

VACUUM INSULATION PANEL MANUFACTURING METHOD, AND VACUUM  
INSULATION PANEL

ABSTRACT

A vacuum insulation panel manufacturing method that makes it  
5 possible to manufacture low-cost, high-performance vacuum  
insulation panels, and a vacuum insulation panel are provided.  
This method of manufacturing a vacuum insulation panel (1)  
involves: a stacking step in which a first metal plate (20) is  
stacked on one side of an insulating core material (10), and  
10 in which a backing member (50) having an opening (51) and a  
second metal plate (30) having an evacuation port (32) are  
stacked, with the opening (51) and the evacuation port (32)  
stacking, on the other surface of the core member (10) in the  
order of backing member (50) and second metal plate (30) from  
15 the core member (10) side; a first welding step for welding  
outwards of where the core member (10) is arranged in the  
first metal plate (20) and the second metal plate (30); an  
evacuating step from the evacuation port (32) to create a  
vacuum in an inner area which is held between the first metal  
20 plate (20) and the second metal plate (30) and in which the  
core member (10) is arranged; and a laser welding step in  
which, in a state in which the inner area is made into a  
vacuum by the evacuating step, the evacuation port (32) is  
sealed by means of a sealing material (60) and the sealing  
25 material (60), the second metal plate (30) and the backing  
member (50) are laser welded.

Figure 7