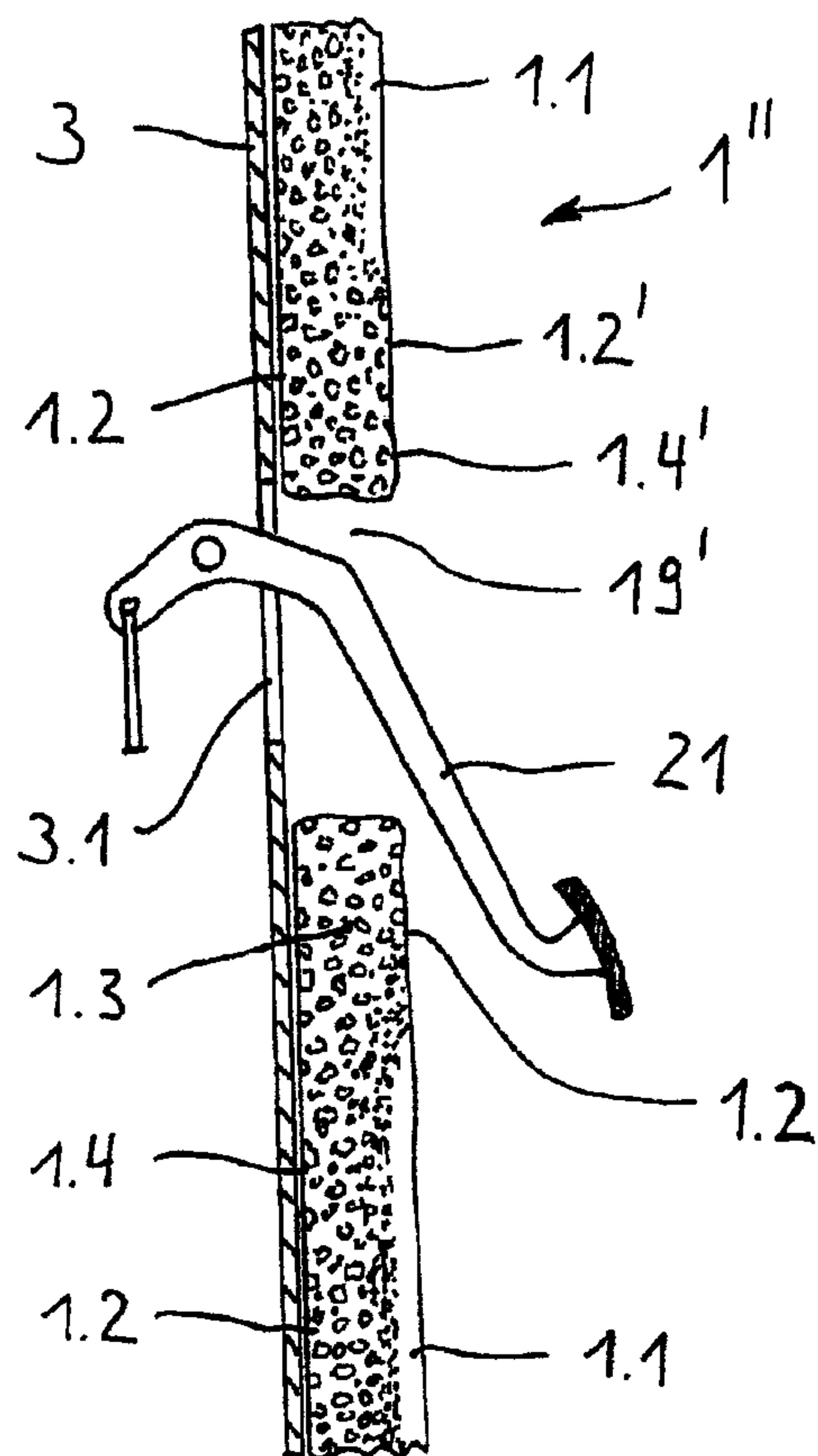




(86) Date de dépôt PCT/PCT Filing Date: 2007/02/26  
(87) Date publication PCT/PCT Publication Date: 2007/08/30  
(85) Entrée phase nationale/National Entry: 2008/08/25  
(86) N° demande PCT/PCT Application No.: EP 2007/051785  
(87) N° publication PCT/PCT Publication No.: 2007/096427  
(30) Priorité/Priority: 2006/02/24 (DE10 2006 009 134.5)

(51) Cl.Int./Int.Cl. *B29C 44/04* (2006.01),  
*B60R 13/08* (2006.01)  
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(54) Titre : PROCEDE AMELIORE POUR LA FABRICATION D'UN REVETEMENT D'ISOLATION PHONIQUE LEGER  
POUR LES VEHICULES AUTOMOBILES ET REVETEMENT CORRESPONDANT  
(54) Title: IMPROVED METHOD FOR PRODUCING A LIGHTWEIGHT, SOUND-INSULATING COVERING FOR MOTOR  
VEHICLES AND CORRESPONDING COVERING



(57) **Abrégé/Abstract:**

The invention relates to a method for producing a lightweight, sound-insulating covering (1'') for a body part of a motor vehicle, in particular a lightweight front wall covering, and to a covering (1'') of this type. The covering (1'') is produced as a foamed, sound-

(57) **Abrégé(suite)/Abstract(continued):**

absorbing moulded part in a single-stage operation by injection of a reaction mixture, which contains polyol and isocyanate, into a cavity of a foaming tool, wherein before and/or during the injection at least one predetermined, cavity-bounding surface region of the foaming tool is temperature-controlled in such a manner that the foamed moulded part has an integral, essentially pore-free skin (1.1) with a thickness of at least 0.5 mm on one side and an open-pore surface (1.2) and/or a thinner, sound-permeable skin (1.4) on its side opposite said skin (1.1).

**ABSTRACT**

A method for producing a lightweight, sound insulating  
5 covering (1, 1', 1'', 1''') for a body component of a motor  
vehicle, in particular a lightweight dashboard covering,  
wherein the covering (1, 1', 1'', 1''') is produced as a foamed,  
sound absorbing molded part in a single-stage operation by  
10 injecting a reactive mix, comprising polyol and isocyanate,  
into a cavity (11) of a foaming tool (9), wherein before  
and/or during the injecting, at least one predetermined  
surface portion (17), defining the cavity (11) of the foaming  
tool (9), is temperature-controlled in such a manner that the  
foamed molded part comprises an integral substantially pore  
15 free skin (1.1) with a thickness of at least 0.5 mm on one  
side, and comprises an open porous surface (1.2) and/or a  
thinner, sound permeable skin (1.4) on its side opposite to  
said skin (1.1).

20 Fig. 4 is designated for the Abstract.

MY/js 051110WO  
14. August 2008

**IMPROVED METHOD FOR PRODUCING A LIGHTWEIGHT SOUND INSULATING  
COVERING FOR MOTOR VEHICLES AND CORRESPONDING COVERING**

5

The invention relates to an improved method for producing a lightweight, sound-insulating covering for a body component of a motor vehicle and to a corresponding covering, in particular configured as a dashboard covering to be disposed in a  
10 passenger compartment.

