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(54) **STAND-UP PADDLING BOARD IN STRUCTURE WITH DOUBLE INDEPENDENT SAFE AIR CHAMBERS AND MANUFACTURING METHOD THEREOF**

(57) The invention discloses a stand-up paddling board in a structure with double independent safe air chambers. The stand-up paddling board includes a paddle board body, wherein the paddle board body includes a middle air chamber and a paddle board air chamber; the middle air chamber and the paddle board air chamber are air bags formed by tailoring wire-drawing cloth materials; a groove containing the middle air chamber in a matched manner is formed in the middle of the paddle board air chamber, and the middle air chamber is arranged in the groove; the paddle board air chamber and the middle air chamber are aligned in surface; a sealing layer is located on the outer side wall of the paddle board air chamber, a sealing layer is also located on the outer side wall of the middle air chamber, and an independent

sealing layer is located on the inner side wall of the paddle board air chamber; the middle air chamber is fastened and connected with the paddle board air chamber, a connection layer is located on the joint of the middle air chamber and the paddle board air chamber, and a circular reinforced layer is located on the connection layer; a reinforced layer is located on the bottom surface of the paddle board air chamber; and high-pressure safety air valves are respectively arranged on the paddle board air chamber and the middle air chamber, and a sealing layer and a reinforced layer are arranged on the junction of each high-pressure safety air valve and the paddle board body. The invention further discloses a manufacturing process of the stand-up paddling board in a structure with double independent safe air chambers.

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Description

TECHNICAL FIELD

[0001] The invention relates to a stand-up paddling board in a structure with double air chambers and also relates to a manufacturing method of the stand-up paddling board in a structure with double air chambers.

DESCRIPTION OF RELATED ART

[0002] Stand-up paddling (SUP) is an aquatic entertainment sport which is rooted in Hawaii, America, has becomes popular in the world and is fastest developed in the world at present. SUP shorts for Stand-Up Paddling and also refers to "stand-up paddling" or "stroke paddle board". The SUP boards are mainly made from a novel space cloth (DWF) and a netted sandwich cloth attached to the novel space cloth, thereby having the advantages of being portable, capable of being folded for storage, high in support strength and the like. There are various types of SUP boards, such as ALL-ROUND, TOURING, SUPF, JUNIOR, WHITE WATER, YOGA, WINDSURF, RACE, MULTI-PERSON and the like, which are suitable for different environments and different people from courtyard swimming pools to outdoor water areas, and SUP is a sport which is very simple, easy to learn and suitable for both the young and the old.

[0003] Most SUP boards in the current market adopt a paddle board, which is provided with one air chamber and does not have a safety precaution function, and in order to guarantee the safety of users, the manufacturing process should be very strict.

[0004] SUP boards have quite high special requirements for bearing strength and materials; in order to guarantee the safety of users on water, a SUP board in a structure with double air chambers and a process thereof are developed by our company; and when the SUP board is in use, once one air chamber is fractured, customers can still smoothly return to a shore under the protection of the other air chamber.

BRIEF SUMMARY OF THE INVENTION

[0005] Aiming at the defects of the prior art, embodiments of the invention provide a stand-up paddling board in a structure with double independent safe air chambers to solve the problems that a paddle board with one air chamber does not have a safety precaution function, and that a structure with double air chambers in current market is unreasonable, influences the support strength of a paddle board due to the failure to bear high-strength tensile force and generates larger potential safety hazards for the selling gimmick of double air chambers. In addition, the invention also provides a manufacturing method of the stand-up paddling board in a structure with double independent safe air chambers.

[0006] In order to solve the above problems and to re-

alize high strength, high support strength and high safety guarantee of a product, the invention provides a stand-up paddling board in a structure with double independent safe air chambers. The stand-up paddling board includes a paddle board body, wherein the paddle board body includes a middle air chamber and a paddle board air chamber; the middle air chamber and the paddle board air chamber are air bags formed by tailoring wire-drawing cloth materials; a groove containing the middle air chamber in a matched manner is formed in the middle of the paddle board air chamber, and the middle air chamber is arranged in the groove; and the paddle board air chamber and the middle air chamber are aligned in surface. The stand-up paddling board has the follow innovation points: a sealing layer is located on the outer side wall of the paddle board air chamber, a sealing layer is located on the outer side wall of the middle air chamber, and an independent sealing layer is located on the inner side wall of the paddle board air chamber; the middle air chamber is fastened and connected with the paddle board air chamber, a connection layer is located on the joint of the middle air chamber and the paddle board air chamber, and a circular reinforced layer is located on the connection layer; a reinforced layer is located on the bottom surface of the paddle board air chamber; and high-pressure safety air valves are respectively arranged on the paddle board air chamber and the middle air chamber, and a sealing layer and a reinforced layer are arranged on the junction of each high-pressure safety air valve and the paddle board body.

[0007] According to the stand-up paddling board in a structure with double independent safe air chambers in one embodiment, a reinforced layer is located on the outer side wall of the middle air chamber, and a reinforced layer is located on the inner side wall of the paddle board air chamber.

