

Cannon

Planta de grandes dimensoes para producao descontinua de panéis de isolamento

Congresso Internacional de
Poliuretano 2012

Palestrante: Riccardo Mezzera

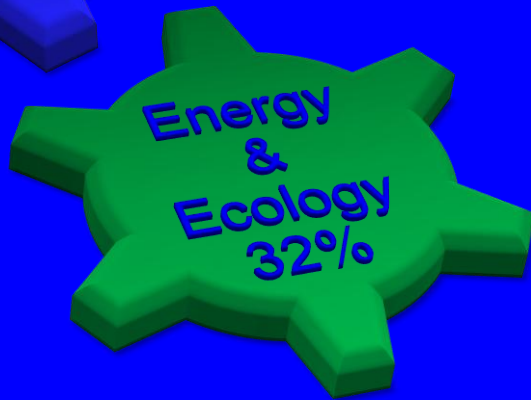


Feira e Congresso Internacionais
de Composites, Poliuretano e
Plásticos de Engenharia

Expo Center Norte • Pavilhão Verde
São Paulo - SP - Brasil



**Yearly Global
Turnover: 200-250 Mil €**



**PU is our Core-
Competence:**

**the highest number of
machines installed in
production**



High and low pressure technologies

- From 1 g/s to 1,000 Kg/min
- More than 13,000 machines sold in production lines
- More than 30,000 mixheads sold in production lines

Canyon

in South America



Cannon do Brasil

Production of very large building sandwich panels

- One shot pouring
- No compartments
- No inside beams
- Up to 20m (66ft) by 4.2m (14ft)
- Roof and wall panels



Solution



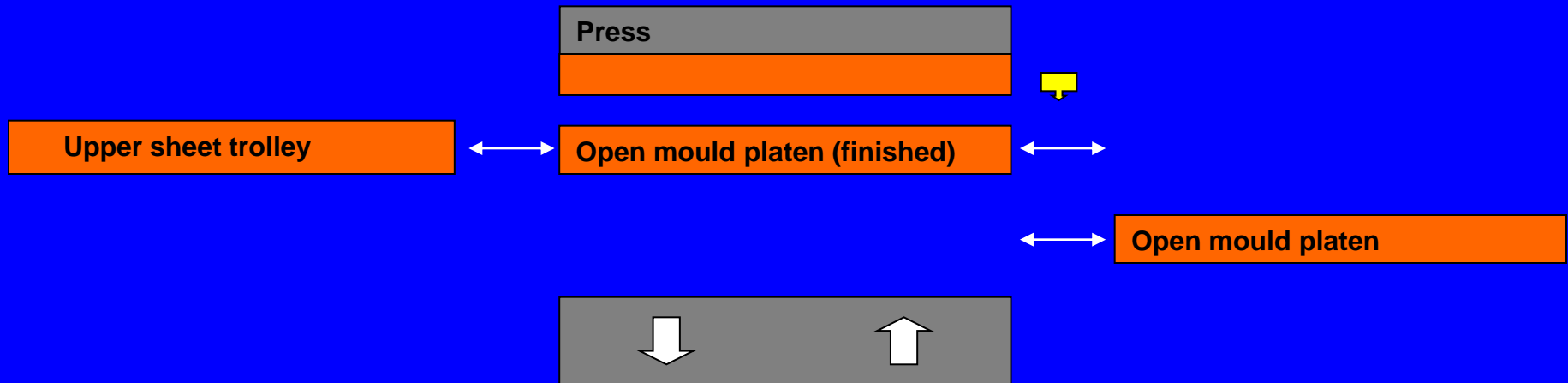
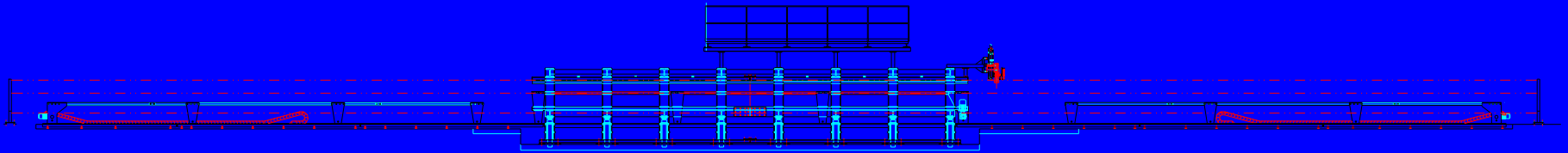
**Open mould
discontinuous system**