15

Conventional dashboard coverings for motor vehicles are configured from a sound insulating heavy layer and from a foam layer or a textile fleece layer, wherein the foam layer or the  
15 fleece layer act as an elastic spring, and the heavy layer acts as an acoustic spring-mass-system. The weight per area of such dashboard coverings is typically in the range above 2 kg/m<sup>2</sup>.

20

From DE 27 35 153 A1, a spring-mass-system with low specific weight is known, which is configured as a double mat, which is comprised of soft polyurethane foam with open pores and a of cover layer of filled heavy polyurethane foam, and which is intended in particular as a front wall covering for a motor  
25 vehicle. The heavy polyurethane foam is thus configured as integral foam and comprises a shore-hardness A of 80 to 90, and comprises additional filler content of 400% to 500% by weight. In order to achieve said hardness specification of the cover layer, a polyol mix made of commercial hard foam polyol  
30 and commercial soft foam polyol is used. The cover layer and the polyurethane soft foam layer are connected amongst one another by back-foaming, wherein the cover layer is inserted

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into a mold and back-foamed with the soft polyurethane foam. The production of said double mat is relatively time and cost intensive.

5 It is the object of the present invention to provide a sound insulating and sound absorbing covering, in particular a dashboard covering for motor vehicles, which comprises a low weight and which can be realized at relatively low cost. Simultaneously, a cost effective method for producing such  
10 sound insulating covering shall be provided.

With respect to the manufacturing process, this object is accomplished according to the invention by a method with the features of patent claim 1.

15

The method according to the invention is characterized in that the covering is produced as a foamed sound absorbing molded part in a one step process by injecting a reactive mix comprising polyol and isocyanate into a cavity of a foaming  
20 tool, wherein before and/or after the injection at least one predetermined surface portion of the foaming tool defining the cavity is temperature-controlled in such a manner that the foamed molded component comprises an integral, substantially pore-free skin with a thickness of at least 0.5 mm on one  
25 side, and an open-pore surface and/or a sound permeable skin on its side opposite to said skin.

The foaming tool is e.g. temperature-controlled such that a temperature difference of at least 15°C, preferably of at  
30 least 25°C exists between its surface portions, where the integral and substantially pore free skin can be generated on the one hand, and where the surface with open pores and/or the



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thinner sound permeable skin can be generated, on the other hand.

By means of the method according to the invention, lightweight  
5 sound-insulating coverings can be produced in a one step  
process from only one reactive mix, without changing the upper  
or lower half tool, wherein said coverings insulate and absorb  
sound. The obtained coverings thus produced substantially  
reduce the sound level in the passenger compartment and thus  
10 improve the driving comfort of the motor vehicle equipped  
therewith. On the other hand, they increase the weight of  
motor vehicle only slightly, which is advantageous for a high  
performance, in particular for the acceleration of said motor  
vehicle and for low fuel consumption.

15

Compared to the method known from DE 27 35 153 A1, the number  
of required material components is reduced in the method  
according to the invention. The reduction or minimization of  
the material components used is advantageous with respect to  
20 material storage and material cost, since less storage  
containers and associated equipment are required. When  
purchasing larger quantities of one or a few material  
components, typically a better price can be achieved than when  
purchasing respective volumes, which comprise a larger number  
25 of material components.

The production method according to the invention thus requires  
only relatively low investment, since it does not provide for  
a change of the upper and/or lower half mold of the foaming  
30 tool.

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Furthermore, coverings produced according to the inventive method are characterized by advantageous recycling properties since they are produced from a single reactive mix.

5 A preferred optional embodiment of the method according to the invention is characterized in that filler material, preferably barium sulfate and/or calcium carbonate, is added to the reactive mix formed from polyol and isocyanate before it is injected into the foaming tool. By adding filler material, the material cost of the covering can be substantially reduced. In this context, it is furthermore recommended to combine the filler material (barium sulfate and/or calcium carbonate) with carbon dioxide. Through this combination further cost optimization can be achieved.

15

It can be advantageous to provide the integral, substantially pore-free skin of the foamed molded component with a cover layer on the outside. Through the cover layer, the mechanical strength, the sound insulation effect, the sound absorption capability and/or the appearance of the foamed molded component can be improved. Another embodiment of the method according to the invention thus provides to insert a material web section or a blank of a plastic foil, in particular of a foam material foil, or of a fibrous fleece, in particular of a volume fleece, into the foaming tool, at the at least one surface portion, where the integral, substantially pore-free skin of the foamed molded component can be produced, and to inject it from behind with the reactive mix comprising polyol and isocyanate. This way, the injected molded component can be reliably and cost effectively connected to the cover layer.

- 5 -

With respect to the desired covering, the object mentioned above is accomplished according to the invention by a covering comprising the features of patent claim 11.

5 The covering according to the invention is substantially comprised of a sound absorbing molded part, foamed in a one-step process, made of open-cell soft polyurethane foam, which comprises an integral and substantially pore-free skin with a thickness of at least 0.5 mm on its one side, and which  
10 comprises an open-pore surface and/or thinner sound permeable skin on its side opposite to said skin. The substantially pore free skin has a sound insulating effect, while the remaining portion of the molded part has sound absorbing properties. The position, surface size and/or thickness of the substantially  
15 pore-free skin is dimensioned according to the acoustic properties and requirements. If required, the covering according to the invention can comprise several integral substantially pore-free skin portions, which are offset from one another.

20

Since the covering according to the invention is provided in particular as an inner dashboard covering, it can comprise one or plural openings for the arrangement or pass-through of units, like a pedal assembly, a steering column, cables and/or  
25 fluid conduits, when necessary. With respect to such a pass-through, it is provided according to a preferred embodiment of the covering according to the invention that an end of the pass-through is surrounded at a distance by the integral, substantially pore-free skin of the sound absorbing molded  
30 component, and that between said skin and the opening an open porous surface and/or a thinner sound permeable skin is



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formed. It has been found that an optimized sound absorption can be achieved hereby at the opening.

5 In another preferred embodiment of the covering according to the invention, it is provided that the substantially pore free skin forms a flexible lip seal at the rim of the covering. The flexible lip seal compensates for possible manufacturing tolerances and thus assures an optimum adaptation of the covering to adjacent components or body sections. Hereby, the  
10 sound insulating effect of the covering according to the invention is optimized.

Further preferred and advantageous embodiments of the covering according to the invention and of the method for its  
15 production are indicated in the dependent claims.

Subsequently, the invention is described in more detail with reference to a drawing depicting plural embodiments, schematically showing in:  
20

Fig. 1 a sectional view of the front section of a motor vehicle with a dashboard covering disposed at the inside at the dashboard separating the passenger compartment from the engine compartment;

25 Fig. 2 a sectional view of a dashboard covering enlarged in comparison to Fig. 1;

Fig. 3 a sectional view of a section of a covering  
30 according to the invention according to a second embodiment;

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Fig. 4 another sectional view of a section of a covering according to the invention;

5 Fig. 5 a sectional view of a foaming tool for producing a covering according to the invention;

Fig. 6 a sectional view of another foaming tool for producing a covering according to the invention;

10 Fig. 7 a sectional view of a section of a covering according to the invention according to another embodiment; and

15 Fig. 8 a sectional view of a section of a covering according to the invention according to another embodiment.

The sound insulating covering according to the invention is preferably configured as an inner dashboard covering 1 for a  
20 motor vehicle 2. As a matter of principle, it can, however, also be configured as a sound insulating covering for other body components of a motor vehicle, e.g. as a sub-layer for a vehicle carpet.

