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Crawler Shot Blasting Machine

Crawler Shot Blasting Machine for Valve Cleaning



Q32 series crawler shot blasting machine is a small shot blasting cleaning equipment, mainly by the room the shotblast cleaning, shot blasting machine assembly, hoisting machine, separator, shot blasting machine electrical system and other accessories.

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The Batch Crawler shot blasting machine produces large amounts of components that are suited for processing in tumble belt batch machines, regardless of what elements they are constructed from. It can handle tiny and fragile parts up to large and hardened components maintaining highest standard output. These tumble belt batch machines can also be equipped with a steel belt that would enable the machine to accommodate components weighing up to 15 kg.

Crawler shot blasting machines are ideal for blast cleaning work pieces in batches. Optimum blast results are achieved on small delicate metallic or plastic parts, to large, heavy castings, partially covered with sand or scale. During the shot blast process the work pieces are constantly cascading over each other resulting in effective all-around blast coverage. The continuous contact between the work pieces accelerates the deburring process and/or the loosening and discharge of sand cores from sand castings.

Model	—	Q326C	Q3210C
Productivity	t/h	0.6-1.2	3-5
Feeding amount	kg	200	800
Maximum weight of a single piece	kg	10	150
Diameter of end disk	mm	Φ650	Φ1000
Effective volume	m ³	0.15	0.4
Abrasive flow rate	kg/min	100	250
Ventilation capacity	m ³ /h	2200	6000

Power consumption	KW	12.6	32.6
Machine Dimensions	mm	3681*1650*5800	3644*2926*5856

The Barrel Shot Blast Machine



Tilting Drum Type Shot Blasting Machine is one of the updated products based on GN series steel track shot blasting machine, with the features of high efficiency and uniformity. Due to the use of the roller mechanism, the drum not only rotates but shakes up and down during steel shot operating. Therefore, the products in the drum are stirred without impact, and the steel shot is evenly shot. Especially suit for small pieces and thin-walled pieces. All kinds of small castings; forgings; stamping parts which may be stuck in other kinds of shot blasting machines also can be handled.

Composition and Main features of The Barrel Blast Machine

Tilting drum:

- ① The drum is made of 10mm thick rolled high-quality Mn13 high-manganese steel plate, and the service life can reach 1-2 years.
- ② Compared with traditional equipment, it reduces wearing parts, saves time and money for maintenance and repair, and greatly reduces the use cost and maintenance costs.
- ③ The drum shell is a 10mm high-quality carbon steel plate; and the diameter of the holes which in the drum is 6mm.

Screw Conveyor:

- ① 1 set screw conveyor, which located at the top of the shot blasting chamber, used to convey the mixer materials to the Separator. One high-performance gear motor is used to drive this screw conveyor.
- ② Another set of screw conveyor is located at the bottom of the shot blasting room and is shared motor with the bucket elevator.
- ③ Spiral blades are made of wear-resistant steel (Mn16).

Bucket Elevator:

- ① The maximum conveying capacity of the Bucket elevator is 30t / h, which is used to lift the mixer materials to the Separator.
- ② The Bucket elevator is made of precisely welded steel plates and can be disassembled in sections. With maintenance and inspection windows, easy to overhaul.

③ One drive motor is located on the top of the Bucket elevator, which is used as the power source.

④ The system includes 2 precision-machined wheels, 1 Bucket elevator cover, 1 high-performance wear-resistant belt and several hoppers.

Separator:

① Mainly Used to separate qualified steel shot, broken steel shot and dust.

② Welded structure, there are multiple well-designed cells inside for wind guide. The front is an openable access door for daily observation and maintenance.

③ Multi-stage baffle structure, adjustable. Used to adjust the uniformity of the sand curtain.

④ The following is connected to the bin. After sorting, the qualified steel shot flow through the bin for storage, ready to be reused.

Steel shot distribution system:

① The shot gate valve controlled by the cylinder is used to control the supply of the steel shot at a long distance.

② We can through adjust the bolts on the shot controller to obtain the required shot blasting amount.

③ This technology is independently developed by our company.

Impeller Head assembly:

① Independently developed and manufactured by our company which in accordance with the characteristics of the equipment, has the features of extremely high dynamic balance performance, perfect shot output efficiency and convenient maintenance.

② One impeller, 8 high-hardness, wear-resistant and high-chromium blades, directly pluggable, installed on the impeller; an orientation sleeve and a distribution wheel, which respectively control the shot direction and pre-accelerated shot.

③ The shell of the Impeller Head is made of highly wear-resistant material, and the inner wall is attached with a wear-resistant steel plate, which is easy to replace.

