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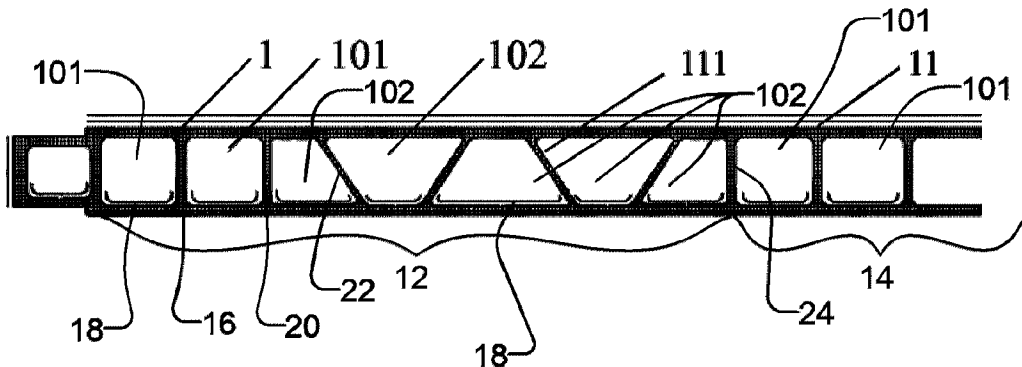
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(54) Title: COMPOSITE MATERIAL VEHICLE BODY AND COMPOSITE MATERIAL LAYING STRUCTURE AND LAYING
METHOD



(57) Abrégé/Abstract:

A composite material laying structure, a composite material vehicle body, and a composite material laying method, the composite material laying structure comprising a profile (1) provided with multiple quadrilateral cavities reinforced by lap joints after butt joint connection, the quadrilateral cavities comprising square cavities (101) and profile cavities (102), and the square shape of the square cavities (101) transitioning along the profile (1) into the trapezoidal shape of the profile cavities (102). The present composite material laying structure employs the laying structure of the composite material profile (1) and a butt joint lap-joint form.

ABSTRACT

A composite material laying structure, a composite material vehicle body, and a composite material laying method, the composite material laying structure comprising a profile (1) provided with multiple quadrilateral cavities reinforced by lap joints after butt joint connection, the quadrilateral cavities comprising square cavities (101) and profile cavities (102), and the square shape of the square cavities (101) transitioning along the profile (1) into the trapezoidal shape of the profile cavities (102). The present composite material laying structure employs the laying structure of the composite material profile (1) and a butt joint lap-joint form.

COMPOSITE MATERIAL VEHICLE BODY AND COMPOSITE MATERIAL LAYING STRUCTURE AND LAYING METHOD

5 FIELD

The present application relates to the technical field of composite material laying, and in particular to a composite material vehicle body. In particular, the present application relates to a composite material laying structure. The present application further relates to a composite material laying method.

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BACKGROUND

A sandwich panel or a winding structure is generally used in a composite material vehicle body or an apron board structure, which cannot solve the problem of mechanical property reduction caused by butt connection of multi-axial cloth in a vertical pultrusion direction of a composite pultruded profile with a complex cross section.

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In the first conventional technology, a load-bearing skeleton is made of fiber-reinforced resin matrix composite material coated on a foam inner core structure, and an inner panel is made of fiber-reinforced resin matrix composite material, and a part of an outer panel located on an inner surface is made of fiber-reinforced resin matrix composite material. In the second conventional technology, a sandwich structural form with a paper honeycomb core material filled between inner and outer carbon fiber skins is used in the vehicle body, the inner and outer skins of the vehicle body, including an intersecting area of a side wall and a roof of the vehicle body, are all formed by continuous laying of carbon fiber prepreg, and there is lapping area at an edge of each layer of the carbon fiber prepreg. None of the above conventional technologies has the design of a form of profile structure, which cannot solve

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the problem of mechanical property reduction caused by butt connection of multi-axial cloth in a vertical pultrusion direction of the composite pultruded profile with a complex cross section.

Therefore, how to provide a composite material laying structure with a laying design having a profile structure to solve the problem of mechanical property reduction caused by butt connection of the multi-axial cloth in the vertical pultrusion direction of the composite pultruded profile with the complex cross section is an urgent technical problem for those skilled in the art to solve.

