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## Roller Conveyor Shot Blasting Machine

### Pavers Shot Blasting Machine



Pavers Shot Blasting Machine Pavers shot blasting machine is special equipment for pavers roughing which is dedicated designed by our company for the pavers processing industry. It is mainly used to increase the friction coefficient of the surface of the pavers and improve the surface decoration effect. After being processed by the pavers shot blasting machine, the surface of the pavers will show an effect similar to that of the litchi surface. Widely used in the fields of marble wall hanging and anti-skid on the ground. For the moment, more and more ground paving prefers the rough surface, has a board market prospect.

#### Main features of Pavers Shot Blasting Machine

Simulated shot diagram (including the determination of the model, number and spatial arrangement of the impeller head) and all drawings of the stone shot blasting machine are completely drawn by CAD. And after many times of practical experience optimize, to achieve a more perfect shot effect.

The body of the cleaning room is made of a high-quality Q235A steel plate (thickness 8-10mm). The inner wall is lined with a 10mm thick "Rolled Mn13" protective plate which has the reputation of "the best protective plate" and "lifetime", and adopts the "Block type" protective plate layout.

The Impeller Head is based on fully absorbing Shinto. Japan technology, and after continuously optimized, independently designed and manufactured by ourselves, with the feature of large blasting volume and high shot speed.

Adopting advanced "BE" type full-curtain Separator, and this separator was independently developed by our company on the basis of completely absorbed the technology of Swiss GEORGE FISCHER DISA (GIFA) and American Pangborn company, with perfect separation effect.

**Steel shot control system:**

The shot gate valve controlled by the cylinder is used to control the supply of the steel shot at a long distance, We can through adjust the bolts on the shot controller to obtain the required shot blasting amount. This technology is independently developed by our company.

### The Application of Pavers Shot Blasting Machine

It consists of the following components: Shot blasting room, Front sealed chamber, Rear sealed chamber, Feeding in roller table, Sending out roller table, Longitudinal screw conveyor, horizontal screw conveyor, Bucket elevator, Separator, Platform, Roller in blasting chamber, Dust removal system, Electrical system, Steel shot distribution system, Screw conveyor, etc.

### Working Principle of Pavers Shot Blasting Machine

During the cleaning process, the frequency conversion motor drove the roller table to send the work-piece into the shot area of the cleaning room.

The impact of the powerful and dense steel shot in the coordinate direction makes the corroded skin and dirt on the pavers drop rapidly, and the stone obtains a smooth surface with a certain roughness.

The steel shot and rust falling on the top surface of the work-piece is transported to the projectile circulation through the screw conveyor.

Under the operating of the industrial shot blasting machine, the surface of the pavers will quickly erode the flat surface into a three-dimensional litchi surface and fire surface.

This processing method has a fast processing speed, usually each team can handling more than 2000 square meters (according to 8 hours), it is very popular with customers.

Name	Q698	Q6910	Q6912	Q6915
cleaning dimention	plate	length(mm)	2000-9000	2000-9000
width(mm)	800	1000	1200	1500
tkickness(mm)	2-35	2-35	2-40	2-45
section steel height(mm)	width(mm)800 ≤1600	800 ≤1600	800 ≤1800	1000 ≤2000
speed	m/min	0.5-3	0.5-3	0.5-2
blasting quantity	kg/min	4*250	4*250	4*250
section steel abrsive caacity	kg/min	8*250	8*250	10*250
ventilation capacity	m3/h	8000-14500	9000-14500	12000-18000

# Steel Plate Shot Blasting Machines



Steel Plate Shot Blasting Machine strongly blasts the sheet metal and profiles to remove surface rust, welding slag and scale, making it the slow uniform metal color, improve coating quality and corrosion prevention effect. Its processing ranges from 1000mm to 4500mm, and it can easily integrated into preservation lines for automatic painting.

