



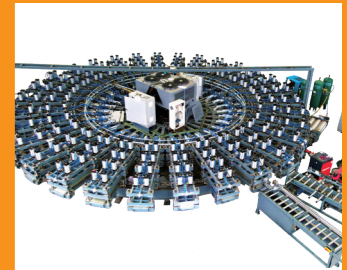
中国·青岛西海岸新区普华智造园
(疏港高速隐珠出口正西700米北五路与珠山路交汇处)
China · Qingdao · West coast new district · Qingdao Puhua Group
(750 Meters west of Beiwu road and Zhushan road junction)



国际热线 (International tel) : 86-532-88191002
国内热线 (Domestic tel) : 18669853399



www.puhua-machinery.com



专注智能机械装备制造
Focus On The Intelligent Mechanical Equipment

企业简介

COMPANY PROFILE

青岛智领机械装备有限公司位于青岛西海岸新区, 隶属普华重工集团旗下, 主要产品有抛丸清理设备、砂处理设备、涂装设备; 数控转塔冲床, 激光切割机, 游艇船舶等。为目前国内集表面清理设备、铸造机械、涂装生产线、数控锻压、激光应用设备及自动化设备科研开发、多行业生产贸易为一体的高科技技术企业。

公司先后通过法国BV认证、知识产权管理体系认证、欧盟CE认证、ISO9001质量管理体系认证。公司现已拥有发明及实用新型专利50余项, 并被认定为国家高新技术企业、青岛市企业技术中心。公司于2018年登录蓝海证券科创板。

公司以“科技创新、真情服务”为经营导向, 依托高端的技术和产品, 加快国际市场开拓, 积极参与国际竞争, 助推中国制造走向世界, 产品远销欧洲、北美、中南美、东南亚、中东、非洲、澳洲等90多个国家和地区, 并在美国、沙特、伊朗、乌克兰、越南、俄罗斯、印度等国家和地区设有代理商。建立了“高效联动、国际联保”的售后服务体系。

公司秉承“诚信、创新、整合”的经营理念, 以“信息化、全球化”为发展导向, 坚持“科技创新、真情服务”, 为各界同仁倾心打造高性价比的产品价值与服务!

ZHILING MACHINERY CO., LTD. is located in Qingdao West Coast New District, Qingdao China. Belonging to PUHUA HEAVY INDUSTRY GROUP. The main products include shot blasting equipment, sand blasting booth, spray paint coating equipment; CNC punching machine, laser cutting machine; aluminum and FRP yacht, etc. A high-tech enterprise integrating scientific research and development and multi-industry production that integrates surface cleaning equipment, casting machinery, spray coating production line, CNC forging equipment, laser cutting machine and automation equipment.

The company has passed the BV, CE, and ISO9001 certification. The company now owns more than 50 invention and utility model patents, and has been identified as national high-tech enterprises and Qingdao Enterprise Technology Center.

The company takes "scientific and technological innovation and true service services" as its business orientation, relying on high-end technology and products, accelerate the development of international markets, actively participate in international competition, and promote Chinese manufacturing to the world.

Products are exported to more than 90 countries and regions such as Europe, North America, Central South America, Southern Asia, Middle East, Africa, and Australia, and have agents in the United States, Saudi Arabia, Iran, Ukraine, Vietnam, Russia, India and other countries and regions.

Adhering to the business philosophy of "integrity, innovation, and integration", the company adheres to "informationization and globalization" as a development orientation, adheres to "scientific and technological innovation, true service services", and builds high cost-effective product value and services for colleagues from all walks of life!

企业文化

COMPANY CULTURE

企业愿景: 创智能锻压首选品牌, 造表面清理一流设备
Company vision: Create the preferred brand for intelligent forging equipment, Build first-class surface cleaning equipment.

企业使命: 专注智能制造, 为助力中国成为世界智造强国而奋斗终身
Company mission: Focus on Intelligent Manufacturing, Struggle for life to Help China Become a World Powerful Intellectual Power.

核心价值观: 成就客户, 诚信负责; 拥抱变化, 超越自我
Core values: Achieve customers, Integrity and responsibility; embrace change and surpass ourselves



