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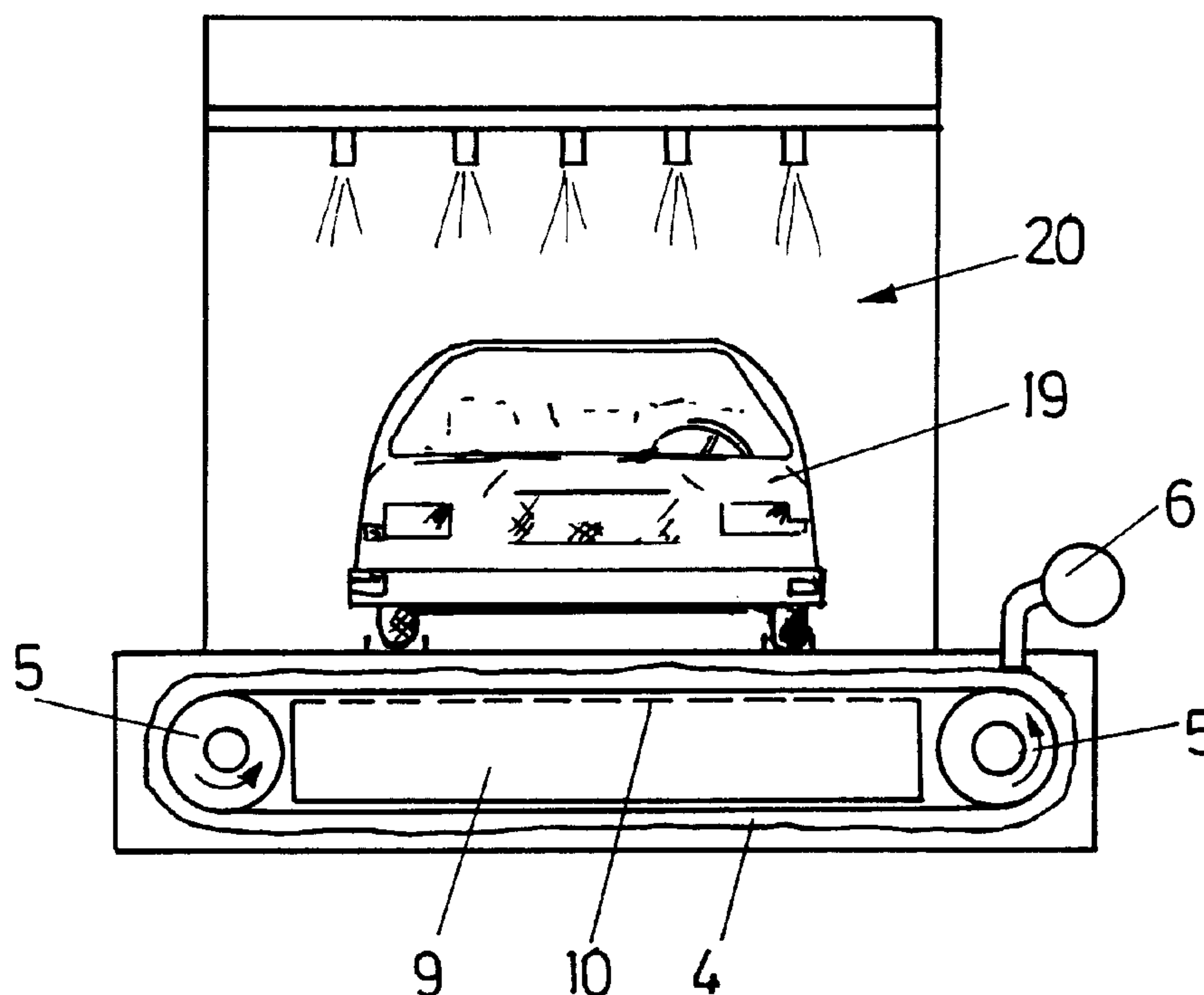
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(54) Titre : UN APPAREIL POUR LE PEINTURAGE D'ARTICLES PAR PULVERISATION HUMIDE

(54) Title: AN APPARATUS FOR THE WET-PAINT SPRAY PAINTING OF ARTICLES



(57) Abrégé/Abstract:

Apparatus for the wet-paint spray painting of articles having a device for catching the paint surplus which has an air-permeable dry filter, wherein the dry filter (4) is arranged movably and there is provided a suction removal device (6) which sucks the dried paint particles away from the dry filter (4).



ABSTRACT

5 Apparatus for the wet-paint spray painting of articles having a device for catching the paint surplus which has an air-permeable dry filter, wherein the dry filter (4) is arranged movably and there is provided a suction removal device (6) which sucks the dried paint particles away from the dry filter (4).

(Figure 1)

Description

The invention concerns an apparatus for the wet-paint spray painting of articles, having a device for catching the paint surplus, which has an air-permeable dry filter.

