

专业的抛丸机, 喷砂房生产厂家

PROFESSIONAL SHOT BLASTING MACHINE, SAND BLASTING ROOM MANUFACTURER



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COMPANY PROFILE

公司简介

青岛青工机械有限公司位于青岛工业园,为全球用户提供抛丸机、预处理线、喷砂房、喷漆房等铸造设备的完美解决方案。

青工机械秉承高效、智能、创新、环保、兼容的产品开发理念,打造多元化、综合化的抛丸设备生产线。青工机械注重可持续发展,能更好的服务于所有客户。

强大的生产基地,丰富的生产经验,专业的工程师团队,一对一的售后服务,为铸造行业的发展做出了贡献。

从标准设备到非标准的自动化抛丸生产线,青工机械随时为您服务!

Qingdao Qingong (Seth) Machinery Co., Ltd is located in Qingdao Industrial Park, providing perfect solutions for shot blasting machine, preservation line, sandblasting room and spray booth to users around the world.

QGMA 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. QGMA focuses on sustainable development, can better serve future customers.

Strong production bases, abundant manufacturing experience, professional engineer team and One to One after-sales service contribute to the in-depth development of blasting machines.

From standard machines to non-standard automatic blasting lines, QGMA's team is at your disposal to define and answer all your needs related to the blasting machine.



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钢板抛丸机

STEEL PLATE SHOT BLASTING MACHINE



设备参数 EQUIPMENT PARAMETER

型号 Type	单位 Unit	QGRB600	QGRB1000	QGRB1500	QGRB2000	QGRB2500	QGRB3000
有效清理宽度 Effective blasting width	mm	600	1000	1500	2000	2500	3000
开口尺寸 Dimension of entrance(W×H)	mm	800×300	1200×300	1700×300	2200×300	2700×300	3200×300
工作速度 Work speed to achieve a 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
抛丸器数量及功率 Number of wheels×power	kW	4×7.5/11	4×11/15	4×11/15	6×11/15	8×11/15	8×11/15
抛丸器选配 Wheel optional	kW	-	-	-	4×15	6×15/18.5	6×15/18.5
磨料首次添加量 Abrasive initial filling capacity	kg	2000	4000	4000	4500	6000	6000
清理工件长度 Processed length of work piece	mm	1200~12000	1200~6000	1200~12000	3000~12000	2400~12000	3000~18000
地坑要求 Foundation pit required		No 否	No 否	No 否	Yes 是	Yes 是	Yes 是

现场照片 SCENE PHOTO



设备特点 EQUIPMENT CHARACTERISTICS

- 钢板抛丸机是一种通过式自动抛丸设备,主要用于各种钢板的表面除锈清理和应力消除,增强涂层的表面附着力,提高钢板的抗疲劳性能,延长其使用寿命。采用滚扫+螺旋+吹风的弹丸清理方式,清理后的工件表面无弹丸积存,无粉尘吸附。
- 本设备自动化程度高,可大大提高清理工作的效率,减轻清理工作的劳动强度和对环境的污染。
- The steel plate shot blasting machine is an automatic pass-through shot blasting equipment. It is mainly used for surface rust cleaning and stress relief of various steel plates to enhance the surface adhesion of the coating, improve the fatigue resistance of steel plate and extend its service life. The abrasive cleaning up system including nylon brush, screw conveyor and blowing fan to ensure no shots accumulation and floating dust on the surface of workpieces after cleaning.
- With a high degree of automation, the shot blasting machine can greatly improve the efficiency of cleaning work, also reduce the labor intensity and environmental pollution of cleaning work.

H钢抛丸机

H BEAM SHOT BLASTING MACHINE



设备特点

EQUIPMENT CHARACTERISTICS

- 抛丸室采用高锰钢护板, 耐磨性强。
 - 采用高性能抛丸器, 抛丸效率高, 磨料损耗小。
 - 采用变频调速辊道输送系统。
 - 采用二级分离的磨料循环系统。
 - 采用先进的文丘里式除尘器系统。
 - 采用智能磨料控制系统。
-
- The blasting chamber adopts Mn15Cr1 guard plate, long service time.
 - 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 dust Collector system.
 - Adopt steel shot flow intelligent control system.

设备参数

EQUIPMENT PARAMETER

型号 Type	单位 Unit	QGB600	QGB1000G	QGB1500	QGB2000	QGB2500	QGB3000
有效清理宽度 Effective blasting width	mm	600	1000	1500	2000	2500	3000
开口尺寸 Dimension of entrance(W×H)	mm	800×550	1200×550	1700×550	2200×550	2700×550	3200×550
清理速度 Work speed to achieve a 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
抛丸器数量×功率 Number of wheels×power	kW	4×7.5/11	4×11/15	4×11/15	6×11/15	8×11/15	8×11/15
首次加砂量 Abrasive initial filling capacity	kg	2000	4000	4000	4500	6000	6000
处理的工件长度 Processed length of work piece	mm	1200~12000	1200~6000	1200~12000	3000~12000	2400~12000	3000~18000
是否需要地坑 Foundation pit required		No	No	No	Yes	Yes	Yes

现场照片 SCENE PHOTO



钢结构抛丸机

STEEL STRUCTURE SHOT BLASTING MACHINE



设备特点

EQUIPMENT CHARACTERISTICS

- 钢结构抛丸机主要适用于船舶、汽车、机车车辆、桥梁、机械等行业，专为清理大型工字钢、H型钢等尺寸较大的钢结构件而设计，不但可以去除工件表面的氧化皮、锈迹、焊渣等杂质，获得一定的表面粗糙度以增加漆膜附着，而且可以消除工件的焊接应力，提高工件的抗疲劳强度，最终达到提高表面及内在质量的目的。
- 此设备应用广泛，采用PLC自动控制，工件自进自出，显著提高了生产效率。
- The steel structure shot blasting machine is mainly used in ship, automobile, locomotive vehicle, bridge and machinery industry and specially designed for cleaning steel structure, like large H beam, I beam, etc., which can not only remove the oxide scale, rust, welding slag and other impurities on the surface of workpieces to get a certain roughness of the clean surface and increase the adhesion of the paint film, but also eliminate the welding stress on workpiece to improve the fatigue strength of workpieces. and ultimately achieving the purpose of improving the surface and internal quality of steel structure.
- This machine is widely used and adopts PLC automatic control, the workpieces can come in and out automatically, which significantly improves production efficiency.

现场照片 SCENE PHOTO



设备参数

EQUIPMENT PARAMETER

型号 Type	单位 Unit	QGX600	QGX1200	QGX1200	QGX1500	QGX1800	QGX2000
有效清理宽度 Effective blasting width	mm	600	1200	1200	1800	2000	3000
开口尺寸 Dimension of entrance(W×H)	mm	800×1400	1400×1600	1400×2000	1700×1600	2000×1700	2200×2400
工作速度 Work speed to achieve a 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
抛丸器数量及功率 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
抛丸器选配 Wheel optional	kW	—	—	10×11/15	10×11/15/18.5	10×11/15/18.5	14×11/15/18.5
磨料初始添加量 Abrasive initial filling capacity	kg	4000	4000	4000	4500	8000	11000
工件加工长度 Processed length of work piece	mm	1200~120	1200~6000	1200~12000	3000~12000	2400~12000	2400~18000

