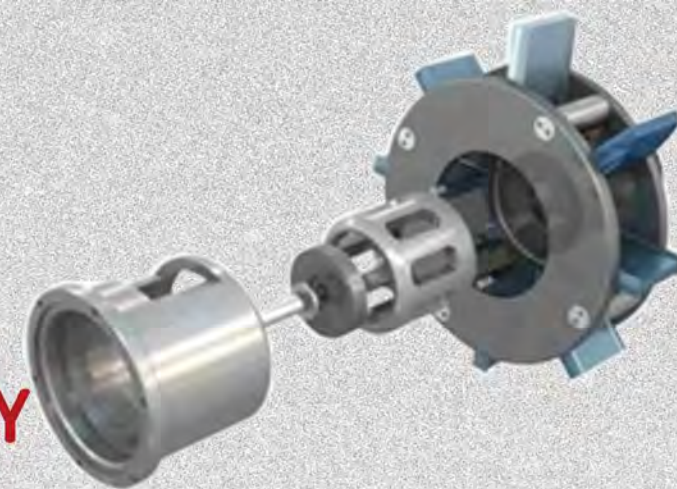




QINGGONG

青工机械
QINGGONG GROUP

Welcome to QINGGONG MACHINERY



QINGGONG MACHINERY was founded in 1975, providing perfect solutions for shot blasting machine, sandblasting room and CNC turret punch press to users around the world. QINGGONG MACHINERY adheres to the concept of efficient, intelligent, creative, environmental protection and compatible product development, insist on the strategy of brand operation, to create a diverse and comprehensive blasting equipment line. QINGGONG MACHINERY focuses on sustainable development, can better serve future customers.

Strong production bases, abundant manufacturing experience, and a professional engineer team contribute to the in-depth development of blasting machines. From standard machines to non-standard automatic blasting lines, QINGGONG MACHINERY's team is at your disposal to define and answer all your needs related to the blasting machine.

Qingdao Qinggong Machinery Co., Ltd.

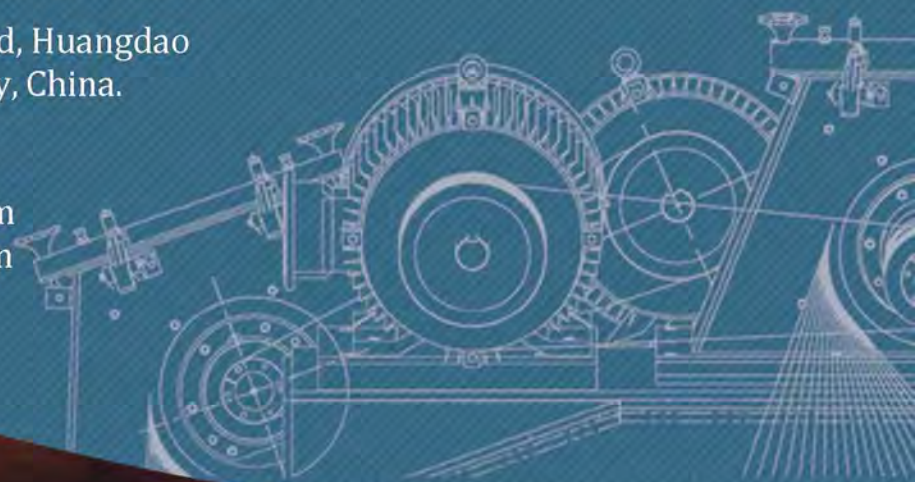
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Steel Plate
Shot Blasting Machine



H Beam
Shot Blasting Machine



Hanger Type
Shot Blasting Machine



Single Hook
Shot Blasting Machine



Steel Structure
Shot Blasting Machine



Mesh Belt
Shot Blasting Machine



Double Hook
Shot Blasting Machine



Roller Conveyor
Shot Blasting Machine



Overhead Rail
Shot Blasting Machine



Tunnel
Shot Blasting Machine



Rotary table
Shot Blasting Machine



Pipe
Shot Blasting Machine



Tumble Belt
Shot Blasting Machine



Cylinder
Shot Blasting Machine



Barrel Type
Shot Blasting Machine



Wire Rod Coil
Shot Blasting Machine



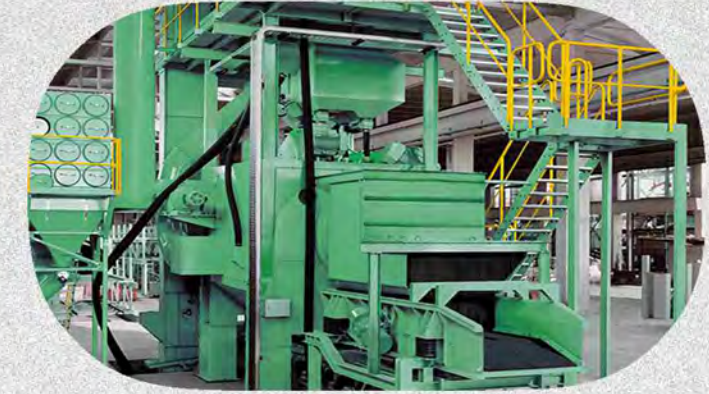
Preservation Line



Floor Shot Blaster



Continuous Rocker Barrel
Shot Blasting Machine



Continuous Tumble Pass-Thru
Shot Blasting Machine



Pavers
Shot Blasting Machine



Shot Peening Machine



Trolley
Shot Blasting Machine



Anchor Chain
Shot Blasting Machine

STEEL PLATE SHOT BLASTING MACHINE

Steel plate shot blasting machine is one kind of roller conveyor shot blasting machines. It can remove all rust, corrosion and mill scale from steel plate and provides ideal surface finish (SA2.5) for securing a continuous and effective bond between the steel surface and coat.

Product Feature :

The blasting chamber adopts full manganese steel guard plate, the service life is 5-10 years.
 Adopt high performance wheel blast turbine: high cleaning performance, low abrasive loss.
 Adopt variable frequency speed regulating roller conveyor system.
 Adopt a secondary separation system for cracked abrasive.
 Adopt advanced Venturi wet dust Collector system.
 Adopt steel shot flow intelligent control system.