25 As illustrated in Figs. 1 and 2, the covering 1 is adapted to the contour of the dashboard 3, which separates the passenger compartment 4 from the engine compartment 5. The covering 1 is self-supporting and is characterized by a relatively low weight. Its total weight per unit area is preferably less than  
30 900 g/m<sup>2</sup>, for example less than 800 g/m<sup>2</sup>. It is produced as a foamed molded component from a reactive soft foam mix, comprising polyol and isocyanate in a one-shot process, this

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means in a single-stage process step by means of a foaming tool.

In order to describe the manufacturing process, reference is made in particular to Fig. 5, in which a multi-component foaming tool 9 is schematically illustrated. Additional equipment elements, like e.g. storage tanks, containers with agitators, pumps, tubular conduits, a mixing head, etc., are not shown for reasons of clarity.

The major components (isocyanate and polyol) of the reactive mix are transferred from storage tanks into processing tanks, brought to the required temperature, and fed through dosage units to a mixing head, associated with a feed opening 10 of the foaming tool 9.

Filler material is preferably added to the reactive mix or to its main components. Optionally, however, the filler material can also be omitted. Barium sulfate and/or chalk are e.g. suitable as filler materials. The filler material ( $\text{BaSO}_4$  and/or chalk) is preferably combined with  $\text{CO}_2$ . Through the addition of  $\text{CO}_2$ , the raw density of the foamed covering can be reduced.

The foaming tool 9 comprises a lower half mold 9.1 and an upper half mold 9.2, which define a cavity 11 in combination and in a closed state of the tool, wherein said cavity corresponds to the molded component to be produced. Injecting the reactive mix into the cavity 11 is performed through a feed- and distribution channel 12, configured in the upper half mold 9.2. The foaming tool 9 is provided with a tempering device, which comprises fluid channels 13, 14, 15, which are separately controllable and by which specific surface portions

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of the foaming tool 9, defining the cavity, can be tempered (cooled) in a controlled manner.

5 Tempering surface portions of the foaming tool in the present context means a relative cooling of the respective surface portions with respect to the warmer soft foam reactive mix.

10 The upper half mold 9.2 comprises a first group of fluid channels 13, which are connected to a common distribution manifold (not shown), which feeds a fluid, and which are connected to a common collector conduit (not shown), which drains the fluid. The temperature of said fluid, provided to said group of fluid channels 13, is regulated, so that the tool surface 16, disposed most proximal to said fluid channels 15 13, comprises a temperature in a range of 50°C to 90°C, e.g. approximately 70° ± 15°C, or a temperature in said range is established there.

20 The fluid channels 14, integrated in the lower half mold 9.1, form a second group of fluid channels, which are connected to a common distributor manifold (not shown) feeding fluid, and which are connected to another collector manifold (not shown), draining said fluid, wherein the temperature of the fluid is controlled such that the tool surface 17 of the lower half 25 mold 9.1, disposed most proximal to the second group of fluid channels 14, comprises a temperature in the range of 15°C to 60°C, e.g. approximately 35°C ± 15°C, or that a temperature in this range is established in said portion.

30 The temperature difference between the tool surfaces 16 and 17 is at least 15°C, preferably at least 25°C.



- 10 -

The foam structure of the one-layer molded component 1 is substantially produced by the propellant gases, produced during the chemical linking of the reactive mix. In the process the CO<sub>2</sub> combined with the filler material supports the  
5 foaming process.

Through the relative cooling of the tool surface 17 of the lower half mold 9.1, relative to the tool surface 16 of the upper half mold 9.2, the foaming process in the reactive mix  
10 is suppressed in a portion adjacent to the colder tool surface, so that an integral, substantially pore-free skin 1.1 with a thickness of at least 0.5 mm, preferably at least 0.8 mm, particularly preferably at least 1 mm, is produced there. The skin 1.1 acts as a sound insulating insulation  
15 layer. It is preferably airtight or at least substantially airtight.

At the warmer tool surface 16 of the upper half mold 9.2, however, a sound absorber with open pores is formed by the  
20 foaming process, wherein the sound absorber has an open porous surface 1.2, or only a very thin skin 1.4, wherein said skin, however, is sound permeable or sound transparent.

The sound permeable skin 1.4 has a thickness of less than  
25 400 µm, preferably less than 250 µm. For example, it is thinner than 150 µm, and can also be only partially formed.

The one-piece covering 1 can optionally comprise a flexible seal lip 8 at the rim, which can compensate for possible  
30 manufacturing tolerances, and thus assures a tight adaptation of the covering 1 to the adjacent components or car body sections (re. Figs. 2 and 3).



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In order to configure the lip seal 8 substantially without pores, fluid channels 15 are provided in the upper half tool 9.2 close to the cavity section corresponding to the lip seal 8, which are also connected to the fluid manifold (not shown), associated with the second group of fluid channels 14. The fluid flowing through the fluid channels 14 and 15 thus has the same temperature.

10 In the lower half mold 9.1, furthermore pushrods 18 are integrated, by means of which the completed molded part, thus the covering 1, can be ejected from the foaming tool 9 after opening. Such ejection elements 18 can also be integrated in the upper half mold 9.2, or only in the upper half mold 9.2.

15

The open porous sound absorbing portion 1.3 of the one layer soft foam covering 1 comprises a raw density in the range of 0.02 to 0.06 g/cm<sup>3</sup>. The raw density of the substantially pore free non-air permeable skin 1.1, on the other hand, is in the range of 0.08 to 2.0 g/cm<sup>3</sup>, preferably in the range of 0.08 to 1.4 g/cm<sup>3</sup>, in particular in the range of 0.1 to 1.1 g/cm<sup>3</sup>.

20

In many sound insulating coverings for body components, openings have to be provided, e.g. for passing cables, hoses or mechanical units through. As illustrated in Fig. 3, at an opening 19 for a cable or for a hose conduit, preferably an elastically expandable grommet 20, for sealed pass-through of the cable or of the hose conduit (not shown) is formed on the side of the one layer covering 1', which comprises the skin, thus on the side, comprising the integral, substantially pore free skin 1.1.

30

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In Fig. 4, a section of a dashboard 3 of a motor vehicle is shown in a schematic sectional view, wherein said dashboard comprises an opening 3.1 with a pedal assembly 21, reaching through said dashboard. At the inside of the dashboard 3, a covering 1" according to the invention is disposed, which comprises a pass-through 19' for the pedal assembly 21. The one layer dashboard covering 1" comprises the substantially pore-free skin 1.1 on its side, facing the passenger compartment. The skin 1.1 acting as an insulation layer surrounds the opening 19' at a distance. Between the air permeable skin 1.1 and the pass-through 19', a surface portion 1.2' with open pores is configured, which optimizes the sound absorbing effect of the covering 1" in the portion of the opening 19'. The open porous surface portion 1.2 surrounds the opening 19', e.g. in an annular manner.