For catching the paint surplus in wet-paint spray painting
5 (that is to say when spray painting liquid media, for example by way of spray nozzles or spray guns), it is already known for the paint surplus to be picked up by a filter surface and then washed out of the filter surface. Such a wet separation procedure however must involve the use of solvents which are not really environmentally compatible,
10 and it is also necessary to provide drying devices in order to dry the filter material after the washing operation.

Besides such wet separation procedures which are known for example from German laid-open applications (DE-OS) Nos 36 18 642 and 43 00 400, it is also already known to use air-permeable dry filters
15 which are discarded after they are clogged by the paint surplus. That is not only uneconomical but also prohibitive from the point of view of safeguarding the environment.

The object of the present invention is to provide an environmentally compatible apparatus which is inexpensive in operation
20 for the wet-paint spray painting of articles.

In accordance with the invention, in an apparatus of the general kind set forth in the opening part of this specification, that is achieved in that the dry filter is arranged movably and that there is provided a suction removal device which sucks away from the dry
25 filter the paint particles which have dried on during a given time.

The invention is based on the realization that there is no need in the wet-paint spray painting operation to wash out the paint surplus which is caught by the filter with liquid solvent in a wet separation procedure, but that on the contrary it is sufficient to
30 suck the paint surplus away from the dry filter after a given drying section, so that the dry filter does not have to be discarded. Suction removal of matter from filters has long been known in the case of powder coating installations. In such installations a powder is

applied electrostatically to the articles to be coated and the powder surplus is sucked away (see for example DE 28 13 854 C2). In contrast thereto the invention concerns a different general kind of subject-matter, namely wet-paint spray painting with liquid media. In that
5 wet-paint spray painting procedure, in contrast to mere powder, the paint surplus clings substantially more firmly to the filter surface and it was therefore hitherto considered that either a dry filter had to be discarded or it had to be washed out in an expensive wet process. Surprisingly however the applicants' tests have shown that,
10 even in the wet-paint spray painting of articles, the paint surplus can be sucked away from a dry filter without involving an expensive wet separation procedure.

In that respect it is particularly advantageous if the suction removal device is disposed at a location which is remote from
15 that region in which the dry filter receives the paint surplus because then the paint particles, even in the case of a continuously moved dry filter, have sufficient time to dry completely so that they can be easily sucked away.

Further advantages and details of the invention will be
20 described more fully with reference to the following specific description.

Figure 1 is a plan view of an embodiment of an apparatus according to the invention for the hand wet-paint spray painting of articles,

25 Figure 2a is a view in cross-section of an embodiment of a dry filter according to the invention,

Figure 2b shows an underview of the Figure 2a dry filter,

Figure 3 shows a direction-changing drum for the movable dry filter according to the invention,

30 Figure 4 is a front view of a further embodiment of a device according to the invention for catching the paint surplus,

Figure 5 shows an embodiment for spray painting of a motor vehicle, and

Figure 6 is a diagrammatic perspective view of an embodiment of a suction removal device with a suction nozzle which is movable transversely to the dry filter.

Figure 1 shows an apparatus for the wet-paint spray painting of articles 1 by means of a hand-operable spray gun 2 which for example has a container for liquid paint and which is connected to a compressed air line 3. In accordance with the invention, provided for catching the paint surplus which goes past the article 1 is an air-permeable dry filter 4 which is arranged movably over direction-changing drums 5. In addition, in accordance with the invention there is provided a suction removal device 6 whose suction intake opening 7 is disposed at a location which is as far removed as possible, in the direction of movement of the dry filter 4, from the region 8 in which the dry filter receives paint excess. Connected between the front run and the rear run of the endlessly circulating dry filter is an exhaust air passage 9 of an exhaust air installation which sucks air out of the exhaust air passage 9. The front side of the exhaust air passage 9 is of an air-permeable configuration or is perforated at the location 10 so that the exhaust air which passes through the dry filter 4 can pass into the exhaust air passage 9. When that happens the paint particles are caught by the dry filter 4 and are later removed by suction by the suction removal device 6. In that way it is possible for the dry filter 4 to be continuously cleaned. The dry filter can be continuously moved. However discontinuous movement is also possible, for example in a separate cleaning run in the evening.

The dry filter 4 is advantageously of a two-part configuration, namely comprising an air-permeable statically stable but nonetheless flexible carrier 4a and the actual dry filter material 4b. The filter material is preferably a fleece, desirably a polyester fleece or a glass fiber fleece, which is of a height of typically some centimeters. The carrier 4a can be provided with holes 11, as is

shown by the view from below in Figure 2b. Desirably the carrier comprises conveyor material, for example fiber-reinforced rubber. It is also possible for the carrier 4a to be formed from an air-permeable fabric (that is to say without discrete holes 11).

5 For the purposes of joining the carrier 4a to the actual filter material 4b, it is desirable for them to be glued together.

In order to permit a guidance effect for the circulating dry filter 4, two guide projections 12 are provided at the rear side of the dry filter 4 in the embodiment shown in Figures 2a and 2b. Those
10 guide projections 12 can then be guided in suitable guide grooves (not shown) in the direction-changing rollers 5 and then guide the circulating dry filter 4 in the transverse direction.