## Details of BESTECH Steel Plate Shot Blasting Machine

This production line consists of a feeding roller table, a workpiece detection device, shot blasting cleaning, shot material circulation system, cleaning device, chamber roller table, feeding roller table, shot blasting dust removal system, and electric control system.

The workpiece is moved to the feeding roller table by the loading forklift or row crane, and then sent to the closing shot blasting cleaning room by the roller table conveyor system. Impact on the surface of the workpiece, scrape to remove the rust and dirt on the surface of the workpiece, and then use the roller brush, pill collection screw and high-pressure blowpipe to clean the accumulated particles and floating dust on the surface of the workpiece, and then send it out of the purge chamber by the roller conveyor. Arrive at the delivery roller table, and then transport to the designated unloading rack via forklift or crane.

## Advantages of BESTECH Steel Plate Shot Blasting Machine

The shot blaster layout is computer-simulated and arranged in a diamond shape. The upper and lower shot blasters correspond to each other to improve the utilization rate of the abrasive. Make the abrasive coverage uniform.

## BESTECH Steel Plate Shot Blasting Machine

1. Shot blasting Chamber guard plates adopt 8mm thick impact-resistant and wear-resistant 65Mn, and adopts building block installation method. The arrangement of the guard plate more effectively improves the room protection effect. The number of shot blasters can be determined according to the size of the workpiece, which can reduce unnecessary energy waste and reduce unnecessary damage to the equipment.

2. Separation device adopts advanced full-curtain flow curtain-type slag separator, and the separation efficiency can reach 99.9%

3. Workpiece detection device, effectively controls the opening and stopping time of the shot blasting machine, avoid the empty emptying of the shot blasting machine, save energy, and improve the lives of the wearing parts such as the room guard plate and the shot blasting machine.

4. Automatic fault detection and alarm, and automatic stop after the delay.

5. Dust removal system adopts high-efficiency filter drum dust collector, the dust emission is within 100mg / m<sup>3</sup>, and the workshop dust emission is within 10mg / m<sup>3</sup>, which greatly improves the worker's operating environment.

6. The bearing protection at both ends of the elevator, separator, and screw conveyor adopts a labyrinth sealing device and a U-shaped boss structure. The separation screw and screw conveyor discharge ports are arranged at a distance from the end, and at the end of the screw Add reverse conveying blades.

7. The hoist adopts special polyester wire core hoist transmission belt, and the upper and lower reels of the hoist adopt chamfered squirrel cage structure, which not only increases friction to avoid slipping, but also prevents scratching of the belt. Each power point of the abrasive circulation system is provided with a fault alarm function.

8. The large nut fixed by our company adopts cast special iron nut, its structure and the contact surface of the protective plate are larger, and it is more effective to prevent the broken ring caused by the abrasive entering the shell due to the loosening of the nut.

9. abrasive cleaning

10. In order to meet the requirements of higher production efficiency, we use:

11. First-level cleaning: high-strength nylon roller brush + pill collecting screw; cleaning brush life ≥5400h

12. Secondary air blowing: high-pressure fan blows shots and blows dust inside and outside the cleaning chamber to ensure that there are no shots on the surface when the steel plate is cleaned out of the cleaning room.

13. Roller drive adopts stepless frequency conversion speed regulation (using a frequency converter, the manufacturer is generally Mitsubishi, can also be specified), instead of speed regulation motor, the entire workpiece conveying system frequency conversion stepless speed regulation. (Speed range 0.5-4m / min)

14. Input, output and segmented transmission of the chamber roller table, stepless speed regulation, that is, it can run synchronously with the entire line, and can also run quickly, so that the steel can quickly travel to the work position or quickly exit to the discharge station purpose.

15. Adopt full line PLC programmable controller power, automatic detection and automatic search for fault point, sound and light alarm.