As illustrated in Fig. 5, the foaming tool 9 can comprise at least one protrusion 22, disposed in the cavity 11, which generates an opening 19' in the respective molded component when injecting the reactive mix. It is furthermore illustrated in Fig. 5 that the fluid channels 14 in the lower half mold 9.1 are offset relatively far from the protrusion 22. The surface portion 17 of the foaming tool 9, at which the integral, substantially pore free skin 1.1 of the molded component can be created, surrounds the protrusion 22 accordingly at a certain distance. This way, as illustrated in Fig. 4, an open porous annular portion 1.2' remains about the opening 19' on the side of the covering 1", which comprises a substantially pore free skin.

30

Fig. 6 schematically illustrates another foaming tool 9' for producing a covering according to the invention. Different

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from the foaming tool according to Fig. 5, in this case, the soft foam reactive mix is injected or introduced into an open cavity of a foaming tool 9', comprised of a lower half mold 9.1' and an upper half mold 9.2'. Introducing the soft foam reactive mix is performed by means of an injection conduit 24, which is preferably operated by a robot (not shown). After introducing the soft foam reactive mix, the foaming tool 9' is closed for molding the sound insulating covering.

10 Fig. 7 illustrates another embodiment of a covering 1''' according to the invention. Different from the embodiment illustrated in Fig. 3, the integral substantially pore-free skin 1.1 is provided on the outside on the entire surface or only on a partial surface, and that in selected portions, with  
15 a cover layer 23. The cover layer 23 is effective acoustically. It can be comprised of a thin cover fleece material (fibrous fleece material), which provides a more esthetic appearance and/or a higher mechanical strength, in particular tear strength, to the covering 1'''. The cover  
20 fleece 23 e.g. comprises a weight per area in the range of 20 g/m<sup>2</sup> to 250 g/m<sup>2</sup>.

Alternatively, the cover layer 23 can be comprised of a sound absorbent volume fleece, which comprises a weight per area in  
25 the range of 200 to 700 g/m<sup>2</sup>, in particular 200 to 500 g/m<sup>2</sup>, and a layer thickness in the range of 5 mm to 20 mm, in particular 5 mm to 10 mm.

The cover fleece or volume fleece is formed e.g. from  
30 polyester fibers, cotton or other natural or synthetic fibers.

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Furthermore, the cover layer 23 can also be comprised of a plastic foil, in particular a foam material foil. The cover layer 23 can thus function in particular as a barrier layer.

- 5 In the embodiment illustrated in Fig. 8, the integral, substantially pore-free skin 1.1 of the foamed molded part is also provided with a cover layer 23.

10 The integral skin 1.1 is bonded to the cover layer 23. The bonded connection is established by inserting a material web section or a blank from a foil or from a fleece into a foaming tool according to Figs. 5 or 6, and that to the surface portion 17 of the foaming tool, at which the integral, substantially pore free skin 1.1 of the foamed molded part can  
15 be created. Thereafter, the foil or the fiber fleece is injected from behind with the reactive mix, including polyol and isocyanate, wherein the foaming tool 9, 9' is brought to different temperatures in different portions as described above.

20

Practicing the invention is not limited to the exemplary embodiments described above. Rather, various variations are conceivable, which use the inventive idea, defined in the patent claims in different embodiments. Thus, the covering 1,  
25 1', 1" or 1''' according to the invention can also comprise plural partial sound insulation portions, this means plural integral, offset, substantially pore free, non air permeable skin portions 1.1, which are disposed on the covering 1, 1', 1" or 1''' according to the acoustic sound insulation  
30 requirements in an selected manner.



- 15 -

It shall be understood, that performing the method according to the invention is not limited to the described relative cooling of the lower half mold 9.1 relative to the upper half mold 9.2. Thus, it is included in the scope of the invention  
5 to cool the tool surface of the upper half mold, relative to the tool surface of the lower half mold, or to bring it to a respective temperature, in order to form an integral substantially pore free skin at the tool surface of the upper half mold. When required, the reactive mix can be injected  
10 into the tool cavity through a feed channel configured in the lower half mold.



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**PATENT CLAIMS**

1. A method for producing a lightweight, sound insulating  
5 covering (1, 1', 1'', 1''') for a body component of a motor  
vehicle, in particular a lightweight dashboard covering,  
wherein the covering (1, 1', 1'', 1''') is produced as a  
foamed, sound absorbing molded part in a single-stage  
10 operation by injecting a reactive mix, comprising polyol  
and isocyanate, into a cavity (11) of a foaming tool (9),  
wherein before and/or during the injecting, at least one  
predetermined surface portion (17), defining the cavity  
(11) of the foaming tool (9), is temperature-controlled  
15 in such a manner that the foamed molded part comprises an  
integral substantially pore free skin (1.1) with a  
thickness of at least 0.5 mm on one side, and comprises  
an open porous surface (1.2) and/or a thinner, sound  
permeable skin (1.4) on its side opposite to said skin  
(1.1).
- 20
2. A method according to claim 1, wherein the at least one  
surface portion (17) of the foaming tool (9), where the  
integral, substantially pore free skin (1.1) of the  
foamed molded part can be produced, is cooled to a  
25 temperature in the range of 15°C to 60°C.
3. A method according to claim 1 or 2, wherein the surface  
portion (16) of the foaming tool (9), at which the open  
porous surface (1.2) and/or the thinner sound permeable  
30 skin (1.4) can be produced, is temperature-controlled to  
a temperature in the range of 50°C to 90°C.

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4. A method according to one of the claims 1 through 3,  
wherein the foaming tool (9) is temperature-controlled in  
such a manner that between its surface portion (17), at  
which the integral, substantially pore free skin (1.1) of  
the foamed molded part can be produced, and its surface  
portion (16), at which the open porous surface (1.2)  
and/or the thinner sound permeable skin (1.4) can be  
produced, a temperature difference of at least 15°C,  
preferably 25°C, exists.
5. A method according to one of the claims 1 through 4,  
wherein filler material is added to the reactive mix  
formed from polyol and isocyanate before injecting it  
into the foaming tool.
6. A method according to claim 5, wherein barium sulfate  
and/or calcium carbonate are added to the reactive mix as  
filler material.
7. A method according to claim 5 or 6, wherein carbon  
dioxide is added to the filler material.
8. A method according to one of the claims 1 through 7,  
wherein as a foaming tool (9) a foaming tool is used  
which comprises at least one protrusion (22) disposed in  
the cavity, wherein said protrusion defines an opening  
(19') in the molded part produced when the reactive mix  
is injected, wherein the at least one surface portion  
(17) of the foaming tool, at which the integral,  
substantially pore free skin (1.1) of the molded part can  
be produced, surrounds the protrusion (22) at a distance.