Item	Unit	QGRB600	QGRB1000	QGRB1500	QGRB2000	QGRB2500	QGRB3000
Effective blasting width	mm	600	1000	1500	2000	2500	3000
Dimension of entrance	mm	800×300	1200×300	1700×300	2200×300	2700×300	3200×300
Work speed to achieve cleaning of Sa2.5 ISO8501	m/min	0.5~3	0.5~3	0.5~3	0.5~3	0.5~3	0.5~3
Number of wheels×power	kw	4×7.5/11	4×11/15	4×11/15	6×11/15	8×11/15	8×11/15
Wheel optional	kw	—	—	—	4×15	6×15/18.5	6×15/18.5
Abrasive initial filling capacity	kg	2000	4000	4000	4500	6000	6000
Processed length of the workpiece	mm	1200~12000	1200~6000	1200~12000	3000~12000	2400~12000	3000~18000
Foundation pit required		No	No	No	Yes	Yes	Yes

The technical data is not binding and may be subject to change.
 Depending on the type of parts, production method, etc., further machine types and measurement specification sheets upon request.





H BEAM SHOT BLASTING MACHINE

H beams shot blasting machine is the most efficient and the most effective process to remove all forms of rust and corrosion materials from h beams prior to painting or coating. In the blasting process, use the roller conveyor system which is controlled by frequency converter to transmit h beams into the blast chamber, blast wheel throw steel shot and hit the surface of h beams, make oxide layer and dirt rust wore off quickly, after the h beam blasting, sent out from the other side.

Product Feature :

- The blasting chamber adopts full manganese steel guard plate, the service life is 5-10 years.
- Adopt high performance wheel blast turbine: high cleaning performance, low abrasive loss.
- Adopt variable frequency speed regulating roller conveyor system.
- Adopt a secondary separation system for cracked abrasive.
- Adopt advanced Venturi wet dust Collector system.
- Adopt steel shot flow intelligent control system.

Item	Unit	QGB600	QGB1000G	QGB1500	QGB2000	QGB2500	QGB3000
Effective blasting width	mm	600	1000	1500	2000	2500	3000
Dimension of entrance	mm	800×550	1200×550	1700×550	2200×550	2700×550	3200×550
Work speed to achieve cleaning of Sa2.5 ISO8501	m/min	0.5~3	0.5~3	0.5~3	0.5~3	0.5~3	0.5~3
Number of wheels×power	kw	4×7.5/11	4×11/15	4×11/15	6×11/15	8×11/15	8×11/15
Wheel optional	kw	—	—	—	4×15	6×15/18.5	6×15/18.5
Abrasive initial filling capacity	kg	2000	4000	4000	4500	6000	6000
Processed length of the workpiece	mm	1200~12000	1200~6000	1200~12000	3000~12000	2400~12000	3000~18000
Foundation pit required		No	No	No	Yes	Yes	Yes

The technical data is not binding and may be subject to change. Depending on the type of parts, production method, etc., further machine types and measurement specification sheets upon request.



STEEL STRUCTURE SHOT BLASTING MACHINE

Steel structure shot blasting machine is specially designed to clean all kinds of steel structure, the machine is designed with large dimension capacity to produce different work-pieces of all sizes. Work-pieces are transported by a roller conveyor system into blasting chamber, all surfaces can be blasted evenly.

Product Feature :

- The blasting chamber adopts full manganese steel guard plate, the service life is 5-10 years.
- Adopt high performance wheel blast turbine: high cleaning performance, low abrasive loss.
- Adopt variable frequency speed regulating roller conveyor system.
- Adopt a secondary separation system for cracked abrasive.
- Adopt advanced Venturi wet dust Collector system.
- Adopt steel shot flow intelligent control system.



Type	Unit	QGXB600	QGX1200	QGX1200	QGX1500	QGX1800	QGX2000
Effective blasting width	mm	600	1200	1200	1500	1800	2000
Dimension of entrance(W×H)	mm	800×1400	1400×1600	1400×2000	1700×1600	2000×1700	2200×2400
Work speed to achieve cleaning of Sa2.5 ISO8501	m/min	0.5~3	0.5~3	0.5~3	0.5~3	0.5~3	0.5~2
Number of wheels×power	kW	8×7.5/11	8×11/15	8×11/15	8×11/15/18.5	8×11/15	12×11/15/18.5
Wheel optional	kW	—	—	10×11/15	10×11/15/18.5	10×11/15/18.5	14×11/15/18.5
Abrasive initial filling capacity	kg	4000	4000	4000	4500	8000	11000
Processed length of the workpiece	mm	1200~12000	1200~6000	1200~12000	3000~12000	2400~12000	2400~18000
Foundation pit required		Yes	Yes/No	Yes/No	Yes	Yes	Yes

The technical data is not binding and may be subject to change.
Depending on the type of parts, production method, etc., further machine types and measurement specification sheets upon request.



MESH BELT SHOT BLASTING MACHINE

Wire mesh belt shot blasting machine is suitable for continuous blasting thin and collision-sensitive die castings, pressure castings, ferrous and non-ferrous castings, forgings, automotive accessories, and weldments. Workpiece weight ranging from 1kg to 100kg. A highly wear-resistant wire mesh belt, with tension adjustment, provides the part transport. Wire mesh belt width has 600mm, 800mm, 1000mm and 1200mm.

Product Feature :

- Adopt full manganese steel body + full manganese steel guard plate, service life 10 years
- Adopt high performance wheel blast turbine: high cleaning performance, low abrasive loss.
- Adopt all-manganese steel mesh belt frequency conversion speed control conveying system
- Adopt a secondary separation system for cracked abrasive.
- Adopt advanced Venturi wet dust Collector system.
- Adopt steel shot flow intelligent control system.



Working process :

Treated objects are placed on horizontal network conveyor going through the shot blasting machine. In the process of shot blasting the treated objects move through jets of shot blasting agent from turbines, which are installed at different angles with regard to the direction of the movement which provides efficient treatment.

Item	Unit	QGM-600	QGM-800	QGM-1000	QGM-1250	QGM-1500
Max. workpiece dimension Ø x b	mm	600x400	800x400	1000x400	1250x400	1500x400
wheels Number x power	kw	4x11	4x11	4x11	4x15	4x15
Alternative wheels Number x power	kw	4x15	4x15	4x15	6x7.5	6x11
Foundation pit		no	no	no	yes	yes

The technical data is not binding and may be subject to change.
Depending on the type of parts, production method, etc., further machine types and measurement specification sheets upon request.





OVERHEAD RAIL SHOT BLASTING MACHINE

Overhead rail shot blasting machine allows the workpieces to move with constant speed through the machine. The conveyor consists of a chain and trolley system suspended from a monorail, and can be driven at a constant speed or can be indexed. A special feature of the continuous shot blasting machine is the constant traveling speed of the workpieces. The ability to adapt the moving speed of the workpiece and the wheel power ensures that the machine can be easily and smoothly integrated into an existing production line.