10 SUMMARY

An object according to the present application is to provide a composite material laying structure, which has a laying structure of composite material profile and a laying form in butt connection and lapping joint, and solves the problem of mechanical property reduction caused by butt connection of multi-axial cloth in a vertical pultrusion direction of the composite pultruded profile with a complex cross section. Another object according to the present application is to provide a composite material vehicle body. Yet another objection according to the present application is to provide a composite laying method.

In order to achieve the above objects, a composite material laying structure is provided according to the present application, which includes a profile, the profile is provided with multiple quadrilateral chambers which are butt connected and then reinforced by lapping joint, the quadrilateral chambers includes square chambers and profile chambers, and the square chambers in a square shape are transitioned into the profile chambers in a trapezoidal shape along the profile.

Preferably, an outer surface of the profile is laid with multi-axial carbon fiber cloth.

Preferably, the multi-axial carbon fiber cloth is a bidirectional plain carbon fiber fabric or a bidirectional twill carbon fiber fabric or a patterned carbon fiber fabric or a fine woven fabric with an angle of $\pm 45^\circ$.

Preferably, the multi-axial fiber cloth is the bidirectional plain carbon fiber fabric which has been treated with a thickening process.

Preferably, inner surfaces of the quadrilateral chambers are laid with multi-axial carbon fiber

cloth.

Preferably, an interior of the profile is unidirectional carbon fiber wire.

Preferably, a seam for butt connection of the quadrilateral chambers and a reinforcing sheet for lapping joint of the quadrilateral chambers are located on lower surfaces of the quadrilateral chambers.

A composite material vehicle body is provided according to the present application, having the above composite material laying structure.

A composite laying method is provided according to the present application, for manufacturing the above composite material laying structure, which includes:

10 using a form of inner layers of the quadrilateral chambers with butt connection and lapping-joint reinforcement around inner chambers;
introducing a lapping-joint reinforcement layer before entering a forming mold; and
transitioning the shape of the inner layers of the quadrilateral chambers from square into trapezoidal by using a multi-section transition mold.

15 Preferably, after the step of transitioning the shape of the inner layers of the quadrilateral chambers from square into trapezoidal by using a multi-section transition mold, the method further includes:

treating the plain carbon fiber fabric with a thickening process and laying the plain carbon fiber fabric on the outer surface of the profile.

20 Compared with the background technology, the composite material laying structure according to the present application includes the profile, the profile is provided with multiple quadrilateral chambers which are butt connected in sequences and then reinforced by lapping joint, the quadrilateral chambers include square chambers in a square shape and profile chambers in a trapezoidal shape, and the square chambers (101) in a square shape of the profile are transitioned into the profile chambers. The composite material laying structure forms the inner layers in the form of the profile structure by providing the multiple quadrilateral chambers that are butt connected and then reinforced by lapping joint, so as to provide the composite material profile that meets the mechanical property requirement of the vehicle body, and solve the problem of mechanical property reduction caused by butt connection of the multi-axial cloth in the vertical pultrusion direction of the composite

pultruded profile with a complex cross section.

BRIEF DESCRIPTION OF THE DRAWINGS

For more clearly illustrating embodiments of the present application or technical solutions in the conventional technology, the drawings referred to for describing the embodiments or the conventional technology will be briefly described hereinafter. Apparently, the drawings in the following description are only some examples of the present application, and for those skilled in the art, other drawings may be obtained based on the provided drawings without any creative efforts.

FIG. 1 is a schematic structural view of a composite material laying structure provided according to an embodiment of the present application; and

FIG. 2 is schematic flowchart of a composite material laying method provided according to the embodiment of the present application.

The reference numerals include:

1 profile, 101 square chamber,
102 profile chamber.

DETAILED DESCRIPTION OF THE EMBODIMENTS

Technical solutions of embodiments of the present application are clearly and completely described hereinafter in conjunction with the drawings of the embodiments of the present application. Apparently, the embodiments described in the following are only some embodiments of the present application, rather than all embodiments. Based on the embodiments in the present application, all of other embodiments, made by the person skilled in the art without any creative efforts, fall into the scope of protection of the present application.

In order to enable those skilled in the art to better understand the solution of the present application, the present application will be further described in detail below with reference to the accompanying drawings and specific embodiments.

Referring to FIG. 1 and FIG. 2, FIG. 1 is a schematic structural view of a composite material

laying structure provided according to an embodiment of the present application; and FIG. 2 is schematic flowchart of a composite material laying method provided according to the embodiment of the present application.