16. The equipment has a compact structure, a reasonable layout, and is very convenient for maintenance.

### **Application of Steel Plate Shot Blasting Machine**

Steel Sheet Shot Blasting Machine is designed based on a roller conveyor and especially developed to meet the needs of the fabrication industry, the range of machines descales and removes rust prior to fabrication. Rolled steel plate, shapes and fabrications are used across a wide range of sectors, from construction to shipbuilding. It provides a better surface for welding and improves coating adhesion. Large sections can be cleaned quickly, saving time and reducing bottlenecks in production.

Name	Q698	Q6910	Q6912	Q6915	Q6920	Q6925	Q6930	Q6935		
cleaning			2000-	2000-	3000-	3000-	4000-	4000-	6000-	6000-
dimention	plate	length(mm)	9000	9000	9000	9000	12000	12000	12000	12000
width(mm)	800	1000	1200	1500	2000	2500	3000	3500		

thickness(mm)	2-35	2-35	2-40	2-45	3-50	4-60	5-60	6-60	
section steel width(mm)	800	800	800	1000	1400	1800	2000	2500	3000
height(mm)	≤1600	≤1600	≤1800	≤2000	≤2000	≤2500	≤2500	≤3000	
speed	m/min	0.5-3	0.5-3	0.5-2	0.5-2.5	0.5-2.5	0.5-2	0.5-2.5	0.5-3
blasting quantity	kg/min	4*250	4*250	4*250	4*250	4*250	6*250	6*250	6*250
section steel abrsive caacity	kg/min	8*250	8*250	10*250	10*250	10*250	12*250	12*250	16*250
ventilation capacity	m3/h	8000-14500	9000-14500	12000-18000	13000-24000	13000-24000	16000-28000	16000-28000	18000-28000

## Spring Shot Blasting Machine



Spring shot peening machine are mainly used for shot peening coil spring, suspension, valve and leaf springs. Shot peening is a process specially designed to increase the fatigue strength of components subjected to alternating stress. It mainly improve the fatigue fracture and stress corrosion fracture resistance of the springs, and it also strengthened the reliability and durability of the springs. Bestech spring shot peening machine systems deliver reliable process-safe treatment of workpieces of all geometries, sizes and qualities. The systems are flexible, and so offer longterm investment security if process or production requirements change.

### Key Benefits of Spring Shot Blasting Machine

The Bestech's Peening machines has lower production costs, this due to automatic operation, high output and uniform quality.

The blasting turbines are high specific blast performance, parts are estechestechalways shot peened in the hot spot of the blast stream, so the blast effect are optimied.

The machines feature with High energy efficiency and high economy. Blast wheels fully exploit the energy applied and transform it to blast effect.

The well proven separation system always maintains the shot operating mixture within the desired nominal size.

### Features of Spring Shot Blasting Machine

Continuous throughfeed operation is simple, safe and ideally suited for fully automatic production.

Flexible loading / unloading concepts ideally meet user requirements.

Automatic systems with high performance and manufacturing consistency reduce production costs.

Adjustable dwell times and throughput speeds ensure process-safe, defined peening in uniform quality.

## Applications of Spring Shot Blasting Machine

Shot peening machine are mainly used for shot peening suspension, valve and leaf springs.

Shot peening is a process bestech specially designed to increase the fatigue strength of components subjected to alternating stress. It mainly improve the fatigue fracture and stress corrosion fracture resistance of the springs, and it also strengthened the reliability and durability of the springs.

## Spring Shot Blasting Machine

Shot peening machine are mainly used for shot peening suspension, valve and leaf springs. The impact of the high velocity projectile stream on the surface of the spring causes the surface to produce a cyclic plastic strain layer, thereby causing a favorable change in the microstructure of the spring skin and introducing the skin into the residual compressive stress field.