客户案例

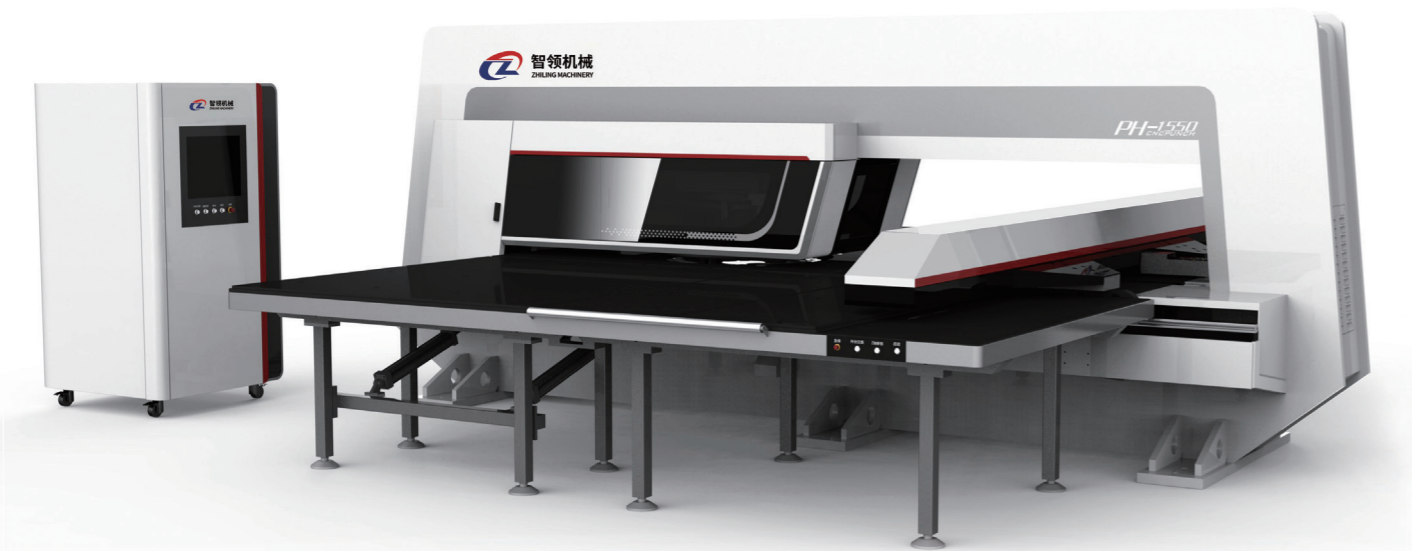
CUSTOMER CASE



产品索引

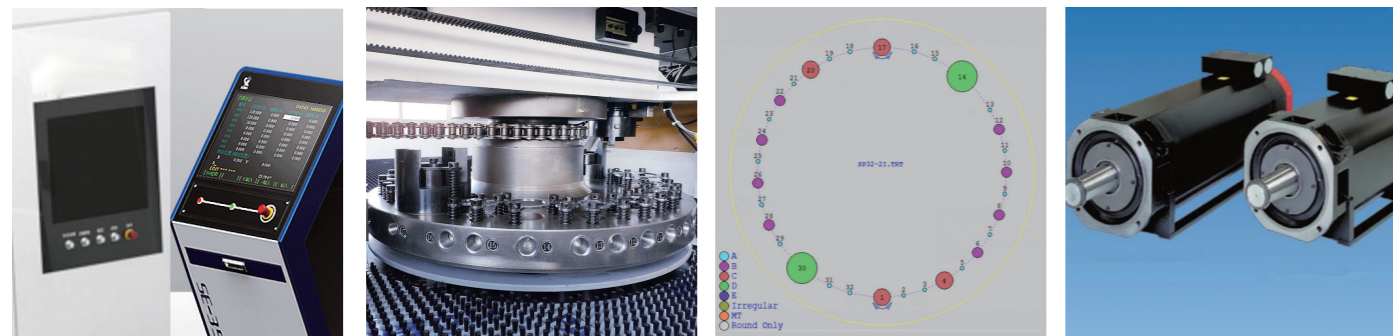
PRODUCT INDEX

05	PH-1550闭式伺服式数控转塔冲床 PH-1550 Servo Type CNC Turret Punching Machine	41	转台式强化、抛丸清理机 Q35 Turntable Type Strengthening Shot Blasting Machine
07	PH-2050铝单板专用伺服数控转塔冲床 PH-2050 Servo CNC Punch Machine for Aluminum Veneer	43	移动式路面抛丸清理机 Mobile Type Road Surface Shot Blasting Machine
09	PH-357 闭式机械数控转塔冲床 PH-357 Mechanical CNC Turret Punch Machine	45	PHGT15 型倾斜滚筒式抛丸清理机 PHGT15 Tilting Drum Type Shot Blasting Machine
11	PH-1550数控转塔冲床激光一体机 PH-1550 Combined CNC Punch Machine with Laser Cutting	47	台车式抛丸清理机 Trolley Type Shot Blasting Machine
13	钣金柔性生产单元 Sheet Metal Flexible Production Unit	49	钢筋抛丸机(线材抛丸机) Steel Bar Shot Blasting Machine (Wire Shot Blasting Machine)
15	全自动换刀柔性折弯中心 Automatic Tool Changing Flexible Bending Center	50	盘圆抛丸机 Coiled Wire Rod Shot Blasting Machine
17	吸盘式柔性折弯中心 Sucker type flexible bending center	51	垂直移动式抛丸机 Vertical Mobile Shot Blasting Machine
18	门板发泡注塑系统 Door Panel Foaming and Injection System	53	高速带钢抛丸机 Strip Steel/Steel Coil Shot Blasting Machine
19	Q69系列钢板型材抛丸清理机 Q69 Series Steel Profiles Shot Blasting Machine	55	机械手抛丸机 Manipulator Shot Blasting Machine
21	QXY系列钢板型材预处理线 QXY series steel plate profile pretreatment line	57	带连抛丸器 Belt Driven Shot Blasting Turbine
23	Q37系列吊钩式抛丸清理机 Q37 Series Hook Type Shot Blasting Machine	57	直联抛丸器 Direct-Driven Shot Blasting Turbine
25	全自动回收喷砂房 Automatic Recycling Sand Blasting Room	58	脉冲反吹式布袋除尘器 Pulse Blowback Bag Type Dust Collector
27	喷漆房 Painting Room	59	SZ25系列中速混砂机 SZ25 Series Medium Speed Sand mixer
29	QG系列钢管内外壁抛丸清理机 QG Series Inner And Outer Wall Special Shot Blasting Machine	59	GS系列高速转子混砂机 GS Series High Rotor Mixer
31	Q38、Q48、Q58系列悬链、积放链式抛丸清理机 Q38, Q48, Q58 Series Hanging Chain & Piled And Released Chain Type Shot Blasting Machine	60	Z14系列微震式造型机 Z14 Series Microseism Moulding Machine
33	QWD网带式抛丸清理机 QWD Mesh Belt Shot Blasting Machine	61	树脂砂处理工艺生产线 Resin Sand Production Line Process