5 In a first specific embodiment, a form of a profile structure is used in the composite material structure provided according to the present application, an interior of the profile 1 includes multiple quadrilateral chambers reinforced by lapping joint after connected by butt connection, the quadrilateral chambers includes square chambers 101 and profile chambers 102, the quadrilateral chambers in the profile 1 in square shape is transitioned into the profile chambers 102 in trapezoidal shape.

10 In this embodiment, the composite material profile of this special design can meet the mechanical property requirement of the vehicle body, which can solve the problem of mechanical property reduction caused by butt connection of multi-axial cloth in a vertical pultrusion direction of the composite pultruded profile 1 with a complex cross section.

It should be noted that, the shape of the inner chamber layers is gradually transitioned from
15 being straight to the shape of the profile chambers by using the design of a multi-section transition mold, and a lapping-joint reinforcement layer needs to be introduced before entering a forming mold. Specifically, the square shapes of the square chambers 101 are square and/or rectangle, and the trapezoidal shapes of the profile chambers 102 are isosceles trapezoid and/or right angle trapezoid. During the transition from the square chambers 101 to
20 the profile chambers 102, firstly, multiple square chambers 101 at a first section 12 are butted at right angle edges sequentially (see for example butt connection 16 in FIG. 1), and then the right angle edges of the square chambers 101 at an end of the first section 12 are butted with right angle edges of the profile chambers 102 (see for example butt connection 20 in FIG. 1) while the trapezoidal inclined edges of the multiple profile chambers 102 are butted with each
25 other (see for example butt connection 22 in FIG. 1), the right angle edges of the profile chambers 102 at the end of the first section 12 can continue to be butted with right angle edges of the square chambers 101 at a head of a second section 14 (see for example butt connection 24 in FIG. 1), and the multiple square chambers 101 at the second section 14 continue to be connected sequentially. On this basis, a connection form of the first section 12
30 and the second section 14 of the above profile 1 can be repeated to form a profile 1 with more sections. In this profile 1, the square chambers 101 are spaced apart from the profile chambers 102, the square chambers 101 are transitioned into the profile chambers 102, and

the shape of inner chamber layers of the profile 1 is gradually transitioned from being straight into the shape of the profile chambers.

In this embodiment, inner layers of the quadrilateral chambers are in a laying form with butt connection and lapping-joint reinforcement around inner chambers, a seam for butt
5 connection of the quadrilateral chambers and a reinforcing sheet 18 for lapping joint of the quadrilateral chambers are located on lower surfaces of the quadrilateral chambers, more specifically the seam for the butt connection after laid around the inner chambers is located at a corner of the lower surface of the chambers.

Besides, an outer surface 11 of the profile 1 is laid with multi-axial carbon fiber cloth; inner
10 surfaces of the profile chambers 102 are also laid with multi-axial carbon fiber cloth. In other words, inner surfaces 111 of the quadrilateral chambers are laid with multi-axial carbon fiber cloth.

In this embodiment, the function of the multi-axial carbon fiber cloth is to provide shear resistance for the profile 1. In a case that the inner surface and the outer surface of the profile
15 are laid with the multi-axial carbon fiber cloth, the inner surface and the outer surface of the profile 1, that is, the whole profile 1 has good shear resistance.

Exemplarily, an appearance surface layer of the profile 1 is laid by a bidirectional plain carbon fiber fabric. It should be noted that the appearance surface layer of the profile 1 includes but not limited to the bidirectional plain carbon fiber fabric, and may also be
20 replaced with a bidirectional twill carbon fiber fabric or a patterned carbon fiber fabric or a fine woven fabric with an angle of $\pm 45^\circ$, which should also belong to the description scope of this embodiment.

On this basis, the plain carbon fiber fabric on the outer surface of the profile 1 is treated by thickening; in the specific treatment process, the plain carbon fiber fabric is introduced by a
25 pressing roller and is laid on the outer surface of the profile 1.

In addition, an interior of the profile 1 is unidirectional carbon fiber wire.

In this embodiment, the function of the unidirectional carbon fiber wire is to provide the profile 1 with bending resistance.