Applications :

Removal of mill and forge scale as well as rust

Removal of burrs and scales

Removal of molding sand

Increase of surface roughness

Applications include blast cleaning welded steel fabrications, deburring and homogeneous die-cast parts, and peening dynamically stressed components. Batches of small components or singular large, heavy workpieces can be treated.

Item	Unit	QGM-600	QGM-800	QGM-1000	QGM-1250	QGM-1500
Max. workpiece Dia. x b	mm	300*600	500*1200	800*2000	1000*2500	1200*3000
Max height	mm	4700	5900	6700	7200	7700
Max width	kw	4200	5100	5900	6100	6300
Max length	kg	5000	8500	8500	10500	10500
No. of wheels x power	kw	4x 7.5	8x7.5	12x11	12x 11	12x 11
Total installed power	kw	41	72	143	147	157
Exhausted air quantity	m3/h	6000	12000	18000	22000	25000
Foundation pit		Yes	Yes	Yes	Yes	Yes

The technical data is not binding and may be subject to change.
Depending on the type of parts, production method, etc., further machine types and measurement specification sheets upon request.



TUNNEL TYPE SHOT BLASTING MACHINE

Tunnel type shot blasting machine is a non-standard shot blasting machine that is according to workpieces information to design. The tunnel type shot blasting machine is mainly used for surface treatment of large steel structures to achieve the removal of rust, old patent leather, and old putty, etc.

For large workpieces, it can use a double electric hoist to lift the workpieces through the shot blasting chamber, and workpieces can be shot blasted.

The tunnel type shot blasting machine adopts imported PLC control and has automatic/manual control mode, the whole hook through the type of shot blasting machine to achieve automatic fault detection.



Item	Unit	HTK 04/05	HTK 08/09	HTK 12/09	HTK 12/11	HTK 12/11Q
Max. workpiece Dia. x b	mm	300*600	500*1200	800*2000	1000*2500	1200*3000
Max height	mm	4700	5900	6700	7200	7700
Max width	mm	4200	5100	5900	6100	6300
Max length	kg	5000	8500	8500	10500	10500
No. of wheels x power	kw	4x 7.5	8x7.5	12x11	12x 11	12x 11
Total installed power	kw	41	72	143	147	157
Exhausted air quantity	M3/h	6000	12000	18000	22000	25000
Foundation pit		Yes	Yes	Yes	Yes	Yes



The technical data is not binding and may be subject to change. Depending on the type of parts, production method, etc., further machine types and measurement specification sheets upon request.

HANGER SHOT BLASTING MACHINE

Hanger type shot blasting machine is the most flexible and versatile shot blasting machine. It comes in two options the single hook I type shot blasting machine and two hooks Y type shot blasting machine. Hanger type shot blasting machine is specifically suitable for descaling of forgings, and desanding of castings, removal of burrs and scales, surface treatment and deburring of welded constructions, etc.

Technical Support:

1. The material of hanger type shot blasting machine housing is wear-resistant manganese steel plate, that additional protection of the most exposed parts.
2. The hanger type shot blasting machine with high-efficiency abrasive cycle system. With crosswise screw conveyor, longitudinal screw conveyor, bucket elevator and separator. The abrasive from blast wheel to parts, then the crosswise screw conveyor to reclaim the abrasive to a crosswise screw conveyor, then into bucket elevator and separator.
3. Cantilever centrifugal high-efficiency blast wheel can operate clockwise or counter-clockwise, the optimum abrasive flow rate for faster cleaning.
4. The standard electrical element of hanger type shot blasting machine includes PLC Siemens, display, timer, automatic or manual mode, pneumatic cylinders on the door, revolving hooks, automatic start-up of turbines, working-hours counter, etc.
5. Hanger type shot blasting machine is non-standard shot blasting machine, can be manufactured by order, with adjusted size, blast wheel quantity and power, I type or Y type, etc.



Hanger type shot blasting machine working principle:

One batch of parts hang on the hook, then enter into the blasting chamber, blast wheels give an angular hit of shots to unevenly shaped components resulting in the best finish on the components. Moves off the parts after blasting, then another hook enters into the chamber.

Item	Unit	QGH7/12	QGH10/16	QGH12/18	QGH14/22	QGH16/23	QGH18/25	QGH30/30
Max. diameter of workpiece batch	mm	700	1000	1200	1400	1600	1800	3000
Max. height of workpiece	mm	1200	1600	2000	2200	2300	2500	3000
Max. weight of workpiece	kg	600	800	1000	2000	3000	5000	10000
No. of wheels Power(kW)	kW	2×7.5	2×11	2×15	3×15	3×15	4×15	5×15
Foundation pit		No	No	No	No	Yes	Yes	Yes



The technical data is not binding and may be subject to change. Depending on the type of parts, production method, etc., further machine types and measurement specification sheets upon request.

SINGLE HOOK TYPE SHOT BLASTING MACHINE

Single hook type shot blasting machine is suitable for surface cleaning or strengthening treatment of medium and small castings and forgings in the casting, construction, chemical, electrical, machine tool and other industries. It is especially suitable for surface cleaning and shot blasting of castings, forgings, aluminum alloy castings and steel structural parts of multiple varieties and small batches to remove a small amount of sticky sand, sand core and oxide scale on the surface of the workpiece.

Technical Support:

1. The international advanced cantilever centrifugal blast turbines with large shot blasting volume and high shot speed is adopted to improve the cleaning rate and cleaning quality.
2. All drawings of the simulated projectile diagram and shot blasting machine are drawn by computer-aided design (CAD) and the selection and layout of the blast turbine are more reasonable.
3. The use of a pit-free structure not only saves the construction cost and time of the pit foundation, but also solves the problem of rust and agglomeration of shot sand in the bucket elevator caused by the user due to the water in the pit. The hook has the functions of lifting, running and indoor rotation.
4. The blasting chamber adopts high chromium guard plate, the service life is greatly improved and the appearance is beautiful and easy to replace.
5. The single hook shot blasting machine can lift workpieces with a weight of more than 3 tons, which is suitable for small workload requirements.

Single hook type shot blasting machine working principle:

The hook descends to lift the workpiece, rises to a certain position and then enters the blasting chamber along the track and stop. Then starts to rotate when it reaches the predetermined position. At this time, close the gate of the blasting chamber, turn on the blast turbines and open the abrasive valves. The machine starts to clean the workpiece.