35	Q32系列履带式抛丸清理机 Q32 Series Tumble Belt Shot Blasting Machine	61	粘土砂处理工艺生产线 Clay Sand Producing Line Process
37	QT37系列环轨通过式抛丸清理机 QT37 Series Circular Track Through Type Shot Blasting Machine	62	全自动粉末涂料喷涂系统 Automatic Powder Coating Steel Structure Spray Painting System
39	15/28GN钢履带式抛丸机 15/28GN Steel Crawler Shot Blasting Machine		



PH-1550闭式伺服式数控转塔冲床 PH-1550 Servo Type CNC Turret Punching Machine

应用实例 The Instance



产品特点 Product Features

采用德国西门子/力士乐/日本FANUC系统和伺服模块, 扭矩大, 响应快, 精度高;
厚转塔、长导向采用高强度耐磨球墨铸铁, 抗氧化及承载能力强, 不变形。对中性、导向精度高, 转盘与转盘轴整体式结构, 铸造后通过一次装夹精密加工而成, 保证整个转盘机构的精度与可靠性;
五轴全电动控制, 实现冲压, 拉伸, 滚压成型等工艺, 适用于精密钣金加工;
节能, 待机无电消耗, 有效的降低能耗; 可选择柔和模式, 静音环保。

Adopts Siemens / Rexroth / FANUC system and servo module, with quick response and high precision.
The thick turret adopts high-strength wear-resistant ductile iron, with strong anti-oxidation and carrying capacity, no deformation. The centering and guiding precision is high, the turret integral structure is precisely processed to ensure the accuracy and reliability of the turret mechanism.
5 axis CNC system can realize punching, stretching, and roll forming and other technology, it is suitable for precision sheet metal processing.
Energy conservation, no electricity consumption when standby, effectively reduce energy consumption; can choose soft mode, quiet and environment protection.

技术参数 Technical Parameters

参数 Specification	单位Unit	PH-1550
冲压力 Punch force	KN(T)	300(30)
工本综合功率 Integrated power	KW	10
最大加工板材尺寸 Max. processing sheet size	mm	5000*1250/1500/2000(含一次再定位)
最大加工板材厚度 Max. processing sheet thickness	mm	6.35
一次最大冲孔直径 Max. punch diameter once	mm	Ø88.9
板料移动速度 Max. sheet moving speed	m/min	105
最高冲孔频率 Max. punching frequency	hpm	1800
冲孔精度 Hole accuracy	mm	±0.1
工位数 Number of stations in turret	No.	24/32
模具结构 Mold structure		85系列国标厚塔标准模具
转盘速度 Turret rotating speed	rpm	30
控制轴数 Controlled axis	No.	5
旋转工位 Auto-index station	No.	2
空气压力 Air pressure	mpa	≥0.55
外形尺寸 Outline dimension	mm	5400*5200*2150
设备重量 Machine weight	T	13/14



