



Flatbed laminating line KFK-E 2100

Application:

Manufacturing of sandwich panels for car headliner production.

Material:

PU/PUR foam panels are coated at both sides with glass roving and cover non-woven.

Depending on compound structure, it is possible to laminate at the same time headliner decor material to the visible side.

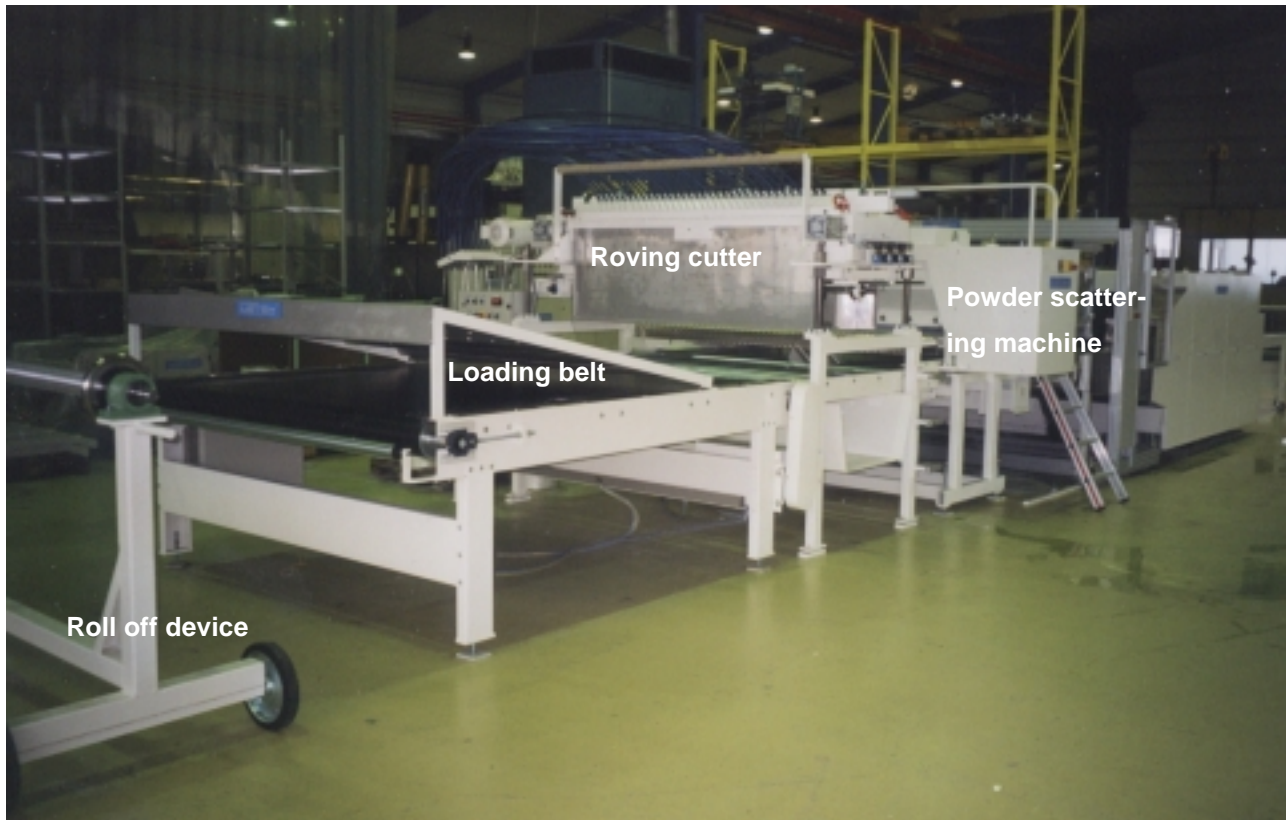
Production:

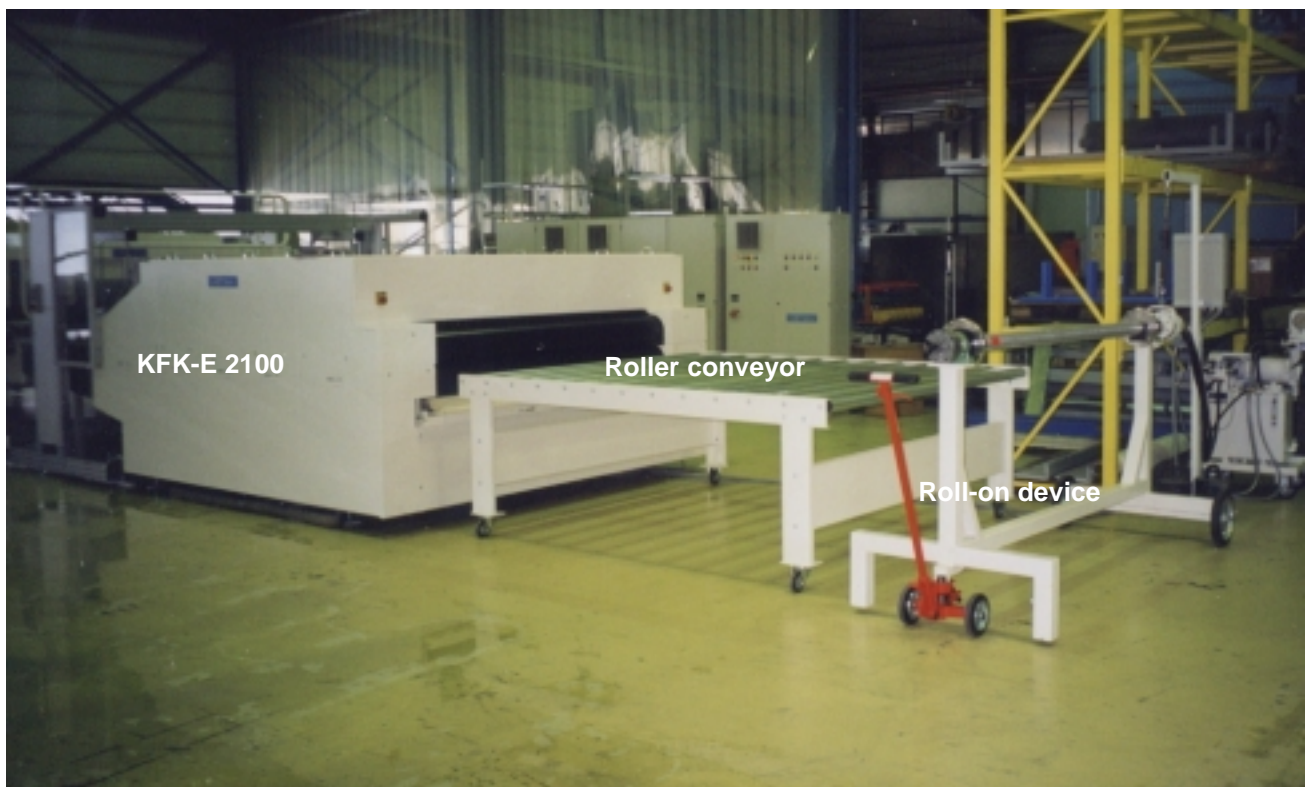
1. Liner production: Non-woven is scattered with glass roving and PE powder – afterwards it is laminated by means of the laminating machine.
2. Car headliner production: The pre-produced liner is rolled-off from the roll-off device at the inlet of line. The PU foam panels are loaded onto the liner by semi-automatic panel positioning system. Then, this compound is scattered with glass roving and PE powder.

Inside the infrared station, the scattered PE powder is heated until it reaches its thermoplastic stage.

The top cover non-woven is fed from the roll-off device located above the top inlet roller of the laminating line. In the succeeding laminating line, the car headliner compound is laminated and can afterwards be cut on the roller conveyor.

Components of the laminating line





Technical data KFK-E 2100

Length	4,700 mm
Width	3,000 mm
Height	1,650 mm
Weight	6 tons
Total connected load:	
Current	158 kW
Air	6 bar
Water runback	4 x 1"
Water flow	4 x 1"
Height adjustment	0 – 150 mm
Level adjustment of top pressure roller	-3 till +7 mm
Speed of conveyor belt	2 – 25 m/min
Working temperature	220 °C
Working width	2,000 mm
Pressure	0 – 18 N/cm ²
Length of heating system	1,350 mm
Heating power	146 kW
Number of heating elements	84
Number of control zones	
in run direction	2
in cross direction	3
total (top + bottom)	12
Cooling length	1,150 mm
Required cooling capacity	102 kW
Number of cooling circuits	
top	6
bottom	4
total (top + bottom)	10
Flow rate	12,000 l/h