Item	Unit	QGS7/12	QGS10/16	QGS12/18	QGS14/22
Max. diameter of workpiece batch	mm	700	1000	1200	1400
Max. height of workpiece	mm	1200	1600	1800	2200
Max. weight of workpiece	kg	600	800	1000	2000
No. of wheels Power	kW	2×7.5	2×11	2×15	3×15
Foundation pit		No	No	No	No

Larger sizes are available, as are a huge range of options.
Represented here are the Standard /Stock pre-engineered machines. Please contact us for further information.



DOUBLE HOOK SHOT BLASTING MACHINE

Double hook type shot blasting machine has a high production efficiency and a large flexibility span. It is an ideal cleaning and strengthening equipment and it is easy to operate. It is widely used in the surface cleaning or strengthening treatment of small and medium-sized castings and forgings in the casting, construction, chemical, electrical, machine tool and other industries.

Technical Support:

1. The international advanced cantilever centrifugal blast turbines with large shot blasting volume and high shot speed is adopted to improve the cleaning rate and cleaning quality.
2. All drawings of the simulated shot diagram and blasting machine are drawn by computer-aided design (CAD), the selection and layout of the blast turbine are more reasonable.
3. The use of a pit-free structure not only saves the construction cost and time of the pit foundation, but also solves the problem of rust and agglomeration of shot sand in the bucket elevator caused by the user due to the water in the pit. The hook has the functions of lifting, running and indoor rotation.
4. The blasting chamber adopts high chromium guard plate, the service life is greatly improved and the appearance is beautiful and easy to replace.
5. The double hook shot blasting machine suitable to lift workpieces with a weight of less than 3 tons. Double hook has large volume, high cleaning efficiency, large effective room space, compact structure, no pit form, no special requirements for the shape and structure of the cleaning workpiece and one machine can be used for multiple purposes.



Double hook type shot blasting machine working principle:

Double hook shot blasting machine load the workpiece to be processed on the machine, press the start button and go through a short period of time (usually 5-7 minutes). It uses two hooks to load workpieces alternately into the blasting chamber. Use the blast turbines to throw steel shot to the surface of the workpiece to make the surface of the workpiece reach a certain roughness to change the compressive stress of the workpiece to increase its life. After the entire cleaning process is completed and all dust and residual shots are removed.

Item	Unit	QGDH7/12	QGDH10/16	QGDH12/18	QGDH14/22
Max. diameter of workpiece batch	mm	700	1000	1200	1400
Max. height of workpiece	mm	1200	1600	1800	2200
Max. weight of workpiece	kg	600	800	1000	2000
No. of wheels Power	kW	2×7.5	2×11	2×15	3×15
Foundation pit		No	No	No	No

The technical data is not binding and may be subject to change. Depending on the type of parts, production method, etc., further machine types and measurement specification sheets upon request.



ROLLER CONVEYOR SHOT BLASTING MACHINE

Roller conveyor shot blasting machine is the most environment-friendly and the most effective process to remove all forms of rust and corrosion materials from steel plate, pipes, steel structure, h beams, steel tube, profiles, steel angles and channels, etc.

The roller conveyor shot blasting machine can not only remove the rust, but can also remove the welding slag on the structural parts, eliminate welding stress and improve the fatigue strength, increase film adhesion painting, provides ideal surface finish (SA2.5-3.0) for securing a continuous and effective bond between the steel surface and coat. It is used in almost every industry that uses metal, including aerospace, automotive, construction, foundry, shipbuilding, rail, and many others.

Applications:

Large quantities of steel plates, strip steel, weighing instruments, trailer pallet axles, frame, radiator, stone, profile, profile steel, drilling tools, H-shaped steel, steel structure, profile, aluminum, steel pipe, angle steel, channel steel, round steel, Bar, steel plate, aluminum plate, coil, strip steel, iron tower, rebar, etc.



Details About Roller Conveyor Shot Blasting Machine:

The components cross the tunnel laid on a roller conveyor, extendible outside with modular lengths. The surface treatment is done during the running through the blasting room: at one single pass it is possible to achieve the required finishing degree, according to the specification of standard ISO 8501-1 and SIS SS 055900. Length of roller conveyor depends on customer requirements. Shot blasting machine for blasting plates and profiles can be equipped with side loading ramps, preheated chambers, scrubbers, with the chamber for painting or drying tunnel.

The shot blasting machine is made of solid manganese steel plates. Blast part can be further protected by wear-resistant shields made from manganese steel. Working speed rollers during the process of blasting can be constantly updated. Innovative pressure washers provide high-quality sand cleaning abrasive. The entire device is made in accordance with the strictest European standards.



ROTARY TABLE SHOT BLASTING MACHINE

Rotary table shot blasting machine is suitable for various shapes and dimensions, casts, forged parts, pressed parts, steel, and non-ferrous metal parts and parts made from fragile materials, cleaning surface, removing casting sand and filings, consolidating the surface (micro handling), roughing the surface before colouring, etc.

Product Feature :

The machine's housing is robust and protected by wear-resistant materials. High efficiency of the machine is enabled by the system for continued returning and cleaning of the abrasive, along with efficient turbines made from wear-resistant materials. Standard equipment of larger machines includes PLC Siemens, display, timer automatic or manual mode, automatic start-up of turbines, working-hours counter, etc. For shot blasting cast containing larger quantities of casting sand, a magnetic sand cleaner may be installed.



Item	Unit	RT1000/900	RT1200/900	RT2000/1500
Maximum dimension of chamber	mm	Φ1350×560	Φ1350×860	Φ2654×560
Maximum workpiece weight	Kg	400	400	1000
Diameter of Turn Table	Mm	Φ1200	Φ1200	Φ2500
Number of wheels×power	Kw	11	2×7.5	2×15
Overall dimension	Mm	1500×3450×3780	1900×3450×4160	4260×3647×5366
Ventilation requirements	m3/h	4000	6000	8000
Material of table		Manganese	Manganese	Manganese
Material of Protective lining		Manganese/Cast alloy	Manganese/Cast alloy	Manganese/Cast alloy
Material of blast chamber		Mild steel	Mild steel	Mild steel

The technical data is not binding and may be subject to change.
Depending on the type of parts, production method, etc., further machine types and measurement specification sheets upon request.



PIPE SHOT BLASTING MACHINE

Pipe shot blasting machine is suitable for any diameter and length of steel pipe cleaning, it can remove the oxide, rust, and scale from welded steel pipe, so that the pipe surface shows metallic colors.