**Sandwich panels made by
open mould pouring discontinuous**

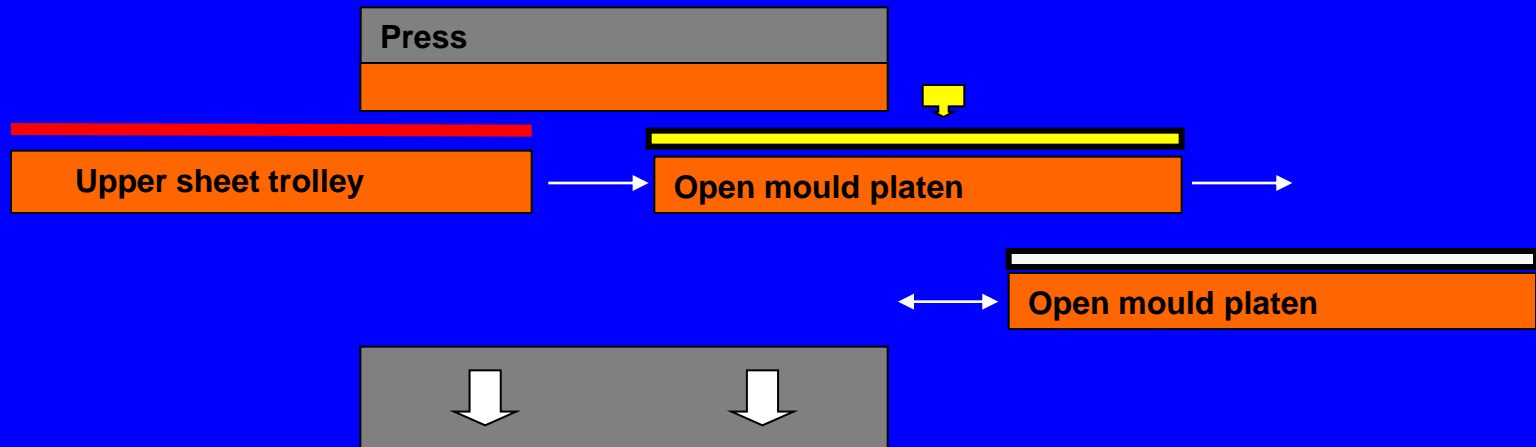


