

(19)



Europäisches Patentamt

European Patent Office

Office européen des brevets



(11)

EP 0 860 252 B1

(12)

EUROPEAN PATENT SPECIFICATION

(45) Date of publication and mention
of the grant of the patent:
13.11.2002 Bulletin 2002/46

(51) Int Cl.7: **B27G 11/00, B05D 1/34**

(21) Application number: **98200265.1**

(22) Date of filing: **11.02.1998**

(54) **A method for supplying a fluid**

Verfahren zur Abgabe einer Flüssigkeit

Procédé pour délivrer un fluide

(84) Designated Contracting States:
**AT BE CH DE DK ES FI FR GB GR IE IT LI LU MC
NL PT SE**
Designated Extension States:
AL LT LV RO SI

(30) Priority: **21.02.1997 EP 97850029**

(43) Date of publication of application:
26.08.1998 Bulletin 1998/35

(73) Proprietors:
• **AKZO NOBEL N.V.**
6800 SB Arnhem (NL)
• **Casco Products AB**
100 61 Stockholm (SE)
Designated Contracting States:
FI SE

(72) Inventors:
• **Vesterlund, Lennart**
129 36 Hägersten (SE)
• **Andersson, Sven-Erik**
131-34 Nacka (SE)

(74) Representative: **Jönsson, Christer et al**
Eka Chemicals AB,
Patent Department,
Box 11556
100 61 Stockholm (SE)

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Description

[0001] The present invention relates to a device for supplying a multicomponent fluid thermosetting resin gluing system. Furthermore, it also relates to use of the device particularly for production of laminated wood or glue laminated timber.

[0002] Production of laminated wood and glue-laminated timber usually involves agglutination of (i.e. gluing together) two or more wooden members surfaces by means of a multicomponent thermosetting resin gluing system, such as gluing systems based on urea-formaldehyde resins, melamine-formaldehyde resins, phenol-formaldehyde resins, phenol-resorcinol-formaldehyde resins, isocyanate resins, polyurethane resins, polyvinyl acetate resins, etc. Such gluing systems are based on at least two components, a resin component and a hardener component. A device used for such a system is known for example from WO 88/00 498. In the exemplified gluing systems the hardener component is based on formaldehyde, organic isocyanates, or acids like formic acid, i.e. substances known to evaporate into gaseous emissions giving rise to unpleasant odours or even respiratory irritation. This emission problem is particularly evident when the gluing system or its components are applied by means of some curtain coating technique, at which the evaporating substance falls freely through the ambient air down to one of the surfaces to be agglutinated. The problem is particularly outspoken when the evaporating component is applied separate from the other components, as in that case neither the evaporating component nor the emitted vapours may react with any other gluing system component. On the other hand, if the hardener is mixed with the resin component prior to application, the pot life of the gluing system as applied is considerably reduced. Such pre-mixing usually also entails palpable problems regarding cleaning the application equipment, as cured resin may clog the nozzles of the apparatus. This latter problem may of course also reside with resin-hardener system that does not involve any component causing emission problems.

[0003] Various solutions have been proposed to the above problems. In the case of pre-mixing, cooling of the mixture has been utilised in order to decrease the reaction rate as well as the vapour pressure of the evaporating substance. This is apparently a technologically complicated solution. In other cases the proposed solutions relate to lowering the content of the evaporating component in the gluing system, or providing additives that may absorb any excess of the evaporating component. Drawbacks of these solutions are that they imply that part of the evaporating component is withdrawn from the intended glue-curing reaction, which in turn means longer curing times or inferior adhesion properties of the cured resin, or both.

[0004] The above problems are overcome by the present invention as defined by appended claim 1. More specifically the present invention relates to a device for supplying a multicomponent fluid thermosetting resin gluing system, which comprises a first hollow body provided with outlet conduits, a second hollow body having at least as many outlet apertures as there are outlet conduits of the first hollow body, whereby each conduit is introduced into one aperture, there being an interspace between the conduit and the edges of the aperture.

