

领先的专业铸造机械设备制造商
Advanced professional foundry machinery provide company



清理机械设备

BLAST CLEANING MACHINE

Q69系列辊道通过式清理机 Q69 SERIES PASS-THROUGH TYPE SHOT BLAST MACHINE

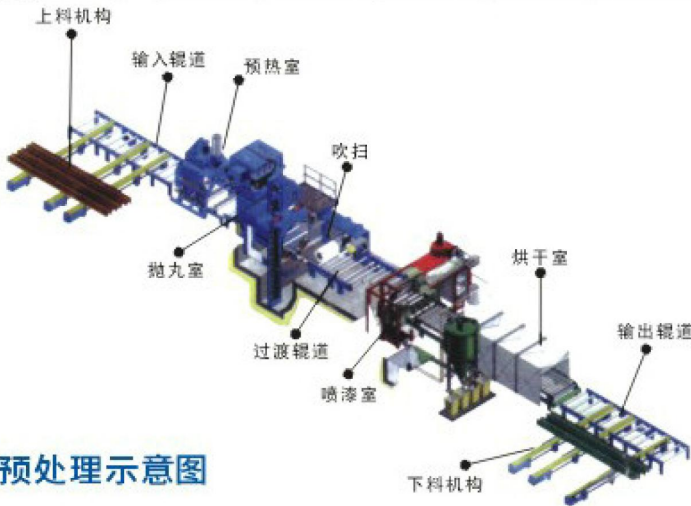
Q69系列钢板、型材抛丸清理机适用于船舶、汽车、机车车辆、桥梁、机械等行业的钢板、型材及结构件的表面除锈。

Q69 series steel plate and section steel pretreatment line is mainly composed of such stage as preheating,shot blast cleaning, painting and stove,etc.It is suitable for the surface derusting and painting craft for steel plates and sections in such industries as shipmaking,automobile making,locomotive vehicle,bridge,and machinery.



技术参数 Technique parameter

序号 Serial number	项目 Item	单位 Type	Q698	Q6912	Q6915	Q6920	Q6925	Q6930	Q6940
1	有效清理宽度 Effective cleaning width	mm	800	1200	1500	2000	2500	3000	4000
2	工件开口尺寸 Dimension of initial opening	mm	800×1600	1200×400	1500×400	2000×400	2500×800	3000×800	4000×400
3	清理工件长度 Length of clearing piece	mm	1200-12000	1200-6000	1200-12000	1200-12000	3000-12000	2400-12000	4000-18000
4	抛丸速度(无级调速) Roller speed(stepless speed regulation)	m/min	0.5-4	0.5-4	0.5-5	0.5-4	0.5-4.5	0.5-4	2-8
5	清理钢板厚度 Thickness of clearing steel plate	mm	3-60	3-60	1.5-60	3-60	3-60	3-100	4.5-100
6	处理型材规格 Specification of the treated sectional bars		□18-28	□≤204<≤164	□≤204<≤164	□≤204<≤164		□18-300×1000	
7	抛丸量 Abrasive flow rate	Kg/min	8×120	4×250	4×250	6×250	6×250	6×300	8×300
8	首次抛丸量 Abrasive initial filling	Kg	4000	4000	4000	4000	4000	8000	11000
9	刮板(刮刀)调整高度 Adjusting height of rolling brush (scraping plate)	mm	4000	200	350	450	600	850	900
10	通风量 Ventilation capacity	m³/h	22000	17500	19000	19500	27750	28000	38000
11	外形尺寸 Outline dimensions	mm	25017×4200×9015	12100×4250×7095	15200×5370×6797	30250×6850×9005	31200×6850×9005	44042×6305×7758	48000×7030×11117
12	地面以下深度 Pit depth	mm	1937	1616	2257	2800	2353	2800	4370
13	总功率(不含除尘) Total power(excluding dedusting)	Kw	90	78.3	113.5	156.6	224.55	204.8	293.6



钢板预处理示意图

QH69系列H型钢抛丸清理机

QH69 SERIES SECTION STEEL AND STRUCTURE SHOT BLAST CLEANING MACHINDS

该系列属于辊道式抛丸清理机，主要用于建筑、桥梁等行业。用大型工字型钢、H型钢尺寸较高的钢结构件消除应力及表面除锈清理。

This series of machines belong to the roller type shot blast-cleaning machine, and mainly used to de-stress and surface de-rust the steel structures, such as Large-scale H steel, etc. in the construction and bridge professions.