④ Main technical parameter of the Impeller Head:

Impeller size: 380mm

Blade: 8 pieces

Impeller: Double Disc Venturi Sealing Technology

Motor power: 22kw / blasting special motor

The maximum initial velocity of steel shot: 70m / s

Maximum flow of steel shot: 200kg / min

Frequency conversion speed regulation technology can be used to adjust the strength of shot blasting.

Hydraulic loading system:

① Hydraulic system is an independent integrated power transmission device, which converts mechanical energy or electrical energy into slewing force, and then a pump part that converts the slewing force into fluid energy. The valve section is equipped with two-cylinder ports, which is the interface of the actuator piping.

- ② The hydraulic system is composed of a motor, pump, electromagnetic directional valve, oil control check valve, throttle stop valve, mailbox, etc.
- ③ Electromagnet on and off (the two electromagnets of the electromagnetic directional valve cannot be charged at the same time), can realize various actions separately.
- ④ By adjusting the throttle valve to adjust its speed or close the action of the actuator.
- ⑤ This system uses 46 # anti-wear hydraulic oil.
- ⑥ The most suitable working temperature of the whole hydraulic system is 30-55 °C, when the oil temperature is too high, it should be shut down and Check the cause of fever.
- ⑦ Main technical parameters of hydraulic system:

Fuel tank volume: 80L
 Motor drive power: 5.5KW
 Rated pressure: 16Mpa
 Rated flow: 20L / min

Automatic cutting system:

- ① A set of automatic blanking mechanism, the work-pieces are reversed from the blasting chamber, and falls on the automatic blanking mechanism, and then through the conveyor belt into the material receiving frame. (Dimensions: 1200X600X800).
- ② Adopts rubber conveyor belt, which can effectively prevent the parts from colliding with each other and play a good protective role.
- ③ The blanking belt is additionally extend 1750mm long and 600mm wide on the original basis.

I Dust removal system(Donaldson cartridge type dust collector system):

- ① Integrated design, integrated on the back of the host.
- ② There are 6 dust filter cartridges inside.
- ③ Equipped with a set of secondary filtering devices. Suitable for indoor emissions, dust emission 5mg / m³.
- ④ With an automatic blowback cleaning device, you can set the blowback time interval.
- ⑤ Equipped with filter cartridge replacement detection instrument, can prompt the operator when to replace the filter cartridge.
- ⑥ The air inlet of the dust collector is equipped with a damper. Air volume can be adjusted according to equipment usage.

⑦ Main technical parameters:

Fan power: 5.5kw
 Dust collector air volume: 5000 m³ / h
 Dust emission: ≤5mg / m³

Electrical control system:

- ① Control cabinet:
- ② Three-phase alternating current of main power supply: 400V ± 10%, 50Hz ± 2%

- ③ Control voltage: DC24V, 50Hz \pm 2%
- ④ A lighting lamp is installed in the control cabinet, the door is turned on and the door is turned off.
- ⑤ Equipped with equipment data storage area.
- ⑥ The panel is equipped with an indicator lamp to check the normal operation of the button, so as to detect at any time.
- ⑦ There are three color indicator lights on the bottom: red light flashes for fault status, yellow light flashes for maintenance status, green light flashes for hand.
- ⑧ Dynamic state, green continuous light indicates that the machine tool is in a normal working state, or sound and light alarm.
- ⑨ A 10-inch color touch screen is used to control the entire device.

Tumble Belt Shot Blasting Machine



The working principle of crawler shot blasting machine is that the specified number of workpiece is added into the cleaning warehouse, then the door is closed and the machine is started. The workpiece is driven by the drum and starts to turn over. At the same time, the projectiles thrown by the high speed shot blasting machine form a fan beam and hit the surface of the workpiece evenly, so as to achieve the purpose of cleaning

Advantages of Bestech's Tumble Blaster for Sale

1. Thicker guard board, high wear-resisting cast iron
2. with frame stronger
3. Thicker track, high content gum
4. Uniform speed
5. Small machine vibration
6. Longer lifetime
7. Especially widely used
8. 4-5 levels efficiency for your choose
9. Best wear-resisting protective liner

Each Part's Character of Tumble Blast Machine

1. Blast wheel motor

Use ABB motor or China brand, good sealing, good dynamic balance, stable and reliable performance.

2. Blast chamber

Welded with all manganese steel. The top is equipped with a three-layer sealing structure to prevent the steel shot from leaking. Wear-resistant rubber tracks, with fascia, make the workpiece easy rolling.