[0005] One embodiment (not shown in the drawings) of the present device furthermore comprises an intermediate hollow body having at least one outlet conduit, whereby substantially all of the conduits of the first hollow body are introduced into one of the conduits in the intermediate hollow body and each conduit of the intermediate hollow body is introduced in the same aperture in the second hollow body as the first hollow body conduit is introduced into itself, and there being an interspace between the conduits of the intermediate and the first hollow body and an interspace between the conduit of the intermediate hollow body and the edges of said aperture. The device may be equipped with additional intermediate hollow bodies arranged in a way corresponding to said intermediate body, the upper number being limited by requirement/demand and economy only.

[0006] The first hollow body is preferably provided with an inlet duct, and the outlet conduit has suitably an outlet nozzle. The second hollow body is preferably provided with an inlet duct and comprises suitably a shell having interior and exterior surfaces enveloping the first hollow body. Said nozzle is preferably flushed with the interior or the exterior surface of the second hollow body shell or extends beyond said exterior surface, each conduit being introduced into different apertures. The intermediate hollow body, if any, is preferably provided with an inlet duct and the outlet conduit has suitably an outlet nozzle. The intermediate hollow body may envelope the first hollow body and may itself be enveloped by the second hollow body.

[0007] The shape of the first hollow body, the intermediate hollow body, and the second hollow body is preferably substantially tubular.

[0008] In a preferred embodiment at least one of the apertures in the second hollow body shell is fitted with an externally protruding outlet conduit having an outlet nozzle. The length of substantially all of the conduits of the second hollow body measured from the nozzle thereof to the exterior side of the shell of the second hollow body is preferably less than about 50%, in particular less than 20%, of the overall cross-sectional dimension of the second hollow body.

[0009] In one embodiment of the present device substantially all of the nozzles of the conduits of the first and any intermediate bodies introduced into the same aperture are flushed with the nozzle of the second hollow body conduit fitted to that same aperture. This embodiment is advantageous in that it provides good mechanical stability: all nozzles are flushed with each other, the conduits of the inner and intermediate bodies being protected from externally inflicted

strains and impacts.

[0010] According to another embodiment at least one of the conduits of the first and any intermediate bodies introduced into the same aperture extends beyond the nozzle of the second hollow body conduit fitted to that same aperture. This embodiment is advantageous in that it provides an improved possibility to diminish or prevent clogging of the interspaces between the conduits when the device is used for supplying a resin-hardener system if the resin is supplied from the second hollow body and the hardener through the extending conduit, or vice versa. If clogging appears it will be at the nozzle of the extending conduit, not in said interspaces; such clogging is clearly much easier to attend to than clogging in the interspaces. The surface of the extending conduit may also be treated in such a way that it is not wetted by the second fluid component (i.e. the component exiting the nozzle of the second hollow body conduit); said surface may thus be made hydrophobic, e.g. by means of some hydrophobic coating, when the second fluid component is aqueous. In this way the risk of clogging at the nozzle of the extending conduit will also be diminished.

[0011] According to a further embodiment at least one conduit of the first hollow body or of an intermediate hollow body, if any, extends beyond the exterior surface of the second hollow body shell, whereby the conduit of the first hollow body or the intermediate hollow body comprises openings substantially transverse to the longitudinal axis of the conduits, positioned in the part of the conduit extending between the second hollow body conduit nozzle and the interior surface of the second hollow body shell. This embodiment is advantageous in those cases when some premixing is necessary, as the absence of the same would lead to unacceptable long curing times, e.g. when applying emulsion polymer isocyanate (EPI) or polyvinyl acetate (PVAc) gluing systems. In this embodiment the transverse openings cause or contribute to some turbulence in the co-flowing resin and hardener streams.

[0012] The present invention also relates to the use of a device according to the present invention for supplying a multicomponent fluid thermosetting gluing system.

[0013] In particular, the use of the device involves a first fluid component being brought to flow in a first stream, and a second fluid component being brought to flow in a second stream, whereby the flow of the second stream is brought to essentially encircle the flow of the first stream.

