

[DESCRIPTION]

[Title of Invention]

FOREIGN MATTER REMOVING APPARATUS, GYPSUM-BASED
BUILDING BOARD MANUFACTURING APPARATUS, AND FOREIGN
5 MATTER REMOVING METHOD

[Technical Field]

[0001]

The present invention relates to a foreign
10 matter removing apparatus, a gypsum-based building
board manufacturing apparatus, and a foreign matter
removing method.

[Background Art]

15 [0002]

PTL 1 discloses a gypsum board sorting and
processing apparatus including: a crushing means
(pulverizing means) that roughly crushes (roughly
pulverizes) gypsum board; a primary sorting means
20 that separates the roughly crushed (roughly
pulverized) gypsum board into gypsum components and
crushed pieces (pulverized pieces) mixed with both
the gypsum components and the paper components; an
impact crusher that further finely pulverizes the
25 crushed pieces (pulverized pieces) mixed with both
the gypsum components and the paper components
obtained by the primary sorting means; a secondary
sorting means that separates a pulverized product
pulverized by the impact crusher into gypsum
30 components, paper components, and a pulverized
product mixed with both the gypsum components and
the paper components; and a wind-powered sorter that
separates the pulverized product mixed with both the

gypsum components and the paper components obtained in the secondary sorting process into gypsum components and paper components.

[0003]

5 PTL 1 further discloses providing a metal foreign matter removing means consisting of a magnetic pulley provided at least one end of an endless belt.

10 [Citation List]

[Patent Literature]

[0004]

[PTL 1] Japanese Laid-Open Patent Publication No. 2004-313896

15

[Summary of Invention]

[Technical Problem]

[0005]

20 A foreign matter removing apparatus has conventionally been studied for the purpose of removing foreign matter in raw materials or resources collected for the purpose of recycling or reuse.

[0006]

25 As described above, PTL 1 discloses a sorting and processing apparatus including a wind-powered sorter and a metal foreign matter removing means consisting of a magnetic pulley. However, according to the sorting and processing apparatus disclosed in
30 PTL 1, only very light foreign matter such as paper and foreign matter with magnetism can be removed. For this reason, in the gypsum board sorting and processing apparatus disclosed in PTL 1, non-

magnetic non-ferrous metals and foreign matter with high specific gravity such as pebbles could not be removed except for the foreign matter with magnetism.

5 [0007]

In view of the problems of the above conventional technology, one aspect of the present invention aims to provide a foreign matter removing apparatus capable of removing foreign matter with
10 high specific gravity.

[Solution to Problem]

[0008]

In order to solve the above problem, according
15 to one embodiment of the present invention, a foreign matter removing apparatus for removing foreign matter in a powder and granular material is provided. The foreign matter removing apparatus includes: a conveyance device configured to convey
20 the powder and granular material from a supply port to a discharge port that are for the powder and granular material; and a foreign matter sedimentation device that is provided between the supply port and the discharge port on a conveyance
25 path of the conveyance device, and is configured to sediment the foreign matter in the powder and granular material. The foreign matter sedimentation device includes both a foreign matter discharge port provided at a lowest position in a height direction
30 and a bottom inclined toward the foreign matter discharge port.

[Advantageous Effects of Invention]

[0009]

According to one embodiment of the present invention, it is possible to provide a foreign matter removing apparatus capable of removing
5 foreign matter with high specific gravity.

[Brief Description of Drawings]

[0010]

[FIG. 1] FIG. 1 is an explanatory diagram of a
10 foreign matter removing apparatus according to an aspect of the present disclosure.

[FIG. 2] FIG. 2 is an explanatory diagram of a modification example of a foreign matter removing apparatus according to an aspect of the present
15 disclosure.

[Description of Embodiments]

[0011]

In the following, embodiments of the present
20 invention will be described with reference to the drawings. However, the present invention is not limited to the following embodiments, and various modifications and substitutions can be added thereto without departing from the scope of the present
25 invention.

[Foreign Matter Removing Apparatus]

One exemplary configuration of the foreign matter removing apparatus according to the present embodiment will be described.

30 [0012]

The foreign matter removing apparatus according to the present embodiment is a foreign matter removing apparatus for removing foreign matter in a

powder and granular material, and includes a conveyance device and a foreign matter sedimentation device described below.

[0013]

5 The conveyance device can convey the powder and granular material from a supply port to a discharge port.

[0014]

10 The foreign matter sedimentation device is provided between the supply port and the discharge port on a conveyance path of the conveyance device, and can sediment foreign matter in the powder and granular material. The foreign matter sedimentation device can include a foreign matter discharge port
15 provided at the lowest position in the height direction and a bottom inclined toward the foreign matter discharge port.

[0015]

20 An exemplary configuration of the foreign matter removing apparatus according to the present embodiment will be described with reference to FIGS. 1 and 2. FIG. 1 is a side view of a foreign matter removing apparatus 10 according to the present embodiment, passing through a foreign matter
25 discharge port 131 of a foreign matter sedimentation device 13, and along a conveyance path of the powder and granular material. FIG. 2 is an explanatory diagram of a modification example of the foreign matter removing apparatus according to the present
30 embodiment, and is an explanatory diagram of when an air box and the like is provided as described later. Therefore, FIG. 2 will be used when necessary, and description will be made mainly using FIG. 1.