Product Feature :

Steel pipe moves through the machine on skew roller conveyors. Such form of the conveyor provides simultaneous rotation and transition movement of the pipes through the machine, which can achieve evenly blasted surface. KT series turbines made from wear-resistant materials, with power from 5.5 to 45kw provide efficient and quality shot blasting. The shot blasting part of the machine's robust housing is protected by wear-resistant shields made from manganese steel. Entry and exit seals chamber with a series of rubber screens keep the abrasive inside the machine. Screw conveyor, an elevator and sand cleaner provide returning and continuing cleaning of the abrasive. Standard equipment includes PLC Siemens, display, automatic or manual mode, automatic start-up of turbines, working-hours counter, variable frequency drive of the cylinder drive, etc. Machines may be built into highly productive lines for basic color application, including drying chamber, automatic coloring chamber and drying tunnel.



Item	Unit	ST500	RT800	RT15000
Dimension of pipe(Dia.×L)	mm	Φ(50-500)×(6000-10000)	Φ1350×860	Φ2654×560
Wheel conveyor speed	Kg	1 to 3	1 to 3	1 to 3
Number of blast wheels and power	Kw	2×15	2×15	2×15
Ventilation requirements	m3/h	5000 to 7000	8000 to 14500	20000-26000
Material of table		Manganese	Manganese	Manganese
Material of Protective lining		Manganese/Cast alloy	Manganese/Cast alloy	Manganese/Cast alloy
Material of blast chamber		Mild steel	Mild steel	Mild steel



The technical data is not binding and may be subject to change.
Depending on the type of parts, production method, etc., further machine types and measurement specification sheets upon request.

TUMBLE BELT SHOT BLASTING MACHINE

Tumble belt shot blasting machine or crawler shot blasting machine is the most universal among all shot blasters as their design makes them suitable for processing parts of different sizes in bulk loads. Shot blasting of casts, forged and pressed parts, remodelled cold or hot, of various complicated forms, springs, etc. (weighing up to 20 kg and manufactured in smaller and large series, the volume of a particular filling may be up to 500 L, mass up to 1,000 kg), cleaning surface, removing casting sand and filings and consolidating the surface (microhandling), roughing the surface before colouring, etc.

Product Feature

Machines have a perpetual caterpillar made from perforated rubber belt. Treated objects are put by a special filling contraction to caterpillar. When caterpillar moves its special shape causes treated objects to turn and roll, which causes the whole surface of the treated object to be qualityblasted in a jet of abrasive. For emptying, caterpillar is started-up in the opposite direction turning mode. The machine's housing is protected by wear-resistant manganese steel. High efficiency of the machine is provided by the system for continued returning and cleaning of the abrasive, along with efficient turbines made from wear-resistant materials. Standard equipment of larger machines includes: PLC Siemens, display, timer automatic or manual mode, automatic start-up of turbines, working-hours counter, etc. The machine can be equipped with a magnetic separator, vibration conveyor and variable frequency drive for the turbines.



Item	Unit	MB150G	MB300G	MB400G
Productivity	t/h	0.6-1.2	1.5-2.5	3-5
Max volume charge	dm ³	150	300	400
Max advised load	kg	200	600	800
Drum diameter	mm	650	1000	1000
Wheel power	Kw	7.5(11)	11/15(2*11)	11/15(2*11)
Ventilation requirements	m ³ /h	2200	5000	6000
Power consumption	Kw	12.6	24.3	32.6
Wheels		1	1(2)	1(2)
Material of Protective lining		Manganese/Cast alloy	Manganese/Cast alloy	Manganese/Cast alloy

The technical data is not binding and may be subject to change. Depending on the type of parts, production method, etc., further machine types and measurement specification sheets upon request.



GAS CYLINDER SHOT BLASTING MACHINE

Gas cylinder shot blasting machine is used to automatically clean the surface of the cylinders by blasting of the abrasive coming from the blast turbines of the machine in a confined chamber.

The cylinders get shot blasted as they pass through the blasting chamber on the base of the machine. The cylinders also get rotated on the rollers as they pass through to ensure the cleaning of the complete surface.

QINGGONG MACHINERY has 3 solutions for gas cylinder shot blasting : skew roll shot blasting machine, hanger type shot blasting machine and overhead rail shot blasting machine.

1. Skew roll shot blasting machine (Diabolo shot blasting machine)
2. Hanger type shot blasting machine
3. Overhead rail shot blasting machine



3 solutions for gas cylinder shot blasting :

First type is diabolo roller conveyor type, which makes the lpg cylinder move forward horizontally and rotate when it moves forward. One or two blast wheels are fixed on top of the blasting chamber. Due to the LPG cylinder rotate when it moves forward, the blast wheel can blast it thoroughly from all sides. This machine is a continuous type.

Second type is spinner hanger type blasting machine, which has I or Y track rail overhead. This is normally for small quantity blasting job.

Third type is the monorail hanger type blasting machine, which is a continuous moving process, and it can be connected to previous and following procedure of the whole production line. Customer can choose the suitable type according the production requirement.



PRESERVATION LINES

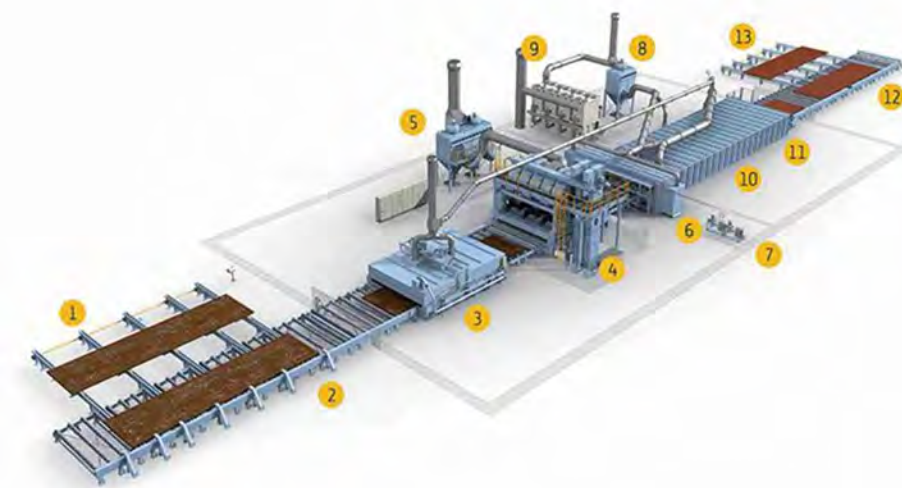
On the preservation line, sheets and profiles are thoroughly blast cleaned and provided with a temporary corrosion protection coating. Along with the external transportation unit, the preservation line consists of a pass through blasting and painting machine, a painting unit and a drying tunnel with its associated slat conveyor.