Principle open mould discontinuous



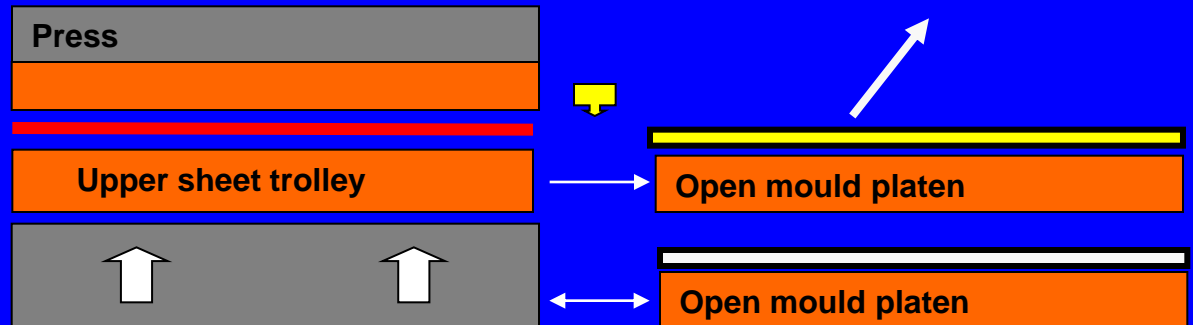
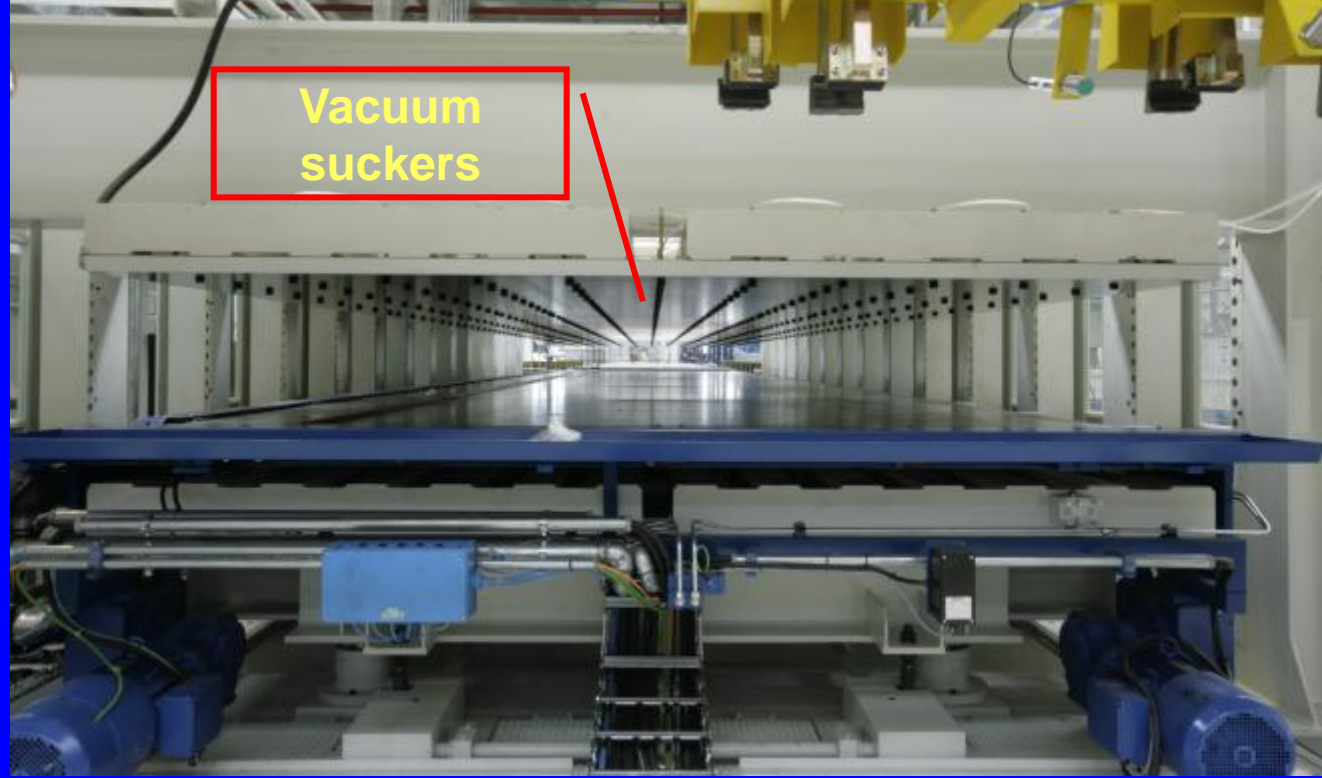
End of curing