[0014] In the present context the term "stream" refers to a stream as well as to a jet or a ray. The flow of each or both of the component streams may be pumped or propelled by gravitational forces, or a combination thereof. The term "encircle" means that the second stream encircles, encompasses, or circumvents, the first stream, or in other words that the second stream flows in a circumjacent relation to the first stream.

[0015] If one of the ingredients of the multicomponent fluid thermosetting resin gluing system causes noxious or toxic gas emissions this ingredient is suitably comprised in the first fluid component. By encircling the first fluid component with a second fluid component the vapours emitted from the first fluid component are then shielded from the ambient air. In this way it is also possible to use resin-hardener systems with high proportions of hardener.

[0016] Although the stream of the first fluid component may be discontinuous or comprise regular or irregular dripping, whereby the portions or droplets are essentially completely encircled by the second fluid component, the stream is preferably continuous, i.e. unbroken, whereby said first stream is encircled by the second stream in the direction transverse to the flow direction of both streams.

[0017] The present use of the device is particularly suited for supplying thermosetting resin gluing systems chosen from a group comprising urea-formaldehyde resin gluing systems, melamine-formaldehyde resin gluing systems, melamine-urea-formaldehyde resin gluing systems, phenol resin gluing systems, phenol-formaldehyde resin gluing systems, resorcinol-phenol-formaldehyde resin gluing systems, polyurethane resin gluing systems, polyvinyl acetate gluing systems, emulsion and dispersion isocyanate resin gluing systems, and various combinations of two or more of these gluing systems.

[0018] The hardener components of these gluing systems are preferably used as the first fluid component.

[0019] In the present context the term "hardener" refers both to catalytic hardeners and reactive curing agents.

[0020] As the resin component is not brought in contact with the hardener component until the components exit the supply device, the pot life is prolonged, compared with prior art in which the components are premixed in or prior to entering the supply device. Consequently the clogging problem is also strongly diminished or even removed.

[0021] In a particularly preferred embodiment the present method is applied in a process for production of laminated wood or glue-laminated timber by agglutinating surfaces of two or more wooden members. In this process a multicomponent gluing system is prepared by mixing a hardener component and a resin component, whereupon the freshly prepared gluing system is applied on at least one of the surfaces to be agglutinated, whereby the hardener component is brought to flow in a first stream from an application device to said surface and the resin component is brought to flow in a second stream, whereby the second stream is brought to essentially encircle the first stream in the direction transverse to the direction of flow of the first as well as of the second stream.

[0022] In one embodiment of the use of the device according to the present invention at least one of the apertures in the second hollow body shell is fitted with an externally protruding outlet conduit having an outlet nozzle, the length of substantially all conduits of the second hollow body measured from the nozzle thereof to the exterior side of the shell of the second hollow body being less than about 50% of the overall cross-sectional dimension of the second

hollow body, and at least one of the conduits introduced into the same aperture extending beyond the nozzle of the conduit fitted to that same aperture, for supplying a multicomponent fluid thermosetting resin gluing system by means of a method in which a first fluid component is brought to flow in a first stream, and a second fluid component is brought to flow in a second stream, wherein the second stream is brought to essentially encircle the first stream.