[0016]

In FIGS. 1 and 2, optional components that the foreign matter removing apparatus according to the present embodiment may include are also illustrated.

5 The foreign matter removing apparatus according to the present embodiment is not limited to such a configuration. In FIGS. 1 and 2, the powder and granular material to be processed is not illustrated.

10 [0017]

In FIGS. 1 and 2, the X-axis direction is the direction in which a conveyance device 12 conveys the powder and granular material, the Y-axis direction is the width direction of the conveyance device 12, and the Z-axis direction is the height direction.

[0018]

The components included in the foreign matter removing apparatus according to the present embodiment will be described below.

(1) Conveyance Device

20 The foreign matter removing apparatus 10 according to the present embodiment can include the conveyance device 12 that conveys the powder and granular material from a supply port 111 to a discharge port 112.

[0019]

30 The powder and granular material to be processed by the foreign matter removing apparatus 10 according to the present embodiment may include one or more kinds selected from a powder consisting of fine particles and a powder and granular material consisting of particles with a particle size larger

than the powder. That is, an aggregate of particles
can be used as the powder and granular materials
without being limited by the particle size, particle
size distribution, shape, and the like of the
5 constituting particles. Therefore, the powder and
granular material may also contain, for example, a
pulverized product of various building materials
such as gypsum board, particles of large particle
size such as ores, and particles of small particle
10 size that is a pulverized product of ores and the
like, and mixtures of these materials.
[0020]

According to the foreign matter removing
apparatus according to the present embodiment,
15 foreign matter with high specific gravity can be
removed. For example, foreign matter with relatively
high specific gravity, such as various metals and
pebbles, can be removed among the materials that
constitutes the powder and granular material to be
20 processed. The foreign matter to be removed may or
may not be magnetic. According to the foreign matter
removing apparatus according to the present
embodiment, non-magnetic foreign matter, such as
non-ferrous metals, for example, can also be
25 removed. The non-magnetic foreign matter means
foreign matter with weak or no magnetic attraction,
such as non-ferrous metals and pebbles.
[0021]

The foreign matter removing apparatus according
30 to the present embodiment can be applied to any
powder and granular material from which foreign
material with high specific gravity is required to
be removed. The term "capable of removing foreign

matter with high specific gravity" does not only mean that the foreign matter is completely removed, but also includes the case where a part of the foreign matter with relatively high specific gravity
5 contained in the powder and granular material is removed and its content is reduced.

[0022]

The types of the powder and granular material are not particularly limited. Gypsum is a natural
10 resource, and in recent years, it is often used as a gypsum board or the like and then recovered and reused. In the case of either natural resource gypsum or recycled gypsum, foreign matter with high specific gravity is often contained, and it has been
15 desired to remove such foreign matter with high specific gravity. Therefore, it is preferable that the powder and granular material contains gypsum, and it is more preferable that the powder and granular material is gypsum. When the powder and
20 granular material contains gypsum, the type of the gypsum is not particularly limited, but one or more types selected from, for example, dihydrate gypsum, calcined gypsum (hemihydrate gypsum), and anhydrous gypsum may be used. It is often desired to reduce or
25 remove the foreign matter from calcined gypsum because calcined gypsum is used as a raw material for gypsum boards and the like and has better fluidity than dihydrate gypsum or anhydrous gypsum. Therefore, when the powder and granular material
30 contains gypsum, the gypsum preferably contains calcined gypsum. Calcined gypsum is also called calcium sulfate hemihydrate, and is an inorganic compound with hydraulic properties.

[0023]

The conveyance device 12 may be any device that, when passing through the foreign matter sedimentation device 13 described later, temporarily
5 supplies the powder and granular material, which is conveyed, into the foreign matter sedimentation device 13, collects the powder and granular material after the sedimentation process in the vicinity of the upper end of the foreign matter sedimentation
10 device 13, conveys the material, and discharges the material to the discharge port 112. Therefore, as the conveyance device 12, a chain conveyor or a screw conveyor may be used, for example.

[0024]

15 In FIG. 1, a casing of the conveyance device 12 is illustrated, and a specific conveyance means is not illustrated.

[0025]

FIG. 1 illustrates an example in which the
20 conveyance device 12 is arranged horizontally, that is, in parallel with the X-axis, but it is not limited to such a configuration and it may be inclined. That is, an angle may be formed with a horizontal plane P illustrated in FIG. 1. The angle
25 with the horizontal plane P is preferably less than 90 degrees, and more preferably 60 degrees or less. The horizontal plane P is a plane parallel to the X-axis in FIG. 1.

[0026]

30 The conveyance device 12 is preferably arranged so that the powder and granular material containing the foreign matter pass through a separation tank 133 of the foreign matter sedimentation device 13,

especially through the upper end of the separation tank 133.