PH-2050铝单板专用伺服数控转塔冲床 PH-2050 Servo CNC Punch Machine for Aluminum Veneer

应用实例 The Instance



产品特点 Product Features

采用德国西门子/力士乐/日本FANUC系统和伺服模块, 扭矩大, 响应快, 精度高;
厚转塔、长导向采用高强度耐磨球磨铸铁, 抗氧化及承载能力强, 不变形。对中性、导向精度高, 转盘与转盘轴整体式结构, 铸造后通过一次装夹精密加工而成, 保证整个转盘机构的精度与可靠性;
五轴全电动控制, 实现冲压, 拉伸, 滚压成型等工艺, 适用于精密钣金加工;
节能, 待机无电消耗, 有效的降低能耗; 可选择柔和模式, 静音环保。

Adopts Siemens / Rexroth / FANUC system and servo module, with quick response and high precision.
The thick turret adopts high-strength wear-resistant ductile iron, with strong anti-oxidation and carrying capacity, no deformation. The centering and guiding precision is high, the turret integral structure is precisely processed to ensure the accuracy and reliability of the turret mechanism.
5 axis CNC system can realize punching, stretching, and roll forming and other technology, it is suitable for precision sheet metal processing.
Energy conservation, no electricity consumption when standby, effectively reduce energy consumption; can choose soft mode, quiet and environment protection.

技术参数 Technical Parameters

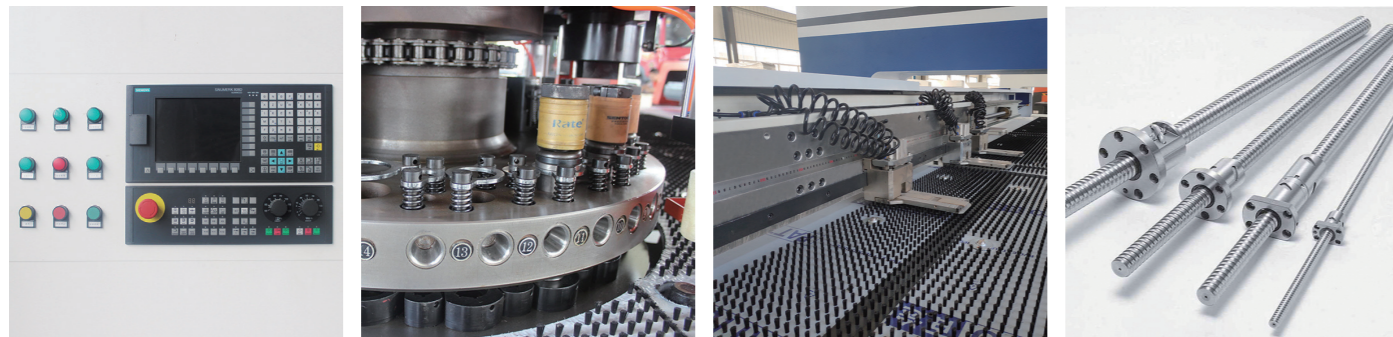
参数 Specification	单位 Unit	PH-2050
冲压力 Punch force	KN(T)	300(30)
工本综合功率 Integrated power	KW	10
最大加工板材尺寸 Max. processing sheet size	mm	5000*2000(含一次再定位)
最大加工板材厚度 Max. processing sheet thickness	mm	6.35
一次最大冲孔直径 Max. punch diameter once	mm	Ø88.9
板料移动速度 Max. sheet moving speed	m/min	105
最高冲孔频率 Max. punching frequency	hpm	1800
冲孔精度 Hole accuracy	mm	±0.1
工位数 Number of stations in turret	No.	24/32
模具结构 Mold structure		85系列国标厚塔标准模具
转盘速度 Turret rotating speed	rpm	30
控制轴数 Controlled axis	No.	5
旋转工位 Auto-index station	No.	2
空气压力 Air pressure	mpa	≥0.55
外形尺寸 Outline dimension	mm	6400*5200*2150
设备重量 Machine weight	T	16



PH-357 封闭式机械数控转塔冲床

PH-357 Mechanical CNC Turret Punch Machine

应用实例 The Instance



产品特点 Product Features

传动系统采用国际品牌的高精度、大行程滚珠丝杠、直线导轨，精度高、性能好；
采用德国西门子系统，配合数字交流伺服电机，速度快、可靠性好；
主要气动元件、电气元件采用国际知名品牌，使机床性能更趋完美；
高精度厚转塔有效提高了转塔的精度及寿命，并有16/24/32工位可供用户选择；
模具采用先进的加工及热处理工艺，使用寿命长；
集中润滑装置，减少各运付的摩擦，提高机器使用寿命；
整体式横梁结构，拖板与横梁一体化设计，增强刚性，定位精准，高速送料更平稳，杜绝工作台X、Y轴动态偏移情况。