[0023] The present invention is illustrated in more detail below by means of examples and with reference to the appended drawing, in which Fig 1 shows an embodiment of the device according to the invention which comprises a first hollow body 10 provided with three outlet conduits 20, 21, 22, a second hollow body 30 having as many outlet apertures 40, 41, 42 as there are outlet conduits of the first hollow body. Each conduit is introduced into one aperture, there being an interspaces 50, 51, 52 between the conduit and the edges 60, 61, 62 of the apertures. The first hollow body 10 is provided with an inlet duct 70 and the outlet conduits 20, 21 have outlet nozzles 80, 81. The second hollow body 30 is provided with an inlet duct 90 and comprises a shell 100 having one interior 110 and one exterior 120 surface, and envelopes the first hollow body. Nozzles 80, 81 extend beyond said exterior surface 120, and each conduit 20, 21, 22 is introduced into different apertures 40, 41, 42. The first hollow body as well as the second hollow body both have tubular form. All the apertures in the second hollow body shell is fitted with externally protruding outlet conduits 130, 131, 132 having outlet nozzles 140, 141, 142. Nozzle 80 of conduit 20 is flushed with nozzle 140 of conduit 130, which is fitted to aperture 40, i.e. the same aperture into which conduit 20 is introduced. Nozzle 81 of conduit 21 extends beyond nozzle 141 of conduit 131, which is fitted to aperture 41, i.e. the same aperture into which conduit 21 is introduced. Conduit 22 comprises openings 150 which are substantially transverse to the longitudinal axis of conduits 22 and 130, which openings are positioned in the part of conduit 22 extending between the nozzle 142 and the shell interior surface 110.

[0024] Comparative Example 1: A resorcinol-phenol-formaldehyde gluing system was prepared according to conventional technology by stirring 100 parts by weight of a resorcinol-phenol mixture and 20 parts by weight of an aqueous formaldehyde solution containing 40 percent by weight of formaldehyde. After said stirring the glue was applied to a surface in an amount of 400g/m². The formaldehyde concentration above said surface was analysed by sucking air through a filter impregnated with dinitrophenylhydrazine, leaching the filter with acetonitrile, and then analysing the extract, by means of HPLC, with regard to the content of HCHO. The volume of analysed air was 28.42 litres, which passed the filter with a flow of 0.98 litres/minute. The results of the analysis are set forth in the Table below.

[0025] Comparative Example 2: A resorcinol-phenol-formaldehyde gluing system was prepared in the same manner and according to the same recipe as in Comparative Example 1. The glue was applied to a surface in an amount of 400g/m². The formaldehyde concentration above said surface was analysed by sucking air through a filter impregnated with dinitrophenylhydrazine, leaching the filter with acetonitrile, and then analysing the extract, by means of HPLC, with regard to the content of HCHO. The volume of analysed air was 14.79 litres, which passed the filter with a flow of 0.51 litres/minute. The results of the analysis are set forth in the Table below.

[0026] Example 1: A resorcinol-phenol-formaldehyde gluing system was prepared using a device according to the present invention equipped with conduits having flushed nozzles (corresponding to nozzles 80 and 140 of conduits 20 and 130, respectively, in Fig 1) and using the same component recipe as in Comparative Example 1. The glue was applied to a surface in an amount of 400g/m². The formaldehyde concentration above said surface was analysed by sucking air through a filter impregnated with dinitrophenylhydrazine, leaching the filter with acetonitrile, and then analysing the extract, by means of HPLC, with regard to the content of HCHO. The volume of analysed air was 28.42 litres, which passed the filter with a flow of 0.98 litres/minute. The results of the analysis are set forth in the Table below.

[0027] Example 2: A resorcinol-phenol-formaldehyde gluing system was prepared in the same way, using the same kind of equipment and the same amounts of components as in Example 1. The glue was applied to a surface in an amount of 400g/m². The formaldehyde concentration above said surface was analysed by sucking air through a filter impregnated with dinitrophenylhydrazine, leaching the filter with acetonitrile, and then analysing the extract, by means of HPLC, with regard to the content of HCHO. The volume of analysed air was 14.79 litres, which passed the filter with a flow of 0.51 litres/minute. The results of the analysis are set forth in the Table below.

Example	Amount of HCHO in air sample, µg	Concentration of HCHO in air sample, mg/m ³
Comparative Example 1	255.53	9.0
Example 1	69.96	2.5
Comparative Example 2	183.08	12.4
Example 2	74.23	5.0

[0028] As evident from the results presented in the above Table, the present invention has a most pronounced effect on the formaldehyde emissions.