End of curing
Press opens
Platen goes out
Upper sheet enters



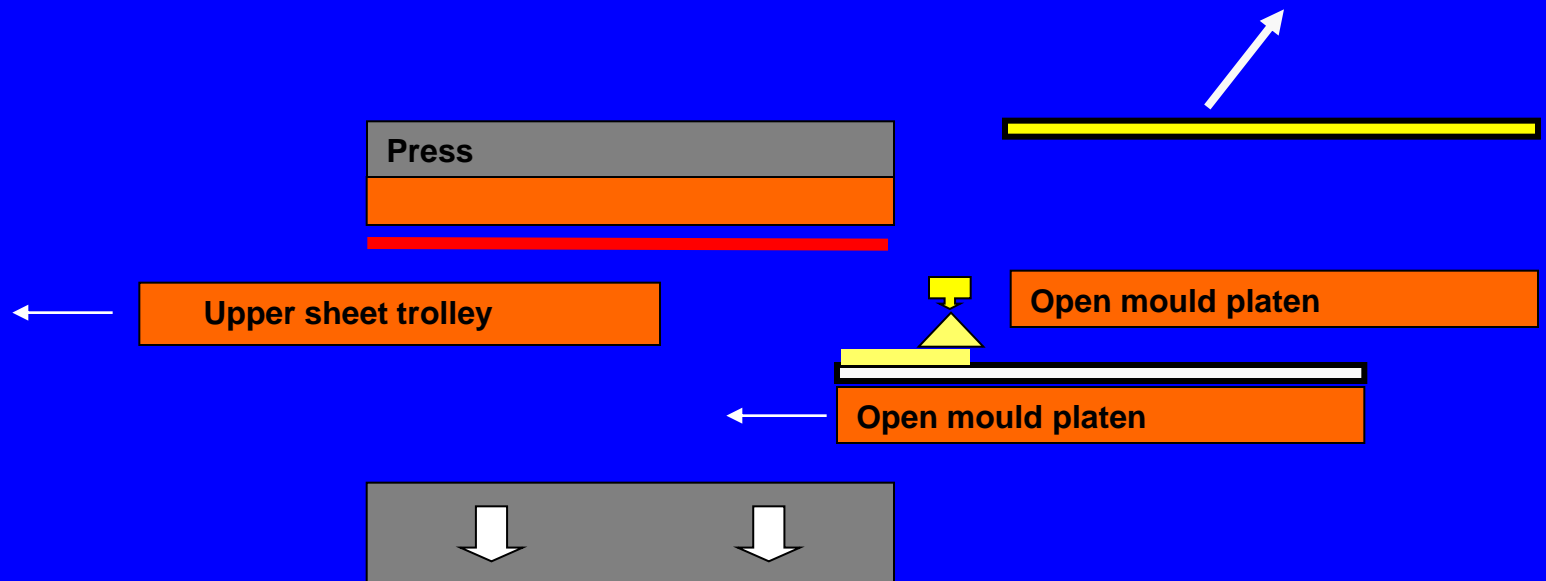
Loading upper sheet

Press closes to fix
upper sheet by
vacuum
Foamed panel is
unloaded



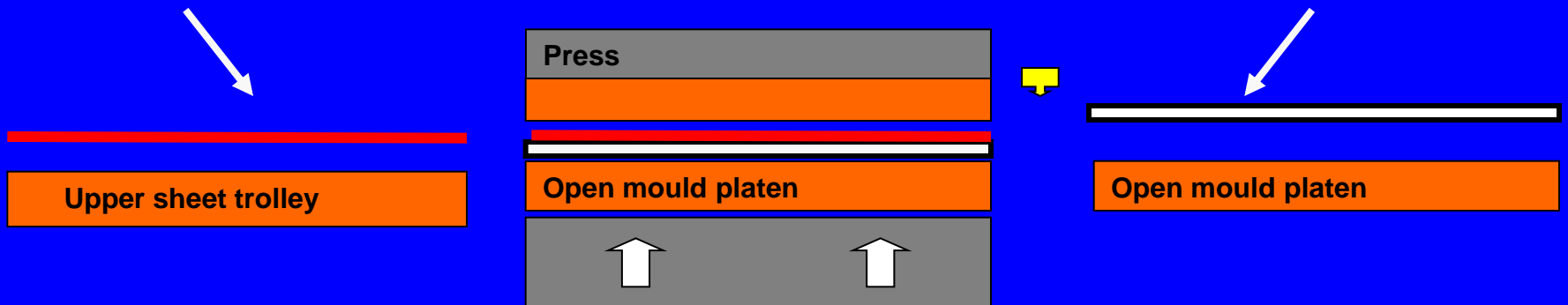
Foaming

- Mixing head lower
- Upper sheet trolley goes out
- Simultaneously panel on lower trolley is foamed while entering