[0027]

The conveyance device 12 may be arranged so
5 that the powder and granular material pass through
the separation tank 133 as described above.
Accordingly, when the powder and granular material
containing the foreign matter, which is conveyed by
the conveyance device 12, passes above the foreign
10 matter sedimentation device 13, the powder and
granular material temporarily falls into the
separation tank 133 in the vicinity of an inlet 13A
of the foreign matter sedimentation device 13, and
is supplied to the separation tank 133. At this
15 time, the foreign matter is collected in the
vicinity of the foreign matter discharge port 131
due to its higher specific gravity than that of the
powder and granular material and the inclined bottom
of the separation tank 133. Therefore, the powder
20 and granular material with reduced foreign matter
content is placed above the separation tank 133,
especially in the vicinity of an outlet 13B.

[0028]

The conveyance device 12 conveys the powder and
25 granular material containing the foreign matter and
causes the powder and granular material to
temporarily fall into the separation tank 133 of the
foreign matter sedimentation device 13. The
conveyance device 12 then collects the powder and
30 granular material in the vicinity of the outlet 13B
of the foreign matter sedimentation device 13 and
conveys it to the discharge port 112. The conveyance
device 12 can collect and convey the powder and

granular material with reduced foreign matter content after the sedimentation process because the powder and granular material with reduced foreign matter content by the sedimentation process is placed in the vicinity of the outlet 13B of the separation tank 133 as described above.

(2) Foreign Matter Sedimentation Device

The foreign matter removing apparatus 10 according to the present embodiment can include the foreign matter sedimentation device 13. The foreign matter sedimentation device 13 can be provided between the supply port 111 and the discharge port 112 on the conveyance path of the conveyance device 12.

(2-1) Configuration of Foreign Matter Sedimentation Device

(2-1-1) Foreign Matter Discharge Port and Bottom

The foreign matter sedimentation device 13 can include the foreign matter discharge port 131 provided at the lowest position in the height direction. The foreign matter sedimentation device 13 can include bottoms 132A and 132B inclined toward the foreign matter discharge port 131. The height direction is the Z-axis direction in FIG. 1.

[0029]

As illustrated in FIG. 1, the foreign matter discharge port 131 can be provided to be the lowest part in the foreign matter sedimentation device 13 and can include the bottoms 132A and 132B inclined toward the foreign matter discharge port 131. The space surrounded by the foreign matter discharge port 131 and the bottoms 132A and 132B is the separation tank 133 for sedimenting the foreign

matter in the powder and granular material.

[0030]

The shape of the separation tank 133 is not particularly limited, but as illustrated in FIG. 1, for example, the cross-sectional shape along the height direction can have a funnel shape, due to the trapezoidal portion surrounded by the bottoms 132A and 132B and the square portion of the piping of the foreign matter discharge port 131. The separation tank 133 may also include additional sidewalls along the Z-axis above the bottoms 132A and 132B to increase the volume in the separation tank 133 sufficiently. When the sidewalls are provided, it is preferable that they have a shape and size that do not interfere with the conveyance of the powder and granular material by the conveyance device 12.

[0031]

The shape of the separation tank 133 when viewed from the top, that is, the shape of the top when viewed along an arrow A in FIG. 1, is not particularly limited, but may be, for example, a polygonal shape such as a square, or a circular shape such as a circle or an ellipse.

[0032]

The inclination angles of the bottoms 132A and 132B, for example, the angles θ_{132A} and θ_{132B} formed between the bottoms and the horizontal plane P passing through the foreign matter discharge port 131 illustrated in the figure, are not particularly limited, but are preferably 5 degrees or more and less than 90 degrees, for example, and more preferably 7 degrees or more and 60 degrees or less. By setting the inclination angles of the bottoms

132A and 132B to 5 degrees or more and less than 90 degrees, the fluidity of the powder and granular material in the separation tank 133 can be enhanced. [0033]

5 The angle θ_{132A} , which is the inclination angle of the bottom 132A, and the angle θ_{132B} , which is the inclination angle of the bottom 132B, may be the same or different. In FIG. 1, the bottoms 132A and 132B are illustrated as surfaces with uniform
10 inclination angles as an example, but it is not limited to this configuration. The inclination angle may change on the way to the foreign matter discharge port 131. That is, the bottoms 132A and 132B may be formed of a plurality of surfaces with
15 different inclination angles. [0034]

 The foreign matter discharge port 131 can be provided at the lowest position in the height direction as described above. By providing the
20 foreign matter discharge port 131 at the lowest position in the height direction and fluidizing the powder and granular material in the separation tank 133, the foreign matter with high specific gravity is separated due to the difference in specific
25 gravity, gathers in the foreign matter discharge port 131, and can be separated from the powder and granular material. The foreign matter discharge port 131 is sufficient as long as it is an opening for discharging the separated foreign matter, but it can
30 also be configured as an area with a certain thickness, for example, a cylindrical pipe or the like, so that the separated foreign matter can be stored.