钢管外壁抛丸机

STEEL PIPE OUTER WALL SHOT BLASTING MACHINE



设备特点

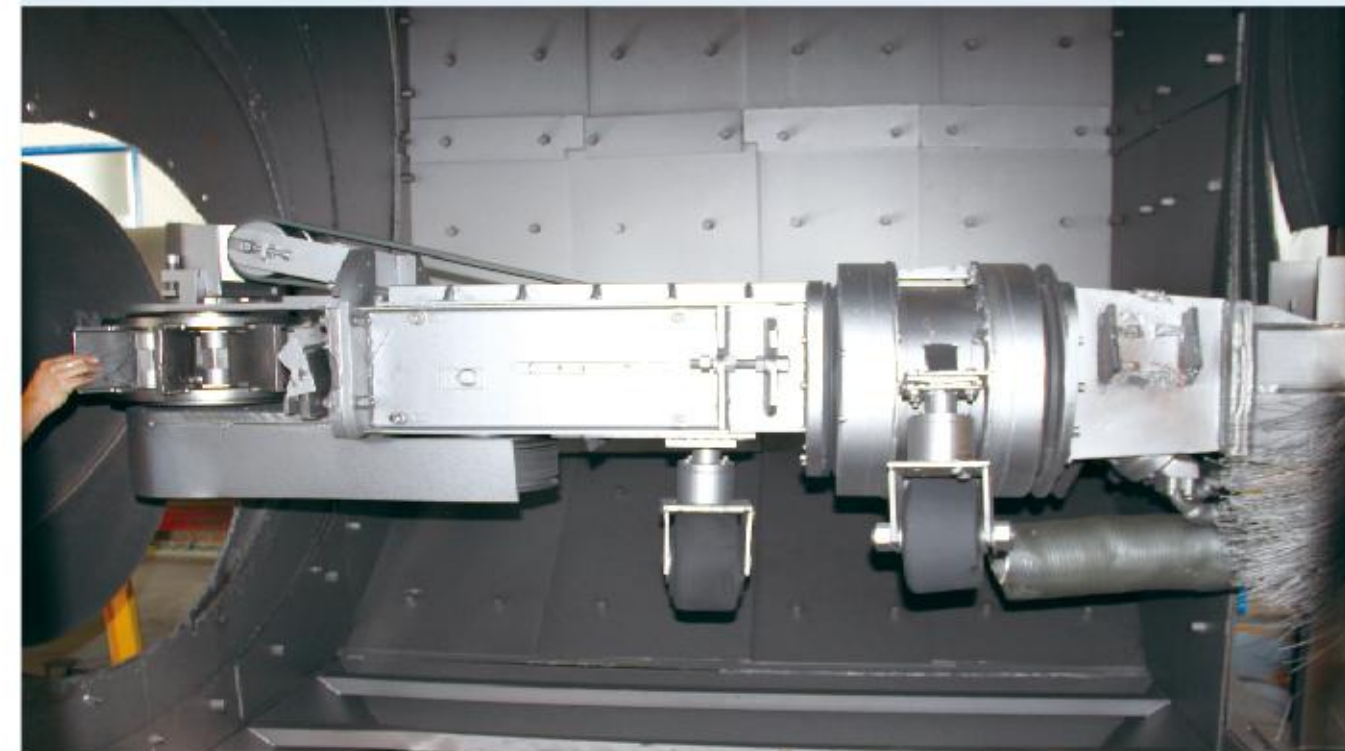
EQUIPMENT CHARACTERISTICS

- 钢管外壁抛丸机可以选择辊道抛丸机和V轮抛丸机,使其清除氧化层以及焊渣等杂物,呈现金属光泽。
- 辊道抛丸机根据钢管的直径设计设备尺寸以及抛丸器数量。
- V轮抛丸机是实现钢管在V轮输送中自转以达到全面抛丸的效果。
- The steel pipe outer wall shot blasting machine including roller conveyor shot blasting machine and Diabolo shot blasting machine to remove the oxide layer, welding slag and other debris and present a metallic luster.
- The roller shot blasting machine designs the equipment size and the quantity of blast turbines according to the diameter of the steel pipe.
- The diabolo shot blasting machine realizes the rotation of the steel pipe during conveyor transportation to achieve a comprehensive shot blasting effect.



钢管内壁抛丸机

STEEL PIPE INNER WALL SHOT BLASTING MACHINE



设备特点

EQUIPMENT CHARACTERISTICS

- 钢管内壁抛丸机是指通过喷枪或者抛丸器在钢管内壁中旋转把钢砂喷射到钢管内表面,去除氧化物,锈蚀,油污等杂质,使内壁达到一定的清洁度和光洁度。
- Steel pipe inner wall shot blasting machine refers to spraying steel shot onto the inner surface of the steel pipe through a blasting gun or blast turbine to rotate in the inner wall of the steel pipe to remove oxides, rust, oil and other impurities, so that the inner wall reaches a certain degree of cleanliness and smoothness.



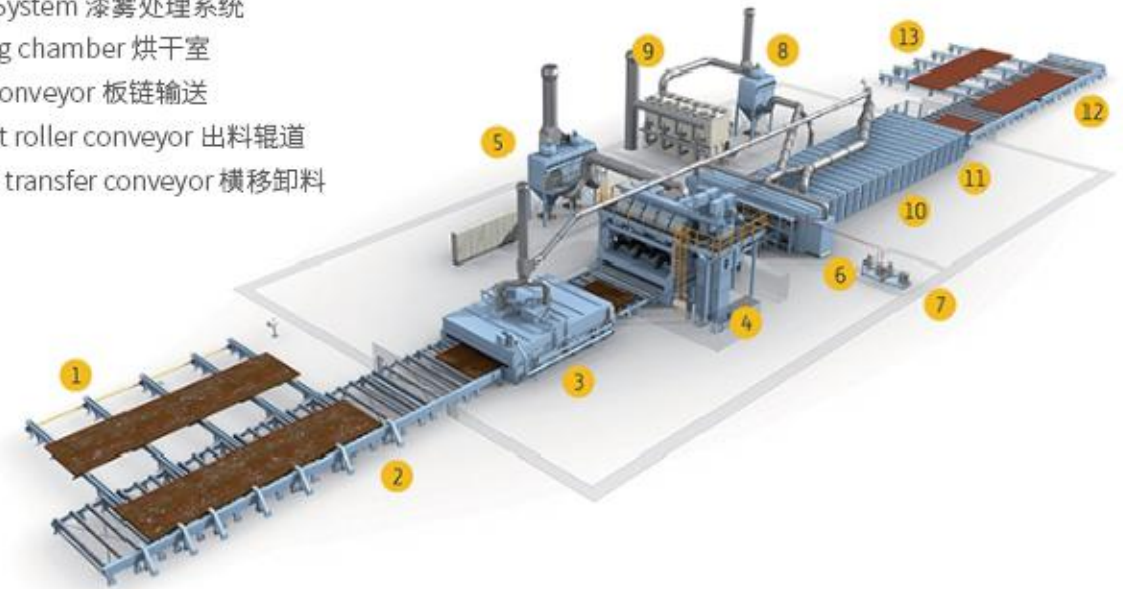
预处理线 PRESERVATION LINE



设备特点 EQUIPMENT CHARACTERISTICS

- 钢板预处理线主要由抛丸清理、喷漆、烘干三大部分组成，根据用户的生产需要，可单机进行抛丸清理工作，也可连线实现预热、抛丸清理、喷漆、烘干的连续作业，此设备主要适用于钢板的表面除锈、涂漆及烘干，从而达到除锈、防锈及表面强化的目的。
- 采用PLC实现整机协调工作，极大提高了生产效率。
- The steel plate preservation line is mainly composed of three parts: shot blasting, paint spraying and drying. According to the user's production needs, shot blasting can be performed on a standalone machine, or the continuous operation of preheating, blast cleaning, paint spraying, and drying can be realized. The steel plate pretreatment line is mainly used for surface rust removal, painting and drying of steel plates, so as to achieve the purpose of rust removal, rust prevention and surface strengthening.
- The steel pretreatment line adopts programmable controller PLC to coordinate the work of the whole machine, which greatly improves production efficiency.

- 1 Cross transfer conveyor 横移上料
- 2 Inlet roller conveyor 送料辊道
- 3 Pre-heater 预热
- 4 Roller conveyor in blasting chamber 抛丸室辊道
- 5 Blast machine filter 抛丸机除尘器
- 6 Paint spray chamber 喷漆室
- 7 Paint supply system 供漆系统
- 8 Filter from VOC-System 漆雾处理系统
- 9 VOC-System 漆雾处理系统
- 10 Drying chamber 烘干室
- 11 Slat conveyor 板链输送
- 12 Outlet roller conveyor 出料辊道
- 13 Cross transfer conveyor 横移卸料



现场照片 SCENE PHOTO



吊钩抛丸机

HOOK SHOT BLASTING MACHINE



设备参数

EQUIPMENT PARAMETER

型号 Type	单位 Unit	QGH7/12	QGH10/16	QGH12/18	QGH14/22	QGH16/23	QGH18/25	QGH30/30
挂件最大直径 Max. diameter of work piece batch	mm	700	1000	1200	1400	1600	1800	3000
工件最大高度 max. height of work piece	mm	1200	1600	2000	2200	2300	2500	3000
工件最大重量 Max. weight of workpiece	kg	600	800	1000	2000	3000	5000	10000
抛丸器数量x功率 No. of wheelsx Power	kW	2×7.5	2×11	2×15	3×15	3×15	4×15	5×15
地坑要求 Foundation pit		No 否	No 否	No 否	No 否	Yes 是	Yes 是	Yes 是

现场照片 SCENE PHOTO



设备特点

EQUIPMENT CHARACTERISTICS

- 吊钩式抛丸机主要适用于中小型铸件、锻件、冲压件、热处理件等工件的清砂、除锈、去氧化皮和表面强化。
- 具有抛丸量大, 清理效率高, 室体有效空间大, 结构紧凑, 且无地坑等特点。
- The hook type shot blasting machine is mainly suitable for sand cleaning, rust removal, scale removal and surface strengthening of small and medium-sized castings, forgings, stamping parts, heat-treated parts and other workpieces.
- It's characterized by large flow rate, high cleaning efficiency, large effective space in the blasting chamber, compact structure and no foundation pit.