A composite material vehicle body having the above composite material laying structure is
30 further provided according to the present application, the composite material profile of the

special design can meet the mechanical property requirement of the vehicle body, which can solve the problem of mechanical property reduction caused by butt connection of multi-axial cloth in a vertical pultrusion direction of the composite pultruded profile 1 with the complex cross section, improve the safety performance of the vehicle body, prolong the service life,
5 and reduce the manufacturing cost, should have all the beneficial effects of the above composite material laying structure, and will not be repeated here.

A composite material laying method for manufacturing the above composite material laying structure is further provided according to the present application, which includes: S1, using an inner laying form of the quadrilateral chambers with butt connection and lapping-joint
10 reinforcement around inner chambers; S2, introducing a lapping-joint reinforcement layer before entering a forming mold; and S3, using a multi-section transition mold to transition the shape of the inner layers of the quadrilateral chambers from square to trapezoidal. The composite material laying structure manufactured based on the above composite material laying method has the form of the profile structure, and can meet the mechanical property
15 requirement of the vehicle body, which can solve the problem of mechanical property reduction caused by butt connection of multi-axial cloth in a vertical pultrusion direction of the composite pultruded profile with the complex cross section.

In this embodiment, an inner layer of the profile 1 is formed by the quadrilateral chambers reinforced by lapping joint after butt connection sequentially, and the quadrilateral chambers
20 in the profile 1 is gradually transitioned from the square chambers 101 in a square shape into the profile chambers 102 in a trapezoidal shape, the inner chamber layers are gradually transitioned from being straight into being with the shapes of the profile chambers by using the design of multi-section transition mold, and the lapping-joint reinforcement layer needs to be introduced before entering the forming mold.

25 In addition, after the step S3, the method further includes: treating the plain carbon fiber fabric with a thickening process and laying the plain carbon fiber fabric on the outer surface of the profile 1.

In this embodiment, the plain carbon fiber fabric on the outer surface of the profile 1 is treated with a thickening process, and is introduced by the pressing roller and laid on the
30 outer surface of the profile 1. The appearance surface layer of the profile 1 may be replaced by a bidirectional plain carbon fiber fabric into a bidirectional twill carbon fiber fabric or a

patterned carbon fiber fabric or a fine woven fabric with an angle of $\pm 45^\circ$.

Specific examples are used in this specification to illustrate the principle and implementation of the present application. The description of the above embodiments is only used to facilitate understanding of the method and core concept of the present application. It should be noted
5 that, for those skilled in the art, many modifications and improvements may be made to the present application without departing from the principle of the present application, and these modifications and improvements are also deemed to fall into the protection scope of the present application defined by the claims.

CLAIMS

1. A composite material laying structure, comprising a profile (1), wherein the profile (1) is provided with a plurality of quadrilateral chambers which are butt connected and then reinforced by a lapping joint, wherein the quadrilateral chambers comprise square chambers (101) and a plurality of profile chambers (102), and the square chambers (101) in a square shape are transitioned into the plurality of profile chambers (102) in a trapezoidal shape along the profile (1),

wherein an outer surface of the profile (1) is laid with a multi-axial carbon fiber cloth,

wherein inner surfaces of the quadrilateral chambers are laid with the multi-axial carbon fiber cloth,

wherein a seam for butt connection of the quadrilateral chambers and a reinforcing sheet for the lapping joint of the quadrilateral chambers are located on lower surfaces of the quadrilateral chambers,

wherein the quadrilateral chambers are in a laying form with butt connection and lapping-joint reinforcement around an inner chamber of the profile (1),

during the transition from the square chambers (101) to the plurality of profile chambers (102), firstly, the square chambers (101) at a first section are butted at right angle edges sequentially, and then the right angle edge of the square chamber (101) at an end of the first section is butted with the right angle edge of one of the plurality of profile chambers (102) while trapezoidal inclined edges of the plurality of profile chambers (102) are butted with each other, the right angle edge of the profile chamber (102) at the end of the first section is continuously butted with the right angle edge of the square chamber (101) at a head of a second section, and the square chambers (101) at the second section continue to be connected sequentially so that a connection form of the first section and the second section is able to repeatedly form the profile (1) with more sections.

2. The composite material laying structure according to claim 1, wherein the multi-axial carbon fiber cloth is a bidirectional plain carbon fiber fabric or a bidirectional twill carbon fiber fabric or a patterned carbon fiber fabric or a fine woven fabric with an angle of $\pm 45^\circ$.