In the embodiment shown in Figure 3, for the purposes of guiding the circulating dry filter 4 and to provide for exact drive
15 thereof, it is provided that the carrier 4a has at least one row of holes 13 into which engage pins 14 arranged on the guide roller 5 which is in the form of a drive wheel. The drive wheel 5 is driven by an electric motor 15 disposed thereabove, possibly by way of a transmission (not shown). The electric motor 15 is controlled by a
20 control device 16.

In the embodiment shown in Figure 4 the dry filter 4 also circulates in the horizontal direction. Guidance in the vertical direction is effected by virtue of the fact that at the top the dry filter 4 has guide elements 17 which are guided in a stationary
25 horizontal guide rail 18 (similarly to a curtain rail). The guide rail 18 can be endlessly taken around the entire periphery above the dry filter. It is however also possible for the guide rail 18 to be disposed only in the front region and the rear region and for the vertical guidance effect in the region of the direction-changing
30 rollers 5 to be afforded by other means, for example by the pins 14 which engage into the rows of holes 13.

Figure 5 shows an apparatus for the spray painting of a motor vehicle 19. Here the dry filter 4 is oriented horizontally and runs beneath the spray cabin 20.

In the embodiment shown in Figure 6 the suction intake opening 7 of the suction removal device is moved transversely to the direction of movement 21 of the dry filter 4. This has the advantage that it is possible to use a small suction nozzle 6a with a high local suction capability in order to suck the dried paint particles away from the dry filter 4. The suction nozzle 6a is connected by way of a flexible hose 6b to the suction unit 6c of the suction removal device. The arrangement has two fixed guide rails 22 which guide the suction nozzle 6a. The movement of the suction nozzle 6a in the vertical direction in Figure 6 is preferably effected by way of a motor drive (not shown), for example by way of a cable pull drive, a spindle drive, a toothed rack drive or the like.

In general the extraction effect will be achieved just with the suction removal action. In cases of a special nature however it is also possible to arrange at the rear side (side of the carrier 4a) of the conveyor belt 4 a device 23 for mechanically knocking against the dry filter 4 in order to be able better to detach the paint particles therefrom. The device 23 can also serve to produce an air flow which is directed from the rear side of the dry filter 4 to the front side and which thus promotes the suction removal air movement.

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CLAIMS:

1. Apparatus for wet-paint spray painting of articles, having a device for catching the paint surplus, which has an air-permeable dry filter, characterised in that the dry filter (4) is arranged movably and that there is provided a suction removal device (6) which sucks away from the dry filter (4) the paint particles which have dried on during a given time.
5
2. Apparatus according to claim 1 characterised in that the dry filter (4) is drivable by way of a drive motor (15).
10
3. Apparatus according to claim 2, characterised in that the drive motor (15) is an electrical drive motor.
- 15 4. Apparatus according to any one of claims 1 through 3 characterised in that the dry filter (4) is in the form of an endlessly circulating filter surface which is guided over direction-changing rollers (5).
- 20 5. Apparatus according to any one of claims 1 through 4 characterised in that an exhaust air passage (9) connected to an exhaust air installation is arranged behind the side of the dry filter (4), which is remote from the article to be painted, and the dry filter (4) is moved when the exhaust air installation is switched on.
- 25 6. Apparatus according to any one of claims 1 through 5 characterised in that the dry filter (4) comprises an air-permeable flexible carrier (4a) and a filter material (4b) secured thereto.
- 30 7. Apparatus according to claim 6 characterised in that the filter material (4b) is a fleece.
8. Apparatus according to claim 7 characterised in that said fleece is made of polyester or glass fibers.

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9. Apparatus according to any one of claims 6 through 8 characterised in that the carrier (4a) is perforated.
- 5 10. Apparatus according to claim 9, characterised in that said carrier (4a) comprises conveyor belt material.
11. Apparatus according to any one of claims 6 through 8 characterised in that the carrier (4a) comprises air-permeable fabric.
- 10 12. Apparatus according to any one of claims 6 through 11 characterised in that the carrier (4a) and the filter material (4b) are glued together.
13. Apparatus according to any one of claims 1 through 12 characterised in that on its rear side the dry filter (4) has at least one guide projection (12).
- 15 14. Apparatus according to any one of claims 1 through 13 characterised in that the dry filter (4) has at least one row of holes into which a drive wheel (5) engages with pins (14).
- 20 15. Apparatus according to any one of claims 1 through 14 characterised in that the dry filter (4) is vertically oriented and is moved horizontally.
- 25 16. Apparatus according to claim 15 characterised in that at the top the dry filter (4) has guide elements (17) which are movably guided in a stationary horizontal guide rail.
- 30 17. Apparatus according to any one of claims 1 through 16 characterised in that the dry filter (4) is moving and at least one suction intake opening (7) of the suction removal device (6) is movable over the dry filter (4) transversely to the direction of movement (21) thereof.
18. Apparatus according to claim 17 characterised in that the suction intake opening(s) (7) is (are) provided on a suction nozzle (6a) which is guided movably on a fixed guide means (22).