Claims

- 5 1. A device for supplying a multicomponent fluid thermosetting resin gluing system comprising a first hollow body (10) provided with outlet conduits (20,21,22); and a second hollow body (30), **characterised in that** the second hollow body has at least as many outlet apertures (40,41,42) as there are outlet conduits of the first hollow body; whereby each conduit is introduced into one aperture, there being an interspace (50,51,52) between the conduit and the edges (60,61,62) of the aperture.
- 10 2. A device according to claim 1, **characterised in that** the first hollow body (10) is provided with an inlet duct (70); the outlet conduit (20,21,) has an outlet nozzle (80,81); the second hollow body (30) is provided with an inlet duct (90), comprises a shell (100) having one interior (110) and one exterior (120) surface, and envelopes the first hollow body; whereby the nozzle is flushed with the interior or the exterior surface of the second hollow body shell or extends beyond said exterior surface, each conduit being introduced into different apertures.
- 15 3. A device according to any of claims 1-2, **characterised in that** the first hollow body (10) and/or the second hollow body (30) have/has tubular form.
- 20 4. A device according to any of claims 1-3, **characterised in that** at least one of the apertures (40,41,42) in the second hollow body shell is fitted with an externally protruding outlet conduit (130,131,132) having an outlet nozzle (140,141,142).
- 25 5. A device according to claim 4, **characterised in that** the length of substantially all of the conduits (130,131,132) of the second hollow body (30) measured from the nozzle thereof to the exterior side of the shell of the second hollow body is less than about 50% of the overall cross-sectional dimension of the second hollow body.
- 30 6. A device according to any of claims 2-5, **characterised in that** substantially all of the nozzles (80,81) of the conduits (20,21) introduced into the same aperture (40,41) are flushed with the nozzle (141,142) of the conduit (130,131) fitted to that same aperture.
- 35 7. A device according to any of claims 4-6, **characterised in that** at least one of the conduits (21) introduced into the same aperture (41) extends beyond the nozzle (141) of the conduit (131) fitted to that same aperture.
8. A device according to any of claims 4-7, **characterised in that** at least one conduit of the first hollow body (10) extends beyond the exterior surface of the second hollow body shell, whereby the conduit (22) of the first hollow body comprises openings (150) substantially transverse to the longitudinal axis of the conduits, positioned in the part of the conduit extending between the second hollow body conduit nozzle (142) and the interior surface of the second hollow body shell.
- 40 9. Use of the device according to any of claims 1-8 for supplying a multicomponent fluid thermosetting resin gluing system.
- 45 10. Use according to claim 9, **characterised in that** a first fluid component that emits vapours is brought to flow in a first stream, and a second fluid component is brought to flow in a second stream, wherein the second stream is brought to essentially encircle the first stream such that the vapours emitted from the first component are shielded from the ambient air by the second stream.
- 50 11. Use according to claim 10, **characterised in that** the second stream is brought to essentially encircle the first stream in the direction transverse to the flow direction.
- 55 12. Use according to any of claims 10-11, **characterised in that** the first fluid component comprises a hardener.
13. Use according to any of claims 9-12, **characterised in that** the multicomponent fluid thermosetting resin gluing system is a urea-formaldehyde resin gluing system, a melamine-formaldehyde resin gluing system, a melamine-urea-formaldehyde resin gluing system, a phenol resin gluing system, a phenol-formaldehyde resin gluing system, a resorcinol-phenol-formaldehyde resin gluing system, a polyurethane resin gluing system, a polyvinyl acetate gluing system, an emulsion or dispersion isocyanate resin gluing system, or a combination of two or more of these gluing systems.

14. Use according to any of claims 9-13, **characterised in that** the multicomponent fluid thermosetting resin gluing system is a emulsion polyisocyanate resin gluing system.
15. Use according to any of claims 9-14, **characterised in that** the gluing system is further supplied onto at least one surface of a wooden member which is agglutinated with one or more other wooden members forming laminated wood, or glue-laminated timber, in which the gluing system is prepared by mixing a hardener component and a resin component