Typical plates widths can vary up to 2500mm, height can vary from 5mm to 1000mm, length can vary from 2000mm to 12000mm.

A Preservation line usually consists of:

- In-and out-feed roller conveyor (sometimes equipped with a cross conveyor to increase the efficiency)
- Pre-heater to heat up and dry incoming material (this enables the later-applied paint to dry more quickly)
- Roller conveyor shot blasting machine (to treat plate widths between 1.5 and 5m, with working speeds of 1.0 – 10m/min)
- Spray booth to coat the freshly cleaned steel material with a layer of water or solvent-based primer to achieve a temporary corrosion protection
- Drying tunnel with slat conveyor to transport and dry the newly painted material and the continuous drying on the way to the exit of the tunnel

Specific features such as: combined direct flame and hot air circulation pre heating ovens, automatic width detection and wheel adjustment, blast turbines, and clean detector system make QINGGONG Preservation lines the number one choice.



Key to Preservation Line:

1. Cross transfer conveyor
2. Inlet roller conveyor
3. Pre-heater
4. Roller conveyor shot blast machine
5. Blast machine filter
6. Paint spray chamber
7. Paint supply system
8. Filter from VOC-System
9. VOC-System
10. Drying chamber
11. Slat conveyor
12. Outlet roller table
13. Cross transfer conveyor





FLOOR SHOT BLASTER

Floor shot blaster is a kind of shot blasting machine for concrete floors, steel plates. The floor shot blaster can clean up the floatation and impurities on the surface of the concrete at one time. It can also roughen the surface of the concrete road to make it uniform and rough, which will greatly enhance the adhesion strength of the waterproof layer and concrete base. So that the waterproof layer and bridge deck can combine much better.

How to choose :

Perfect for industrial floors, warehouses, factories roads and bridges, and supermarkets, the QINGGONG QGLM-250 is an environmentally sound choice for any surface preparation contractor.

Whether improving traction and skid resistance or prepping for coatings and overlays, the versatile QGLM-550 strips clean and profiles concrete and asphalt, or horizontal steel surfaces in one easy step.

QGLM800 is suitable for industrial plant and warehouse floors, parking garages, ship decks, highway or bridgework, airport runways, and other large jobs.

QGLM 200 is an ideal for industrial floors, warehouses, commercial or residential garage floors, this shot blaster can prepare up to 450 to 600 sq. ft. per hour. The QGLM-200 is also perfect as a complementary unit for larger shot blasters.

Floor Shot Blaster Working Principle :

Floor shot blaster is driven by the motor to produce centrifugal force and wind force in high-speed rotation. Operators need to input a certain particle size of shot material that the flow can be controlled. As soon as the shot material is fed into the pellet tube, it will be accelerated into the pellet wheel at high speed. Under the action of the centrifugal force, the shot material is thrown into the directional sleeve by the window of the dividing wheel, then it will be thrown through the directional window which can control the throwing direction of the projectile material. The high-speed rotating blade will pick them up and accelerates along the length direction of the blade until they are thrown out. The thrown projectiles can form a certain fan-shaped stream beam which can impact the working surface and play the role of clearing and strengthening.

Item	Unit	QGLM200	QGLM250	QGLM550	QGLM800
Power	kw	14	0.6-1.2	1.5-2.5	3-5
Effective cleaning width	mm	200	250	550	800
Productivity on concrete	m ² /h	80	120	300	450
Travel speed	m/min	0.5-23	0.5-23	0.5-25	0.5-20
Dust collection type		DC-1300	DC-1300	DC-1330	DC1330

The technical data is not binding and may be subject to change. Depending on the type of parts, production method, etc., further machine types and measurement specification sheets upon request.



PAVERS SHOT BLASTING MACHINE

Paver shot blasting machine is mainly used for surface roughening treatment of marbles, granites, concrete products, and natural stone. It includes stone shot blasting machine and marble shot blasting machine. It provides twin advantage foremost subject field end provides outstanding appearance as a result of the rough surface and therefore the exposed aggregates. Second "roughened" surface has excellent non-slip properties.

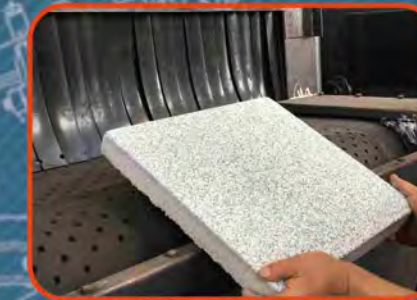
Advantage of paver shot blasting machine:

1. Speed adjustment of conveyor and blast wheels is controlled through an Inverter.
2. The number and the position of the blast wheels can change depending on the geometry, customer requirement and on the workpieces, such as only the blasting of the upper side, or need to blast lateral side.
3. With proper regulated control and type of shot used in the shot blast machine, it is possible to produce different surface finishes to produce an "antique" effect on marble stones and 'bush-hammering's effect on cement products.
4. All paver shot blasting machine with Blow-off station. After blasting, a blow-off station with a high-pressure blower removes the shot from the surface of the concrete blocks/stone. The nozzles are adjustable in height and therefore adaptable for the treatment of different concrete block/stone sizes.



Item	Unit	QGP600	QGP800	QGP1000	QGP1200	QGP1500
Max. working width of machine	mm	600	800	1000	1200	1500
Max. working height of machine	mm	400	400	400	400	400
Working speed(frequency adjustable)	m/min	0.5~6	0.5~6	0.5~6	0.5~6	0.5~6
number of wheels×power	kw	2×7.5/11/15	2×7.5/11/15	2×7.5/11/15	2×7.5/11/15	2×7.5/11/15
Vertical wheel optional		1×7.5/11/15	1×7.5/11/15	1×7.5/11/15	1×7.5/11/15	1×7.5/11/15
Foundation pit required		No	No	No	No	No

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SHOT PEENING MACHINE

Shot peening machine is a process specifically designed to enhance the fatigue strength of components which are subject to high alternating stress. It can help to prevent fatigue cracks, corrosion, deteriorated strength and premature fatigue that can be caused by machining and form metal parts which also creates internal stress concentration. It also helps to prevent crack formation and growth since typically fatigue cracks generally begin at the imperfection on the surface of the material.