[0035]

The position of the foreign matter discharge port 131 in the foreign matter sedimentation device 13 in the horizontal direction is not particularly limited, but it can be provided, for example, between one end of the foreign matter sedimentation device 13, the inlet 13A, and the other end, the outlet 13B, along the conveyance path of the powder and granular material. The foreign matter discharge port 131 is preferably provided so as to extend over a central position between the inlet 13A and the outlet 13B, especially.

[0036]

The powder and granular material containing the foreign matter is continuously supplied to the foreign matter sedimentation device 13 by the conveyance device 12. In the foreign matter sedimentation device 13, the bottoms 132A and 132B are inclined as described above. Therefore, the powder and granular material containing the foreign matter supplied to the foreign matter sedimentation device 13 fluidizes in the separation tank 133 of the foreign matter sedimentation device 13, and the foreign matter with high specific gravity different from that of the powder and granular material settles down into the foreign matter discharge port 131, thereby enabling separation of the powder and granular material and the foreign matter. In the foreign matter removing apparatus 10 according to the present embodiment, the foreign matter and the powder and granular material are separated by the difference in specific gravity, so even when the foreign matter is non-magnetic, it can be separated

and removed.

[0037]

The foreign matter sedimentation device 13 may also include a foreign matter discharge device or a fluidity imparting device, as needed, as described below.

(2-1-2) Foreign Matter Discharge Device

The foreign matter discharge port 131 of the foreign matter sedimentation device 13 is formed as an opening so that the separated foreign matter can be discharged to the outside of the foreign matter sedimentation device 13, and the foreign matter can be removed from the powder and granular material. Because part of the powder and granular material is also discharged from the foreign matter discharge port 131 together with the foreign matter, it is preferable to operate the foreign matter sedimentation device 13 for a certain period of time, and to discharge the foreign matter from the foreign matter discharge port 131 at the timing when the foreign matter gathers in the vicinity of the foreign matter discharge port 131.

[0038]

Therefore, it is preferable that the foreign matter sedimentation device 13 includes a foreign matter discharge device 134 for discharging the foreign matter. The foreign matter discharge device 134 can be provided at the foreign matter discharge port 131.

[0039]

The specific configuration of the foreign matter discharge device 134 is not particularly limited as long as it is a device that can discharge

the foreign matter from the foreign matter sedimentation device 13 at the timing of discharging the foreign matter. As the foreign matter discharge device 134, an opening/closing valve that
5 opens/closes the foreign matter discharge port 131 or a device that can forcibly discharge the foreign matter gathered in the vicinity of the foreign matter discharge port 131, can be used. As the foreign matter discharge device 134, for example,
10 one or more devices selected from dampers, rotary feeders, screw conveyors, rotary valves, or the like, can be used. The foreign matter discharge device 134 is provided at the foreign matter discharge port 131 as described above, and can
15 constitute a part of the foreign matter discharge port 131.

[0040]

As described above, it is preferable to discharge the foreign matter from the foreign matter
20 discharge port 131 at the timing when the foreign matter gathers in the vicinity of the foreign matter discharge port 131. Therefore, it is preferable that the foreign matter discharge device 134 is operated intermittently. For example, an operator may operate
25 the device at any given timing, or a control device (not illustrated) may be connected to the foreign matter discharge device 134 to operate at a predetermined or any given timing by the control device.

30 (2-1-3) Fluidity Imparting Device

As described above, the foreign matter sedimentation device 13 includes the bottoms 132A and 132B that are inclined, so that the powder and

granular material containing the foreign matter
supplied to the foreign matter sedimentation device
13 fluidizes. In order to enhance the fluidity of
the supplied powder and granular material, the
5 foreign matter sedimentation device 13 may also
include a fluidity imparting device 135 for
fluidizing the powder and granular material supplied
into the foreign matter sedimentation device 13.

[0041]

10 The fluidity imparting device 135 is not
particularly limited as long as it is a device
capable of imparting fluidity to the powder and
granular material supplied to the separation tank
133, but one or more devices selected from an air
15 slider, vibrator, and the like, can be used
suitably.

[0042]

The air slider is a device for blowing a gas
such as air into the separation tank 133 to give
20 fluidity to the powder and granular material. The
vibrator is a device for giving vibration to the
powder and granular material in the separation tank
133.

[0043]

25 When the air slider is used as the fluidity
imparting device, it is preferable to provide the
bottoms 132A and 132B with a gas permeating part
such as a fabric, a ceramic, or a metal porous body
that allows gas such as air to pass through without
30 the powder and granular material flowing out to the
outside. It is preferable that a gas such as air is
supplied through the gas permeating part by one or
more gas supply devices selected from a blower, a

fan, a compressor, and the like. In order to efficiently supply gas to the bottoms 132A and 132B, for example, as illustrated in FIG. 2, the outer surfaces of the bottoms 132A and 132B may be covered
5 with an iron plate or the like, and air boxes 21A and 21B, which are spaces formed with the bottoms 132A and 132B, may be provided. A gas supply device 22 may be connected to the air boxes 21A and 21B via pipes 23A and 23B. It is preferable to supply gas
10 from the gas supply device 22 into the air boxes 21A and 21B via the pipes 23A and 23B, which enables pressure to be applied uniformly to the bottoms 132A and 132B.