3. The composite material laying structure according to claim 2, wherein the multi-axial fiber cloth is the bidirectional plain carbon fiber fabric which has been treated with a thickening process.

5 4. The composite material laying structure according to any one of claims 1 to 3, wherein an interior of the profile (1) is unidirectional carbon fiber wire.

5. A composite material vehicle body, having the composite material laying structure according to any one of claims 1 to 4.

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6. A composite material laying method, for manufacturing the composite material laying structure according to claim 1, wherein the method comprises:

using a form of inner layers of the quadrilateral chambers with the butt connection and lapping-joint reinforcement around the inner chamber of the profile (1);

15 introducing a lapping-joint reinforcement layer before entering a forming mold; and

transitioning the shape of the inner layers of the quadrilateral chambers from square into trapezoidal by using a multi-section transition mold.

7. A composite material laying method, for manufacturing the composite material laying structure according to claim 1, wherein an interior of the profile (1) is unidirectional carbon fiber wire and the method comprises:

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using a form of inner layers of the quadrilateral chambers with the butt connection and lapping-joint reinforcement around the inner chamber of the profile (1);

introducing a lapping-joint reinforcement layer before entering a forming mold; and

25 transitioning the shape of the inner layers of the quadrilateral chambers from square into trapezoidal by using a multi-section transition mold.

8. The composite material laying method according to any one of claims 6 to 7, wherein

after the step of transitioning the shape of the inner layers of the quadrilateral chambers from square into trapezoidal by using the multi-section transition mold, the method further comprises:

- 5 the multi-axial carbon fiber cloth is a bidirectional plain carbon fiber fabric, and treating the bidirectional plain carbon fiber fabric with a thickening process and laying the bidirectional plain carbon fiber fabric on the outer surface of the profile (1).

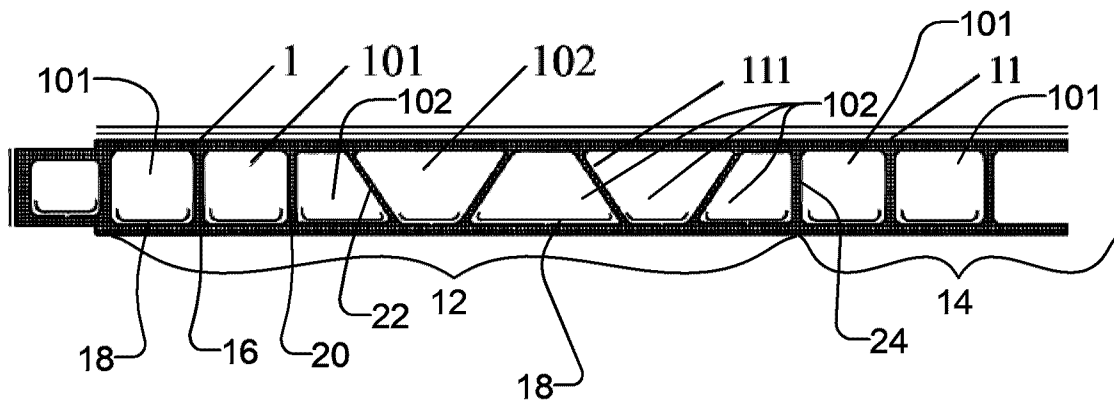


FIG. 1

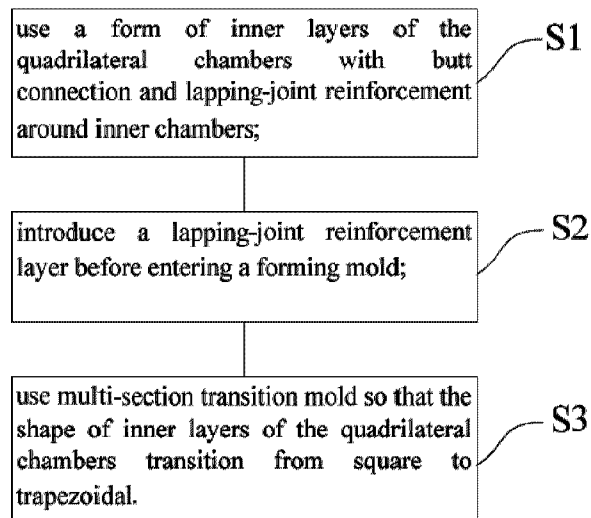


FIG. 2

