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## Steel Pipe Shot Blasting Machine

### Pipe Cleaning Machine



This shot blasting machine is special for cleaning elbow pipe , steel pipe and irregular - shaped tubes and soon on

Qingdao Bestech designs and manufactures fully automated upblast or downblast Pipe Machines for surface profiling and removing rust and mill scale from welded steel pipe. Pipe must be cleaned and dust free prior to the coating process.

Qingdao Bestech works with customers to determine the their requirements and will consider many factors, including:

Steel abrasive types

Profile requirements

Surface cleaning requirement

Line speed requirement

Qingdao Bestech works closely with coating manufacturers to assure proper mill profile is achieved to give the best adherence of coating.

The pipe is conveyed through the wheel shot blasting machine on a specially designed external skew roll type material handling system. An extensive range of high production blast cabinets are available to handle from 5cm (2") to 366cm (144") diameter pipe at variable cleaning speeds.

Qingdao Bestech pipe machines include an air wash and dust collection system that work together to remove contaminants and fines, control dust and maintain correct abrasive size.

| Parameter | Diameter (mm) | Cleaning speed(m/min) |
|-----------|---------------|-----------------------|
| QGW100    | 50-300        | 1-4                   |
| QGW700    | 325-720       | 1-4                   |

|         |           |     |
|---------|-----------|-----|
| QGW1000 | 720-1016  | 1-4 |
| QGW1500 | 1016-1500 | 1-4 |
| QGW2000 | 1500-2000 | 1-4 |
| QGW2500 | 2000-2500 | 1-4 |
| QGW3000 | 2500-3000 | 1-4 |

## Internal Pipe Shot Blasting Machine



Internal pipe blasting machine are suitable for internal pipe blast cleaning process which internal diameter from 50mm to 500mm, meanwhile, it can blast cleaning 1 to 6 pieces at one time.

### Applications

Technically speaking, Bestech's internal pipe blasting equipments are divided into air blasting equipments and wheel blasting equipments. the air blasting equipments are mainly for small pipes which diameter under 700mm, and it can blast processing up to 8 pieces at one time by with automatic pipe handling systems. the wheel blasting equipments are mainly for big pipes which diameter above 500mm, and it can only blast cleaning one piece at a time.

This kind of blasting equipment can not only clear the dirt, scale, welding slag, etc. from the internal pipes, but it also can reduce the internal surface stress. Thus, this kind of equipment can vastly increase the service life of the steel pipe and reduce the internal corrosion of the steel pipe, thereby improving the intrinsic and appearance quality of the steel pipe.

### Internal Pipe Blasting Machine Introduction

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To sum up, it has the following advantages:

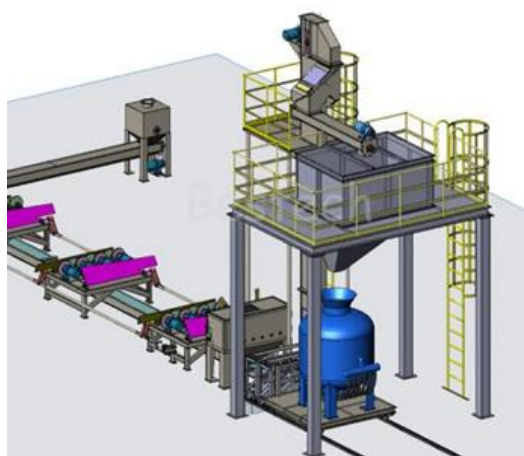
Firstly, improve the corrosion resisting ability.

Secondly, Improve the bonding strength of steel surfaces and coatings.

Further, increase the anti-fatigue capability of the steel tube and extend its life.  
 And optimize the craftwork state of pipe internal surface.  
 Most importantly, the whole blasting unit greatly enhances the efficiency of cleaning.  
 Moreover, Reduce the labor intensity of cleaning works.

| Parameter | Dia of cleaning size(mm) | Cleaning speed(m/min) |
|-----------|--------------------------|-----------------------|
| QGN100    | 50-300                   | 1-4                   |
| QGN700    | 325-720                  | 1-2                   |
| QGN1000   | 720-1016                 | 1-4                   |
| QGN1500   | 1016-1500                | 1-4                   |

## Steel Tube Internal Shot Blasting Machine



The inner wall shot blasting machine equipment is a more commonly used shot blasting cleaning equipment.

**Steel Tube Internal Shot Blasting Machine made by Qingdao bestech.**

**Introduce of Steel tube internal shot blasting machine as follow:**

Steel Tube Internal Shot Blasting Machine use of a new type of steel pipe inner wall shot blasting machine involves a spray gun for steel pipe inner wall strengthening shot peening, especially a steel pipe inner wall strengthening shot peening gun that strengthens the inner wall of austenitic stainless heat-resistant steel pipe to improve its resistance to high temperature steam oxidation corrosion. It has a nozzle and a spray rod. The nozzle is assembled at the front end of the spray rod. The nozzle has an outer tube and a guide core. The front end of the guide core has a larger head end. An annular gap is formed between the openings at the front end of the pipe for the mixed jet of gas to be ejected. During shot peening, the energy of the gas source and the steel pellets are gathered in the narrow annular gap and ejected, which can generate uniformly distributed anti-high temperature oxidation along the inner wall of the steel pipe. Corroded hardened layer. The spray rod is a linear austenitic stainless steel pipe, and its length direction is not plastic, which can ensure that the shot peening speed remains unchanged over the entire length of the steel pipe, and a uniform hardened layer is formed on the inner wall of the steel pipe; in addition, the spray rod shape adopts a large aspect ratio The flexible design helps the nozzle to automatically align the inner wall of the steel pipe

| Type      | cleaning up tube diameter | abrasive flow rate | working speed |
|-----------|---------------------------|--------------------|---------------|
|           | mm                        | kg/min             | m/min         |
| QGN20-50  | 30-500                    | 2*250              | 0.5-4         |
| QGN80-150 | 250-1500                  | 2*250 2*750        | 0.5-4 1-10    |

# Steel Pipe Internal Shot Blasting Machine



Qingdao bestech machinery co.,ltd specialized in steel pipe internal shot blasting machine for many years,our steel pipe internal shot blasting machine have been exported to many countries and get good feedback from our customers.All of our steel pipe internal shot blasting machine can be customized according to the diameter and length given by customer.