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9. A method according to one of the claims 1 through 8,  
wherein as a foaming tool (9) a foaming tool is used  
which comprises several cooled surface portions, offset  
from one another, so that the foamed molded part is  
5 produced with several integral skin portions, offset from  
one another, which are substantially pore free.
10. A method according to one of the claims 1 though 9,  
wherein a material web section or a plastic foil blank,  
10 in particular a foam foil blank or a fibrous fleece  
blank, in particular a volume fleece blank, is inserted  
into the foaming tool (9) at the at least one surface  
portion (17) at which the integral, substantially pore  
free skin (1.1) of the foamed molded component can be  
15 produced, and injected from behind with the reactive mix,  
comprising polyol and isocyanate.
11. A lightweight, sound insulating covering (1, 1', 1'',  
1''') for a body component of a motor vehicle, in  
20 particular provided in the form of a lightweight  
dashboard covering, substantially comprised of a sound  
absorbing molded part, foamed in a one-step process, made  
of a soft open cell polyurethane foam, which comprises an  
integral, substantially pore free skin (1.1) with a  
25 thickness of at least 0.5 mm on one side, and which  
comprises an open porous surface (1.2) and/or a thinner  
sound permeable skin (1.4) on its side opposite to said  
skin (1.1).
- 30 12. A covering according to claim 11, comprising at least one  
opening (19'), wherein an end of the opening (19') is  
surrounded at a distance by the integral, substantially

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pore free skin (1.1), and an open porous surface (1.2') and/or a thinner sound permeable skin (1.4') is configured between said skin (1.1) and the opening (19').

- 5 13. A covering according to claim 11 or 12, comprising plural integral skin portions offset from one another and substantially pore free.