Patentansprüche

1. Vorrichtung zum Liefern eines flüssigen wärmehärtenden Mehrkomponenten-Kunsthartz-Leimsystems, das aufweist: einen ersten Hohlkörper (10), der mit Auslaßrohrkanälen (20, 21, 22) versehen ist, und einen zweiten Hohlkörper, **dadurch gekennzeichnet, daß** der zweite Hohlkörper (30) mindestens so viele Auslaßöffnungen (40, 41, 42) hat, wie es Auslaßrohrkanäle des ersten Hohlkörpers gibt, wobei jeder Rohrkanal in eine Öffnung eingeführt ist, wobei es einen Zwischenraum (50, 51, 52) zwischen dem Rohrkanal und den Rändern (60, 61, 62) der Öffnung gibt.
2. Vorrichtung nach Anspruch 1, **dadurch gekennzeichnet, daß** der erste Hohlkörper (10) mit einer Einlaßrohrleitung (70) versehen ist, der Auslaßrohrkanal (20, 21) eine Auslaßdüse (80, 81) hat, der zweite Hohlkörper (30) mit einer Einlaßrohrleitung- (90) ausgestattet ist und eine Schale (100) aufweist, die eine innere (110) und eine äußere (120) Oberfläche hat und den ersten Hohlkörper umhüllt, wobei die Düse mit der inneren oder der äußeren Oberfläche der zweiten Hohlkörperschale bündig ist oder sich über die äußere Oberfläche hinaus erstreckt, wobei jeder Rohrkanal in verschiedene Öffnungen eingeführt ist.
3. Vorrichtung nach einem der Ansprüche 1 bis 2, **dadurch gekennzeichnet, daß** der erste Hohlkörper (10) und/oder der zweite Hohlkörper (30) eine rohrförmige Form haben.
4. Vorrichtung nach einem der Ansprüche 1 bis 3, **dadurch gekennzeichnet, daß** in mindestens eine der Öffnungen (40, 41, 42) in der zweiten Hohlkörperschale ein nach außen vorstehender Auslaßrohrkanal (130, 131, 132) eingepaßt ist, der eine Auslaßdüse (140, 141, 142) hat.
5. Vorrichtung nach Anspruch 4, **dadurch gekennzeichnet, daß** die Länge im wesentlichen aller Rohrkanäle (130, 131, 132) des zweiten Hohlkörpers (30) von deren Düse bis zur Außenseite der Schale des zweiten Hohlkörpers gemessen weniger als etwa 50% der gesamten Querschnittabmessung des zweiten Hohlkörpers ist.
6. Vorrichtung nach einem der Ansprüche 2 bis 5, **dadurch gekennzeichnet, daß** im wesentlichen alle Düsen (80, 81) der in die gleiche Öffnung (40, 41) eingeführten Rohrkanäle (20, 21) mit der Düse (141, 142) des Rohrkanals (130, 131) bündig sind, welcher in diese gleiche Öffnung eingepaßt ist.
7. Vorrichtung nach einem der Ansprüche 4 bis 6, **dadurch gekennzeichnet, daß** mindestens einer der in die gleiche Öffnung (41) eingeführten Rohrkanäle (21) sich über die Düse (141) des in die gleiche Öffnung eingepaßten Rohrkanals (131) hinaus erstreckt.
8. Vorrichtung nach einem der Ansprüche 4 bis 7, **dadurch gekennzeichnet, daß** mindestens ein Rohrkanal des ersten Hohlkörpers (10) sich über die äußere Oberfläche der zweiten Hohlkörperschale hinaus erstreckt, wobei der Rohrkanal (22) des ersten Hohlkörpers Öffnungen (150) aufweist, die im wesentlichen quer zur Längsachse der Rohrkanäle sind und die in dem Teil des Rohrkanals positioniert sind, der sich zwischen der zweiten Hohlkörper-Rohrkanaldüse (142) und der inneren Oberfläche der zweiten Hohlkörperschale erstreckt.
9. Verwendung der Vorrichtung nach einem der Ansprüche 1 bis 8 zum Liefern eines wärmehärtenden flüssigen Mehrkomponenten-Kunsthartz-Leimsystems.
10. Verwendung nach Anspruch 9, **dadurch gekennzeichnet, daß** eine erste flüssige Komponente, die Dämpfe emittiert, dazu gebracht wird, in einem ersten Strom zu fließen, und eine zweite flüssige Komponente dazu gebracht wird, in einem zweiten Strom zu fließen, wobei der zweite Strom dazu gebracht wird, den ersten Strom derart zu umschließen, daß die von der ersten Komponente emittierten Dämpfe durch den zweiten Strom von der Umgebungsluft abgeschirmt werden.