Shot peening is a process specially designed to increase the fatigue strength of components subjected to alternating stress. It mainly improve the fatigue fractu

In the process of shot peening, the electrically controlled adjustable conveyor roller feeds the springs into the shot peening zone of the machine chamber, and the entire surface of the springs is exposed into the accelerated peening media, the high velocity abrasiv hits and rubs the surface of ssprings, so that the scale, rust layer and dirt are quickly detached, and the surface of the spring obtains a smooth surface with a certain roughness.

Model	QWD60	QWD80	QWD100	QWD120
Belt width	600mm	800mm	1000mm	1200mm
Blasting speed	0.5-4m/min	0.5-4m/min	0.5-4m/min	0.5-4m/min
Shot blasting capacity	4x120kg/min	4x120kg/min	4x180kg/min	4x250kg/min

## Wind Tower Shot Blasting Machine



Vertical Wind Power Tower Shot Blasting Machine is specialized for Large Wind Power Tower, Large Steel pipe

### Wind Power Tower Shot Blasting Machine Description:

The large wind power tower drum in more than 2000 mm in diameter, on a fixed roller frame, to rotate 360 degrees, the outer wall of the mobile tower drum for shot blasting machine start dust removal system in turn Hoist separator shot blasting machine and so on, then start to track drive system again, in longitudinal direction, in turn, to go forward, tower drum inside and outside wall surface peening processing, according to the different diameter of the specifications of the tower drum, adopting Siemens photoelectric detection system, which can realize hydraulic automatic height measurement, shot blasting machine with the detection automatically adjust the best shot distance, for high quality of blasting of intensive and operational security offers help, both inside

and outside wall blasting can be through at a time, The cleaning degree of its surface can reach Sa2.5 level above, which highlights the shot blasting effect and improves the adhesion for antiseptis.

#### Main Features

1. When the traveling speed of the present body and the rotating speed of the cylinder are equal and opposite directions, the wind power tower barrel shot blasting machine can generate a relative static motion inside the cylinder body.
2. It is flexible and convenient to move inside the barrel of the wind-blasting tower shot blasting machine, and it can walk in the horizontal and vertical directions.
3. By adjusting the lifting mechanism of the walking wheel, the cylinders of different diameters can ensure that the throwing mouth and the workpiece can maintain good contact without leaking steel grit.
- 4, adapt to the wind turbine tower shot blasting machine cylinder diameter range is wide, so that the equipment can be easy to operate and easy to use.

## Wire Rod Shot Blasting Machine



Wire Rod Shot Blasting Machine is Specialized in for cleaning surface of steel wire

This machine is the best special equipment which used to cleaning the wire rod, it clean the scale cinder on the surface of the wire and the squama layer on the rolled steel through the blasting process. The surface descaling grade of the steel billet rust reach Sa2.5 level after cleaning, and the surface roughness level reach Ra6.3 ~ 12.5 $\mu$ m. Compared to pickling treatment, it have the characteristics of economy, environmental protection and high efficiency.

Model	QSM40	QSM24
Line section dimension(mm)	5.5~40	6~24
Processing speed (m/min)	MAX120	22~150
Shot blating machine quantity	4	4
Shot blasting machine power(kw)	4*18.5	4*22
Total power(kw)	100	162.75
Outline size	3440*1575*3630	3200*1800*4500

# Stone Grinding Shot Blasting Machine



Roller Conveyor Stone shot blasting machine are used for making rough surface of paver blocks, glaze tiles, marbles, granites, for making antiskides and safe for walking.

Roller Conveyor Stone shot blasting machine are used for making rough surface of paver blocks, glaze tiles, marbles, granites, for making antiskides and safe for walking. The stone and ceramic blast machine comprises continues rubber belt type, where the job is loaded on inlet conveyor and shot blasted tiles with antiskid effect are unloaed outlet side.