[0008] According to the stand-up paddling board in a structure with double independent safe air chambers in one embodiment, each high-pressure safety air valve has an upper half part arranged on the outer surface of the paddle board body and a lower half part arranged in a cavity of the paddle board body.

[0009] According to the stand-up paddling board in a structure with double independent safe air chambers in one embodiment, the upper half part and the lower half part of each high-pressure safety air valve are tightly connected in a spiral manner.

[0010] In one embodiment, the manufacturing process of the stand-up paddling board in a structure with double independent safe air chambers includes the following steps:

(1) forming an air valve hole with a diameter of 3.5-4.5cm in a paddle board body; adopting a circular sealing layer having the inner diameter of 3.5-4.5cm, and adopting a circular reinforced layer having the inner diameter of 3.5-4.5cm and the outer diameter 2-4cm larger than the outer diameter of the circular

sealing layer; concentrically superposing the circular sealing layer, the circular reinforced layer and the air valve hole together through heat sealing or gluing to form a sealing layer and a reinforced layer on the junction of each high-pressure safety air valve and the paddle board body;

(2) cutting a rectangle with a length of 170-30cm in the middle of a wire-drawing cloth, and mounting the corresponding high-pressure safety air valve on the cut rectangle according to step (1); performing heat sealing on four edges of the rectangle by means of a PVC soft netted sandwich cloth with a width of 14-24cm, and forming a middle air chamber by inflating the rectangle, wherein the cut rectangle accounts for 20%-60% of the whole wire-drawing cloth;

(3) performing heat sealing on four edges of a hollowed rectangular part of the wire-drawing cloth by means of a PVC soft netted sandwich cloth with a width of 14-24cm; performing heat sealing on a peripheral edge of a hollowed part by means of a PVC soft netted sandwich cloth with a width of 6-16cm to form a paddle board air chamber;

(4) placing the middle air chamber into the paddle board air chamber, and jointing the edges of the paddle board air chamber and the middle air chamber through a heat sealing process or a gluing process by means of a PVC soft netted sandwich cloth with a thickness of 0.45-0.85mm and a width of 3.5-7cm to form sealing layers on the outer side wall and the inner side wall of the paddle board air chamber as well as a sealing layer on the outer side wall of the middle air chamber respectively;

(5) partially or entirely covering the upper surface and the lower surface of a whole board formed through the connection of the paddle board air chamber and the middle air chamber with a PVC soft netted sandwich cloth with a thickness of 0.45-0.85mm to form a reinforced layer on the bottom surface of the paddle board air chamber and a reinforced layer on the surface of the middle air chamber; and

(6) arranging at least one layer of PVC soft netted sandwich cloth with a thickness of 0.45-0.85mm and a width of 8-20cm on a sealing layer on the peripheral edge of the paddle board air chamber to cover four side surfaces of a paddle board through heat sealing or gluing to respectively form a reinforced layer on the outer side wall of the paddle board air chamber.

[0011] In addition, as a preferable embodiment, the manufacturing process of the stand-up paddling board in a structure with double independent safe air chambers further includes the following steps:

(7) additionally arranging a paddle board body reinforcing strip, namely a layer of netted sandwich cloth which is a high-strength composite material and has a thickness of 0.45-0.9mm, along the outer arc edge of the paddle board air chamber, that is to say, additionally arranging the paddle board body reinforcing strip on an air chamber sealing strip located on the outer edge of the paddle board air chamber, wherein the outer edge reinforcing strip of the paddle board body is 3-4cm wider than the outer edge sealing strip, so that the outer edge sealing strip is completely covered under the outer edge reinforcing strip and is better protected against fractures when impacted, and besides, the support strength of the whole paddle board body is effectively improved;

(8) arranging an EVA non-slip mat with a hardness of 38-55 Pa on the stand-up paddling board, so that the friction between the foot soles of a user and the paddle board body is increased, and the paddle board body can be controlled more easily during paddling;

(9) arranging four stainless steel D-shaped buckles, to be connected with a seat to provide a seat device for a paddler to relax during long-distance paddling, on a middle area of the paddle board body; arranging four elastic rope adapting pieces at the front end of the paddle board body, wherein the elastic rope adapting pieces are combined with elastic ropes to form an article fixing area for the paddler to carry a luggage; arranging two handles 16 at the middle part and the tail part of the paddle board body, wherein the paddle board in an inflated state can be lifted by the paddler through the handles, so as to be moved more conveniently; and

(10) arranging a convenient slide-in large fin at the lower tail part of the paddle board body, and arranging two fixed small fins on two outward sides in front of the large fin, wherein the large fin and the small fins are arranged based on a rule that three center lines extend forwards and are crossed at a center of the front end of the paddle board body, so that the stability and the forward impulse force of the paddle board body are improved; and the small fins located on the two sides are outward and have centers pointing to the center of the paddle board body, so that turning can be flexibly achieved during paddling.