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19. Apparatus according to claim 18, characterised in that the suction nozzle (6a) is moved by motor means.

20. Apparatus according to claim 18 or claim 19 characterised in that the suction removal device comprises a
5 suction unit (6c) and the suction nozzle is connected by way of a flexible hose (6b) to the suction unit (6c) of said removal device.

21. Apparatus according to any one of claims 1 through 20 characterised in that the dry filter (4) receives paint
10 surplus in a region (8) and the suction removal device (6) is arranged at a location which is remote from that region (8).

22. Apparatus according to claim 21 characterised in that the dry filter (4) moves in one direction and the
15 suction removal device (6) is arranged at a spacing, as measured in the direction of movement (21) of the dry filter (4), of at least 50% of the total length as measured in the direction of movement (21) of the dry filter (4), from that region (8) in which the dry filter (4) receives paint
20 surplus.

23. Apparatus according to claim 22, characterised in that the spacing is at least 70% of the total length of the dry filter (4).

24. Apparatus according to any one of claims 1 through 25 23 characterised by a device for mechanically knocking against the dry filter (4).

25. Apparatus according to claim 24 characterised in that said device knocks against the rear side of the dry filter (4).

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26. Apparatus according to any one of claims 1 through 25 characterised by a device for producing an air flow which is directed through the dry filter (4) from the rear side thereof to the front side thereof.