**Main Technical Parameters**  
(Roller Conveyor Stone Shot Blast Cleaning Machine)

Item	Description		Unit	Model		
				QGSC-600	QGSC-800	QGSC-1000
1	Effective Cleaning Dimension (W * H)		mm	600*200	800*200	1,000*200
2	Roller Speed (Frequency Control)		m/min	0.5~6	0.5~6	0.5~6
3	Blasting Wheel	Model	/	QG034- I	QG034- I	QG034- I
		Power	kw	2*11	2*11	2*11
4	Dust Collector	Ventilation Qty.	m <sup>3</sup> /h	7,000	10,000	10,000
		Power	kw	7.5	11	11
6	Total Power		kw	43.4	46.9	47.7
Remarks	More models of machine are available at your request. Some of the technical parameters to be further defined after discussion with customers.					



# Steel Plate Roller Conveyor Shot Blasting Machine



Roller Conveyor Shot Blasting Machine is heavy duty blast cleaning equipment. Roller conveyors are made of three parts, feeding rollers, middle rollers and out-feeding rollers.

Roller Conveyor Shot Blasting Machine is heavy duty blast cleaning equipment. Roller conveyors are made of three parts, feeding rollers, middle rollers and out-feeding rollers. Feeding rollers deliver work pieces to middle rollers in blasting chamber where work pieces will be blasted by blasting wheels mounted on the blasting chamber walls. Out-feeding rollers deliver blasted and finished work pieces out of blasting chamber for unloading.

Feeding rollers and out-feeding rollers are driven by variable speed reducers. Roller speed can be adjustable according to work pieces surface condition and metal surface finish level.

Item	Unit	Q698	Q6912	Q6915	Q6920	Q6930	Q6940
Effective cleaning width	mm	800	1200	1500	1800	3200	4200
Width of feed inlet size	mm	1000	1400	1700	2000		
Length of the workpiece	mm	1200-12000	1200-13000	1500-13000	2000-13000	≥2000	≥2000
Transmission speed	M/min	0.5-4	0.5-4	0.5-4	0.5-4	0.5-4	0.5-4
Shot volume abrasive flow rate	Kg/min	8*180	8*180	8*250	8*250	8*360	8*360
The first time loading capacity	kg	4000	5000	5000	6000	8000	10000
Ventilation	M <sup>3</sup> /h	20000	22000	25000	25000	28000	38000

# Steel Plate Structure Shot Blast Cleaning Machine



Steel Plate Structure Shot blast cleaning Machine for cleaning and strengthening metal surface,it can remove oxide mill and rust for different kind of steel profiles.

## Product Features:

Steel Plate Structure Shot blast cleaning Machine for cleaning and strengthening metal surface,it can remove oxide mill and rust for different kind of steel profiles.

Widely used,high automation, auto feeding/discharging of workpiece, meeting request for production line.

## Production Application:

Steel Plate Structure Shot blast cleaning Machine applies to shipping,car, motorcycle, bridge, machine industries etc. It mainly used for eliminating the stress and surface removing rust of large steel structure,H beam and so on.

We can design and manufacture all kinds of non-standard shot blasting machines

<b>Q69 shot blasting machine</b>					
Parameter	Q698	Q6912	Q6915	Q6920	Q6925
The effective cleaning width (mm)	800	1200	1500	2000	2500
Dimesion of inlet opening	1600*800	1200*400	1700*400	2200*400	2700*800
The length of cleaning workpiece (mm)	1200-12000	1200-12000	1200-12000	1200-12000	3000-12000
The speed of conveyor (m/min)	0.5-4	0.5-4	0.5-4	0.5-4	0.5-4
The thickness of cleaning steel sheet (mm)	3-60	3-60	1.5-60	3-60	3-60
Shot ball flow rate (kg/min)	4*120	4*250	4*250	6*250	6*250
The shot ball first loading (kg)	4000	4000	4000	4500	4500
Roll brush adjusting height (mm)	200	200	350	450	600
Air capacity (m3/h)	22000	17560	19000	19550	27758
Total power (kw)	90	78.3	113.5	156.6	204.8

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