[0044]

15 The fluidity imparting device 135 may be provided at any location and its form is not limited, but it is preferable to provide the fluidity imparting device 135 on the bottoms 132A and 132B, as in the example illustrated in FIG. 1.
20 When the fluidity imparting device 135 is used, an air slider and a vibrator may be used together.

(2-2) Arrangement of Foreign Matter Sedimentation Device

As described above, the foreign matter
25 sedimentation device 13 may be provided on the conveyance path of the conveyance device 12 between the supply port 111 and the discharge port 112, that is, in the area of a length L of the conveyance path illustrated in FIG. 1. It is preferable that the
30 foreign matter sedimentation device 13 is not provided in the immediate vicinity of the discharge port 112, and that it is provided in the area on the conveyance path that does not overlap the area for

discharging the powder and granular material to the discharge port 112.

[0045]

5 The foreign matter sedimentation device 13 may be provided to include the area that overlaps the area for supplying the powder and granular material from the supply port 111, provided that it has a sufficient length to sediment and remove the foreign matter.

10 [0046]

By providing the foreign matter sedimentation device 13 in the area described above, the degree of freedom of where the foreign matter sedimentation device 13 is installed and the size of the foreign matter sedimentation device 13 is increased.

15 Therefore, for example, the size of the foreign matter sedimentation device 13 may be selected according to the degree of removal of the foreign matter required. The longer the length L13 of the foreign matter sedimentation device 13 along the conveyance direction of the powder and granular material, the more the powder and granular material fluidizes properly in the foreign matter sedimentation device 13 and the higher the removing efficiency of the foreign matter, although this depends on the conveyance amount and the conveyance speed of the powder and granular material.

25 [0047]

For example, the length L13 of the foreign matter sedimentation device 13 is preferably shorter than the length L of the conveyance path of the conveyance device 12 and 1.5 times or more and 10 times or less the width of the conveyance path of

the conveyance device 12, and more preferably 3 times or more and 7 times or less the width of the conveyance path of the conveyance device 12. The width of the conveyance path of the conveyance
5 device 12 means the width of the conveyance path in the direction perpendicular to the plane of FIG. 1, that is, in the Y-axis direction. For example, it can be the width of the area enclosed by the casing of the conveyance device.

10 [0048]

A plurality, that is, two or more of the foreign matter sedimentation devices 13 may be provided on the conveyance path. When a plurality of the foreign matter sedimentation devices 13 are
15 provided on the conveyance path, the total length of the length L13 of each foreign matter sedimentation device can be shorter than the length L of the conveyance path of the conveyance device 12. It is preferable that each foreign matter sedimentation
20 device is not provided in the immediate vicinity of the discharge port 112, and that it is provided in the area on the conveyance path that does not overlap the area for discharging the powder and granular material to the discharge port 112.

25 (3) Foreign Matter Separation Device and Circulation Device

As described above, part of the powder and granular material is also discharged from the foreign matter discharge port 131 together with the
30 separated foreign matter. By further removing the foreign matter from the powder and granular material and collecting the powder and granular material, it is possible to reduce the amount of the powder and

granular material disposed together with the foreign matter.

[0049]

For this reason, the foreign matter removing apparatus 10 according to the present embodiment may further include a foreign matter separation device 14 for separating the foreign matter from the powder and granular material that is discharged from the foreign matter discharge port 131 and contains the foreign matter.

[0050]

The foreign matter separation device 14 may be any device that can separate the foreign matter from the powder and granular material that is discharged from the foreign matter discharge port 131 and contains the foreign matter. For example, one or more devices selected from a sieve such as a vibrating sieve, a rotary sorter also called a trommel, or the like may be used. In FIG. 1, an example using one foreign matter separation device 14 is illustrated, but a plurality of foreign matter separation devices 14 may also be provided in series along the conveyance direction of the powder and granular material.

[0051]

When the foreign matter separation device 14 is separated from the foreign matter discharge port 131, the foreign matter removing apparatus 10 may also include a foreign matter separation conveyance device 152 to convey the powder and granular material containing the discharged foreign matter from the foreign matter discharge port 131 to the foreign matter separation device 14 as illustrated

in FIG. 1, for example. The foreign matter separation conveyance device 152 may be any device that can convey the powder and granular material. The foreign matter separation conveyance device 152
5 may be one or more devices selected from devices that can convey the powder and granular material, such as screw conveyors, chain conveyors, belt conveyors, and the like, for example.

[0052]

10 The powder and granular material after the foreign matter being separated by the foreign matter separation device 14 and being collected may be returned to the hopper or the like of the raw material, or may be returned to the conveyance path
15 of the powder and granular material. In this case, the foreign matter removing apparatus 10 according to the present embodiment may also include a circulation device 151 that returns the powder and granular material from which the foreign matter is
20 separated by the foreign matter separation device 14 back onto the conveyance path of the conveyance device 12, as illustrated in FIG. 1, for example.