Fig. 1

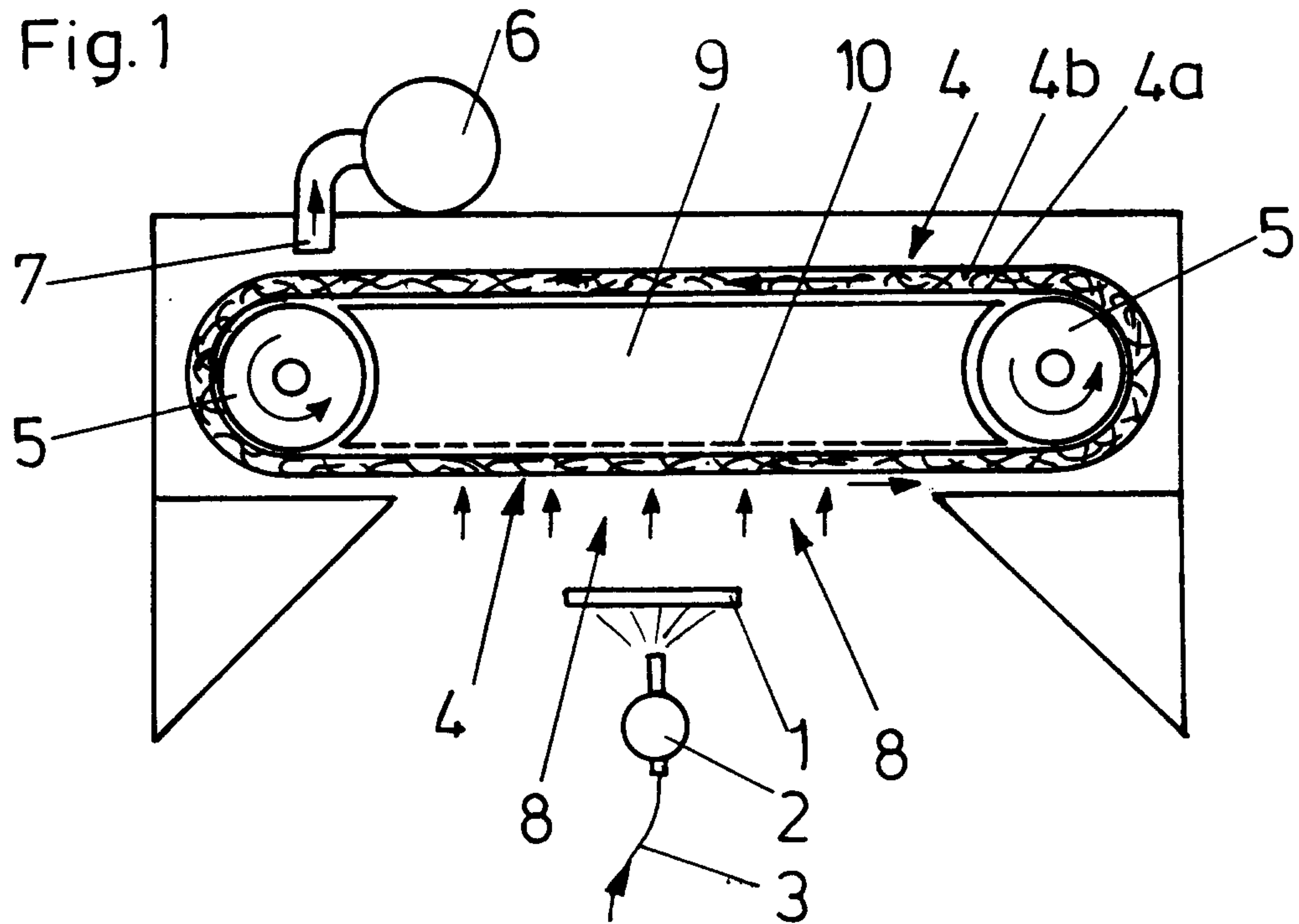


Fig. 2a

