

ABSTRACT

METHOD AND APPARATUS FOR PRODUCING
EXPANSION-MOLDED ARTICLE

Disclosed herein is a method for continuously producing an expansion-molded article, comprising feeding
5 foamed particles between a belt continuously traveling along the upper surface within a passageway defined by structural members and having a rectangular form in section and a belt continuously traveling along the lower surface within the passageway, and then causing the
10 foamed particles to successively pass through a super heated steam-feeding region and a cooling region within the passageway. The foamed particles used are foamed particles of a polyolefin resin, in which a recovery factor from compression defined by the equation (1):
15 Recovery factor from compression (%) = $V_2/V_1 \times 100$ (1)
wherein V_1 is the original bulk volume of the foamed particles, and V_2 is a bulk volume of the foamed particles measured upon elapsed time of 10 seconds after the foamed particles are compressed to a bulk volume of
20 60% on the original bulk volume, and the compressive force is then removed, is at least 80%. The foamed particles are transferred to the super heated steam-feeding region after the foamed particles are compressed on the upstream side of the super heated steam-feeding
25 region, and then released from a part or the whole of the compression. An apparatus for producing the expansion-molded article is also disclosed.

Figure : None