The transmission system use the international brand with high precision, long guide ball screw, linear guide rail are high precision and good performance.
Adopts Siemens CNC system and match up AC servo motor to make it fast and reliable.
Main pneumatic components, electric components and other parts adopt international well known brand products, which makes the punch press performance more perfectly.
High precision thick turret improve the precision and service life, and there are 16/24/32 stations for choose.
Mold adopts advanced processing and preheating technology, long service life.
Centralized lubricating device, reduce each parts friction, prolong the machine service life.
Monolithic beam structure, strengthen rigidity, positioning accuracy. High-speed feeding is more stable, eliminate the dynamic shift of the X and Y axes of the table.

技术参数 Technical Parameters

参数 Specification	单位Unit	PH-357
冲压力 Punch force	KN(T)	300(30)
最大输出功率 Max output Power	KW	15
最大加工板材尺寸 Max. processing sheet size	mm	5000*1250/1500/2000(含一次再定位)
最大加工板材厚度 Max. processing sheet thickness	mm	6.35
一次最大冲孔直径 Max. punch diameter once	mm	Ø88.9
板料移动速度 Max. sheet moving speed	m/min	80
冲孔频率 Punching frequency	hpm	270
冲孔精度 Hole accuracy	mm	±0.1
工位数 Number of stations in turret disc	No.	16/24/32
模具结构 Mold structure		85系列国标厚塔标准模具
转盘速度 Turret rotational speed	rpm	30
控制轴数 Controlled axis	No.	3/4
旋转工位 Auto-index station	No.	0/2
空气压力 Air pressure	mpa	≥0.55
外形尺寸 Outline dimension	mm	4980*5300*2110
设备重量 Machine weight	T	12/13



产品特点 Product Features

采用智领独立研发的工控机系统和伺服模块,扭矩大,响应快,精度高;
五轴全电动控制,实现冲压,拉伸,滚压成型等工艺,适用于精密钣金加工;
配备高效激光系统,与数控转塔系统联动,实现高效切割,与冲孔功能互补;
节能,待机无电消耗,有效的降低能耗;可选择柔和模式,静音环保。

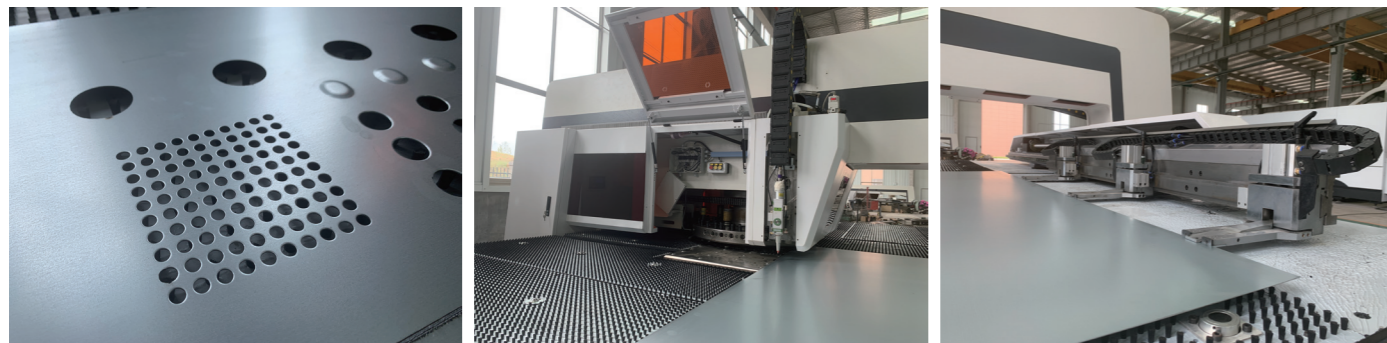
Adopting the IPC system independently developed by Zhiling and servo module, fast response and high precision;
5 axis CNC system can realize punching, stretching, roll forming and other technology, suitable for precision sheet metal processing.
Equipped with an efficient laser system, linked with the CNC turret system to achieve efficient cutting, complementary with the punching function;
Energy saving, no power consumption in standby mode, effectively reducing energy consumption; soft mode can be selected, silent and environmentally friendly.