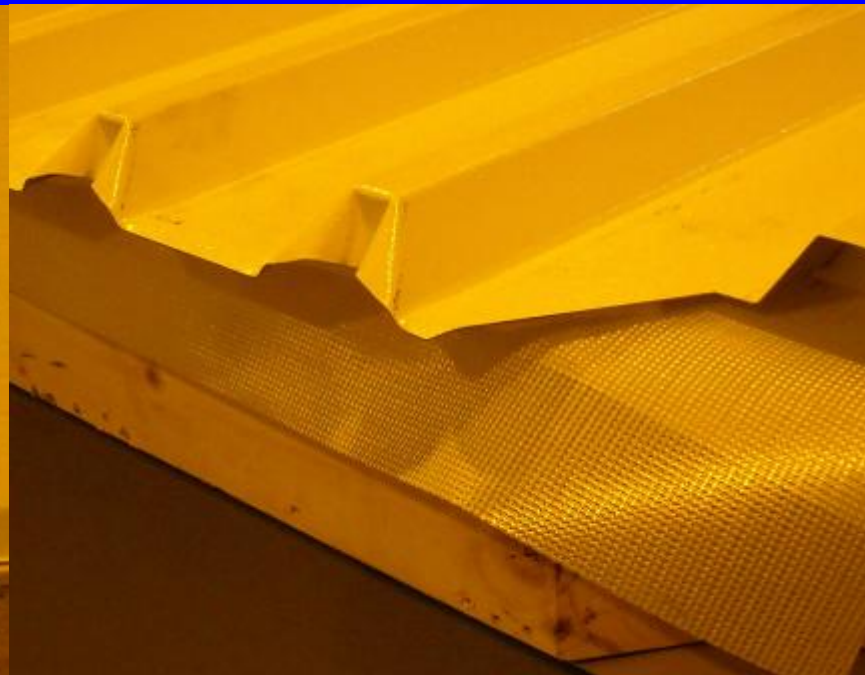
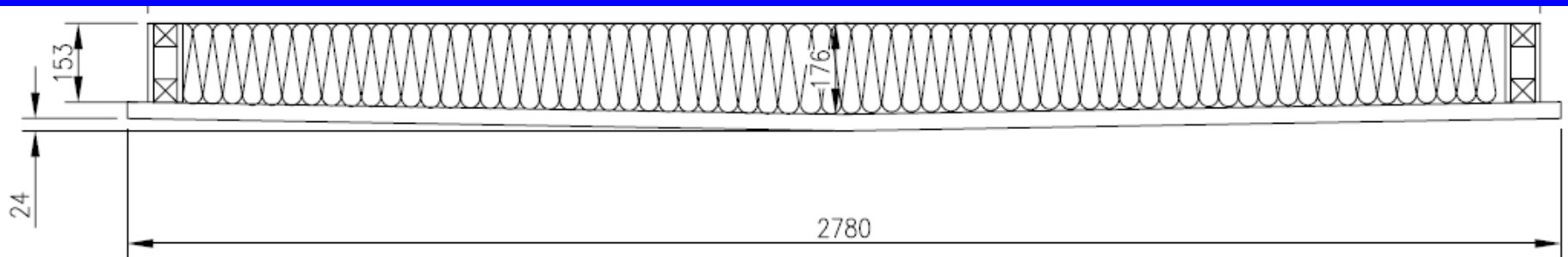
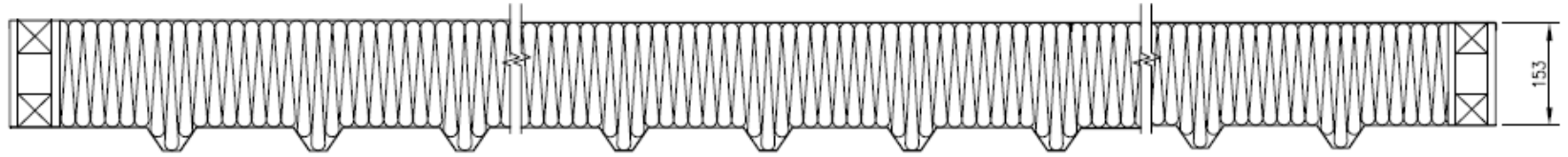