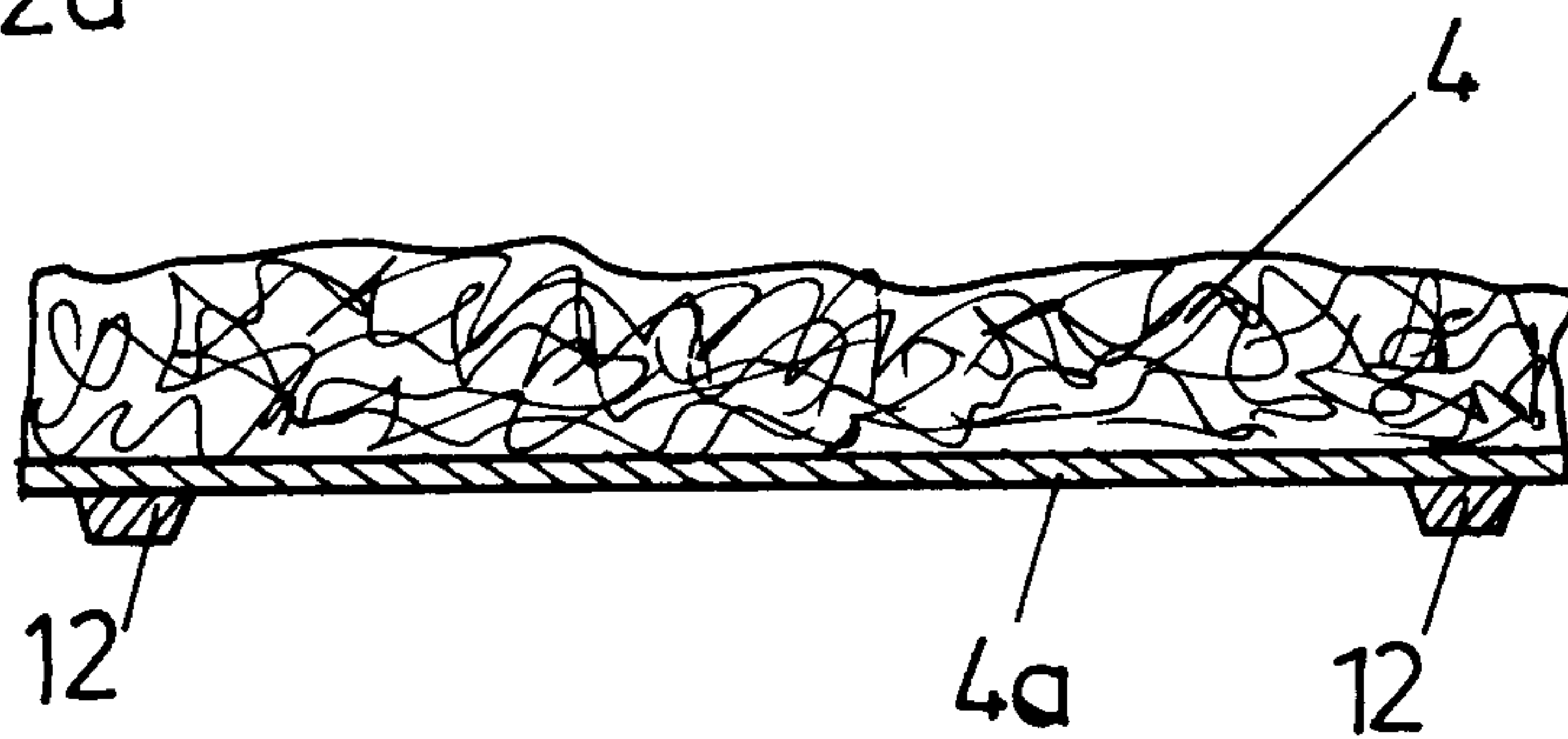


Fig. 2 b

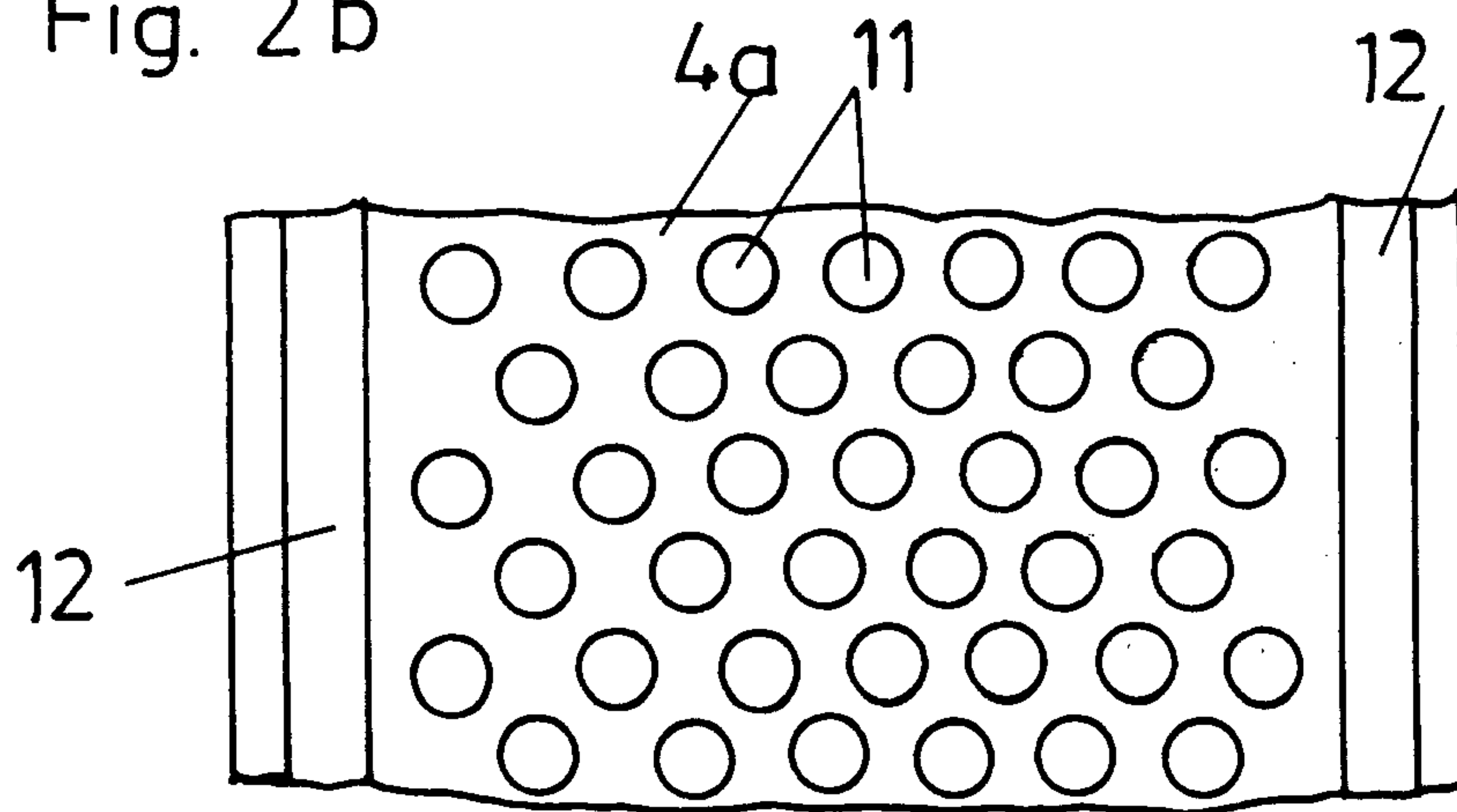