[0053]

 The circulation device 151 may be any device
25 that can convey the powder and granular material between the foreign matter separation device 14 and the conveyance device 12. For example, when the foreign matter separation device 14 is provided above the conveyance device 12 as illustrated in
30 FIG. 1, the circulation device 151 may be a simple pipe because the powder and granular material can be returned to the conveyance path by free fall. When the foreign matter separation device 14 is separated

from the conveyance device 12, the circulation
device 151 may be one or more devices selected from
devices that can convey the powder and granular
material, such as screw conveyors, chain conveyors,
5 belt conveyors, and the like.
[0054]

According to the foreign matter removing
apparatus according to the present embodiment
described above, the non-magnetic foreign matter
10 contained in the powder and granular material can be
easily removed by providing the foreign matter
sedimentation device described above on the
conveyance path of the conveyance device.
[Gypsum-Based Building Board Manufacturing
15 Apparatus]

In the gypsum-based building board
manufacturing apparatus according to the present
embodiment, the foreign matter removing apparatus
described above can be provided on a conveyance path
20 for a raw material that contains gypsum.
[0055]

Specifically, for example, the foreign matter
removing apparatus described above may be provided
on the conveyance path for the raw material
25 containing gypsum, such as calcined gypsum.
Accordingly, the foreign matter in the raw material
can be reduced and removed.
[0056]

The conveyance path of the raw material
30 containing gypsum, such as calcined gypsum, includes
at least one of the following: a conveyance path of
raw gypsum (dihydrate gypsum) from a pulverizing
device to a calcining device; a conveyance path of

calcined gypsum from the calcining device to a storage silo or the like; a conveyance path of the calcined gypsum from the storage silo to the a weighing device; a subsequent conveyance path of the calcined gypsum from the weighing device to a slurry conditioning mixer; and the like, for example.

[0057]

Other than the above points, the apparatus can be configured in the same manner as a common gypsum-based building board manufacturing apparatus, so the explanation is omitted here.

[0058]

The type of the gypsum-based building board manufactured by the gypsum-based building board manufacturing apparatus according to the present embodiment is not particularly limited, but examples include a glass mat gypsum board, a gypsum-containing plate with glass fiber nonwoven fabric, a gypsum board specified in JIS A 6901(2014), a gypsum board that is lighter or heavier than the gypsum board specified in JIS A 6901(2014), a slag plasterboard, and the like. Hereinafter, gypsum boards specified in JIS described above and gypsum boards that are lighter or heavier than that specified in JIS are collectively called "gypsum board".

[Foreign Matter Removing Method]

Next, an exemplary configuration of the foreign matter removing method in the present embodiment will be described. The foreign matter removing method according to the present embodiment may be performed using the foreign matter removing apparatus described above. Therefore, the

explanation of the matters already described will be omitted.

[0059]

5 The foreign matter removing method according to the present embodiment is a method of removing the foreign matter in the powder and granular material, and may include a foreign matter removing process of removing the foreign matter in the powder and granular material by using the foreign matter removing apparatus described above.

[0060]

Specifically, the foreign matter removing method according to the present embodiment is, for example, a foreign matter removing method of removing the foreign matter in the powder and granular material, and the foreign matter removing process may include, for example, a conveyance process and a foreign matter sedimentation process as described below.

20 [0061]

In the conveyance process, the powder and granular material may be conveyed by the conveyance device from the supply port to the discharge port of the powder and granular material.

25 [0062]

In the foreign matter sedimentation process, the foreign matter in the powder and granular material may settle down in the course of the conveyance process.

30 [0063]

In the foreign matter sedimentation process, the foreign matter in the powder and granular material may be sedimented by using the foreign

matter sedimentation device including the foreign matter discharge port provided at the lowest position in the height direction and the bottom inclined toward the foreign matter discharge port.

5 (1) Conveyance Process

In the conveyance process, the conveyance device 12 may be used to convey the powder and granular material from the supply port 111 to the discharge port 112 of the powder and granular material. Because the conveyance device 12 has already been described, its description is omitted here.

[0064]

The powder and granular material to be conveyed in the conveyance process has already been described. As described above, it is preferable that the powder and granular material contains gypsum, and it is more preferable that the powder and granular material is gypsum. When the powder and granular material contains gypsum, the gypsum preferably contains calcined gypsum.

20 (2) Foreign Matter Sedimentation Process

The foreign matter sedimentation process may be performed in the course of the conveyance process, and the foreign matter in the powder and granular material may be sedimented by using the foreign matter sedimentation device.

[0065]

As described using FIG. 1, the foreign matter sedimentation device 13 includes the foreign matter discharge port 131 and the bottoms 132A and 132B inclined toward the foreign matter discharge port 131. The space surrounded by the foreign matter

discharge port 131 and the bottoms 132A and 132B is the separation tank 133 for sedimenting the foreign matter in the powder and granular material.