上料机构



技术参数 Technical parameters

型号 Type	Q698	Q6912	Q6915	Q6920	Q6925	Q6930	Q6940
项目 Item							
有效清理宽度(mm) Effective cleaning width	800	1200	1500	2000	2500	3000	4000
箱体进口尺寸(mm) Dimension of inlet opening	800 x 1600	1200 x 400	1500 x 400	2000 x 400	2500 x 800	3000 x 800	4000 x 400
清理工件长度(mm) Length of cleaning piece	1200-12000	1200-6000	1200-12000	1200-12000	3000-12000	2400-12000	4500-18000
抛丸速度(m/min) Shot speed (stepless speed regulation)	0.5-4	0.5-4	0.5-5	0.5-4	0.5-4.5	0.5-4	2-8
清理钢板厚度(mm) Thickness of cleaning steel plate	3-60	3-60	1.5-60	3-60	3-60	3-110	4.5-100
处理材料规格 Specification of the treated sectional bar	Q16-28	[<20] < 16#	[<20] < 16#	[<20] < 16#		60 x 8-300 x 1000	
抛丸量(kg/min) Abrasive flow rate	8 x 120	4 x 250	4 x 250	6 x 250	6 x 250	6 x 360	8 x 360
首次装量(kg) Abrasive initial filling	4000	4000	4000	4500	4500	8000	11000
罩料(钢板)厚度(mm) Abrasive initial filling thickness	4000	200	350	450	600	850	900
通风量(m³/h) Ventilation capacity	22000	17560	19000	19550	27758	28050	38000
外形尺寸(mm) Outline dimensions	25017 x 4500 x 9015	12180 x 4250 x 9015	15200 x 5370 x 6797	30650 x 6850 x 7095	31200 x 8070 x 7500	44042 x 6385 x 7758	45000 x 7830 x 11117
总功率(不含除尘)(kw) Total power (excluding dedusting)	90	78.3	113.5	156.6	224.55	204.8	293.6
机器总重量 Gross weight of machine	20	20.4	33	41	53.2	71.8	75

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QG系列钢管内外壁抛丸清理机

QG SERIES STEEL PIPE INNER/OUTER WALL SHOT BLAST CLEANING MACHINE

适用于钢管及钢管类产品的内外表面的抛丸处理，清除其氧化层及钢管类产品的内外表面的抛丸处理，清除其氧化层及焊渣等物，呈现出金属光泽，以利于工件喷漆及涂敷。

QG series steel pipe inner/outer wall special purpose shot blast cleaning machine is suitable for blast cleaninner/outer surfaces of steel pipes,remove the scales and weld dregs,make it show metal color,increase its ratio surface area,and thus contribute to painting and coating.

钢管内壁技术参数 Technique parameters of the steel pipe inner

清理钢管范围
Scope of the steel pipe

直径φ500-3200mm
Diameter φ500-3200mm



技术参数 Technical parameters

型号	清理管径mm	抛丸量kg/min	清理速度m/min
Type	Tidy up tube diameter	Abrasive flowrate	Tidy up speed
QGW20-50	30-500	2x250	0.5-4
QGW80-150	250-1500	2x250 2x750	0.5-4 1-10

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Q38 Q48系列悬链式抛丸清理机

Q38 Q48 SERIES HANGING CHAIN TYPE SHOT-BLASTING MACHINE

Q38 Q48连续式、步进式、积放式抛丸清理机适用于大批量中小工件的抛丸处理。工件随吊链可连续运行或步进运行或采用先进的积放推式悬链输送工件，使工件在上卸料及抛丸区分别处于停止状态，实现定点装卸及抛丸工序，单钩吊重50~2000kg，且生产率高，运行可靠，是积放链具有的特点。

This series has three types: continuous mix, step-by-step and accumulating roller conveyor. Q38 Q48 cleaning machines are suitable for processing large batches middle-and small-sized work pieces. The work pieces, along with the pendent chain, move continuously or step-by-step, or by accumulating roller conveyor transporting. They can stop at given position and shot-blasting room. It is very easy and exact to finish the static loading/unloading and shot blasting works. The single hook can load capacity of 50~2000kg, accumulating roller chains has unique advantages: high efficiency and reliable operation.