Curing

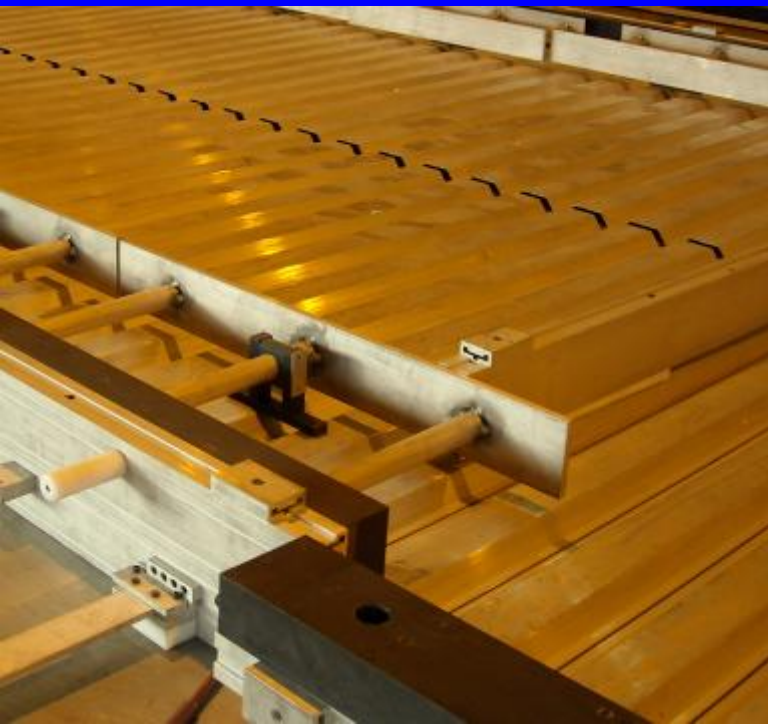
- The press closes and the curing starts
- A new panel is prepared in masked time
- A new upper sheet is loaded