[0012] Compared with the prior art, the invention has the following advantages: first, two air chambers are independently manufactured, the air impermeability of each air chamber is inspected in advance to ensure the safety of each air chamber, then double-surface connection and double-surface reinforcement are performed on the two air chambers to realize large tensile force of double isolation layers as well as a safe structure of inde-

pendent sealing of independent air chambers, and tested air pressure reaches 1.5 times (22.5Psi) of normal pressure 15Psi; second, a rectangular air chamber is obtained through partition, and air is compressed in a regular space to be limited in flowing so as to form a high-pressure support structure; and compared with a same-sized paddle board with one air chamber, the support strength of the paddle board of the stand-up paddling board is improved by 30%, and the usability a product is brought into full play.

BRIEF DESCRIPTION OF THE SEVERAL VIEWS OF THE DRAWINGS

[0013]

Fig. 1 is a partition diagram of a space cloth for preparing a stand-up paddling board in a structure with double air chambers in an embodiment of the invention;

Fig. 2 is a manufacturing diagram of independent air chambers of the stand-up paddling board in a structure with double air chambers in the embodiment of the invention;

Fig. 3 is an assembly diagram of a middle air chamber of the stand-up paddling board in a structure with double air chambers in the embodiment of the invention;

Fig. 4 is connection diagram of a paddle board air chamber inside the stand-up paddling board in a structure with double air chambers in the embodiment of the invention;

Fig. 5 is a connection reinforcing diagram of the paddle board air chamber inside the stand-up paddling board in a structure with double air chambers in the embodiment of the invention;

Fig. 6 is a reinforcing diagram of an air chamber sealing strip of the stand-up paddling board in a structure with double air chambers in the embodiment of the invention;

Fig. 7 is a schematic diagram of fins of the stand-up paddling board in a structure with double air chambers in the embodiment of the invention;

Fig. 8 is a display diagram of a finished stand-up paddling board in a structure with double air chambers in the embodiment of the invention.

[0014] Reference Signs: 1, paddle board air chamber space cloth; 2, middle air chamber space cloth; 3, air chamber sealing strip; 4, air plug; 5, paddle board air chamber; 6, center air chamber; 7, air chamber connect-

ing strip; 8, air chamber connection reinforced strip; 9, air chamber sealing reinforced strip; 10, EVA non-slip mat; 11, slide-in large fin; 12, fixed small fin; 13, PVC soft reinforced netted sandwich cloth piece; 14, elastic rope adapting piece; 15, stainless steel D-shaped buckle; 16, handle.

DETAILED DESCRIPTION OF THE INVENTION

[0015] The invention is further detailed as follows in combination with the drawings and embodiments. The embodiments are ought to be comprehended as being only used for explaining the invention, but not used for limiting the protection scope of the invention. After reading contents recorded in the invention, those skilled in this field are permitted to make various changes or modifications, these equivalent changes and modifications should also fall within the scope limited by the claims of the invention.

[0016] As shown in Fig. 1-Fig. 8, the preferable embodiment of the invention provides a stand-up paddling board in a structure with double independent safe air chambers. The stand-up paddling board includes a paddle board body, wherein the paddle board body includes a middle air chamber 6 and a paddle board air chamber 5; the middle air chamber 6 and the paddle board air chamber 5 are air bags formed by tailoring wire-drawing cloth materials; a groove containing the middle air chamber 6 in a matched manner is formed in the middle of the paddle board air chamber 5, and the middle air chamber 6 is arranged in the groove; and the paddle board air chamber 5 and the middle air chamber 6 are aligned in surface. A sealing layer is located on the outer side wall of the paddle board air chamber 5, a sealing layer is located on the outer side wall of the middle air chamber 6, and an independent sealing layer is located on the inner side wall of the paddle board air chamber 5; the middle air chamber 6 is fastened and connected with the paddle board air chamber 5, a connection layer is located on the joint of the middle air chamber 6 and the paddle board air chamber 5, and a circular reinforced layer is located on the connection layer; a reinforced layer is located on the bottom surface of the paddle board air chamber 5; and high-pressure safety air valves are respectively arranged on the paddle board air chamber 5 and the middle air chamber 6, and a sealing layer and a reinforced layer are arranged at the junction of each high-pressure safety air valve and the paddle board body.

[0017] When the invention is specifically implemented, a reinforced layer is arranged on the outer side wall of the middle air chamber 6, and a reinforced layer is arranged on the inner side wall of the paddle board air chamber 5.

[0018] When the invention is specifically implemented, each high-pressure safety air valve has an upper half part arranged on the outer surface of the paddle board body and a lower half part arranged in a cavity of the paddle board body, and the upper half part and the lower

half part of each high-pressure safety air valve are tightly connected in a spiral manner.