网带抛丸机

MESH BELT SHOT BLASTING MACHINE



设备参数 EQUIPMENT PARAMETER

项目 ITEMS	单位 Unit	铸铁 CAST IRON	铸铝 CAST ALUMINIUM	铸铁 CAST IRON	铸铝 CAST ALUMINIUM
网带宽度 MESH BELT WIDTH	mm	1250	1250	800	800
生产率 PRODUCTIVITY	t/h	3.5/7.5	根据工件 BASED ON WORKPIECES	3.5/7.5	根据工件 BASED ON WORKPIECES
通过速度 PASSING SPEED	m/min	0.5-2.5/1-5	0.5-2/1-4	0.5-2.5/1-5	0.5-2/1-4
抛丸器数量 NUMBER OF BLAST TURBINES		4/8	4/8	4/8	4/8
抛丸器功率 POWER OF BLAST TURBINES	kW	11-18.5	7.5-15	11-18.5	7.5-15

设备特点

EQUIPMENT CHARACTERISTICS

- 网带式抛丸机主要用于薄壁和脆弱的铁或铝合金铸件等小型零件的表面抛丸清理, 亦可用于机械零部件抛丸强化。
- 具有连续性好, 清理效率高, 变形小等特点, 可实现全自动化作业, 既可单独使用, 又可配线。
- The mesh belt shot blasting machine is mainly used for surface cleaning of thin-walled and fragile iron or aluminum alloy castings and other small parts. It can also be used for blast cleaning and strengthening of mechanical parts.
- With the advantages of good continuity, high productivity and small deformation, the mesh belt shot blasting machine can realize fully automatic operation and be used alone or as a part of the production line.

现场照片 SCENE PHOTO



金属履带抛丸机

STEEL BELT SHOT BLASTING MACHINE



设备特点

EQUIPMENT CHARACTERISTICS

- 金属履带抛丸机适合不怕碰撞的, 高温的, 有菱角的工件的表面除锈清理。
- 金属履带提供翻滚的动作, 保证钢砂覆盖工件的各个面。在抛丸结束后, 金属履带自动反转进行卸料工作。
- 与橡胶履带相比, 金属履带耐磨性更强, 使用时间更长。
- Metal track shot blasting machine is suitable for non-collision, high temperature, with diamond Angle of the workpiece surface rust cleaning.
- The metal belt provides the tumbling action to expose all areas of the components to the blast stream, to ensure complete cleaning in one cycle. After the blast cycle, the automatic reversal of the metal belt conveyor discharges the components ready for further processing.
- Compared with rubber belt, the metal belt have better wear resistance and longer service time.

现场照片 SCENE PHOTO



橡胶履带抛丸机

TUMBLE BELT SHOT BLASTING MACHINE



设备特点

EQUIPMENT CHARACTERISTICS

- 履带抛丸机主要用于不怕碰撞的铸件, 锻件, 热处理件及弹簧等的表面除锈或抛丸强化。履带式抛丸机工作噪音小, 尘埃少, 生产效率高, 同时弹丸可自动回收利用, 耗料少, 成本低。该设备既可以单机使用也可以配线使用, 是现代企业理想的表面处理设备。大多数型号可以通过增加自动上下料设备来进一步提高效率。
- The tumble belt shot blasting machine is mainly used for surface rust removal or shot blasting strengthening of castings, forgings, heat-treated parts and springs that are not afraid of collision. The tumble belt shot blasting machine has the advantages of low operating noise, less dust, and high production efficiency. At the same time, the abrasive can be automatically recycled which contributes to less material consumption and lower cost. The machine not only can be used as a stand-alone machine but also as a part of production line, is an ideal surface treatment equipment for modern enterprises. Most models can achieve further efficiency by adding automatic loading and unloading equipment.

现场照片 SCENE PHOTO



强化抛丸机

SHOT PEENING MACHINE

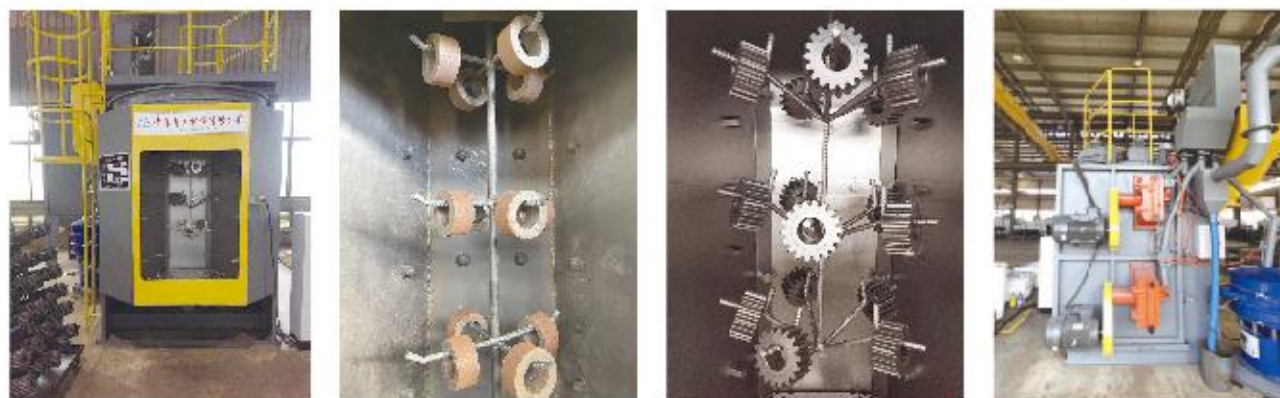


设备特点

EQUIPMENT CHARACTERISTICS

- 抛丸强化是一种机械表面处理工艺。它利用高速运动的弹丸连续冲击被强化工件表面,从而在工件表面和表层产生循环性变形。这一过程会导致显微组织结构发生改性,非均匀的塑变外层引入残余压应力,内表层产生残余拉应力,以及外表面粗糙度发生变化。这种强化方式主要用于提高工件的抗疲劳寿命,改善其接触疲劳特性,并增强工件对外部负荷导致的拉应力的抵抗能力。
- 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.

现场照片 SCENE PHOTO



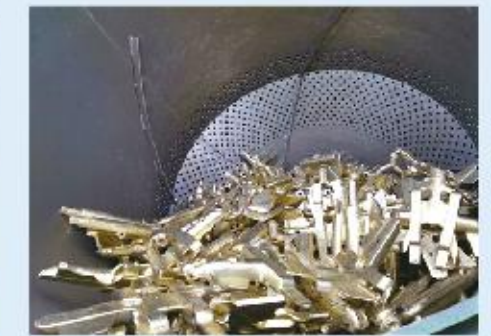
倾斜滚筒抛丸机

BARREL TYPE SHOT BLASTING MACHINE



倾斜滚筒抛丸机特别适用于锻件和防摔灰铁、钢、球墨和可锻铸件的除鳞、清理。

Barrel type shot blasting machines are especially suitable for descaling of forgings and for desanding of tumbleproof grey iron-, steel-, ductile and malleable iron castings.



设备特点

EQUIPMENT CHARACTERISTICS

- 操作原理简单,结构紧凑
- 抛丸器在整个槽内的最佳位置
- 钢砂可覆盖工件所有表面
- 爆破区域长,零件密度低,爆破时间短
- 冲击损伤小,不卡工件
- 易于集成到现有的生产线
- Simple operating principle, compact design.
- Optimum location of blast wheels throughout the trough, optimum utilization of the abrasive energy.
- Full exposure of all workpiece surfaces to the blast stream.
- Short blasting times due to a long blasting zone and low density of parts.
- Less impact damage, no workpiece jamming.
- Easy integration into existing production lines.

设备参数

EQUIPMENT PARAMETER

项目 ITEM	单位 Unit	QGT 700	QGT 1000	QGT 1500
滚筒尺寸 Barrel dimension	mm	Φ700×800	Φ1000×1065	Φ1500×1600
滚筒最大载重 Maximum load of barrel	kg	60-150	200-400	800-1500
生产率 Productivity	Tons	0.3-1	1-2	4-8
滚筒转速 Rotating speed of barrel	r/min	7.1	4.2	3
磨料流量 Abrasive flow rate	Kg/min	1×120	1×380	1×480
设备总功率 Total power	KW	15	35	50

单转台抛丸机

SINGLE ROTARY TABLE SHOT BLASTING MACHINE



设备特点

EQUIPMENT CHARACTERISTICS

- 转台式抛丸机适用于小批量铸件，锻件，铆焊件的表面清理及强化，特别适合扁、怕碰撞的零件及热处理件表面清理，广泛应用于铸造、锻压、汽车制造业等。
- 具有生产效率高，密封效果好，结构紧凑，装卸件方便等特点。
- The rotary table shot blasting machine is used for surface cleaning and strengthening of small batches of castings, forgings, and riveted welding parts, especially suitable for surface cleaning of flat parts and heat-treated parts that can not be collided, widely used in casting, forging and pressing, automobile manufacturing industry, etc.
- The turntable shot blasting machine features high production efficiency, good sealing effect, compact structure, and easy loading and unloading of parts.