Application :

- Crankshafts
- Gear wheels
- Connecting rods
- Automotive gear parts
- Coil springs
- Turbine blade (Aircraft)
- Airframe components
- Suspension springs
- Medical implants

Advantages of shot peening:

- It reduces stress corrosion splitting
- It can prepare components for plating
- It straightens fragments that were deformed when manufactured
- It reduces casting permeability
- It can alter part dimensions
- It will improve oil retention

Shot peening :

Propelling steel abrasives or other media on the surface of parts induces residual compressive stress. This increases the part's fatigue strength and resistance to stress-induced splitting and corrosion cracks. The traditional domain of shot peening is in the automotive and aviation industry. But shot peening applications are now expanding into many new areas with a demand for higher reliability, durability and lighter weight of parts.

Items	Unit	QGHP400	QGHP500-1	QGHP500-2	QGHP500-3
Max working size	mm	Φ400*600	Φ500*1100	Φ500*1100	Φ500*1100
Max loading weight	kg	200	500	500	500
Blast wheel quantity		1	2	2	2
Number of chamber		2	2	3	4

The technical data is not binding and may be subject to change. Depending on the type of parts, production method, etc., further machine types and measurement specification sheets upon request.



BARREL TYPE SHOT BLASTING MACHINE

The Barrel Blast Machine line provides outstanding performance and reliability. Designed for foundry, forge and heat treat requirements.

The Barrel Blast Machine or drum type shot blasting machine is the ideal solution to clean small to medium size parts that would normally become jammed in traditional Tumbblast machine.

The Barrel Machine is the ideal solution to clean parts that would normally become pinched or jammed in our traditional Tumbblast machine, reducing chances of part damage. Barrel machines are designed for easy maintenance to provide shorter downtime.

Applications :

- Automotive
- Iron, steel and metal foundries
- Heat treat operations
- Forging operations
- Small stamping parts manufacturers

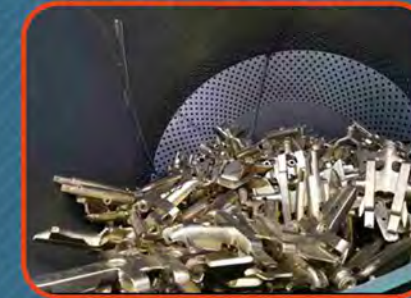
Features :

- Efficient and uniform blast cleaning effect
- Thin and small special parts can also be processed
- Simple and accurate input and discharge
- Simple maintenance

Description :

The central feature of the barrel type machine is the geometry of the rotating barrel. The inside wall of the barrel features specially contoured ridges, while the bottom is shaped in the form of a three-sided pyramid. This unique design creates the innovative "multi-tumbling" action of the different barrel elements: when the drum rotates, the ridges on the internal wall of the barrel tumble and mix the work pieces. At the same time the pyramid causes the parts at the bottom of the barrel to move to the top of the mass. This multi-tumbling action ensures that the blast stream reaches all surface areas, thus producing even and consistent blast results. Brightly cleaned parts surface, free of sand, rust or scale, are achieved in short cycle times with a highly consistent finish.

When it comes to the integrity, consistency and stability of batch processing, multi tumbler meet the highest standards. Numerous customer ideas and requirements are reflected in the development of the QINGGONG design. As multi-purpose machines, which can be used for de-scaling, surface roughening, and general blast cleaning or shot peening; multi tumbler blast machines are unmatched in their performance and productivity. The innovative barrel geometry prevents the work pieces from jamming or nesting, thus averting any damage. Even very tiny work pieces with complex shapes can be processed safely.



WIRE ROD COIL SHOT BLASTING MACHINE

Wire rod coil shot blasting machine is the best special equipment which used to cleaning the wire rod, it cleans the scale cinder on the surface of the wire and the scales on the rolled steel through the blasting process. The surface descaling grade of the steel billet rust reach Sa2.5 level after blasting and the surface roughness level reach Ra6.3 ~ 12.5μm. Compared to pickling treatment, it has the characteristics of economy, environmental protection and high efficiency.

QINGGONG's wire rod shot blasting machine features:

Rotating Door with Two Chambers

2 chambers are arranged at both sides of the rotating door, so worker can load and unload wire coils in one chamber while another chamber in blasting process. This design can offer a higher producing speed and reduce abrasive leakage.

On surface of the rotating door, high resistance manganese steel alloy liners with max thickness of 10 mm can protect the mechanical wear from abrasive stream.

Rotating Coil Holding Arm:

2 rotating arms made by high strengthen steel alloy can offer high weight supporting capacity. They are installed in 2 chambers on the rotating door. A layer of high resistance rubber sheet cover the arms for protection.

With a segmental eccentric design, the arms keep rotating in clockwise and counterclockwise directions in turn, the wire coils can be spreaded and exposed under abrasive stream for an uniformly cleaning result.



Technical specification of wire rod coil shot blasting machine:

Diameter of the wire: Φ 4.5~ Φ 38mm

Minium inner diameter of coil: Φ 800mm

Maximum outer diameter of coil: Φ 1500mm

Maximum load capacity mandrel :2500kg

Productivity: 7-15min/time

Effective length of mandrel:3800mm-5500mm(can be customized)

Wire rod coil handing type: cantilever mandrel loading (One cantilever mandrel inside the blasting chamber will clockwise rotate 15s and then counterclockwise 15s which controled by PLC during blast descaling, the rotation time for each direction is adjustable. while the other Outdoor cantilever mandrel is loading and unloading)

Rotation speed: 10-20 r/min (frequency control)



CONTINUOUS ROCKER BARREL SHOT BLASTING MACHINE

Continuous Rocker Barrel Shot Blasting Machine is automatic, continuous, dust-free shot blasting equipment, with a high degree of flexibility to meet the changing production requirements. It can quickly adapt to the production efficiency, processing technology and market demand changes. It can be easily integrated into the production line with other processing equipment, which can realize the automatic production process. This can ensure the whole production process line reach to the high production efficient and low-cost operation while improving the working environment.

Applications :

Removing sand and cores from castings. Descaling castings and forgings. Handling mixed and single products run. Cleaning cluster. Keeping the blast cleaning performance at a consistently high level, regardless of any fluctuations in production rates.