[0019] As shown in Fig. 1-Fig. 8, when the invention is specifically implemented, the above stand-up paddling board in a structure with double independent safe air chambers is manufactured generally through the following steps:

Step I: in combination with the requirement for safety of an aquatic paddle board, a wire-drawing space cloth is partitioned according to an equant calculation method of 1:1:1 (as shown in Fig. 1, the wire-drawing space cloth is partitioned into a paddle board air chamber space cloth 1 and a middle air chamber space cloth 2) to generate three air support columns with equal strength, so that the strength of the whole paddle board is made uniform, and the balance is better; a middle cuboid air column has a buoyant force of 75L+ and a bearing capacity of 75kg+, and air is effectively compressed in a regular space through reasonable shape division; and compared with a same-sized paddle board with one air chamber, the pressure-bearing rigidity of the whole paddle board body is improved by 30%;

Step II: spaces of the partitioned two parts are sealed with a high-strength composite material 3: 28*28*1000D, namely a specially-made edge sealing material with a thickness of 0.55mm, to form two closed air chambers; the air impermeability of the two closed air chambers are detected; air chamber sealing strips located at the front end and the rear end of the corresponding paddle board body of the paddle board air chamber are obliquely cut by 45°, and air chamber sealing strips located on two sides of the paddle board body are straightly cut; through oblique cutting, the head part of the paddle board body is more streamlined, so that the paddling speed is increased, and the resistance of a water flow is reduced; and through straight cutting, the pressure-bearing area of the paddle board body has a higher rigidity, and the paddle board body is not prone to bending (as shown in Fig. 2) during paddling on a water surface and larger fluctuation on a water surface;

Step III: high-strength press type inflation-deflation integrated air valves 4 are arranged on two independent air chambers, and air valve bodies have a press structure easy and convenient to operate, can achieve manual inflation rapidly within 3min and rapid deflation instantly and adopt dual air sealing, so that the whole paddle board body is safer and more convenient to use;

Step IV: after being manufactured, a middle air chamber 6 is placed back into the original position; the inner and outer air chambers are connected

through an air chamber connecting strip 7 with a pre-set dimension, and the air chamber connecting strip 7 and the air chambers are connected through an aligned back-to-back I-shaped overlapped method which can avoid independent stressed points, so that when the whole paddle board body is inflated to reach a high tensile force of 15-23 PSI, independently-stressed parts can be effectively prevented from bursting through the combination of the aligned back-to-back I-shaped overlapped method and uniform stress of each dotted silk yarn located on a peripheral space cloth body; and according to the aligned back-to-back I-shaped overlapped method, the difference between the width of the connecting strip and the sum of the edges of the two independent air chambers is reasonably set to 5mm, so that the inner and outer independent air chambers reach high integrated strength of an undivided air chamber after being inflated, and a weak tensile force spot (as shown in Fig. 3) is effectively prevented during partition and subsequent bonding of the wire-drawing space cloth;

Step V: an integrally jointed paddle board body with the two air chambers is placed in a room at a constant temperature of 23°C for 24 hours and is inflated to 8-10 PSI after all connecting parts are sufficiently and fixedly connected, the inner and outer air chambers (the paddle board air chamber 5 and the middle air chamber 6) are respectively inflated, and the connection smoothness of the inner and outer air chambers is inspected;

Step VI: a layer of high-strength composite material 8: 20*20*1000D, namely a netted sandwich cloth (as shown in Fig. 5) with a thickness of 0.7mm, is additionally adhered to the air chamber connecting strip to limit the extension of the air chamber connecting strip and to improve the strength of the connecting strip between the two air chambers, and a layer of high-strength composite material 13 is additionally adhered to an air chamber connecting reinforced strip 8 located on the back surface of the paddle board to enhance the whole rigidity of the paddle board;

Step VII: a paddle board body reinforcing strip 9, namely a layer of netted sandwich cloth which is a high-strength composite material: 20*20*1000D and has a thickness of 0.7mm, is additionally arranged along the outer arc edge of the paddle board air chamber, that is to say, the paddle board body reinforcing strip 9 is additionally arranged on the air chamber sealing strip located on the outer edge of the paddle board air chamber; the outer edge reinforcing strip of the paddle board body is 3-4cm wider than the outer edge sealing strip, so that the outer edge sealing strip can be completely covered under

the outer edge reinforcing strip and be better protected against fractures when impacted, and besides, the support strength of the whole paddle board body is effectively improved (as shown in Fig. 6);

Step VIII: an EVA non-slip mat 10 with a hardness of 38-55Pa is placed on the stand-up paddling board, so that the friction between the foot soles of a user and the paddle board body is increased, and the paddle board body can be controlled more easily during paddling;

Step IX: four #316 stainless steel D-shaped buckles 15 are arranged in a middle area of the paddle board body to be connected a seat to provide a seat device for a paddler to relax during long-distance paddling; and four elastic rope adapting pieces 14 are arranged at the front end of the paddle board body; the elastic rope adapting pieces 14 and elastic ropes form an article fixing area for the paddler to carry a luggage; two handles 16 are arranged at the middle part and the tail part of the paddle board body; and the paddle board in an inflated state can be lifted by the paddler through the handles, so as to be moved more conveniently; and

Step X: a convenient slide-in large fin 11 is arranged under the lower tail part of the paddle board body, and two fixed small fins 12 are arranged on two outward sides in front of the large fin 11; the large fin 11 and the small fins 12 are arranged based on a rule that three center lines extend forwards and are crossed at the center of the front end of the paddle board body, so that the stability and the forward impulse force of the paddle board body are improved; and the small fins located on the two sides are outward and have the centers pointing to the center of the paddle board body, so that turning can be flexibly achieved during paddling.