设备参数

EQUIPMENT PARAMETER

项目 ITEM	单位 Unit	RT1000/900	RT1200/900	RT2000/1500
抛丸室最大尺寸 Maximum dimension of chamber	mm	Φ1350×560	Φ1350×860	Φ2654×560
工件最大重量 Maximum workpiece weight	kg	400	400	1000
转台直径 Diameter of turn table	mm	Φ1200	Φ1200	Φ2500
抛丸器数量及功率 Nos of blast wheel and power	KW	1×11	2×7.5	2×15
外形尺寸 Overall dimension	mm	1500×3450×3780	1900×3450×4160	4260×3647×5366
转台数量 Number of table		1	1	1

双转台抛丸机

DOUBLE ROTARY TABLE SHOT BLASTING MACHINE



设备特点

EQUIPMENT CHARACTERISTICS

- 双转台抛丸机适合批量清理重量轻的铸件，锻件，焊接件等。
- 一个转台在抛丸室中工作的同时另一个转台进行上卸料工作，提高了生产效率。
- The double rotary table shot blasting machine is suitable for bulk cleaning of light weight castings, forgings, welds, etc.
- One turntable is working in the shot blasting chamber while the other is loading and unloading, which improves the production efficiency.

设备参数

EQUIPMENT PARAMETER

项目 ITEM	单位 Unit	RTD 1000	RTD 1200	RTD 2000
转台最大直径 Maximum diameter of rotary table	mm	Φ1000	Φ1200	Φ1500
工件最大重量 Maximum workpiece weight	kg	400	400	1000
抛丸器数量及功率 Number of blast wheels and power	KW	1×11	2×7.5	3×11
转台数量 Number of table		2	2	2

悬链抛丸机

OVERHEAD RAIL SHOT BLASTING MACHINE



设备特点

EQUIPMENT CHARACTERISTICS

- 悬链式抛丸机用于大批量生产的各种可吊挂式工件的全方位抛丸清理, 比如铸件、锻件、焊接件、汽车配件、轮辋、油缸、电机壳体等, 广泛用于汽车、拖拉机、柴油机、电机、阀门、化工、机械等行业。
- 此设备具有工件静态装卸、自动快速输送的特点, 可实现工件连续通过抛丸清理与工件旋转清理。结构紧凑, 易于操作, 生产效率高。
- The overhead rail shot blasting machine is used for all-round shot blast cleaning of various hangable workpieces of mass production, such as castings, forgings, welding parts, auto parts, rims, cylinders, motor casings, etc., and is widely used in automobiles, tractors, diesel engines, motors, valves, chemicals, machinery and other industries.
- This equipment is characterized by static loading & unloading and automatic rapid conveying of workpieces, and can realize continuous cleaning and rotation cleaning of workpieces. The overhead rail shot blasting machine features compact structure, easy operation and high production efficiency.

现场照片 SCENE PHOTO



设备参数

EQUIPMENT PARAMETER

型号 Type	单位 Unit	QG382C	QG383C	QG384C	QG583	QG5810
生产率 Productivity	hook/h	35-55	38-50	60-120	30-60	50
吊钩运行速度 Hooks running speed	m/min	0.35-3	0.35-3	0.35-3	0.35-3	0.35-3
单钩吊重 Max. Single hook load	kg	240	300	400	300	1000
抛丸量 Abrasive flow rate	kg/min	4*250	4*250	4*250	4*250	6*360
工件最大直径及高度 Max. workpiece Dia. x Height	mm	600*1600	700*1600	800*2000	1000*1500	750*2400
抛丸器数量 No. of wheels		4	4	4	4	6
通风量 Ventilation quantity	m ³ /h	8000	10480	14500	18000	25000
地坑要求 Foundation pit		Yes	Yes	Yes	Yes	Yes

吊钩通过抛丸机

TUNNEL TYPE SHOT BLASTING MACHINE



设备特点

EQUIPMENT CHARACTERISTICS

- 吊钩通过式抛丸机使用于清理大重量的结构件, 例如拖车底盘, 汽车车厢, 挖掘机臂等等大尺寸工件。
- 一个或多个葫芦吊挂工件进入抛丸室, 前门关闭开始抛丸工作。钢砂覆盖工件的各个表面。抛丸工作结束以后门打开, 葫芦吊挂着工件驶出抛丸室。
- Tunnel shot blasting machine is used to clean large weight structural parts, such as trailer chassis, car compartments, excavator arms and other large size workpieces.
- The workpieces are carried on rotating hooks on the manually operated monorail or conveyed automatically on a (optional) Power & Free conveyor to the blast cabinet where they are blasted by blast wheels. The blast cycle runs in accordance with the preset blast time. When the blast wheels stop, the door is opened and the hook exits automatically.

现场照片 SCENE PHOTO



设备参数

EQUIPMENT PARAMETER

型号 Type	单位 Unit	HTK 04/05	HTK 08/09	HTK 12/09	HTK 12/11	HTK 12/11Q
工件最大直径x高度 Max. workpiece Dia. x Height	mm	300*600	500*1200	800*2000	1000*2500	1200*3000
抛丸室最大高度 Max height of chamber	mm	4700	5900	6700	7200	7700
抛丸器最大宽度 Max width of chamber	mm	4200	5100	5900	6100	6300
抛丸室最大长度 Max length of chamber	mm	5000	8500	8500	10500	10500
抛丸器数量及功率 No. of wheels x power	KW	4x7.5	8x7.5	12x11	12x 11	12x 11
总功率 Total installed power	KW	41	72	143	147	157
排气量 Exhausted air quantity	m ³ /h	6000	12000	18000	22000	25000
地坑要求 Foundation pit		Yes是	Yes是	Yes是	Yes是	Yes是

线材抛丸机

WIRE ROD COIL SHOT BLASTING MACHINE



现场照片 SCENE PHOTO



设备特点

EQUIPMENT CHARACTERISTICS

- 线材抛丸是用于盘圆清理的最佳专用设备,它清除盘条表面的水垢煤渣。
- 钢丝和鳞片在轧钢上经过喷砂处理,喷砂后钢坯表面除锈等级达到Sa2.5级。
- 表面粗糙度达到Ra6.3~12.5 μ m,与酸洗处理相比,具有经济、环保、高效的特点。
- 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 Ra6.3~12.5 μ m.
- Compared to pickling treatment, it has the characteristics of economy, environmental protection and high efficiency.



连续摆床抛丸机

CONTINUOUS ROCKER BARREL SHOT BLASTING MACHINE



设备特点

EQUIPMENT CHARACTERISTICS

- 连续摆床式抛丸机是自动、连续、无尘抛丸设备，具有高度的灵活性，可以满足不断变化的生产要求。能快速适应生产效率、加工工艺和市场需求的变化。可方便地与其他加工设备集成到生产线中，实现生产过程的自动化。这可以保证整个生产工艺线达到高生产效率和低成本运行，同时改善工作环境。
- 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.

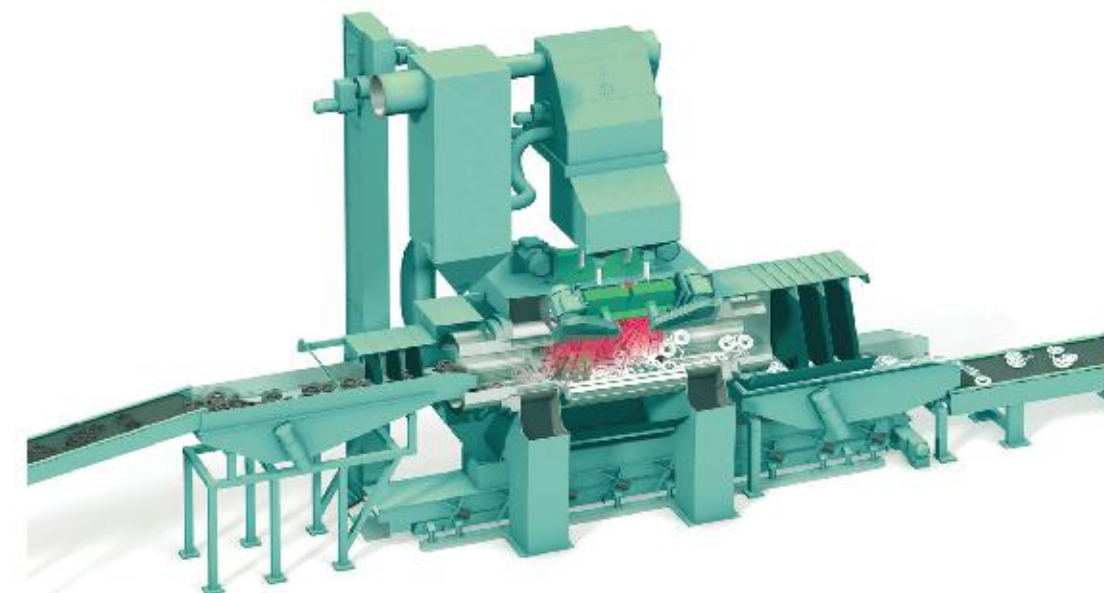
设备参数

EQUIPMENT PARAMETER

项目 ITEM	单位 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
最大工件对角线尺寸 Max. workpiece diagonal	mm	400	850	980	1150
连续处理能力 Throughput rate	t/h	2-5	8-25	15-33	15-38
最大工件重量 Max. workpiece weight	kg	30	150	150	150
抛丸器数量 Number of blast wheels		3	4-10	6-10	6-10
单个抛丸器功率 Power of per blast wheel	KW	45	37-45	37-45	37-45