Fig. 3

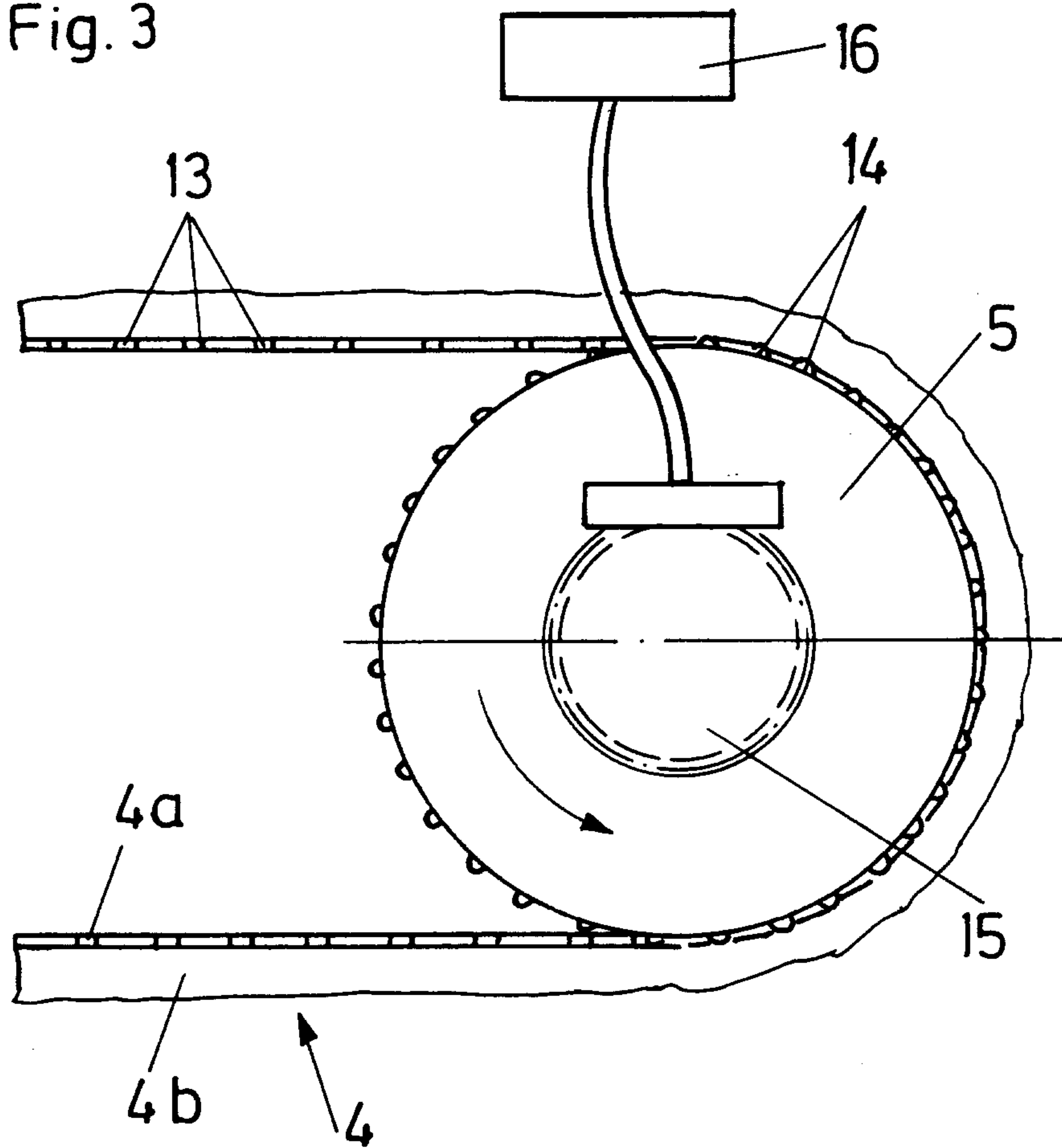


Fig. 4

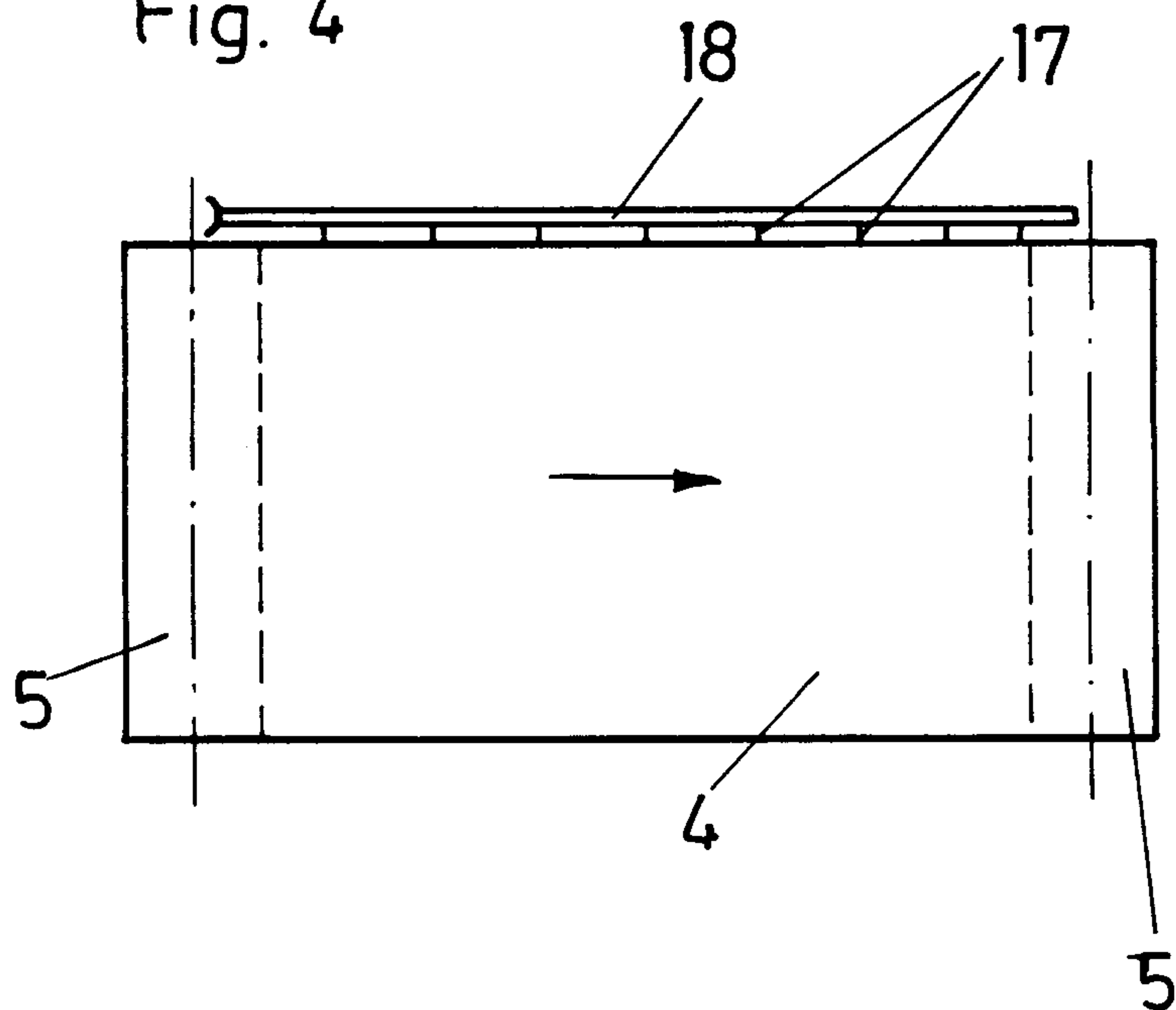