- 10 14. A covering according to one of the claims 11 through 13, wherein the integral, substantially pore free skin (1.1) has a thickness of at least 1 mm.
- 15 15. A covering according to one of the claims 11 through 14, whose total mass per unit area is less than  $900 \text{ g/m}^2$ .
- 20 16. A covering according to one of the claims 11 through 15, wherein its open porous sound absorbing portion (1.3) comprises a raw density in the range of 0.02 to  $0.06 \text{ g/cm}^3$ .
- 25 17. A covering according to one of the claims 11 through 16, wherein its integral substantially pore free skin (1.1) comprises a raw density in the range of 0.08 to  $2.0 \text{ g/cm}^3$ , preferably in the range 0.08 to  $1.4 \text{ g/cm}^3$ .
- 30 18. A covering according to one of the claims 11 through 17, whose sound permeable skin (1.4) comprises a thickness of less than  $400 \text{ }\mu\text{m}$ , preferably less than  $250 \text{ }\mu\text{m}$ .
19. A covering according to one of the claims 11 through 18, which is configured in one piece.

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20. A covering according to one of the claims 11 through 18, whose integral, substantially pore free skin (1.1) is provided partially or on its entire surface with a cover layer (23), comprised of a plastic foil, in particular foam material foil, or a fibrous fleece material, in particular a volume fleece material, wherein the integral skin (1.1) is bonded to the cover layer (23) through injecting from behind.
- 10 21. A covering according to claim 20, wherein the fibrous fleece material has a weight per unit area of 20 to 150 g/m<sup>2</sup>.
- 15 22. A covering according to claim 20, wherein the volume fleece has a weight per unit area of 200 to 700 g/m<sup>2</sup> and/or a thickness of 5 to 20 mm.



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FIG. 1

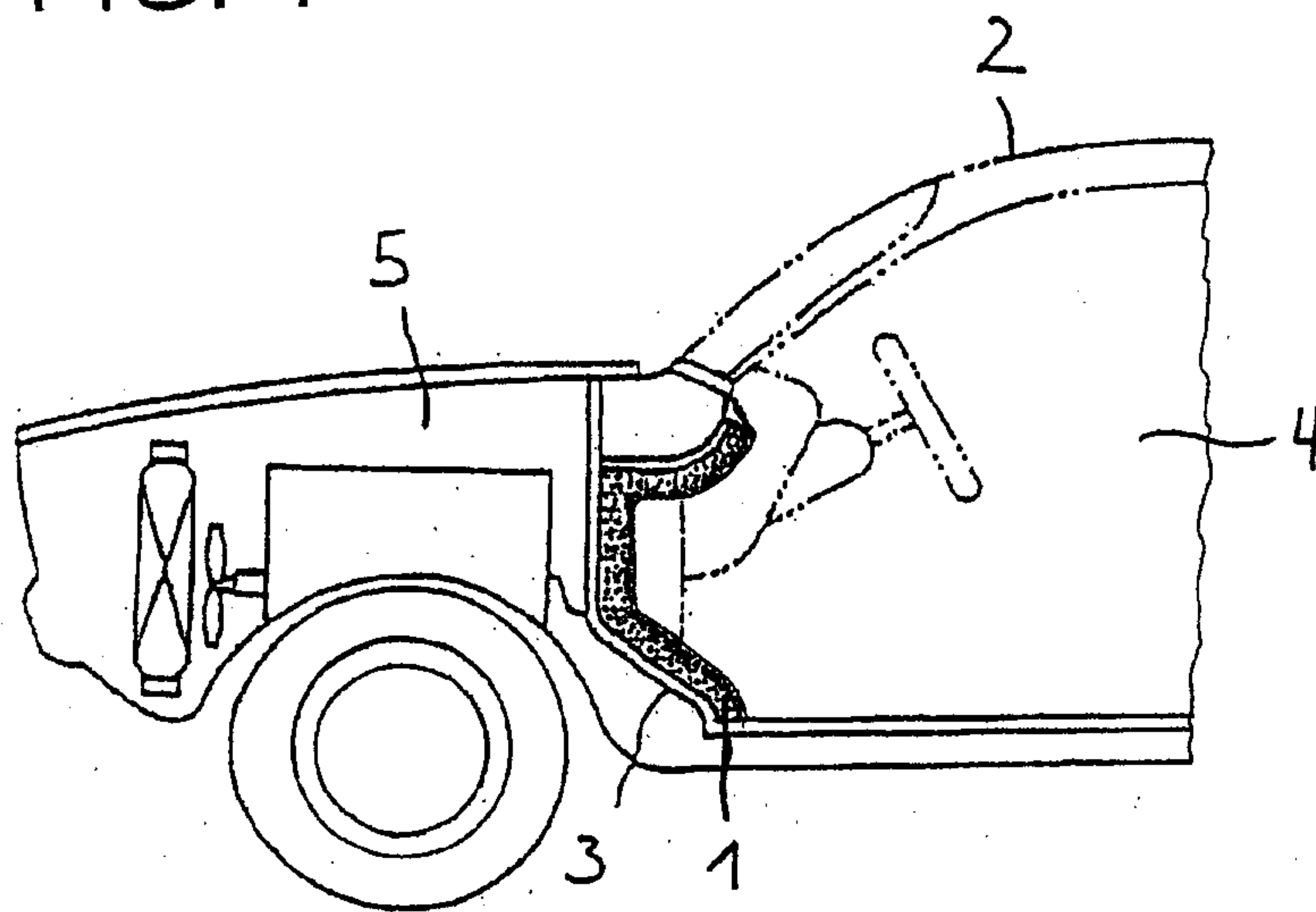
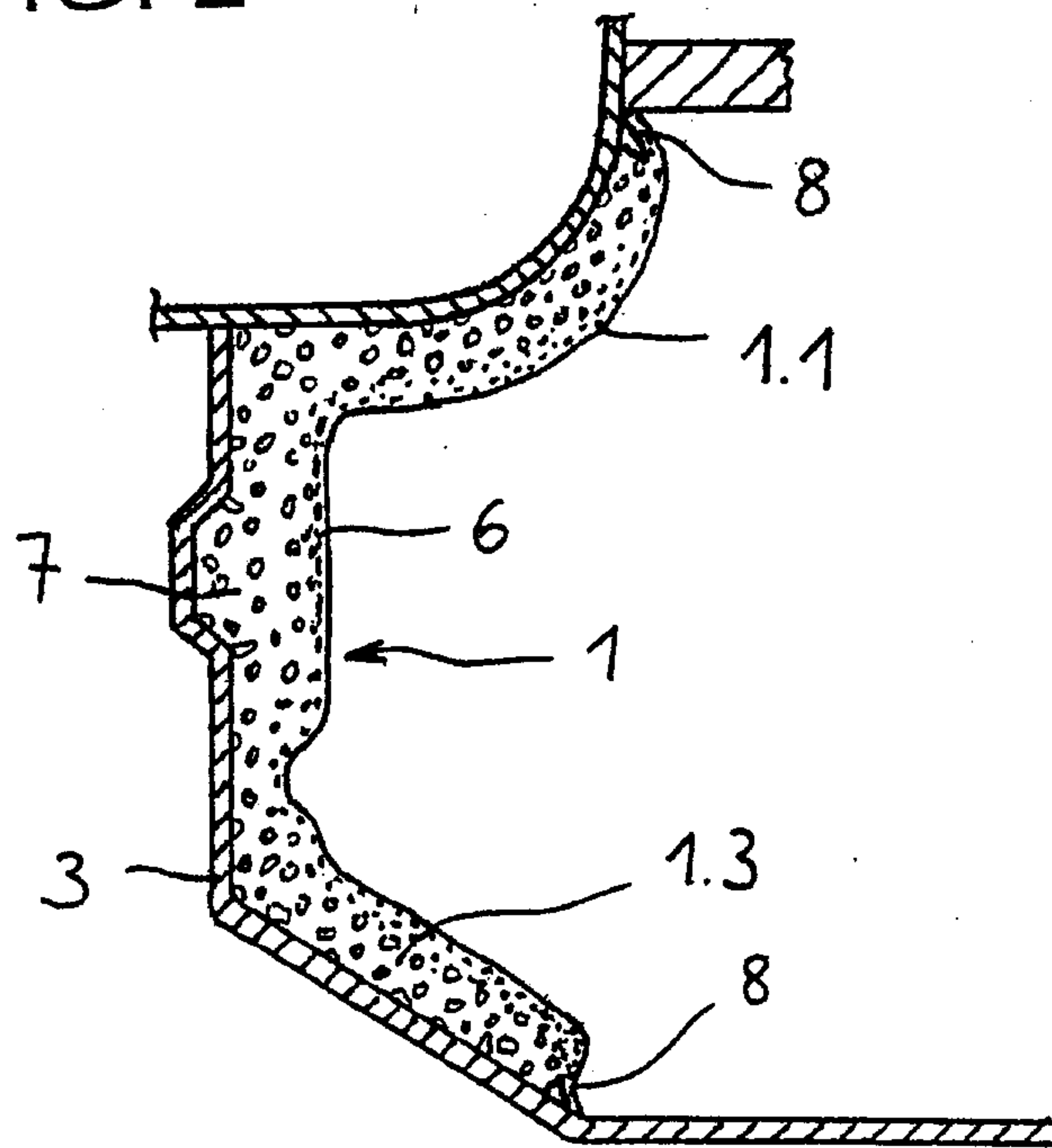