连续履带抛丸机

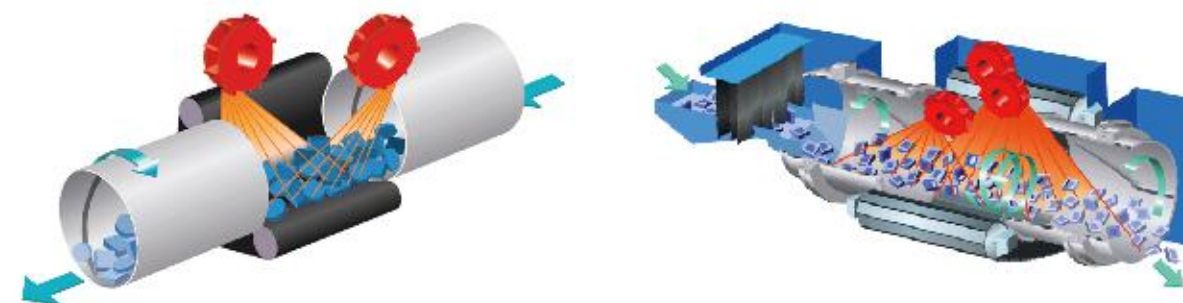
CONTINUOUS TUMBLE PASS-THRU SHOT BLASTING MACHINE



设备特点

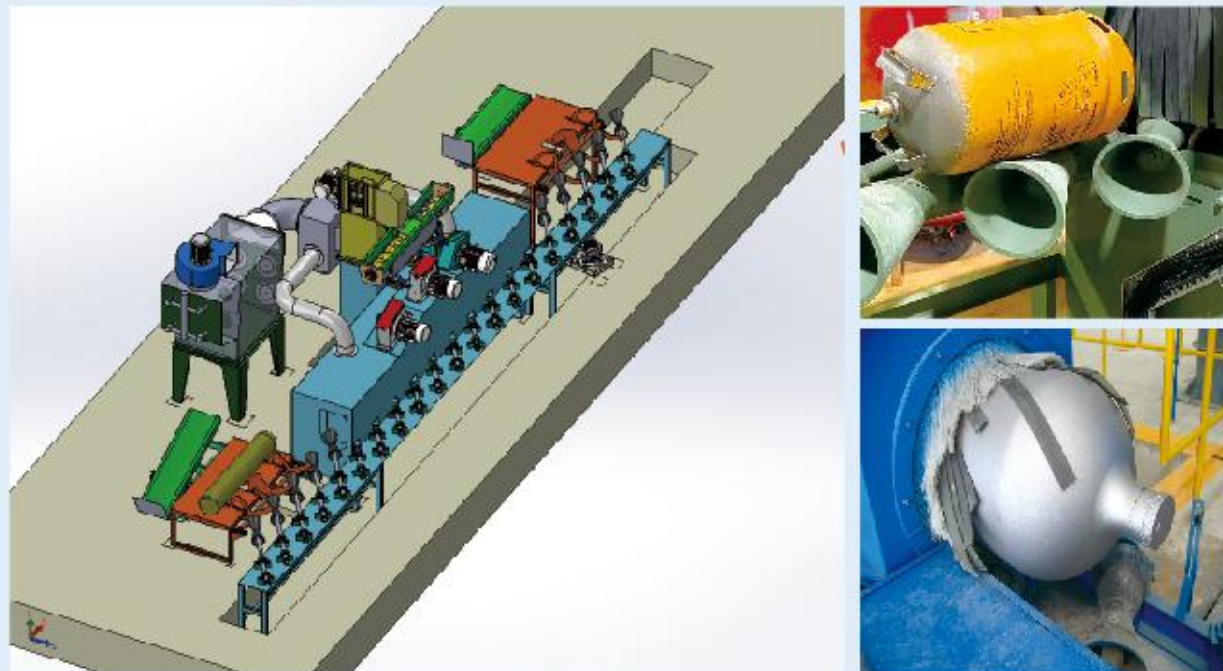
EQUIPMENT CHARACTERISTICS

- 连续履带抛丸机是适合配线使用的高生产效率的抛丸机。
- 抛丸清洗性能始终保持在高水平，而不受生产率波动的影响
- 易于维护设置
- 技术领先，经验卓越
- 可调整的进、出、爆仓设置，以满足不同的工件配置
- 适用于处理防摔易碎铸件
- Continuous tumble pass-through shot blasting machine has high production efficiency and is suitable to be used as a part of the production line.
- Blast cleaning performance is maintained at a consistently high level, regardless of fluctuations in production rates.
- Easy maintenance set up.
- Leading technology, outstanding experience.
- Adaptable inlet, outlet and blastroom set up to meet different workpiece configurations.
- Adaptable to treat tumble-proof fragile castings.



气瓶抛丸机

GAS CYLINDER SHOT BLASTING MACHINE



设备特点

EQUIPMENT CHARACTERISTICS

- 气瓶抛丸机适用于气瓶、LPG气瓶、氧气瓶等的处理。
- 去除粘砂和焊渣
- 腐蚀去除
- 旧油漆剥离
- 除锈和热垢
- 提高疲劳强度和耐腐蚀性
- 延长了气缸的使用寿命
- Cylinder shot blasting machine suitable for the treatment of gas cylinders, LPG cylinders, oxygen bottles, etc.
- Removal of sticky sand and welding slag.
- Corrosion removal.
- Old paint stripping.
- Rust and heat scale removal.
- Increases the fatigue strength and corrosion resistance.
- Prolongs the service life of the cylinder.

设备参数

EQUIPMENT PARAMETER

项目 ITEM	单位 Unit	QGST30	QGST80	QGST150
清理工件最大尺寸 Maximum dimension of workpiece	mm	φ(50-500)×(6000-10000)	φ(150-800)×(6000-10000)	φ(250-15000)×(6000-10000)
运行速度 Running speed	m/min	60-150	200-400	800-1500
抛丸器数量 Number of blast wheels		0.3-1	1-2	4-8
抛丸器功率 Power of blast wheels	KW	7.1	4.2	3
通风量 Ventilation requirements	m ³ /h	1×120	1×380	1×480
地坑要求 Foundation pit requirements		15	35	50

台车抛丸机

TROLLEY SHOT BLASTING MACHINE



设备特点

EQUIPMENT CHARACTERISTICS

- 台车抛丸机适用于小批量或单件生产的大型、重型、形状复杂的铸件抛丸。台车抛丸清理机通过起重装置(吊车、叉车)将工件装载到自卸车的转台上。台车带着工件进入抛丸室进行抛丸工作。
- Trolley type shot blasting machine is designed for shot blasting of large and heavy castings, complicated shapes in small series or single production. By trolley shot blast cleaning machine, 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 one or two-sided doors.

现场照片 SCENE PHOTO



路面抛丸机

FLOOR SHOT BLASTER



设备特点

EQUIPMENT CHARACTERISTICS

- 创建一个粗糙的表面轮廓, 以增加涂层和覆盖层的结合强度。
- 在涂上涂料、覆盖层或修补之前对混凝土或沥青进行表面准备。
- 清除金属表面的污染物, 如铁锈、水垢或旧涂层。
- 清洁和塑造钢或其他金属表面, 以提高涂层或衬里的附着力。
- 用于防滑或装饰目的的表面的纹理, 如地板或人行道。
- 为粘合或焊接准备表面。
- 去除表面上的标记、线条或其他不需要的特征, 如道路标记或跑道橡胶。
- Creating a rough surface profile to increase the bond strength of coatings and overlays.
- Surface preparation for concrete or asphalt prior to applying coatings, overlays, or repairs.
- Remove surface contaminants from metal surfaces such as rust, scale, or old coatings.
- Cleaning and profiling steel or other metal surfaces for improved adhesion of coatings or linings.
- Texturing of surfaces for slip resistance or decorative purposes, such as for flooring or walkways.
- Preparation of surfaces for bonding or welding.
- Removal of markings, lines, or other unwanted features from surfaces, such as road markings or runway rubber.

石材抛丸机

PAVER SHOT BLASTING MACHINE



设备特点

EQUIPMENT CHARACTERISTICS

- 石材抛丸机适用于对大理石, 花岗岩, 路沿石等石材的表面处理。为石材去除粘砂, 提供了荔枝粗糙面, 增加了附着力。工作原理: 不同粒度的磨料被快速旋转的抛丸器抛向石材表面。磨料的巨大冲击力迅速蚀刻出表面独特的三维特征。用这种方法加工的石材具有高质量的表面外观, 无重叠和死区, 生产效率高, 成本低。
- Stone shot blasting machine suitable for surface blast for marble, granite, road traffic stone, etc. For the stone to remove sticky sand, provide litchi rough surface, increase the adhesion. The working principle: different sized abrasive, thrown by the rapidly rotating blast wheel, is accelerated towards the surface being prepared. The huge impact force of the abrasive quickly etches a unique three-dimensional character of the surface.