11. Verwendung nach Anspruch 10, **dadurch gekennzeichnet, daß** der zweite Strom dazu gebracht wird, den ersten Strom im wesentlichen in der Richtung quer zu der Flußrichtung zu umschließen.

12. Verwendung nach einem der Ansprüche 10 bis 11, **dadurch gekennzeichnet, daß** die erste flüssige Komponente einen Härter aufweist.

13. Verwendung nach einem der Ansprüche 9 bis 12, **dadurch gekennzeichnet, daß** das wärmehärtende flüssige Mehrkomponenten-Kunstharz-Leimsystem ein Harnstoff-Formaldehydharz-Leimsystem, ein Melaminharz-Leimsystem, ein Melamin-Harnstoff-Formaldehydharz-Leimsystem, ein Phenolharz-Leimsystem, ein Phenolformaldehydharz-Leimsystem, ein Resorcinol-Phenol-Formaldehydharz-Leimsystem, ein Polyurethanharz-Leimsystem, ein Polyvinylacetat-Leimsystem, ein Isocyanatharz-Emulsions- oder Dispersions-Leimsystem oder eine Kombination aus zwei oder mehr dieser Leimsysteme ist.

14. Verwendung nach einem der Ansprüche 9 bis 13, **dadurch gekennzeichnet, daß** das wärmehärtende flüssige Mehrkomponenten-Kunstharz-Leimsystem ein Polyisocyanatharz-Emulsionsleimsystem ist.

15. Verwendung nach einem der Ansprüche 9 bis 14, **dadurch gekennzeichnet, daß** das Leimsystem ferner auf mindestens eine Oberfläche eines hölzernen Elements aufgebracht wird, das mit einem oder mehreren anderen hölzernen Elementen, die ein Schichtholz oder schichtverleimtes Bauholz bilden, verkittet wird, wobei das Leimsystem hergestellt wird, indem eine Härterkomponente und einer Harzkomponente gemischt werden.

Revendications

1. Dispositif pour délivrer un système adhésif fluide multicomposant à base de résine thermodurcissable comprenant un premier corps creux (10) muni de conduits de sortie (20, 21, 22), et un deuxième corps creux (30), **caractérisé en ce que** le deuxième corps creux comporte au moins autant d'ouvertures de sortie (40, 41, 42) qu'il y a de conduits de sortie dans le premier corps creux, grâce à quoi chaque conduit est introduit dans une ouverture, un interstice (50, 51, 52) existant entre le conduit et les bords (60, 61, 62) de l'ouverture.

2. Dispositif selon la revendication 1, **caractérisé en ce que** le premier corps creux (10) est muni d'une conduite d'entrée (70), le conduit de sortie (20, 21) comporte un ajutage de sortie (80, 81), le deuxième corps creux (30) est muni d'une conduite d'entrée (90), comprend une coque (100) ayant une surface intérieure (110) et une surface extérieure (120), et enveloppe le premier corps creux, grâce à quoi l'ajutage est à niveau avec la surface intérieure ou extérieure de la coque du deuxième corps creux ou bien s'étend au-delà de ladite surface extérieure, chaque conduit étant introduit dans des ouvertures différentes.

3. Dispositif selon l'une quelconque des revendications 1 à 2, **caractérisé en ce que** le premier corps creux (10) et/ou le deuxième corps creux (30) est/sont de forme tubulaire.