FIG. 2



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FIG. 3

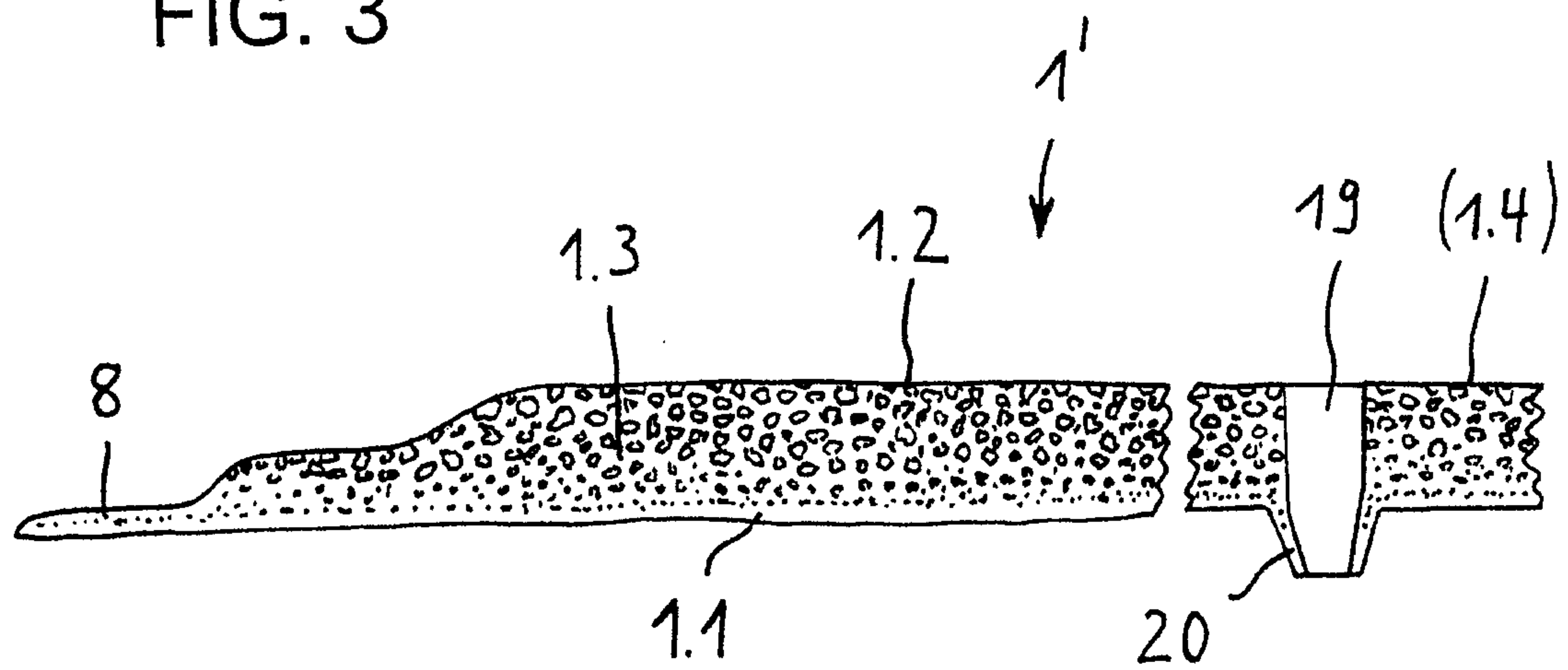
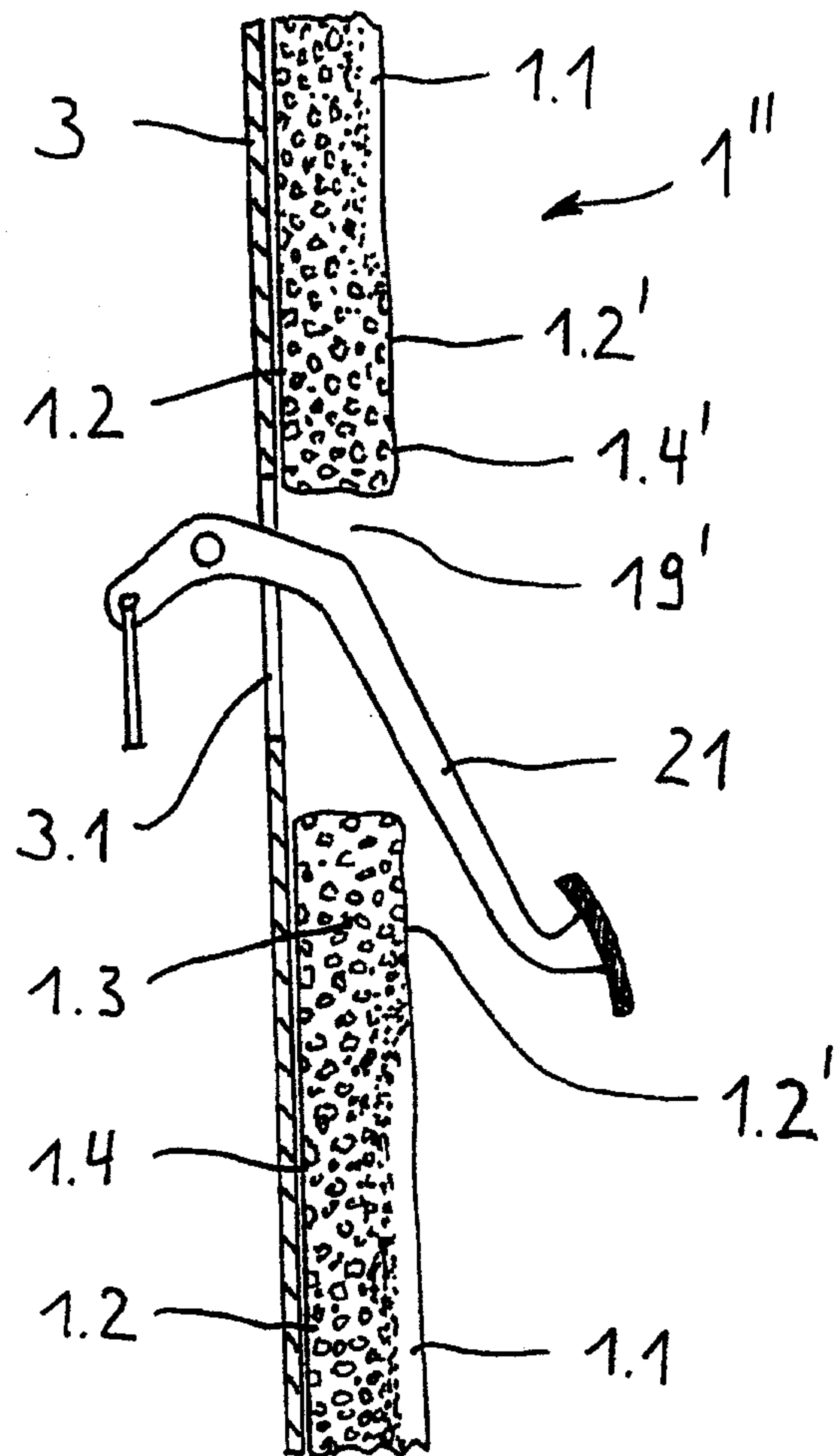