技术参数 Technical Parameters

参数 Specification	单位Unit	PH-1550
冲压力 Punch force	KN(T)	300(30)
工本综合功率 Integrated power	KW	10
激光功率Power of Laser generator	W	1500/2000/3000/6000
最大加工板材尺寸 Max. processing sheet size	mm	5000*1250/1500/2000(含一次再定位)
最大加工板材厚度 Max. processing sheet thickness	mm	6.35
一次最大冲孔直径 Max. punch diameter once	mm	Ø88.9
伺服电机制冷Cooler of punch machine		Air cooler + Water cooler
激光器制冷Cooler of laser cutting		Water cooler
板料移动速度 Max. sheet moving speed	m/min	105
最高冲孔频率 Max. punching frequency	hpm	1800
冲孔精度 Hole accuracy	mm	±0.1
工位数 Number of stations in turret	No.	24/32
模具结构 Mold structure		85系列国标厚塔标准模具
转盘速度 Turret rotating speed	rpm	30
控制轴数 Controlled axis	No.	5
旋转工位 Auto-index station	No.	2
空气压力 Air pressure	mpa	≥0.55
外形尺寸 Outline dimension	mm	5400*5200*2150
设备重量 Machine weight	T	13/14

PH-1550数控转塔冲床激光一体机 PH-1550 Combined CNC Punch Machine with Laser Cutting

应用实例 The Instance

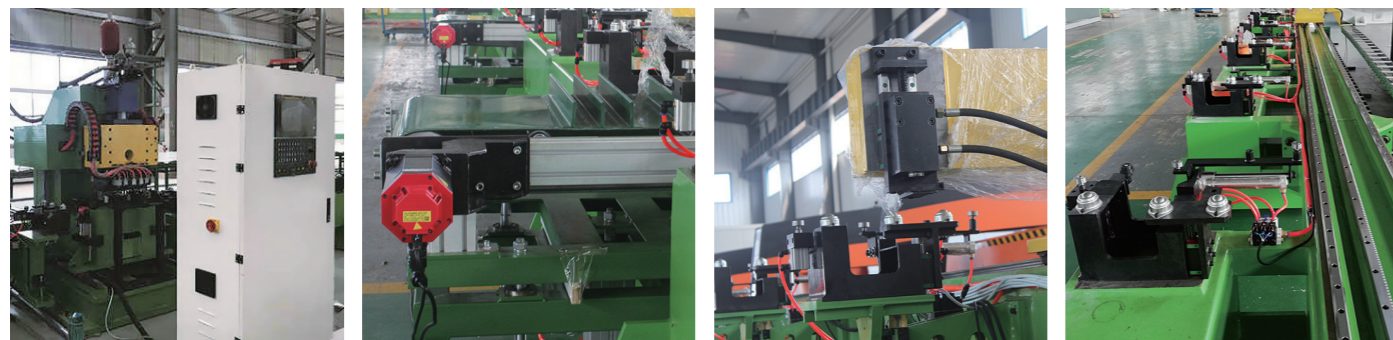




钣金柔性生产单元

Sheet Metal Flexible Production Unit

应用实例 The Instance



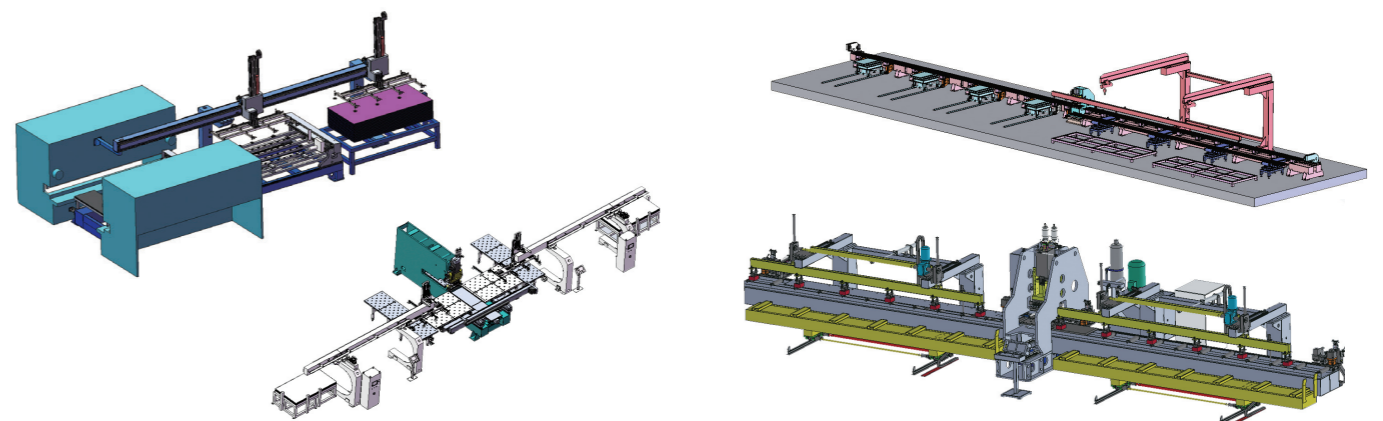
产品特点 Product Features

自动上料、下料, 自动码块;
 模具自动转换, 模具拆装简单;
 夹钳自动避让功能, 无死区加工;
 可移动废料小车, 可吊运, 安装灵活、快捷;
 自动测宽, 自动计算, 中心线定位, 长度方向自动定位;
 主机结构床身为闭式/O型高刚性焊接床身, 承受冲压力, 床身经过有限元分析验证;
 板料完全自动化加工; 样冲功能, 断点续冲功能, 真正的图形显示功能, 生产数据的显示功能; 采用浮动夹钳, 减少意外情况下的部件损坏; 模具拆装简单, 监控措施完善, 环保安全。除必要的维护时间外, 可连续工作; 进口数控系统操作简单, 功能齐全。