4. Dispositif selon l'une quelconque des revendications 1 à 3, **caractérisé en ce que** au moins l'une des ouvertures (40, 41, 42) de la coque du deuxième corps creux est munie d'un conduit de sortie faisant saillie à l'extérieur (130, 131, 132) ayant un ajutage de sortie (140, 141, 142).

5. Dispositif selon la revendication 4, **caractérisé en ce que** la longueur de sensiblement tous les conduits (130, 131, 132) du deuxième corps creux (30) mesurée de leur ajutage à la face extérieure de la coque du deuxième corps creux est inférieure à environ 50 % de la dimension transversale totale du deuxième corps creux.

6. Dispositif selon l'une quelconque des revendications 2 à 5, **caractérisé en ce que** sensiblement tous les ajutages (80, 81) des conduits (20, 21) introduits dans la même ouverture (40, 41) sont à niveau avec l'ajutage (141, 142) du conduit (130, 131) placé sur cette même ouverture.

7. Dispositif selon l'une quelconque des revendications 4 à 6, **caractérisé en ce qu'**au moins l'un des conduits (21) introduits dans la même ouverture (41) s'étend au-delà de l'ajutage (141) du conduit (131) placé sur cette même ouverture.

8. Dispositif selon l'une quelconque des revendications 4 à 7, **caractérisé en ce qu'**au moins un conduit du premier corps creux (10) s'étend au-delà de la surface extérieure de la coque du deuxième corps creux, grâce à quoi le

conduit (22) du premier corps creux comprend des ouvertures (150) sensiblement transversales à l'axe longitudinal des conduits, positionnées dans la partie du conduit s'étendant entre l'ajutage (142) du deuxième corps creux et la surface intérieure de la coque du deuxième corps creux.

- 5 9. Utilisation du dispositif selon l'une quelconque des revendications 1 à 8 pour délivrer un système adhésif fluide multicomposant à base de résine thermodurcissable.
- 10 10. Utilisation selon la revendication 9, **caractérisée en ce que** l'on fait s'écouler en un premier courant un premier composant fluide, qui émet des vapeurs, et **en ce que** l'on fait s'écouler en un deuxième courant un deuxième composant fluide, le deuxième courant étant amené à globalement encercler le premier courant de telle manière que les vapeurs émises par le premier composant sont protégées de l'air ambiant par le deuxième courant.
- 15 11. Utilisation selon la revendication 10, **caractérisée en ce que** le deuxième courant est amené à globalement encercler le premier courant dans la direction transversale à la direction d'écoulement.
- 20 12. Utilisation selon l'une quelconque des revendications 10 à 11, **caractérisée en ce que** le premier composant fluide comprend un durcisseur.
- 25 13. Utilisation selon l'une quelconque des revendications 9 à 12, **caractérisée en ce que** le système adhésif fluide multicomposant à base de résine thermodurcissable est un système adhésif à base de résine urée-formaldéhyde, un système adhésif à base de résine mélamine-formaldéhyde, un système adhésif à base de résine mélamine-urée-formaldéhyde, un système adhésif à base de résine phénolique, un système adhésif à base de résine phénol-formaldéhyde, un système adhésif à base de résine résorcinol-phénol-formaldéhyde, un système adhésif à base de résine polyuréthane, un système adhésif à base de poly(acétate de vinyle), un système adhésif à base de résine isocyanate en émulsion ou en dispersion, ou une combinaison de deux, ou plus, de ces systèmes adhésifs.
- 30 14. Utilisation selon l'une quelconque des revendications 9 à 13, **caractérisée en ce que** le système adhésif fluide multicomposant à base de résine thermodurcissable est un système adhésif à base de résine polyisocyanate en émulsion.
- 35 15. Utilisation selon l'une quelconque des revendications 9 à 14, **caractérisée en ce que** le système adhésif est en outre délivré sur au moins une surface d'un élément en bois qui est agglutiné avec un ou plusieurs autres éléments en bois formant du bois stratifié, ou du bois de construction stratifié-collé, dans laquelle le système adhésif est préparé en mélangeant un composant durcisseur et un composant résine.

Fig. 1