3. Turbine Belt connection centrifugal type blast wheel, more stable and uniform speed. High impeller rotate speed 3000r/min

Item	units	Q326C	QR3210
productivity	t/h	0.6-1.2	1.5-2.5
feeding amount	kg	200	600
max.weight of single piece	kg	10	30
diameter of end disk	mm	650	1000
efectve volume	m3	0.15	0.3
shot-blasting capacity	kg/min	100	250
air volume for dedusting	m3/h	2200	5000
power consumption	kw	12.6	24.3
outline dimension	mm	3681*1650*5800	3972*2600*4768

Barrel Shot Blasting Machines



Ideal solution to clean parts that would normally become pinched or jammed in traditional tumblast machines.

Key Benefits and Features for Barrel Shot Blasting Machines

5/8 thick manganese steel, solid welded drum (zero catch points, no sharp edges to nick or damage parts)

Replaceable actuator cone (different shapes for different part types)

Adjustable drum angles with shock loading suspension (easily modify tumbling dynamics)

5 point drum support (Better stability- durability)

Abrasion Resistant (AR) screws (longer life)

Machine can be fully automated (higher productivity)

Leak resistant piece door (maintenance advantages)

Applications

Automotive

Iron, steel and metal foundries

Heat treat operations

Forging operations

Small stamping parts manufacturers

Barrel Shot Blasting Machines

The Bestech Barrel Shot Blasting Machines are the ideal solution to clean parts that would normally become pinched or jammed in our traditional Tumblast machine, reducing chances of part damage. Barrel machines are designed for easy maintenance to provide shorter downtime. Barrel Machines adopt cost-effective and space-saving rotating drum systems. Versatile, solid manganese drums allow efficient tumbling of parts with no pinch points.

Typical uses for system includes the removal of sand, scale, rust and other contaminants from forged, heat treat and cast parts.

Shot Blasting Machine For Nuts



The working principle of crawler shot blasting machine is that the specified number of workpiece is added into the cleaning warehouse, then the door is closed and the machine is started. The workpiece is driven by the drum and starts to turn over. At the same time, the projectiles thrown by the high speed shot blasting machine form a fan beam and hit the surface of the workpiece evenly, so as to achieve the purpose of cleaning

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. Our company has tumble blaster for sale.

Machines have a perpetual caterpillar made from perforated rubber belt. Treated objects are put by a special filling contraction to the 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 quality blasted in a jet of abrasive. For emptying, the 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 may be equipped with a magnetic separator, vibration conveyor and variable frequency drive for the turbines.

Item	units	Q326C	QR3210	15GN	28GN
productivity	t/h	0.6-1.2	1.5-2.5	5-6	10-12
feeding amount	kg	200	600	1300	3500
max.weight of single piece	kg	10	30	230	363
diameter of end disk	mm	650	1000	1092	1245
efectve volume	m3	0.15	0.3	0.43	0.79
shot-blasting capacity	kg/min	100	250	480	700
air volume for dedusting	m3/h	2200	5000	5300	6500
power consumption	kw	12.6	24.3	49.3	64.5
outline dimension	mm	3681*1650*5800	3972*2600*4768	4597*3262*5709	5300*5432*6814

Automatic Loading Crawler Type Shot Blasting Machine



The automatic feeding crawler type shot blasting machine is a shot blasting device with good cleaning effect, compact structure and low noise. It is applied to the surface derusting or shot blasting strengthening of large and medium batch production

The automatic feeding crawler type shot blasting machine is a shot blasting device with good cleaning effect, compact structure and low noise. It is applied to the surface derusting or shot blasting strengthening of large and medium batch production, and has the following characteristics:

1. Adopt cantilever centrifugal shot blaster, which has the characteristics of long service life and simple structure;
2. The automatic feeding shot blasting machine adopts three projectile speeds of 75 m / s, 80 m / s and 85 m / s.
3. The belt pulley adopts the international advanced quick-change structure, which is conducive to improving production efficiency and reducing labor intensity.
4. The BE-type separator is used, which has good separation effect and high productivity, and has a positive effect on improving the life of the blade;
5. A bag-type dust collector is used, and the dust emission concentration is lower than the national standard, which improves the working environment of the workers;
6. This model adds some special mechanisms such as manual pill gate and discharge gate.
7. This type of track-type shot blasting machine can be used stand-alone or wired.

Parameter	Unit	Q326	Q3210	QR3210
Productivity	T/H	0.6-1.2	3-5	1.5-2.5
Loading Weight	kg	200	800	600
Maximum Weight of One Piece	kg	10	15	30
Diameter of the Roller	mm	650	1000	1000
Available Capacity	m ³	0.15	0.4	0.3
Pill Impelling Volume	kg/min	100	250	250
Power Air Volume	m ³ /h	2200	6000	5000
Power Dissipation	kw	12.6	32.6	24.3
Outline Dimensions	mm	3681*1650*5800	3644*2926*5856	3972*2600*4768
Machine Total Weight	kg	2340	5843	7400

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