技术参数 Technique parameter

类别 Category	型号 Type	工件最大重量 Maximum weight of single piece(kg)	工件尺寸 Piece size(mm)	抛丸量 Capacity of shot- blasting(kg/min)	生产率 Productivity(件/h)	吊链速度 Speed of pendent chain(m/min)	吊链吊距 Lifting distance of pendent chain(mm)	总通风量 Total ventilation capacity(m³/min)	功率(不含除尘) Power(excluding dedusting)(kW)	外形尺寸 Outline dimensions(mm)
吊链步进 式清理机 Stepping hanging chain cleaning machine	Q483	300	Φ1000×1400	2×250	30~50	2.44	2560	6000	38.75	8460×5350×5003
	Q485	500	Φ1200×1700	3×250	30~50	7.34	2560	10000	58.43	12235×5410×9411
	Q4810	800	Φ700×2400	6×360	30~50	2.44	2560	25000	85	4900×5350×9003



Q58系列悬链式抛丸清理机

Q58 SERIES OF HANGING CHAIN TYPE SHOT-BLASTING MACHINE

Q58连续式、步进式、积放式抛丸清理机适用于大批量中小工件的抛丸处理。工件随吊链可连续运行或步进运行或采用先进的积放推式悬链输送工件，使工件在上卸料及抛丸区分别处于停止状态，实现定点装卸及抛丸工序，单钩吊重50~2000kg，且生产率高，运行可靠，是积放链具有的特点。

This series has three types: continuous mix, step-by-step and accumulating roller conveyor. Q58 cleaning machines are suitable for processing large batches middle-and small-sized work pieces. The work pieces, along with the pendent chain, move continuously or step-by-step, or by accumulating roller conveyor transporting. They can stop at given position and shot-blasting room. It is very easy and exact to finish the static loading/unloading and shot blasting works. The single hook can load capacity of 50~2000kg, accumulating roller chains has unique advantages: high efficiency and reliable operation.



技术参数 Technique parameter

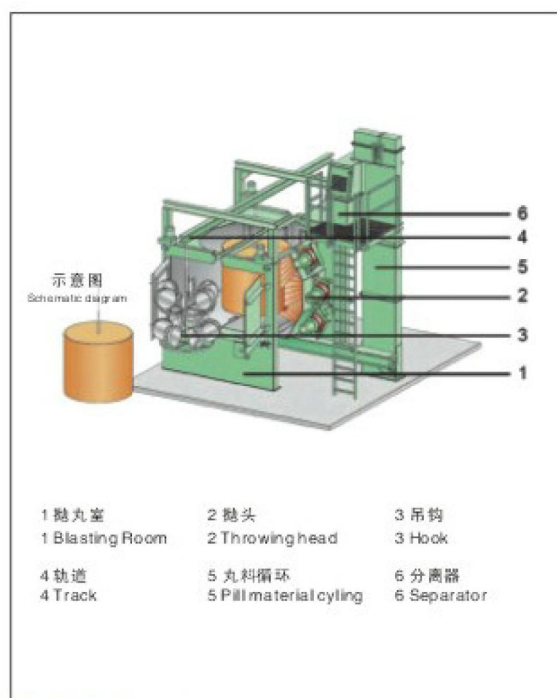
类别 Category	型号 Type	工件最大重量 Maximum weight of single piece(kg)	工件尺寸 Piece size(mm)	抛丸量 Capacity of shot- blasting(kg/min)	生产率 Productivity(件/h)	吊链速度 Speed of pendent chain(m/min)	吊链吊距 Lifting distance of pendent chain(mm)	总通风量 Total ventilation capacity(m³/min)	功率(不含除尘) Power(excluding dedusting)(kW)	外形尺寸 Outline dimensions(mm)
吊链连续 抛丸落砂 清理机 Stepping hanging chain cleaning machine	Q583	300	Φ1000×1500	4×250	30~60	变频	1000	18000	127.25	18600×5960×6440
	Q5810	1000	Φ750×2400	6×360	50	变频	2560	25000	160	17700×9515×10000