ROOF panels 2 widths 90 different dimensions



ROOF tools

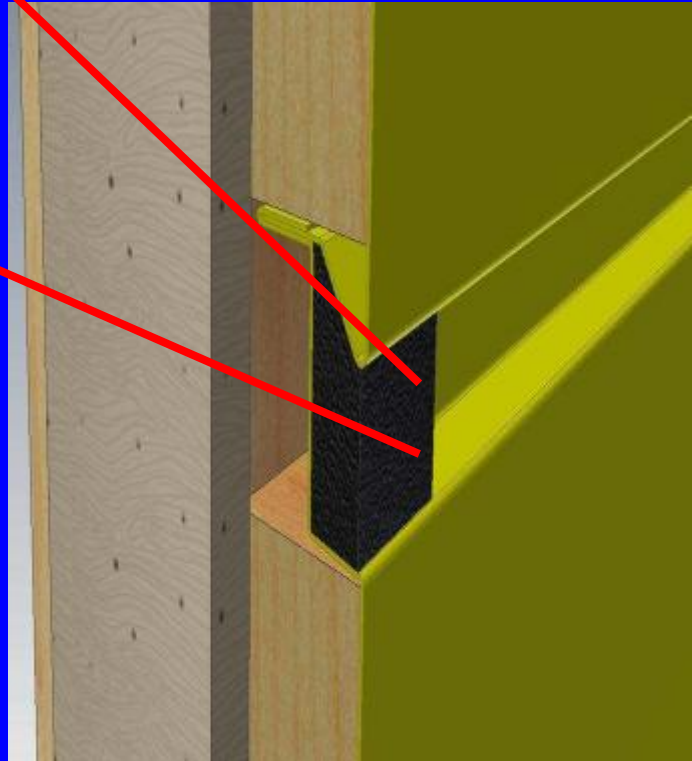
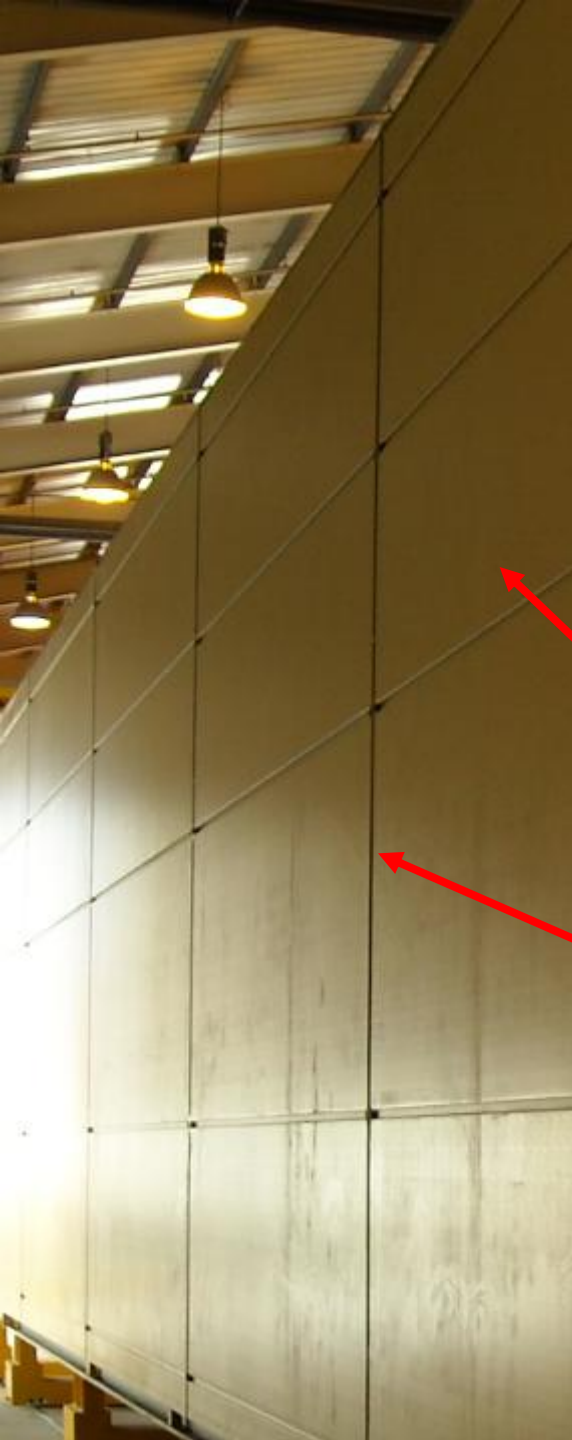