Fig.5

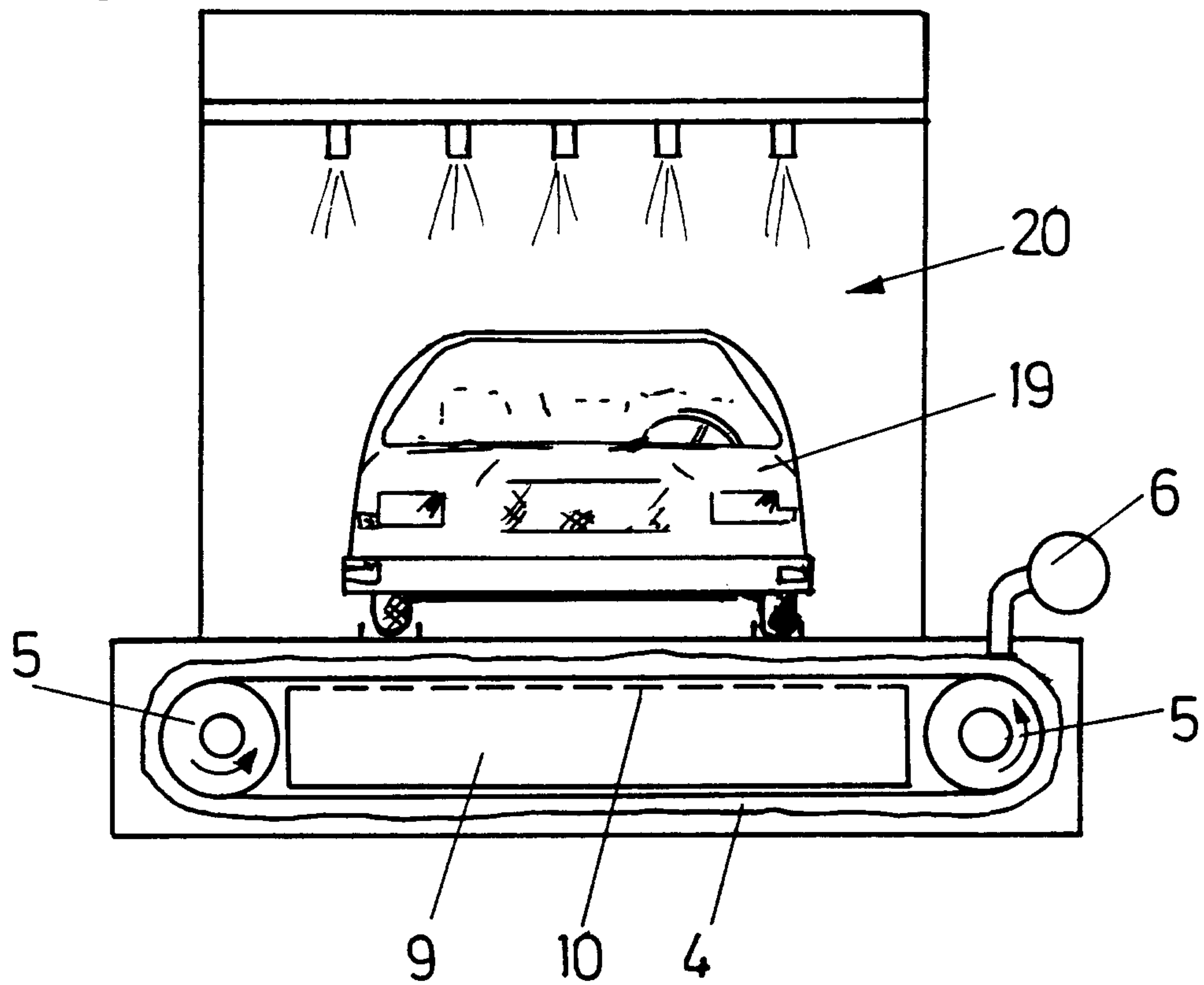


Fig.6