## Steel pipe internal shot blasting machine working process

Steel pipe internal Shot blasting machine is suitable for cleaning and strengthening the surface of large and medium steel pipe.After cleaning, the steel pipe presents a silvery white metallic luster, and the tensile and compressive strength of its surface is improved.This machine is roller through type, the roller table continuously conveying the workpiece, while moving and rotating, without manual feeding, high production efficiency, good cleaning effect.Special shot blasting cleaning machine for the inner wall of steel pipe is suitable for the surface treatment of steel pipe and steel pipe products, remove the surface oxide, welding slag and other sundries, showing a metallic luster, increase the skin area, in order to facilitate the surface of the workpiece spraying and coating is widely used in petrochemical industry, steel, urban central heating, water supply and drainage industries.

In order to configure the right steel pipe internal shot blasting machine,the customer should provide

the following information:

- 1.Max and Min diameter of the steel pipe
- 2.Max and Min length of the steel pipe
- 3.Max weight of the steel pipe

| Model   | Diameter of cleaning pipe(mm) | Cleaning speed(m/min) |
|---------|-------------------------------|-----------------------|
| QG-100  | 50-300                        | 1-4                   |
| QG-700  | 325-720                       | 1-4                   |
| QG-1000 | 720-1016                      | 1-4                   |
| QG-1500 | 1016-1500                     | 1-4                   |

# Steel Pipe Out Wall Shot Blasting Machine



Steel Pipe Out Wall Shot Blasting Machine is one of shot blasting machine made by Qingdao Bestech machinery co.,ltd .

Steel Pipe Out Wall Shot Blasting Machine is mainly used for cleaning the surface of all kinds of diameter of the outer wall of steel pipe, it can be in a state of nature of the surface of the steel with a powerful blast, clear the rusty spot on the its rusty layer and its scale, to get a uniform surface of the metal gloss finish, in order to get rid of stress, improve the quality of steel surface coating and anticorrosion performance. In order to ensure the cleaning effect of the workpiece and the order of the main chamber roller table, the machine is specially equipped with a high-chromium wear-resisting jacket on the main chamber roller table, which can extend the order of the roller table dozens of times.

Steel Pipe Out Wall Shot Blasting Machine is equipped with a pneumatic loading and unloading system on the conveying trolley, which can perform automatic loading and unloading on both sides. After the workpiece is placed in the working position, the mobile sealed chamber moves in the direction of the fixed sealed chamber under the drive of the reducer to seal the steel pipe The ends. During the cleaning process of the steel pipe inner wall sandblasting machine, the projectile and recycling system adopts a wind conveying system. The projectile can be recovered by the negative pressure of the dust removal system inside the steel pipe. When it reaches the enclosed chamber, the space of the auxiliary chamber instantly adds atmospheric force. The conveying force immediately disappeared, and the projectiles landed on the projectile recovery belt conveyor.

| QGW Steel Pipe Out Wall Shot Blasting Machine |               |               |               |               |               |
|---|---------------|---------------|---------------|---------------|---------------|
| Type  | Bestech-QGW10 | Bestech-QGW15 | Bestech-QGW20 | Bestech-QGW25 | Bestech-QGW30 |
| Pipe Diameter (mm)                            | 19-100        | 50-150        | 50-300        | 100-1400      | 1000-3000     |
| Pipe Length (m)                               | 1.2-12.0      | 1.2-12.0      | 1.2-12.0      | 3.0-12.0      | 4.5-12.0      |
| Blast Wheel *Power                            | 2*15 kw       | 4*15 kw       | 4*22 kw       | 6*22 kw       | 8*22 kw       |
| Shot blasting Speed                           | 0.5-4 m/min   |               |               |               |               |

# Steel Tube Out Wall Shot Blasting Machine



QGW Roller type Steel pipe shot blasting machine/External Steel Pipe Cleaning Machine , for the steel pipe and steel products to deal with the outer surface of the shot blasting to remove the oxide layer and debris such as welding slag, showing a metallic luster, to increase their surface area in order to facilitate the work painting and painting. Characteristics: Blast wheel arranged in a suitable location (such as room or the side of body below), the workpiece edge to edge into the rotation, will enable the different effect of diameter of the pipe line Shotblasting..

QGW Steel pipe/tube outer wall shot blasting machine

| Type                | QGW10       | QGW15    | QGW20    | QGW25    | QGW30     |
|---------------------|-------------|----------|----------|----------|-----------|
| Pipe Diameter (mm)  | 19-100      | 50-150   | 50-300   | 100-1400 | 1000-3000 |
| Pipe Length (m)     | 1.2-12.0    | 1.2-12.0 | 1.2-12.0 | 3.0-12.0 | 4.5-12.0  |
| Blast Wheel *Power  | 2*15 kw     | 4*15 kw  | 4*22 kw  | 6*22 kw  | 8*22 kw   |
| Shot blasting Speed | 0.5-4 m/min |          |          |          |           |

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