QT37系列吊钩通过式抛丸清理机

QT37-HOOK AIRLESS BLAST CLEANING MACHINE

QT37系列吊钩通过式抛丸清理机主要用于钢结构件、铸件、铝合金件及其它零件的表面清理和强化。广泛应用于铸造、锻压机械、钢铁等行业。其中QT37系列清理机具有双钩不换轨、结构紧凑、生产率高等特点。

QT37 series hook type airless shot blast cleaning machine is mainly used for surface cleaning and strengthening of steel structural parts, castings, aluminum alloy parts and other spare parts. It is widely used in foundry, forging, mechanical and steel industry. This series has following advantages: no pit, double hook without rail exchanging, compact structure, and high productivity.



技术参数 Technique parameter

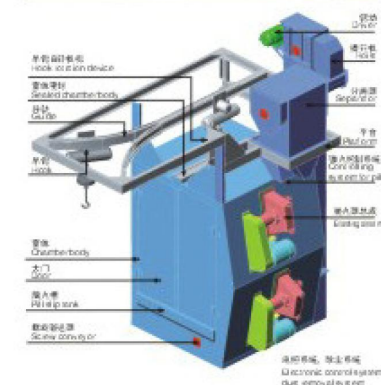
工作最大外形尺寸Maximum dimensions of work piece (直径x高Diameter x height)	Φ3000x2400
挂件最大单重Maximum single weight of hanging workpiece	1000kg
自转速度Rotation speed	3.14 r/min
抛丸器Blasting device	Q034
叶轮直径Impeller diameter	Φ420mm
单台抛丸量Shot-blasting capacity of single machine	250kg/min
铸件清理工作时间Processing time for cleaning castings	8-10min
锻焊件及锻件Processing time for cleaning welding parts and forgings	12-15min
清理室内腔尺寸Interior cavity size for cleaning room (长x宽x高 Length x width x height)	3500x3500x3200mm
大门移动速度Door-moving speed	0.12m/S
弹丸直径Diameter of pill	Φ0.5-1.2mm
总风量Total air volume	18000m³/h
总功率Total power	~85 KW
设备最大尺寸Maximum size of equipment (长x宽x高 Length x width x height)	~11200x9800x8830

Q37系列吊钩式抛丸清理机

Q37SERIES HOOK TYPE SHOT BLASTING MACHINE

Q37系列吊钩式抛丸清理机主要用于钢结构件、铸件、铝合金件及其它零件的表面清理和强化。广泛应用于铸造、锻压机械、钢铁等行业。其中Q37系列清理机具有无地坑、双钩不换轨、结构紧凑、生产率高等特点。

Q37 series hook type airless shot blast cleaning machine is mainly used for surface cleaning and strengthening of steel structural parts, castings, aluminum alloy parts and other spare parts. It is widely used in foundry, forging, mechanical and steel industry. This series has following advantages: no pit, double hook without rail exchanging, compact structure, and high productivity.



技术参数 Technique parameter

产品型号	清理工作尺寸	单钩吊重	抛丸量	提升机提升量	分离器分离量	通风量	功率 (不含除尘)	外形尺寸
Type	Size of workpiece cleaned	Carrying weight of single hook	Capacity of shot-blasting	Lifting capacity of hoist	Separating capacity of separator	Ventilation capacity	Power (excluding dedusting)	Outline dimensions
	mm	kg	kg/min	t/h	t/h	m³/h	kw	mm
Q376	Φ600×1100	500	2×120	15	15	5000	19	4429×2850×3443
Q378	Φ800×1500	1000	2×200	22	22	8000	32.5	4325×2660×5009
Q3710	Φ900×1600	1000	2×250	30	30	9000	36.55	5047×3850×5156
QD3710	Φ900×1600	1000	2×250	30	30	9000	39.65	5844×2742×5716
Q3720	Φ1400×2300	2000	3×250	45	45	15000	61.27	6110×3599×7842
Q3730	Φ1600×2300	3000	3×250	45	45	15000	64.4	7085×4650×8652
Q3750	Φ1800×2500	5000	4×250	60	60	18000	78.4	7062×5460×8652
Q3780	Φ2000×3000	8000	4×250	60	60	20000	81.5	8050×6400×8526