[0066]

5 By performing the conveyance process, the powder and granular material containing the foreign matter is continuously supplied to the foreign matter sedimentation device 13. In the foreign matter sedimentation device 13, the bottoms 132A and
10 132B are inclined as described above. Therefore, in the foreign matter sedimentation process, the powder and granular material containing the foreign matter supplied to the foreign matter sedimentation device 13 fluidizes in the separation tank 133 of the
15 foreign matter sedimentation device 13, and the foreign matter with high specific gravity settles down into the foreign matter discharge port 131, thereby enabling separation of the powder and granular material and the foreign matter.

20 <Foreign Matter Discharge Device>

 The foreign matter sedimentation device 13 may also include a foreign matter discharge device 134 for discharging the foreign matter. The foreign matter discharge device 134 can be provided at the
25 foreign matter discharge port 131.

[0067]

 As described above, it is preferable to discharge the foreign matter from the foreign matter discharge port 131 at the timing when the foreign
30 matter gathers in the vicinity of the foreign matter discharge port 131. Therefore, it is preferable that the foreign matter discharge device 134 is operated intermittently. For example, an operator may operate

the device at any given timing, or a control device
(not illustrated) may be connected to the foreign
matter discharge device 134 to operate at a
predetermined or any given timing by the control
5 device.

<Fluidity Imparting Device>

As described above, the foreign matter
sedimentation device 13 includes the bottoms 132A
and 132B that are inclined, so that the powder and
10 granular material containing the foreign matter
supplied to the foreign matter sedimentation device
13 fluidizes. In order to enhance the fluidity of
the supplied powder and granular material, the
foreign matter sedimentation device 13 may also
15 include a fluidity imparting device 135 for
fluidizing the powder and granular material supplied
into the foreign matter sedimentation device 13.

[0068]

Because the fluidity imparting device has
20 already been described, its description is omitted
here.

[0069]

It is preferable that the fluidity imparting
device is operated continuously during the foreign
25 matter sedimentation process for imparting fluidity
to the powder and granular material, but the
fluidity imparting device may be operated
intermittently at any time.

[0070]

30 After the foreign matter sedimentation process,
the powder and granular material in which the
foreign matter is reduced and removed may be
conveyed again by the conveyance device and

discharged from the discharge port.

(3) Foreign Matter Separation Process and Circulation Process

As described above, part of the powder and granular material is also discharged from the foreign matter discharge port 131 together with the separated foreign matter. By further removing the foreign matter from the powder and granular material and collecting the powder and granular material, it is possible to reduce the amount of the powder and granular material disposed together with the foreign matter.

[0071]

For this reason, the foreign matter removing method according to the present embodiment may further include a foreign matter separation process for separating the foreign matter from the powder and granular material that is discharged from the foreign matter discharge port 131 and contains the foreign matter, by using the foreign matter separation device.

[0072]

In the foreign matter separation process, the powder and granular material after the foreign matter being separated by the foreign matter separation device 14 and being collected may be returned to the hopper or the like of the raw material. The powder and granular material after the foreign matter being separated by the foreign matter separation device 14 may be returned to the conveyance path of the conveyance device 12, as illustrated in FIG. 1, for example.

[0073]

That is, the foreign matter removing method according to the present embodiment may also include a circulation process in which the powder and granular material separated by the foreign matter separation device in the foreign matter separation process is returned to the conveyance path of the conveyance device by the circulation device. By performing the circulation process, the powder and granular material can be quickly returned to the conveyance path, and the speed of the foreign matter processing can be increased.

[0074]

Because the foreign matter separation device and the circulation device have already been described, their description is omitted here.

[0075]

According to the foreign matter removing method according to the present embodiment described above, the foreign matter contained in the powder and granular material with high specific gravity can be easily removed by performing the foreign matter sedimentation process in the course of the conveyance process.

[Example]

[0076]

Hereinafter, specific examples are given, but the present invention is not limited to these examples.

[Example 1]

The foreign matter removing apparatus 10 illustrated in FIG. 1 was used to remove the foreign matter with high specific gravity contained in

calcined gypsum.

[0077]

As illustrated in FIG. 1, the foreign matter removing apparatus 10 includes the conveyance device 12 and the foreign matter sedimentation device 13.

[0078]

The conveyance device 12 is configured to convey the calcined gypsum, which is the powder and granular material, from the supply port 111 to the discharge port 112 of the powder and granular material. As the conveyance device 12, a chain conveyor was used and arranged along the X-axis in FIG. 1, that is, horizontally.

[0079]

The foreign matter sedimentation device 13 is provided between the supply port 111 and the discharge port 112 on the conveyance path of the conveyance device 12, and includes the foreign matter discharge port 131 provided at the lowest position in the height direction and the bottoms 132A and 132B inclined toward the foreign matter discharge port 131. The angles θ_{132A} and θ_{132B} , which are the inclined angles of the bottoms 132A and 132B, were both set to 10 degrees.

[0080]

The length L13 of the foreign matter sedimentation device 13 was set to 1,250 mm, which is about 5 times the width of the conveyance device 12.