Claims

1. A stand-up paddling board in a structure with double independent safe air chambers, comprising a paddle board body, wherein the paddle board body comprises a middle air chamber (6) and a paddle board air chamber (5); the middle air chamber (6) and the paddle board air chamber (5) are air bags formed by tailoring wire-drawing cloth materials; a groove containing the middle air chamber (6) in a matched manner is formed in a middle of the paddle board air chamber (5), and the middle air chamber (6) is arranged in the groove; the paddle board air chamber (5) and the middle air chamber (6) are aligned in surface; a sealing layer and a reinforced layer are located on an outer side wall of the paddle board air chamber (5), a sealing layer is located on an outer

side wall of the middle air chamber (6), and an independent sealing layer is located on an inner side wall of the paddle board air chamber (5); the middle air chamber (6) is fastened and connected with the paddle board air chamber (5), a connection layer is located on a joint of the middle air chamber (6) and the paddle board air chamber (5), and a circular reinforced layer is located on the connection layer; a reinforced layer is located on a bottom surface of the paddle board air chamber (5); and high-pressure safety air valves are respectively arranged on the paddle board air chamber (5) and the middle air chamber (6), and a sealing layer and a reinforced layer are arranged on a junction of each said high-pressure safety air valve and the paddle board body.

2. The stand-up paddling board in a structure with double independent safe air chambers according to claim 1, wherein a reinforced layer is located on the outer side wall of the middle air chamber (6), and a reinforced layer is located on the inner side wall of the paddle board air chamber (5).
3. The stand-up paddling board in a structure with double independent safe air chambers according to claim 1, wherein each said high-pressure safety air valve has an upper half part arranged on an outer surface of the paddle board body and a lower half part arranged in a cavity of the paddle board body.
4. The stand-up paddling board in a structure with double independent safe air chambers according to claim 2, wherein an upper half part and a lower half part of each said high-pressure safety air valve are tightly connected in a spiral manner.
5. A manufacturing process of a stand-up paddling board in a structure with double independent safe air chambers, comprising the following steps:

- (1) forming an air valve hole having a diameter of 3.5-4.5cm in a paddle board body; adopting a circular sealing layer having an inner diameter of 3.5-4.5cm, and adopting a circular reinforced layer having an inner diameter of 3.5-4.5cm and an outer diameter 2-4cm larger than an outer diameter of the circular sealing layer; concentrically superposing the circular sealing layer, the circular reinforced layer and the air valve hole together through heat sealing or gluing to form a sealing layer and a reinforced layer which are located on a joint of each high-pressure safety air valve and the paddle board body;
- (2) cutting a rectangle with a length of 170*30cm in a middle of a wire-drawing cloth, and mounting the corresponding high-pressure safety air valve on the cut rectangle according to step (1); performing gluing or heat sealing on four edges of

the rectangle by means of a PVC soft netted sandwich cloth with a width of 14-24cm, and forming a middle air chamber by inflating the rectangle, wherein the cut rectangle accounts for 20%-60% of the whole wire-drawing cloth;

(3) performing gluing or heat sealing on four edges of a hollowed rectangular part of the wire-drawing cloth by means of a PVC soft netted sandwich cloth with a width of 14-24cm; performing heat sealing on a peripheral edge of the hollowed part by means of a PVC soft netted sandwich cloth with a width of 6-16cm to form a paddle board air chamber;

(4) placing the middle air chamber into the paddle board air chamber, and jointing edges of the paddle board air chamber and the middle air chamber through a heat sealing process or a gluing process by means of a PVC soft netted sandwich cloth with a thickness of 0.45-0.85 mm and a width of 3.5-7cm to form sealing layers on an outer side wall and an inner side wall of the paddle board air chamber as well as a sealing layer on an outer side wall of the middle air chamber respectively;

(5) partially or entirely covering an upper surface and a lower surface of a whole board formed through connection of the paddle board air chamber and the middle air chamber with a PVC soft netted sandwich cloth with a thickness of 0.45-0.85 mm to form a reinforced layer on a bottom surface of the paddle board air chamber 5 and a reinforced layer on a surface of the middle air chamber; and

(6) arranging at least one layer of PVC soft netted sandwich cloth with a thickness of 0.45-0.85mm and a width of 8-20cm on a sealing layer on a peripheral edge of the paddle board air chamber to cover four side surfaces of a paddle board through heat sealing or gluing to respectively form a reinforced layer on the outer side wall of the paddle board air chamber.