**Change from wall to roof
and sheets loading**

Zero weight handling



**WALL
panels
1000
sizes**





**Roof
platen**

**Roof or
wall platen**

**Wall
platen**

**Press with
platform for
wet end**

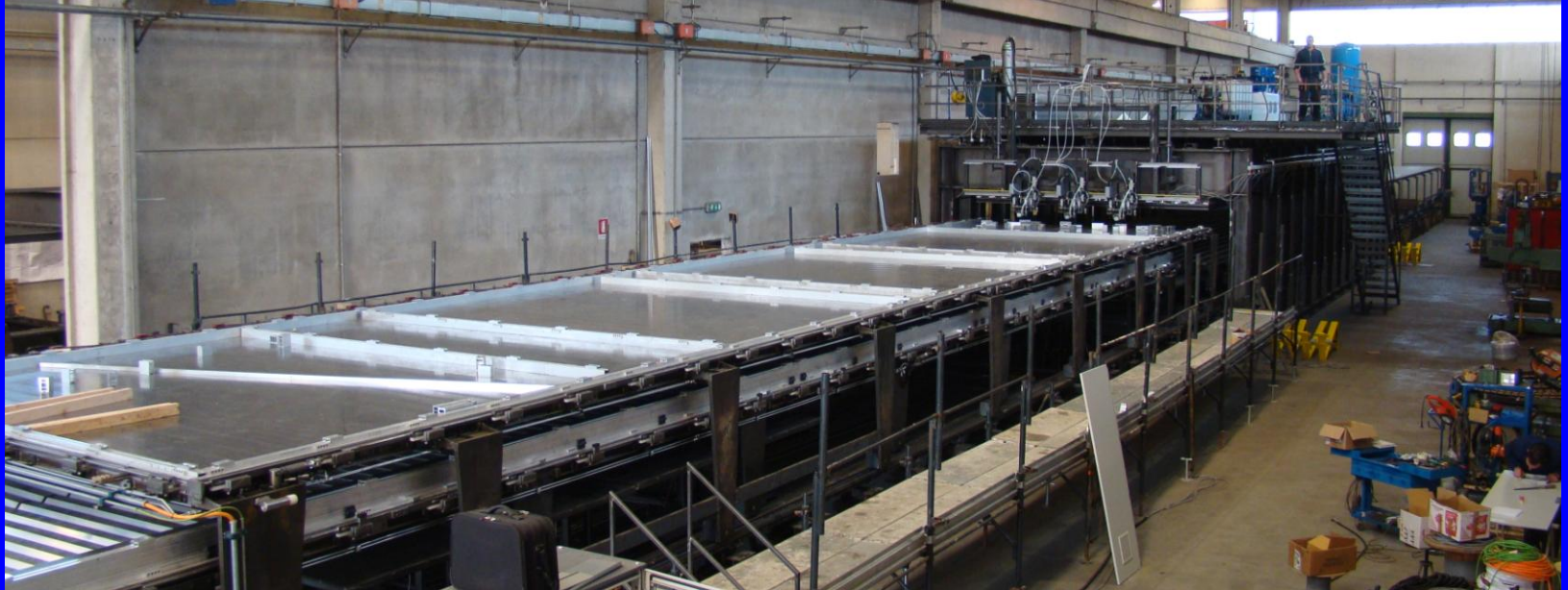
**No weight
handling
trolley**

**Upper
sheet
trolley**



Line about 120m long







Wet end
3 dispensers
total output
over 1000 Kg/min

Data logging

&

Production down loading

NAME		example					
EMPLAT. CYCLE	MACHINE 1	MACHINE 2		MACHINE 3			
REF	IP RECYCLE	IP RECYCLE		IP RECYCLE			
368							
DATA ID							
1		POL	ISO	POL	ISO	POL	ISO
bar		100	100	100	100	100	100
		4.7	4.3	4.7	4.4	4.3	4.4
RATIO	I/P	1.350		1.350		1.350	
		1.349		1.349		1.350	
g/s		4500		4500		4500	
		4502.5		4499.2		4498.5	
g		18966		18966		18966	
		18949.6		18948.3		18969.0	

2 WAITING FOR PRESSING TIME

LC NEXT PRODUCTION DATA

REFERENCE NR. 368 PLATEN USED 4

PERFORED PIPE NO DROP PIPE INSIDE INSIDE WALL / ROOF ROOF

DISP.1 OUTPUT 4500 grams/sec DISP.2 OUTPUT 4500 grams/sec DISP.3 OUTPUT 4500 grams/sec

LOAD NEW CSV FILE

CURING TIME 30 min. SUCKERS VACUUM TIME 120 sec. FILL PIPE SECONDS 0.50 sec. WAIT DROP SECONDS 0.50 sec.

PANEL 1	PANEL 2	PANEL 3	PANEL 4
START FOAM 300 mm	START FOAM 0 mm	START FOAM 0 mm	START FOAM 0 mm
STOP FOAM 600 mm	STOP FOAM 0 mm	STOP FOAM 0 mm	STOP FOAM 0 mm
FOAM SPEED 15.49000000 mt/min	FOAM SPEED 60.00000000 mt/min	FOAM SPEED 60.00000000 mt/min	FOAM SPEED 60.00000000 mt/min
FOAM WEIGHT 56500 grams	FOAM WEIGHT 0 grams	FOAM WEIGHT 0 grams	FOAM WEIGHT 0 grams
POURING TIME 4.20 sec.	POURING TIME 0.00 sec.	POURING TIME 0.00 sec.	POURING TIME 0.00 sec.

Cainoon

Together we can do it!