FIG. 4



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FIG. 5

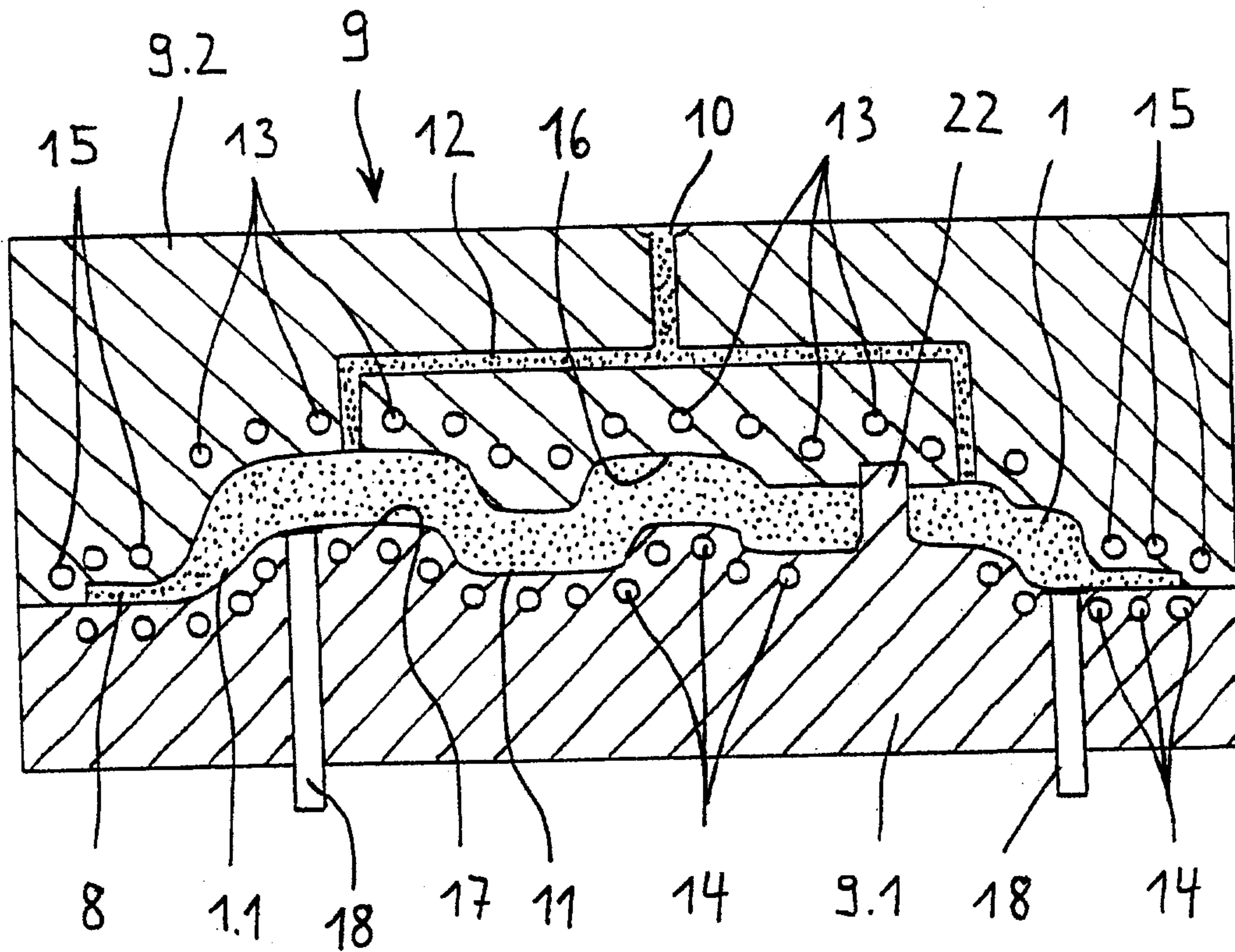


FIG. 6

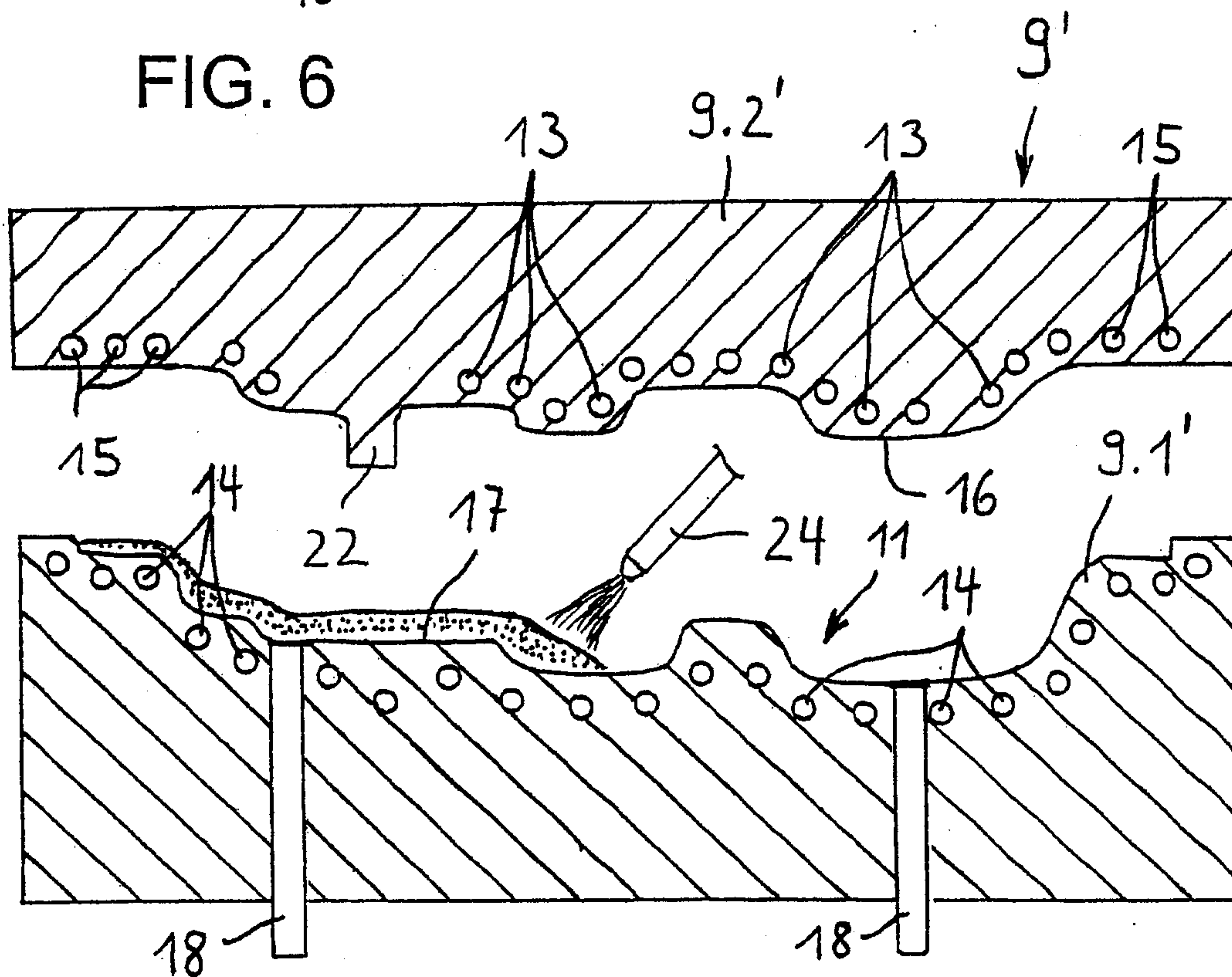


FIG. 7

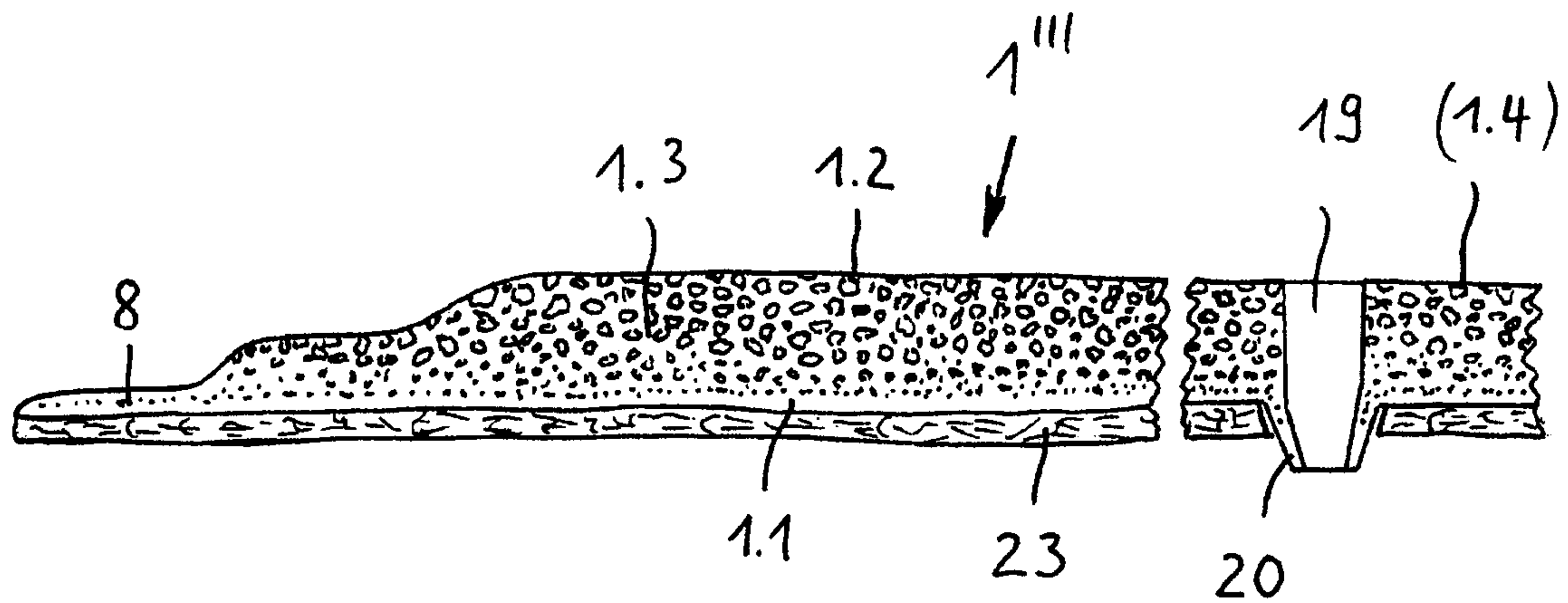


FIG. 8