6. The manufacturing process of a stand-up paddling board in a structure with double independent safe air chambers according to claim 5, wherein the following step is further performed:
- (7) additionally arranging a paddle board body reinforcing strip, namely a layer of netted sandwich cloth which is a high-strength composite material and has a thickness of 0.45-0.9mm, along an outer arc edge of the paddle board air chamber, that is to say, additionally arranging the paddle board body reinforcing strip on an air chamber sealing strip located on an outer edge of the paddle board air chamber, wherein the outer edge reinforcing strip of the paddle board body is 3-4cm wider than the outer edge sealing strip, so that the outer edge sealing strip is completely covered under the outer edge reinforcing

strip.

7. The manufacturing process of a stand-up paddling board in a structure with double independent safe air chambers according to claim 6, wherein the following step is further performed:
- (8) arranging an EVA non-slip mat with a hardness of 38-55Pa on the stand-up paddling board.
8. The manufacturing process of a stand-up paddling board in a structure with double independent safe air chambers according to claim 7, wherein the following step is further performed:
- (9) arranging four stainless steel D-shaped buckles, to be connected with a seat to provide a seat device for a paddler to relax during long-distance paddling, on a middle area of a paddle board body; arranging four elastic rope adapting pieces at a front end of the paddle board body, wherein an article fixing area is formed through combination of the elastic rope adapting pieces and elastic ropes.
9. The manufacturing process of a stand-up paddling board in a structure with double independent safe air chambers according to claim 8, wherein the following step is further performed:
- (10) depositing a convenient slide-in large fin at a lower tail part of the paddle board body, and depositing two fixed small fins on two outward sides in front of the large fin, wherein the large fin and the small fins are arranged based on a rule that three center lines extend forwards and are crossed at a center of the front end of the paddle board body, so that the stability and forward impulse force of the paddle board body are improved, and the small fins located on the two sides are outward and have centers pointing to a center of the paddle board body.