Features:

Shaker Blast / Rocker Barrel Machine

Greatly reduced workforce, no workers are required to transport castings

Comfortable and safe working conditions

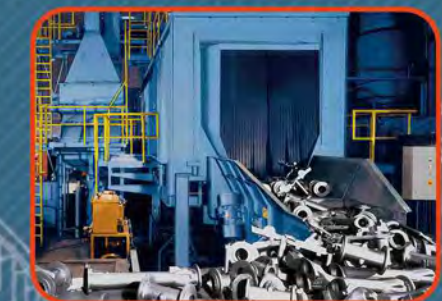
Compact layout is possible requiring only about half the space of an equivalent batch type machine

Reduced lead time-continuous blasting minimizes time loss



Type	Unit	DT-11-350	DT-14-450/ DT-14-650/ DT-14-850/ DT-14-1050	DT-17-650/ DT-17-850	DT 20-650/ DT 20-850
Max. diameter of workpiece batch	mm	400	850	980	1150
Max. height of workpiece	t/h	2-5	8-25	15-33	15-38
Max. weight of workpiece	kg	30	150	150	150
Power per blast wheel	kw	45	37-45	37-45	37-45
No. of wheels Power		3	4-10	6-10	6-10

The technical data is not binding and may be subject to change.
Depending on the type of parts, production method, etc., further machine types and measurement specification sheets upon request.



CONTINUOUS TUMBLE PASS-THRU SHOT BLAST MACHINE

The through-feed blast cleaning process offers a number of distinct advantages and ensures efficient and cost-effective blast cleaning. Continuous tumble shot blasting machines automate production sequences and improve the work environment. Workpiece dwell-time and abrasive throughput rates are controlled by the volume of castings. This results in the best possible cleaning effect and minimal wear on machine components and abrasive. Automatic adaptation to production rate is a standard feature.

Features :

In order to greatly convenient the tumble of the workpieces, the equipment adopts the new patented technology of four-axis structure.

The thumb last belt adjustment uses the automatic cylinder tension device.

The tumble belt rotates speed is adjustable by a frequency inverter, which is adjusted according to the different workpieces actual conditions.

The belt is composed by the thickness of 20mm high manganese plate, the holes on the belt are cut by water jet cutter in order to prevent the deformation, the chainring adopted a unique structure so as to let the spattered blasting media drop into the abrasive reclaim system.



Type	Unit	QGCT4-14
Single part maximum dimension	mm	700(L)*600(W)*500(H)
Diameter of tumble belt	mm	1600
Blast wheel types		KT36,38,42 and 50
numbers of blast wheels		2/4/6
power of blast wheels	kw	22/45/50

The technical data is not binding and may be subject to change.
Depending on the type of parts, production method, etc., further machine types and measurement specification sheets upon request.

TROLLEY SHOT BLASTING MACHINE

Shot blasting parts of different forms and dimensions, castings, forgings, pressed parts, parts and parts from fragile materials, cleaning of the surface, removing of casting sand and filings, consolidating of the surface before coloring, etc. Trolley type shot blasting machine is designed for shot blasting of large and heavy castings, complicated shapes in small series or single production. Working pieces are loaded to a rotating table on tip truck with lifting device (crane, lift truck). This rotating table is then transported in a chamber. In the entrance of this chamber are two-sided doors.

Application:

Shot blasting parts of different forms and dimensions, castings, forgings, pressed parts, parts and parts from fragile materials, cleaning of the surface, removing of casting sand and filings, consolidating of the surface before coloring, etc.

Feature :

- Large loading and high coverage rate of shot blasting.
- Large blasting capacity and high cleaning efficiency.
- Shot blasting combine shot peening, it could spray blasting blind zone, cleaning is complete.
- Large and heavy casting, forging surface cleaning.



Item	Unit	QGT365C	QGT3610	QGT3620	QGT765C	QGT7610	QGT7620	
Cleaning size	mm	2500X1300	2500X1500X280	4000x3000x700	2000x1000	2500x1500x280	4000x3000x700	
Max. loading weight	Kg	5000	10000	20000	5000	10000	20000	
Blasting capacity	Kg/min	2x250	4x250	4x250	2x250	3x250	4x250	
Lifting capacity of elevator	T/h	40	60	75	30	45	60	
Ventilation volume	m³/h	13200	240000	241000	11000	15000	21500	
Blasting capacity	kg/h	2x250	4x250	2x250	3x250	4x250	4x250	
Power(excluding dedusting)	kw	40	189	189	36	189	184	
Machine size		9000x4200x9290	14900x5000x8700	16900x6540x10020	9000x5200x9290	5000x5000x3400	14900x5200x6100	16900x6540x10028

The technical data is not binding and may be subject to change.
Depending on the type of parts, production method, etc., further machine types and measurement specification sheets upon request.



ANCHOR CHAIN SHOT BLASTING MACHINE

Anchor chain shot blasting machine is a new type of special equipment designed and produced according to the requirements of users. It can be used for round-link chain, anchor line and wire shot blast cleaning. The 10-800 anchor chain can get cleaned in it. It can not only remove the surface rust, oxide skin of work piece, but also can improve the anti fatigue strength of anchor line, increase the paint film adhesion of work piece, and ultimately improve the surface and internal quality.

QINGGONG's anchor chain shot blasting machine features:

The equipment compact structure, reasonable design, with high efficiency and energy saving, high blast volume, mass ejection velocity, long service life, convenient maintenance. The main clean interior lining with a layer of modular high strength alloy wear-resistant plate, reduces the maintenance frequency, and make full use of clean steel shot rebound repeatedly against the workpiece to achieve.

Applications :

- Removal of mill and forge scale as well as rust
- Removal of burrs and scales
- Shot peening to increase fatigue strength
- Increase of surface roughness
- Removal of moulding sand



Working principle of anchor chain shot blasting machine:

The working principle for anchor chain shot-blasting machine is mainly by numerous high speed abrasive flow projection to the anchor chain surface, which blast cleaning the oxides and Surface attachment from the anchor chain, and by making the surface plastic deformation to effectively improve the chain's fatigue strength and fracture resistance of corrosion. Main composition and structure characterized by shot blasting Chamber, sealed rooms, elevators, separators, screw conveyors, throwing assembly, Abrasive reclaim system, elevator platform, inbound and outbound guide wheel unit, abrasive dosing unit, foundation, dust collecting system, electrical control components.

Ship anchor chain shot-blasting machine is a tailored equipment which design based on end user's requirements of the equipment performance, it can process $\phi 22$ to $\phi 50$ anchor chain for one-time blast cleaning.