抛喷丸转台式清理机 (Q35/Q36/Q76)

TURNTABLE SHOT BLAST MACHINE (Q35/Q36/Q76)

该系列设备用于钢结构件和铸件的表面清理及强化,更适用于厚钢胚的表面除锈及表面氧化皮的清理,广泛应用于铸造、锻压、机械、钢铁行业。

This machine mainly used in cleaning and strengthening the surface of the castings, and used in removing oxide and welding dregs. It is widely suited for the field of oil casting, forging, machinery, iron and steel industry.



Q7620台车式清理机

Q7620 trolley cleaner

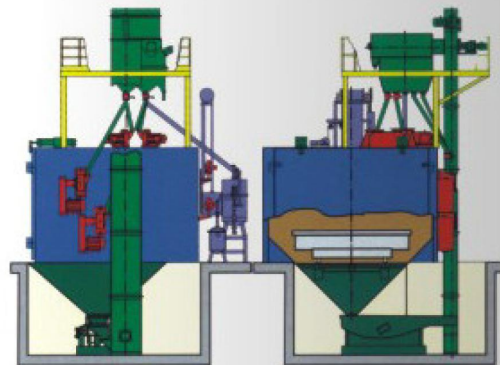
技术参数 Technique parameter

类别	型式	清理工件尺寸	工件最大重量	抛丸量	提升机提升量	分离器分离量	通风量	功率(不含除尘)	外形尺寸
	type	mm	kg	kg/min	t/h	t/h	m³/h	kW	mm
Q35系列 台车式抛丸清理机	Q3512	600x250x250	400	200	15	350	2400	17.3	1500x3450x3780
	Q3525	1000x500x250	1000	2x250	30	150	6200	35.2	2200x3500x4300
Q36系列 台车式抛丸清理机	Q365C	2500x1300	5000	2x250	40	40	13200	39.2	9000x4200x9290
	Q3610	2500x1500x280	10000	4x250	60	60	240000	188.45	14900x5000x8700
	Q3620	4000x3000x700	20000	4x250	75	75	21000	185.25	16900x6540x10020
Q76系列 抛喷丸台车式清理机	Q765C	2000x1000	5000	2x250	30	30	11000	35.8	5000x5200x9290
	Q7610	2500x1500x280	10000	3x250	45	45	15000	188.45	14500x5200x6100
	Q7620	4000x3000x700	20000	4x250	60	60	21500	183.35	16900x6540x10028
	Q7630	4000x2000	30000	4x250	60	60	21500	83.2	9168x7650x10874



Q35系列抛丸清理机

Q35 series airless shotblast machine



15GL履带式抛丸清理机

15GL APRON SHOT BLAST MACHINE

该机是引进美国PANG BORN公司专利技术生产,具有高强度的机身壳体,合理的链转动系统,高质量的铸造链环等特点,具有生产率高,寿命长、易维修等特点。

The machine is made by introducing patent technology from PANG BORN Co, of USA; it high-strength machine body and case, reasonable chain-driving mechanism, and high-quality cast chain iron; and it has the advantages of high productivity, long service life and easy maintenance.

技术参数 Technique parameter

生产率Productivity	6th
加料量Feeding amount	1350kg
单件最大重量Maximum weight of workpiece	250kg
端盘直径Diameter of end disk	Φ1092mm
除尘风量Ventilation capacity of dust collector	500m³/h
工作最大尺寸Maximum size of workpiece	550mm
有效容积Effective volume	0.48m³
抛丸量Abrasive flow rate	480kg/min
功率消耗Power consumption	48.7kw



网带式抛丸清理机 (QWD系列)

SHOT WITH NET-CLEANING MACHINE (QWD SERIES)



该系列主要用于薄壁铸件、薄壁和脆弱的铁或铝合金铸件、陶瓷等小型零件的表面抛丸清理,亦可用于机械零件抛丸强化。具有连续性好,清理效率高,变形小、无地坑等特点;即可单独使用,又可配线。

The series mainly for thin-walled castings, and the fragile thin-walled aluminum or cast iron, ceramics, and other small parts on the surface of the blast cleaning can also be used Shot in the strengthening of machine parts. Continuity is good, clean high-efficiency, small deformation, and on hole, and other characteristics; can be used alone, but also distribution.