设备参数(大于等于60厘米)

EQUIPMENT PARAMETER (L≥60cm)

项目 ITEM	单位 Unit	QGS600	QGS800	QGS1000	QGS1200	QGS1500
最大工作宽度 Max working width of machine	mm	600	800	1000	1200	1500
最大工作高度 Max working height of machine	mm	400	400	400	400	400
抛丸速度(变频调速) Working speed (frequency adjustable)	m/min	0.5~6	0.5~6	0.5~6	0.5~6	0.5~6
抛丸器数量及功率 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
立式抛丸器(可选) Vertical wheel optional		1×120	1×380	1×480	1×480	1×480
地坑要求 Foundation pit required		15	35	50	50	50

什么是喷砂房？

WHAT IS SANDBLASTING ROOM



喷砂房是一种常见的表面处理设备，通过压缩空气作为动力，将磨料喷射到工件表面清除污垢、氧化物、涂层等，增加表面附着力，是涂装之前的重要步骤。同时也可改善表面质量和增强零件强度。

Sandblasting room is a common surface treatment equipment. It uses compressed air as power to spray abrasives onto the surface of the workpiece to remove dirt, oxides, coatings, etc. and increase surface adhesion. It is the first step before painting. It can also improve surface quality and enhance part strength.

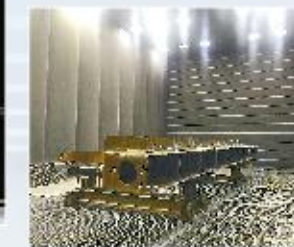
- **主要组成部分:** 房体, 地面回收系统, 磨料循环系统, 喷砂罐, 除尘器, 工件输送系统, 电控系统等。
- **适应行业:** 机械制造, 汽车行业, 建筑行业, 船舶行业, 抛丸喷漆服务业, 石材加工业等等。
- **分类:** 定制喷砂房, 标准集装箱喷砂房, 可移动喷砂房
- **地面回收系统:** 气力回收和机械回收
- **Main components:** blasting room body, floor recovery system, abrasive circulation system, sandblasting pot, dust collector, workpiece transport system, electric control system, etc.
- **Application:** machinery manufacturing, automobile industry, construction industry, shipbuilding industry, shot blasting and painting service industry, stone processing industry, etc.
- **Types:** Customized sandblasting room, standard container sandblasting room, movable sandblasting room.
- **Floor recovery systems:** pneumatic recovery and mechanical recovery.

定制喷砂房房体

CUSTOMIZED SANDBLASTING ROOM WALL

- 室体采用模块化组装而成, 可拆式拼装结构, 保证房体的稳定性。每件模块采用方管做骨架以确保运输及安装过程中不会变形, 骨架内嵌阻燃夹芯彩板, 夹层具有降噪功能。
- 喷砂室体内衬耐磨橡胶板, 防止丸料对板壁的溅击磨损, 同时增加室内照明度。
- 双开门, 卷帘门和平拉门, 可以根据工件性质进行选择。
- 工件输送系统包括平车输送, 叉车输送和悬挂输送。
- The sandblasting room is assembled from many modules and has a detachable assembly structure, which ensure the stability of the room body. Each module uses the square tubes as the basic frame which can guarantee not to deform during transportation and installation. The steel frame is embedded with a flame-retardant sandwich panel with noise attenuation inter layer.
- The sandblasting room body is lined with the wear-resistant rubber plates to prevent the abrasive from splashing & wearing on the room wall and increase the indoor illumination.
- Double swing doors, rolling doors and sliding doors can be selected according to the workpiece.
- Workpiece transport methods: flat car transportation, forklift transportation and hanging transportation.

现场照片 SCENE PHOTO



地面回收系统

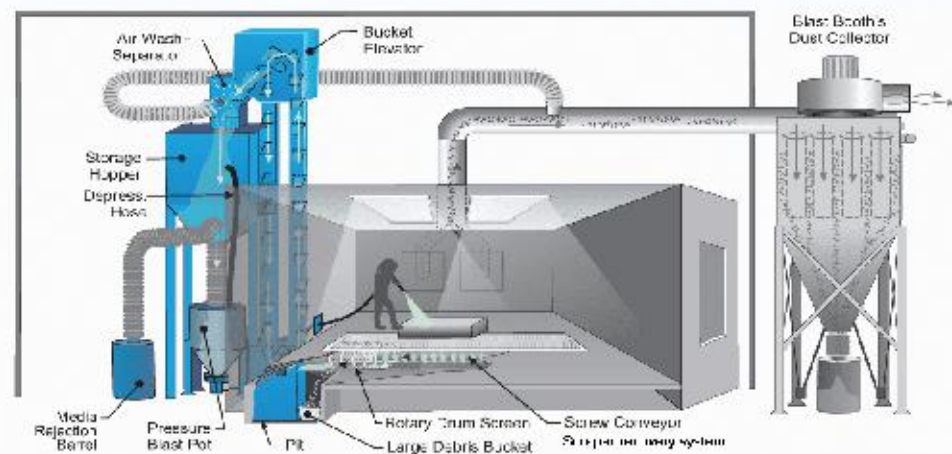
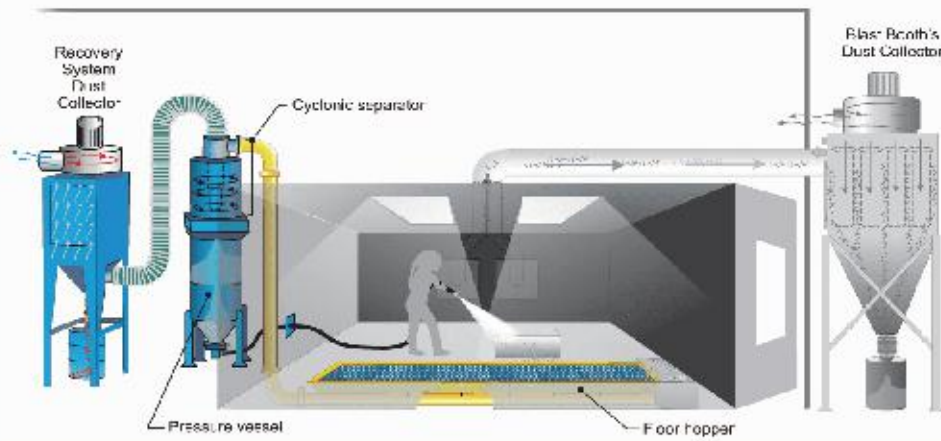
FLOOR RECOVERY SYSTEM

地面回收包括气力回收系统和动力回收系统

- 气力回收运用蜂窝式吸砂地板技术,通过风机负压产生的空气动力将砂料收集,再经管道吸送到分离器进行分离。
- 机械回收一般指刮板回收和螺旋回收。
- 刮板回收通过刮板机构来回往返运动将散落在地面上的砂料收集并输送到分离系统,实现砂料的回收和再利用。刮板采用高分子聚氨酯制作,耐磨性强。
- 螺旋回收通过螺旋轴的不断旋转,推动磨料至提升机中进行循环。

Floor recovery system including pneumatic recovery system and mechanical recovery system.

- Pneumatic recovery uses M-suction floor technology to collect abrasive through the aerodynamic force generated by the negative pressure of the fan, and then sucks it through the pipeline to the separator for separation.
- Mechanical recovery system including scraper recovery and screw conveyor recovery system.
- Scraper recovery uses the back and forth movement of the scraper mechanism to collect and transport the abrasive scattered on the ground to the separation system to realize the recovery and reuse of the abrasive. The scraper is made of high molecular polyurethane and has strong wear resistance.
- The screw conveyor recovery uses the continuous rotation of the screw shaft to push the abrasive into the elevator for circulation.



地面回收模式有半自动和全自动两种

- 半自动包括简易回收, I型回收, L型回收, H型回收, U型回收。
- 简易回收是指完整喷砂工作后人工把磨料运送至提升回收斗中,是最经济的回收模式,适合大型喷砂房。
- I型回收是指在喷砂房的纵向或者横向有一条螺旋或者刮板回收与提升机相连接回收磨料,是最常用的回收模式。
- L型回收是在I型回收的基础上在纵向添加一条刮板或螺旋,在工作的同时可以回收40%-70%的磨料。
- H型回收是指在喷砂房的纵向有两条刮板或者螺旋回收,在中间与横向的一条刮板或螺旋回收相连接,组成H型。在工作的同时可以自动回收60%-80%的磨料。
- U型回收和H型回收相似,不同的地方是横向刮板或者螺旋的位置由中间改成尾端。适合工作量小,尺寸适中的喷砂房。

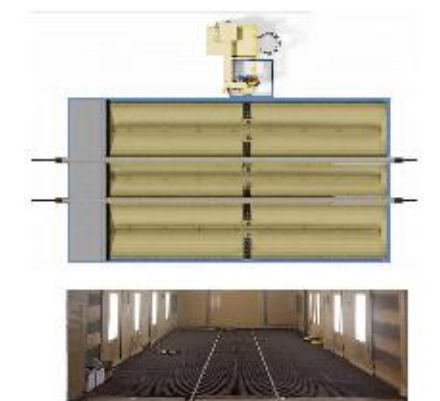
There are two floor recovery modes: semi-automatic and fully automatic.