Automatic loading, unloading, automatic palletizing.
 Automatic mold conversion, mold disassembly and installation is easy.
 Clamp automatic avoidance function, no dead zone processing.
 Movable waste trolley, which can be lifted and installed flexibly and quickly.
 Automatic width measurement, calculation, centerline positioning and automatic positioning on horizontal direction.
 The main frame of the machine is closed. The body is validated by finite element analysis.
 Fully automatic sheet processing; breakpoint continue punch function, data display function; Use floating clamps to reduce the damage of components under unexpected circumstances; The mold is easy disassemble. Work continuously except for necessary maintenance time; The CNC system is easy to operate and has complete functions.

技术参数 Technical Parameters

参数 Specification	单位 Unit	PH-DLC6000/8000	PH-DLC1000/12000
冲压力 Punch force	KN	800	1200
最大加工板材重量 Max. weight of processing sheet	kg	500	700
最大加工板材尺寸 Max processing sheet size	mm	6000*550/8000*550	10000*550/12000*550
最大加工板材厚度 Max processing sheet thickness	mm	12	12
X/Y 向送料行程 X/Y feeding size	mm	X=6000/8000 Y=550	X=10000/12000 Y=550
冲孔频率 Punching frequency	r/min	80	80
板材最大移动速度 Max. sheet moving speed	m/min	60	60
孔距精度 Hole accuracy	mm	±0.1/m	±0.1/m
空气压力 Air pressure	mpa	≥0.5	
电压 Voltage	V/Hz	380±5%/50Hz	



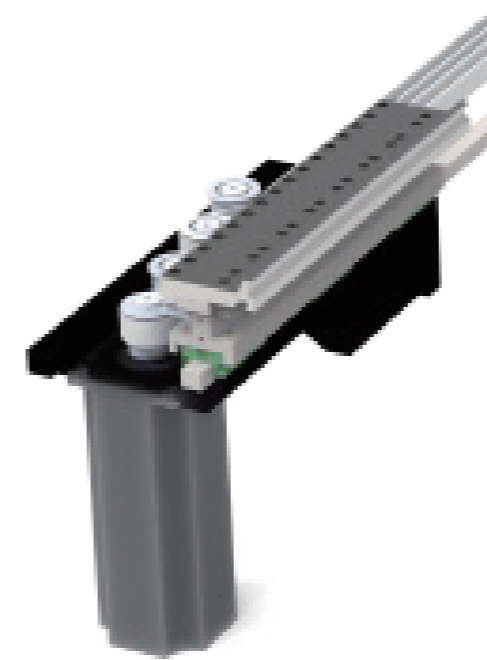
产品特点 Product Features

该设备拥有国内完全自主知识产权全自动换刀柔性折弯中心，颠覆了传统的人工换刀流程，实现了工业生产自动化智能化。三种定位方式适应更多板材，实现高精度、高效率的生产方式，国内独有的全自动拼刀系统，为国内自动柔性折弯中心的发展迈出了历史性的一步。

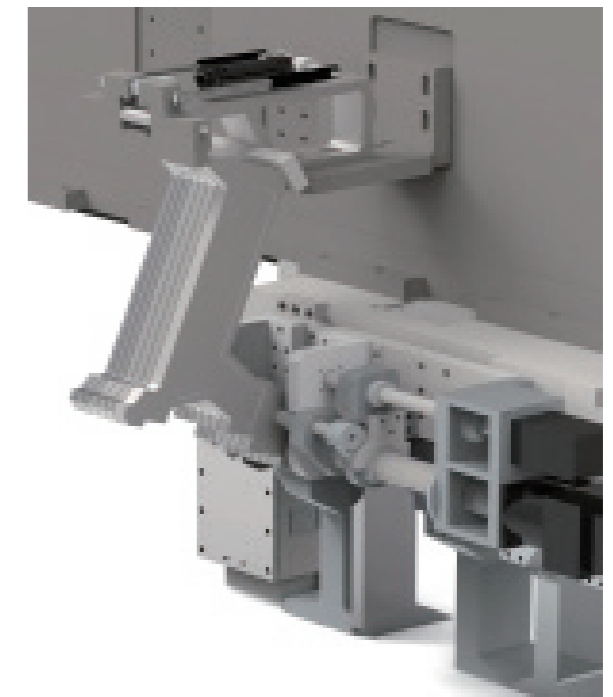
This device has a fully independent domestic intellectual property rights fully automatic tool changing flexible bending center, which subverts the traditional manual tool changing process and achieves industrial production automation and intelligence. Three positioning methods are suitable for more sheets, achieving high-precision and high-efficiency production methods. The exclusive fully automatic cutting system in China has taken a historic step towards the development of automatic flexible bending centers in China.