[0081]

Furthermore, an air slider, which is the fluidity imparting device 135, was provided on the bottoms 132A and 132B of the foreign matter

sedimentation device 13. Air was continuously supplied to the foreign matter sedimentation device while the powder and granular material was supplied, for imparting fluidity.

5 [0082]

The air slider is provided with a gas permeating part, not illustrated, provided on the bottoms 132A and 132B of the foreign matter sedimentation device 13. The air boxes 21A and 21B
10 illustrated in FIG. 2 are provided. The gas supply device 22 is connected to the air boxes 21A and 21B via the pipes 23A and 23B. Thus, the air supplied from the gas supply device 22 to the air boxes 21A and 21B is supplied into the separation tank 133 via
15 the gas permeating part.

[0083]

The foreign matter discharge port 131 is provided so as to extend over a central position between the inlet 13A, one end of the foreign matter
20 sedimentation device 13, and the outlet 13B, the other end, along the conveyance path of the powder and granular material. A screw conveyor, which is the foreign matter discharge device 134, is provided at the foreign matter discharge port 131, for
25 discharging the foreign matter from the foreign matter discharge port 131.

[0084]

The powder and granular material that is discharged from the foreign matter discharge port
30 131 and contains the foreign matter was subjected to a vibrating sieve, which is the foreign matter separation device 14. The powder and granular material from which the foreign matter were removed

were returned to the conveyance path by the circulation device 151.

[0085]

As a result of the removal of the foreign matter with high specific gravity contained in the calcined gypsum using the foreign matter removing apparatus described above, the foreign matter remaining on the vibrating sieve was ferrous metals, non-ferrous metals, pebbles, and the like.

10 [0086]

When approximately 500 tons of the calcined gypsum was conveyed using the chain conveyor of the conveyance device 12, the amount of the foreign matter remained on the vibrating sieve was approximately 500 kg, and most of the foreign matter with high specific gravity could be separated and removed.

[0087]

As described above, the foreign matter removing apparatus, the gypsum-based building board manufacturing apparatus, and the foreign matter removing method have been described in terms of the embodiment, and the like, but the present invention is not limited to the above embodiment, and the like. Various modifications and changes are possible within the scope of the subject matter of the invention described in the claims.

[0088]

The present international application claims priority to Japanese Patent Application No. 2021-081546, filed May 13, 2021, and the contents of Japanese Patent Application No. 2021-081546 are incorporated in the present international

application by reference in their entirety.

[Description of the Reference Numeral]

[0089]

5	10	foreign matter removing apparatus
	111	supply port
	112	discharge port
	12	conveyance device
	13	foreign matter sedimentation device
10	131	foreign matter discharge port
	132A, 132B	bottom
	134	foreign matter discharge device
	135	fluidity imparting device
	14	foreign matter separation device
15	151	circulation device

[CLAIMS]

[Claim 1]

A foreign matter removing apparatus for removing foreign matter in a powder and granular material, the foreign matter removing apparatus comprising:

a conveyance device configured to convey the powder and granular material from a supply port to a discharge port that are for the powder and granular material; and

a foreign matter sedimentation device that is provided between the supply port and the discharge port on a conveyance path of the conveyance device, and is configured to sediment the foreign matter in the powder and granular material,

wherein the foreign matter sedimentation device includes both a foreign matter discharge port provided at a lowest position in a height direction and a bottom inclined toward the foreign matter discharge port.

[Claim 2]

The foreign matter removing apparatus according to claim 1, wherein the foreign matter sedimentation device includes a fluidity imparting device configured to fluidize the powder and granular material supplied into the foreign matter sedimentation device.

[Claim 3]

The foreign matter removing apparatus according to claim 1 or 2,

wherein the foreign matter sedimentation device

includes a foreign matter discharge device
configured to discharge the foreign matter, and
wherein the foreign matter discharge device is
provided at the foreign matter discharge port.

5

[Claim 4]

The foreign matter removing apparatus according
to claim 3, further comprising a foreign matter
separation device configured to separate the foreign
10 matter from the powder and granular material that is
discharged from the foreign matter discharge port
and contains the foreign matter.

[Claim 5]

15 The foreign matter removing apparatus according
to claim 4, further comprising a circulation device
configured to return the powder and granular
material from which the foreign matter is separated
by the foreign matter separation device back onto
20 the conveyance path of the conveyance device.

[Claim 6]

The foreign matter removing apparatus according
to any one of claims 1 to 5, wherein the powder and
25 granular material contains gypsum.

[Claim 7]

The foreign matter removing apparatus according
to claim 6, wherein the gypsum contains calcined
30 gypsum.

[Claim 8]

A gypsum-based building board manufacturing

apparatus comprising the foreign matter removing
apparatus of any one of claims 1 to 7,

wherein the foreign matter removing apparatus
is provided on a conveyance path of a raw material
5 that contains gypsum.

[Claim 9]

A foreign matter removing method comprising:

removing the foreign matter in the powder and
10 granular material by using the foreign matter
removing apparatus of any one of claims 1 to 7.