- **Semi-automatic model** including sweep chute type, I type, L type, H type and U type.
- **Sweep/shovel chute type** is the most economical floor recovery system, which need to push the abrasive into the bucket elevator after blasting work. Suitable for big size blasting room.
- **I type** contains a screw conveyor or scraper conveyor located at the back wall of the blasting room to connect with bucket elevator. More time is required for "clean up" and to sweep the abrasive to the collection point.
- **L-type** recovery system is based on I-type and adds a scraper or screw conveyor in the longitudinal direction, which can recover 40%-70% of the abrasives while working.
- **H type**. Adds two longitudinal conveyors along each sidewall of the sandblast room allowing the abrasive delivered from the blasting nozzle, which is either blown or rebounded off the workpiece, to strike the side walls and fall into the conveyors, automatically reclaiming approximately 60%-80% of the blast media.
- **U-shaped recovery** is similar to H-shaped recovery system. The difference is that the position of the crosswise scraper or screw conveyor is changed from the middle to the end.



- 全自动回收使用多个螺旋或者刮板系统组件一个全自动的、高容量的地面回收系统,保证100%的磨料进入分离系统。节省人工的同时提高了生产效率。非常适合生产效率高的喷砂房。

The full-floor reclaim system utilizes multiple screw conveyor or scraper to create a fully automatic, high volume abrasive reclaim system where 100% of the abrasive blast media is returned to the separator system during the blasting operation. This allows for a faster reclaim as well as full recycling of the abrasive media, saving your blasting operation both time and money.



供料系统

ABRASIVE SUPPLY SYSTEM



供料系统为喷砂房必不可少的关键部件之一，主要由料仓、喷砂罐、磨料控制阀、喷嘴等组成。喷砂罐有多种规格，喷砂罐配置影响整个喷砂作业的效率 and 速度。我们会根据客户要求，配置合适规格的喷砂罐，以防生产瓶颈。

The abrasive supply system is one of the essential key parts of the sandblasting room, mainly consists of the storage silo, sandblasting pot, abrasive dosing units and sandblasting nozzle. Sandblasting pots come in a variety of specifications, and the configuration of the sandblasting pot will affect the efficiency and speed of the entire sandblasting operation. We will recommend the suitable sandblasting pot according to customer requirements to prevent production bottlenecks.

系统参数 SYSTEM PARAMETER

型号 MODEL	单位 UNIT	Q0250	Q0250A	Q0250A-I	Q0250A-I-LX
罐内容积 Volume of tank	m ³	0.3	0.52	0.7	0.7
空气压力 Air pressure	MPa	0.5-0.6	0.5-0.6	0.5-0.6	0.82
喷射量(管直径Φ10) Emitted dose(cablberΦ10)	kg/h	1800-2280	1支枪 1gun 1800-2280 2支枪 2guns 3600-4560	1支枪 1gun 1800-2280 2支枪 2guns 3600-4560	1支枪 1gun 1800-2280 2支枪 2guns 3600-4560
空气消耗量 Air consumption	m ³ /min	6	1支枪 1gun 6 2支枪 2guns 12	1支枪 1gun 6 2支枪 2guns 12	1支枪 1gun 6 2支枪 2guns 12
喷砂管长度 Length of blasting pipe	mm	15000	15000 (2pcs)	15000 (2pcs)	15000 (2pcs)
外形尺寸 Dimension	mm	720*600*1400	1120*900*1890	1122*902*1892	1088*812*2100
重量 Weight	kg	200	380	460	650



磨料循环系统

ABRASIVE CIRCULATION SYSTEM



磨料循环系统用于将喷砂房地面上的磨料输送到斗式提升机的底部, 然后提升机皮带组件将磨料提升到顶部的气洗分离器, 对回收的磨料进行筛选。

破碎后的磨料和粉尘经分离器分离, 合格的磨料将直接进入喷砂锅上方的磨料斗, 准备重复使用。无用的磨料将被分离出来, 并通过波纹管落入废料桶中。

The abrasive circulation system is used to transport the abrasive on the floor of sandblasting room into the bottom of of the bucket elevator, then the elevator belt assembly lifts the abrasive to the air wash separator on top to screen the recovered the abrasive.

The broken abrasive and dust are separated by the separator, and the qualified abrasive will directly enter the abrasive hopper above the sandblasting pot, ready to be reused. The useless abrasive will be separated out and fall into the waste barrel through the bellows.

● 斗式提升机 Bucket elevator

斗式提升机的底部开口与地板回收系统相连, 顶部开口与分离器相连。

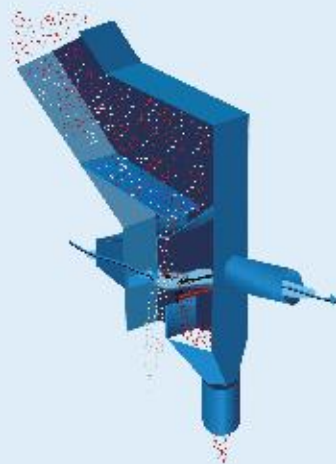
The bottom inlet of the bucket elevator is connected with the floor reclaim system, and the top outlet is connected with the air wash separator.



● 风选分离器 Air wash separator

喷砂房采用国际上最先进的流幕式风选分离器, 丸尘分离效率高达99.5%。

The sandblasting room adopts the most advanced curtain-type air wash purifier in the world, and the shot-dust separation efficiency is up to 99.5%.



除尘系统

DUST COLLECTOR SYSTEM



除尘系统主要由吸排尘管道、吸风口、滤筒除尘器、压力风机等组成。

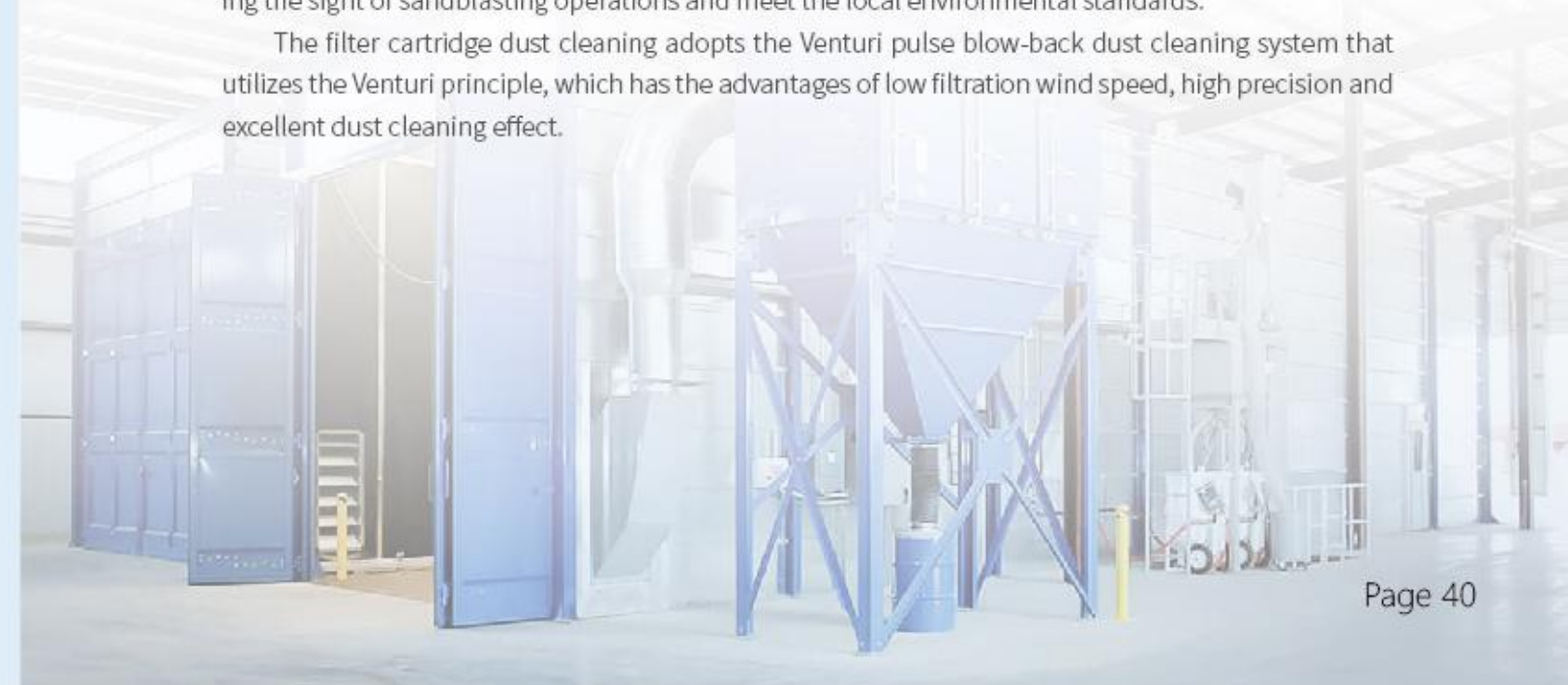
喷砂过程中工件表面破碎的锈迹、氧化皮、杂质产生的粉尘, 由除尘器及时过滤排出, 避免影响喷砂作业视线, 符合当地环保标准。

滤筒清灰采用依据文丘里原理的文氏管脉冲反吹清灰系统, 具有过滤风速低、精度高, 清灰效果好等优点。

The dust removal system is mainly composed of the suction and dust exhaustion pipes, air suction opening, cartridge filter dust collector, pressure fan, etc.