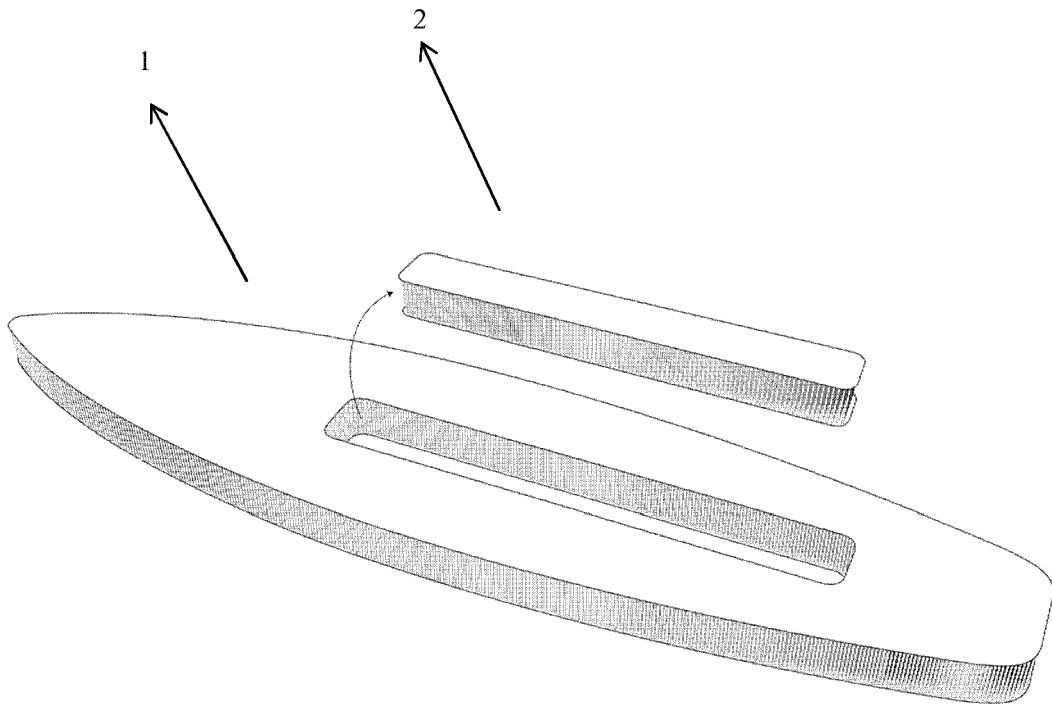


Fig. 1

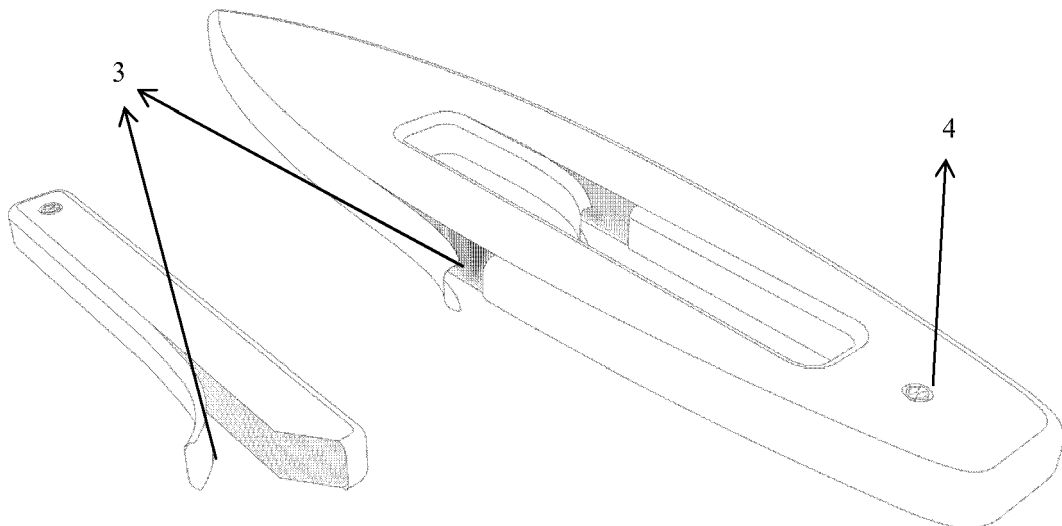


Fig. 2

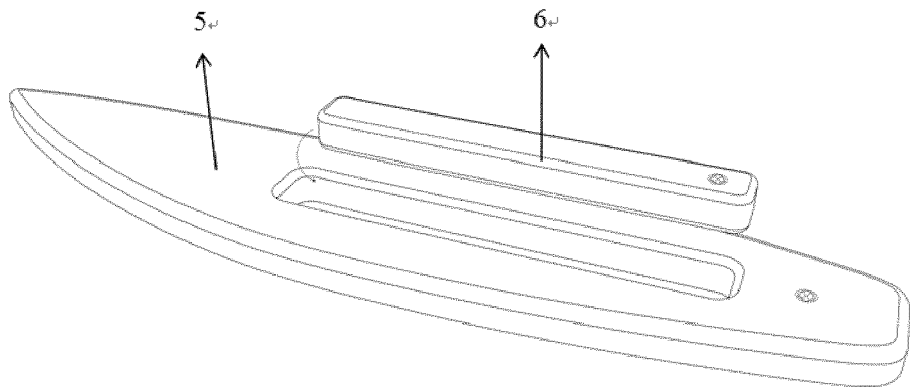


Fig. 3

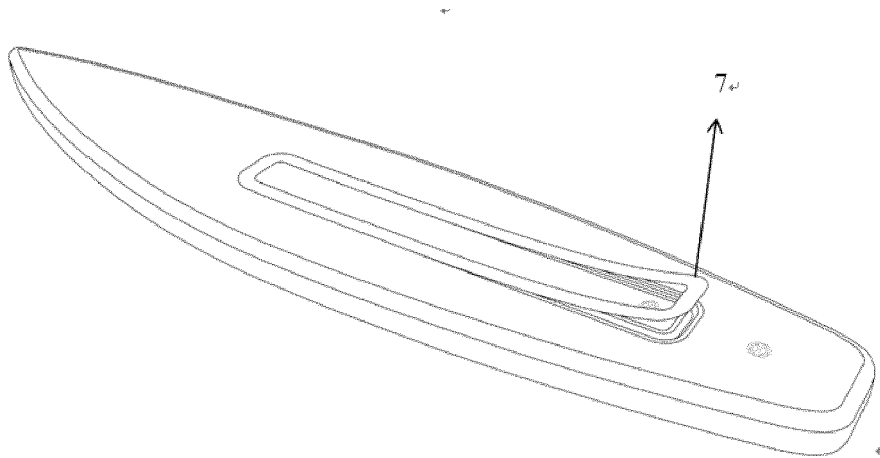


Fig. 4

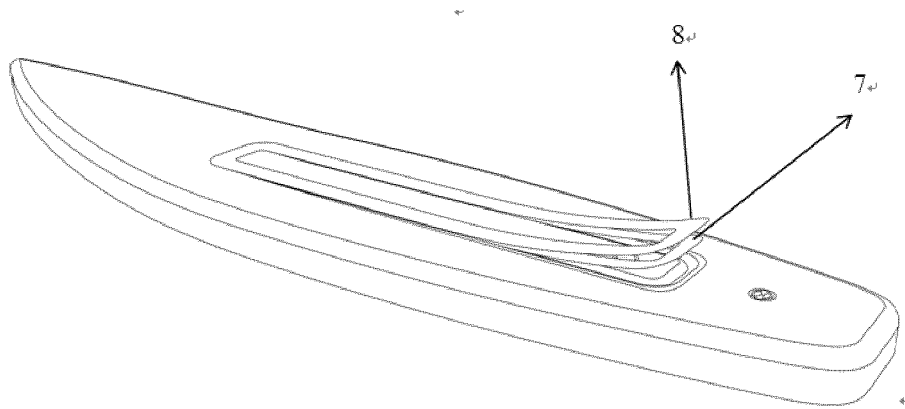


Fig. 5

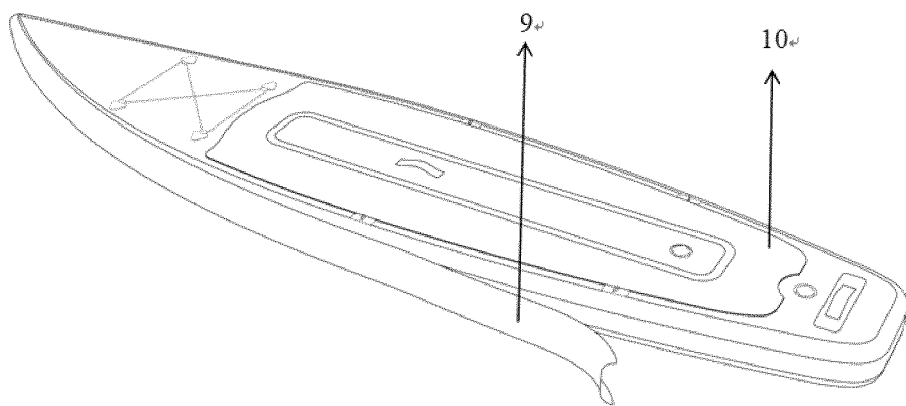


Fig. 6

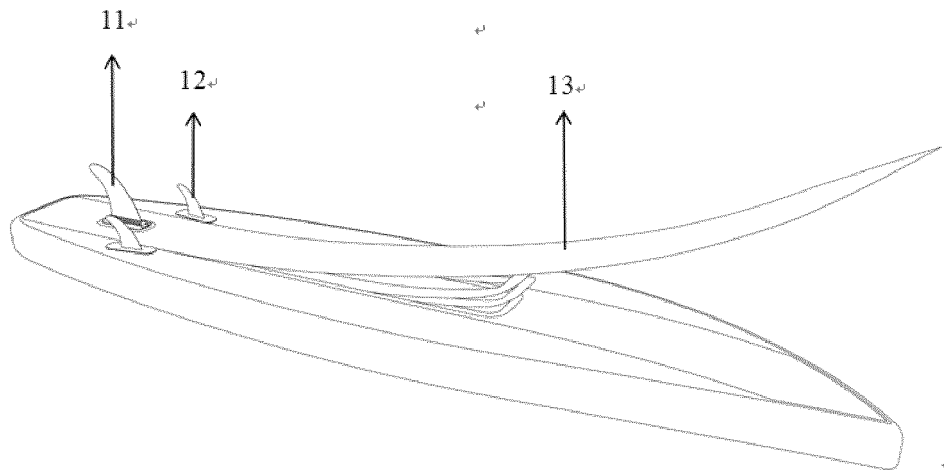


Fig. 7

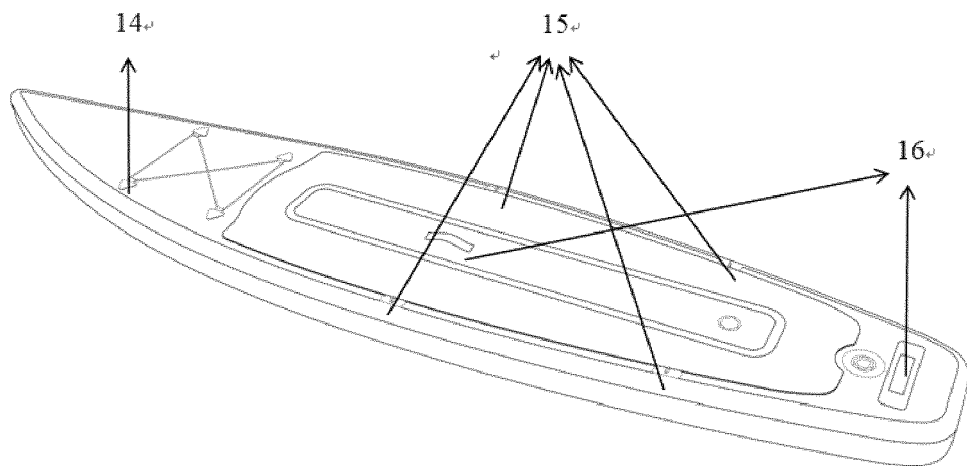


Fig. 8



EUROPEAN SEARCH REPORT

Application Number
EP 19 17 4004

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DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (IPC)
X	EP 2 808 245 A1 (SHANGHAI JILONG PLASTIC PRODUCTS CO LTD [CN]) 3 December 2014 (2014-12-03) * paragraph [0008] * * paragraph [0010] - paragraph [0011] * * figures *	1-9	INV. B63B35/79 B63B7/08
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