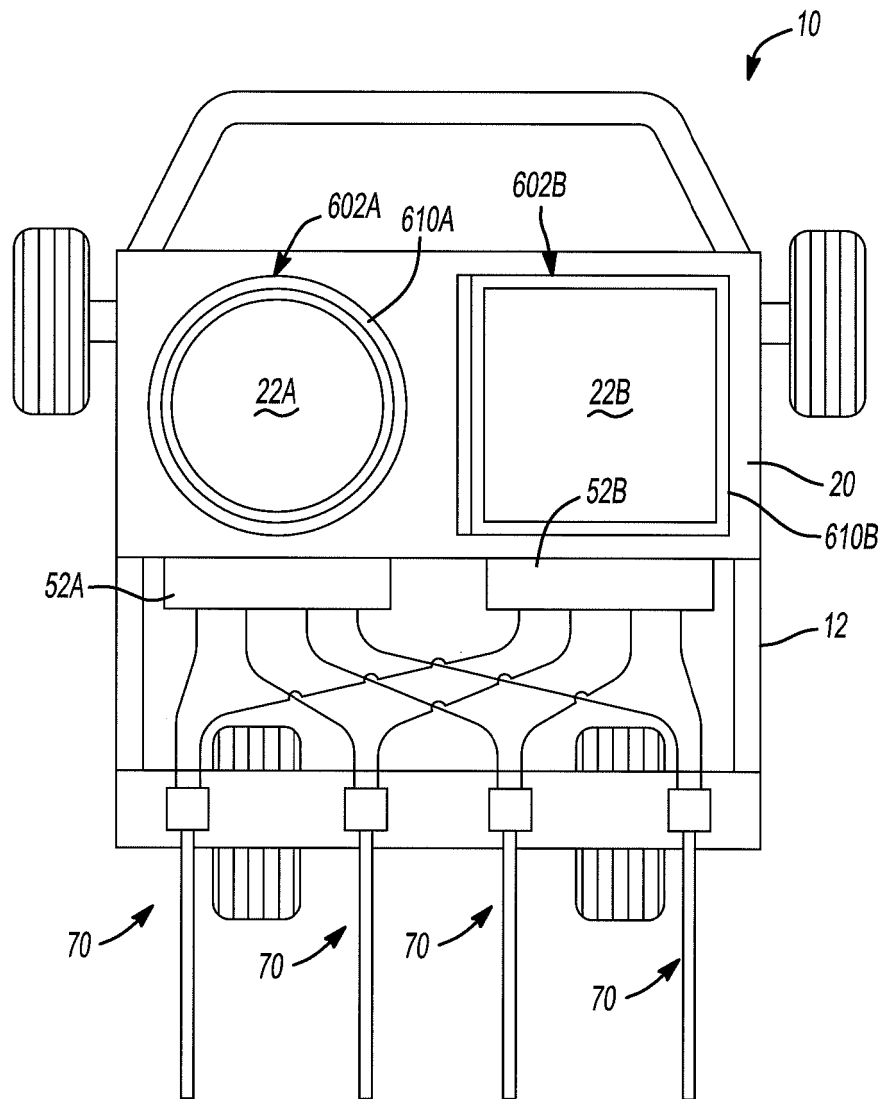
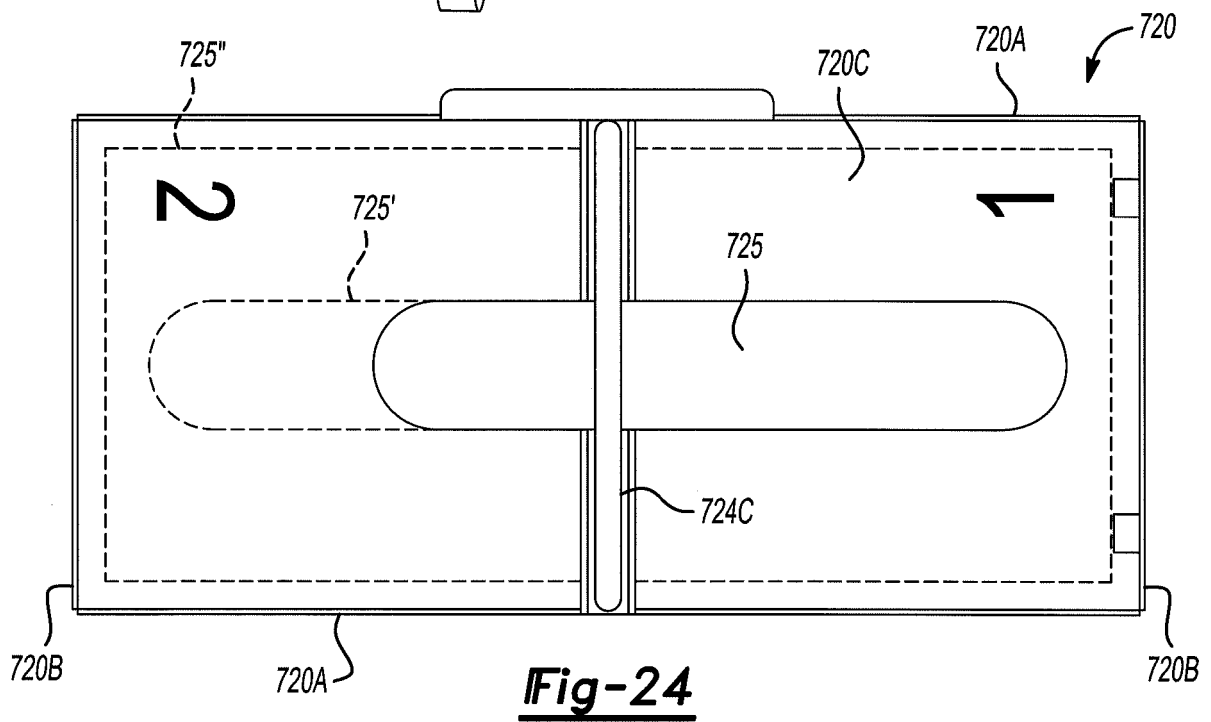
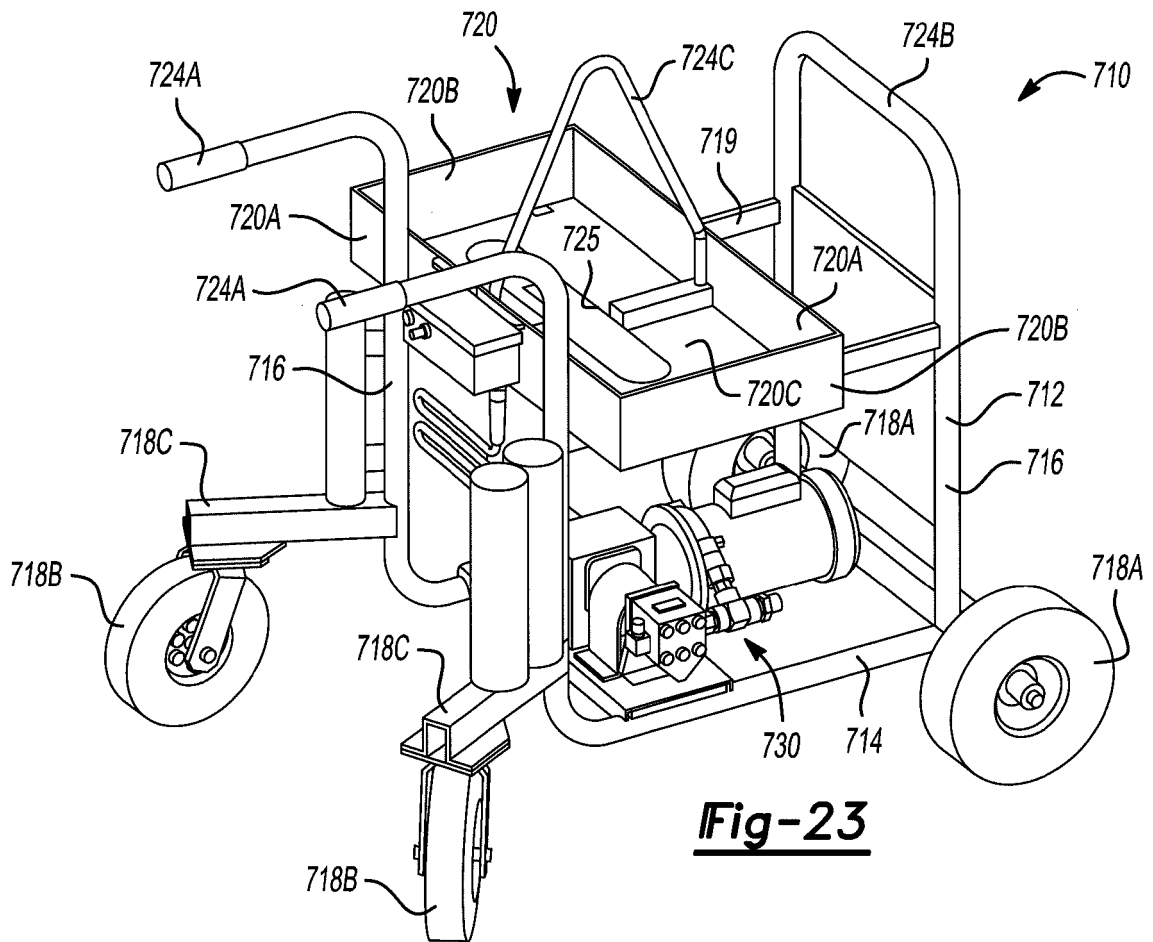


Fig-22



REFERENCES CITED IN THE DESCRIPTION

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