The dust caused by the broken rust, oxide scale and impurities on the surface of the workpiece during the sandblasting process is filtered and discharged timely by the dust collector to avoid affecting the sight of sandblasting operations and meet the local environmental standards.

The filter cartridge dust cleaning adopts the Venturi pulse blow-back dust cleaning system that utilizes the Venturi principle, which has the advantages of low filtration wind speed, high precision and excellent dust cleaning effect.



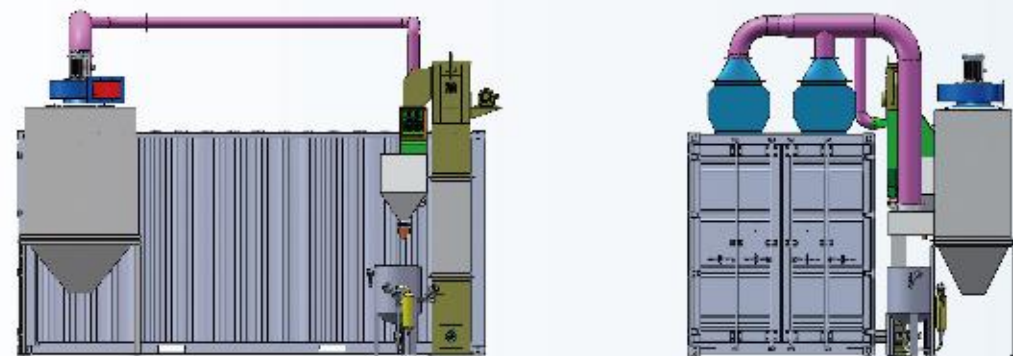
标准集装箱喷砂房

STANDARD CONTAINER SAND BLASTING ROOM



标准集装箱喷砂房是通过20尺或40尺集装箱作为喷砂室的一种固定喷砂房，配有地面回收系统，磨料循环系统，除尘器等部件，适合生产量少并且工件尺寸较小的客户。无地坑，安装简单，与定制喷砂房相比更适合放在室外。

The standard container sandblasting room is a fixed sandblasting room that uses a 20ft or 40ft container as a blasting cabinet. It is equipped with a floor recovery system, an abrasive circulation system, dust collector and other components. It is suitable for small production capacity and small size workpiece. No pit, simple installation, and it is more suitable to be placed outdoors than a custom sandblasting room.



移动式集装箱喷砂房

TRANSPORTABLE CONTAINER SANDBLASTING ROOM



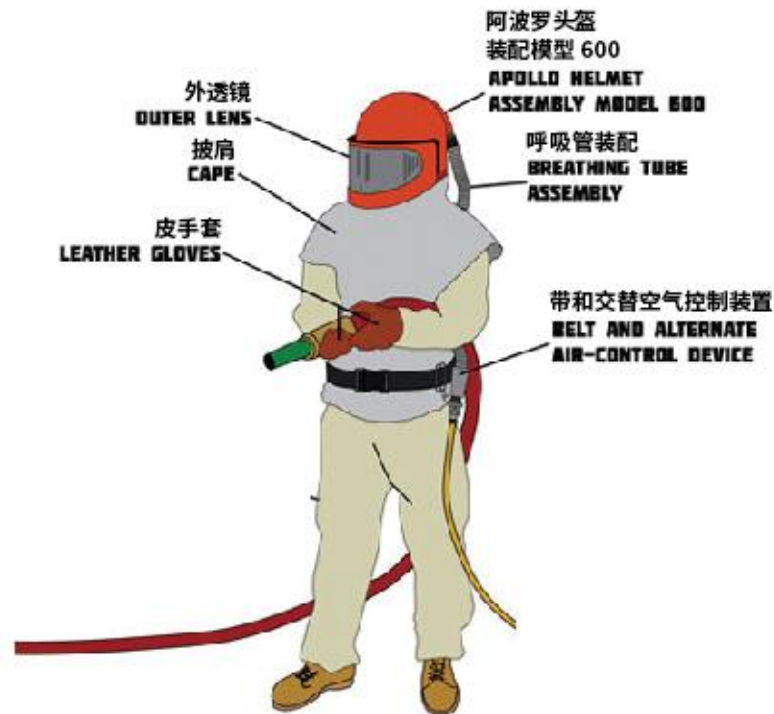
移动式集装箱喷砂房包括20ft和40ft两种型号，喷砂室，磨料循环系统，供丸系统，除尘器和电控柜等都在集装箱内，可以随时根据生产需求更换位置。无需安装，客户收到货后直接使用。

The transportable container sandblasting room includes two models: 20ft and 40ft. The blasting cabinet, abrasive circulation system, abrasive supply system, dust collector and electric control cabinet are all in the container, and can be changed at any time according to production needs. No installation is required, customers can use it directly after receiving the goods.



防护服

SANDBLASTING PROTECTIVE SUIT



防护套装可为操作者提供全面的保护。具体来讲,可保护喷砂作业人员免受具免受过热、过冷、灰尘和噪音等的影响。

喷砂服包括全身防护、头部防护、眼、耳、鼻防护、面部防护、身体防护等。

防护面具可以过滤空气、调节温度,从而使操作人员得到温度适中的清新空气,加上面具开阔的视野,大大改善了工人喷砂时的作业环境,保护了身体健康。

The sandblasting suit can provide the operator with complete protection during the sandblasting process, to be specific, the sandblasting suit can protect the operators from the excessive heat, cold, dust and noise, etc.

The sandblasting protective suits range from full protection, head protection, eye, ear, nose protection, face protection, body protection and so on.

The protective mask can filter the air and adjust the air temperature, so that the operator can get fresh air with moderate temperature. In addition, the mask has a broad field of vision, which greatly improves the working environment for operators during sand blasting process and protects their health.



喷漆房

PAINT SPRAY BOOTH

喷漆房是一个专门用于进行喷漆作业的封闭或半封闭空间。其主要功能是为喷漆操作提供一个稳定、清洁、安全的环境,以确保喷漆质量,并减少对周围环境的污染。

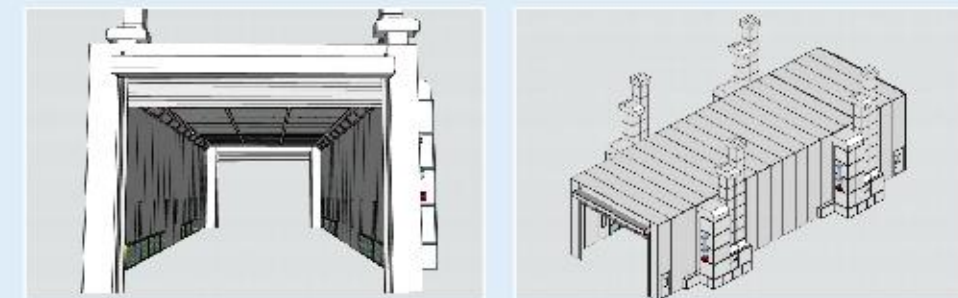
喷漆房通常配备通风系统、照明系统、空气过滤系统和喷漆设备。通风系统用于排出有害气体和漆雾,照明系统提供良好光线,空气过滤系统保证空气洁净,喷漆设备用于均匀喷涂涂料。

同时可以在喷漆房的基础上选择加热方式使其同时具备烘干的功能。

A spray booth is an enclosed or semi-enclosed space dedicated to spray painting operations. Its main function is to provide a stable, clean and safe environment for spray painting operations to ensure the quality of spray paint and reduce pollution to the surrounding environment.

The paint spraying booth is composed of booth structure system, illumination system, air supply system, circulation system, air purification system, paint mist treatment system, pressure control devices, and electrical control system, etc.

It can add a heating method based on the spray booth to have a drying function.



伸缩式喷漆房

RETRACTABLE PAINTING ROOM

伸缩式喷漆房是一种可以自由伸缩移动的喷漆作业空间,它能在使用时自动展开形成封闭或半封闭的环保喷漆环境,不使用时则收缩合拢,节省空间。避免喷漆工作时的污染车间环境。

The automatic retractable spray booth is designed for solving paint problem of heavy work piece. It is composed of multiple groups frame which can keep moving parallelly and tarpaulin to cover the work piece. The moving connection can keep the frame vertical when moving along the trail and meanwhile the tarpaulin open and close. The speed is around 7-10m/min. Due to heavy work piece can not move easily, so the folding spray booth can solve this problem easily. Before painting, firstly make the room folded, after the work piece arrived the painting place by ground trolley, then open the spray booth to cover the work piece to begin painting.