技术参数 Technique parameter

型号	QWD60	QWD80	QWD100	QWD120
网带宽度mm	600	800	1000	1200
清理速度	0.5-4	0.5-4	0.5-4	0.5-4
抛丸量	4x120	4x120	4x180	4x250



Q32系列履带抛丸清理机

Q32 SERIES CRAWLER TYPE SHOT BLASTING MACHINE

本机适合多品种、大中批量生产工作的表面除锈或抛丸强化，清理工作必须是不怕碰撞的铸件及热处理件，该机既可单机使用，又可配线使用。

This machine can be used to derust and streng then the surface of workpieces with mass productions.The workpieces must accept collision.This series machines can be singly used or together with others.



技术参数 Technique parameter

项目 Item	单位 Units	Q326C	QR3210	15GN	28GN
生产率 Productivity	t/h	0.6-1.2	1.5-2.5	5-6	10-12
加料量 Feeding amount	kg	200	600	1300	3500
单件最大重量 Maximum weight of single piece	kg	10	30	230	363
端盘直径 Diameter of end disk	mm	Φ650	Φ1000	Φ1092	Φ1245
有效容积 Effective volume	m³	0.15	0.3	0.43	0.79
抛丸量 Shot-blasting capacity	kg/min	100	250	480	700
除尘风量 Air volume for dedusting	m³/h	2200	5000	5300	6500
功率消耗 Power consumption	kW	12.6	24.3	49.3	64.5
外形尺寸 Out line dimention	MM	3681x1650x5800	3972x2600x4768	4597x3262x5709	5300x5432x6814



QH218抛丸清理机

QH218 THROW PILL TO TIDY UP MACHINE

本设备是我公司根据意大利产品技术独立研制的一种新型设备。工件清理通过皮带将工件移动到清理室，边向前移动边进行清理，自动化程度高，工件变形量小，大大减轻了工人的劳动强度。主要用于刹车片等薄型件的清理。

This is my equipment in accordance with Italy' s independent technology develop edby a new type of equipment. Clean-up work through the belt will be moved to the clean-up work Room,while moving side to sort out,a high degree of automation,small workpiece deformation, reduce labor intensity. For the brake. Thin films such as cleaning up the pieces.

技术参数 Technique parameter

项目	Type	单位 Unit	参数 Parameters
工件尺寸	Workpiece size	mm	600x200
抛丸量	Shot volume	Kg/min	2x160
提升量	Enhance the capacity	T/h	30
分力量	Separation volume	T/h	30
工件运行速度	Workpiece speed	M/min	0-4
通风量	Ventilation	m³/h	8000
功率	Power	Kw	40



ZJ210圆簧抛丸清理机

ZJ210 CIRCLE SPRING SHOT BLASTING MACHINE

该系列抛丸清理强化机是我公司独立研制的一种新型设备,主要清理对象有圆簧、缸套。它具有以下优点：

采用两个大抛丸量、高抛射速度的国际上第四代玄离心式V+S抛丸器；分离器采用美国清邦恩公司BE型满幕帘式分离器技术；整个设备的弹丸循环系统都采用自动检测装置；工件强化通过辊道将工件移动到清理室，边旋转边向前移动边进行强化。

That series throws pill to tidy up to enhance a kind of new equipments that the machine id my company to independently develop and mainly is my company to independently develop mainly tidy up object have a spring, urmset. It has the following excellent Order:

Adopt two greatly throw amunt of pill, Gao Pao She4' s speed of international top the fourth generation hang to leave a hear typr v+the s throw a pill machine; The whole bullet circulatory systems of equipments adopts an automatic examination to equip; The work piece enhances to move the work picce to tidy up through a Gun wayRoom, the side revolves a side to move a side to carry on enhance forward.