全自动换刀柔性折弯中心 Automatic Tool Changing Flexible Bending Center



辅助折刀 Auxiliary jackknife



垫片刀 Gasket knife



技术参数 Technical Parameters

参数 Specification	AT-QS1600	AT-QS2200	AT-QS2600
最大长度maximum length	1600mm	2200mm	2600mm
允许最大对角线maximum diagonal	2000mm	2550mm	2900mm
角度angle	±0°-180°		
最大折弯高度Maximum bending height	100-300mm		
允许配置Allow configuration	压刀自动排列组合、双侧垫片刀、中间合页刀、上下辅助折刀 Automatic arrangement and combination of press knives, double gasket knives, middle hinge knives, upper and lower auxiliary folding knives		



吸盘式柔性折弯中心

Sucker type flexible bending center

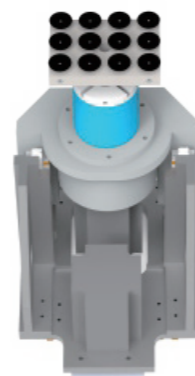
产品特点 Product Features

折弯速度每刀仅0.2秒,设备可以根据折弯工艺自动上折、下折动作实现圆弧、压死边、各种角度的组着折弯,在不更换折弯刀具的情况下可实现多种折弯要求,为企业节省大量的人工和模具成本。

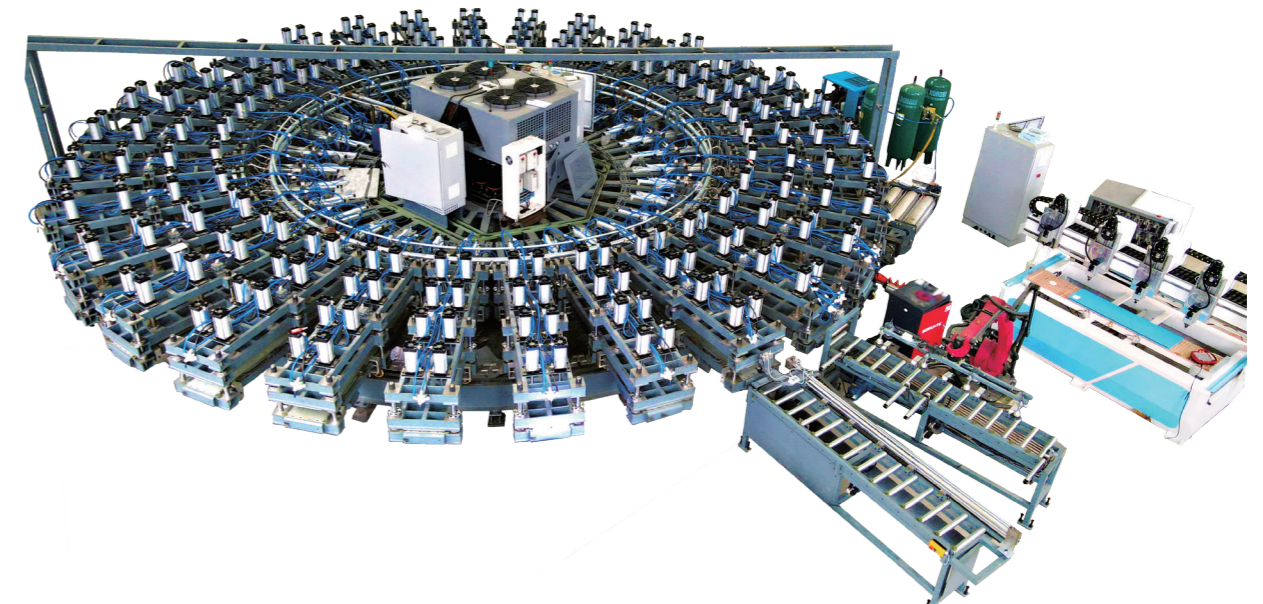
The bending speed is only 0.2 seconds per blade, and the equipment can automatically fold up and down according to the bending process to achieve combined bending of arcs, dead edges, and various angles. It can meet various bending requirements without replacing the bending tool, saving a lot of labor and mold costs for enterprises.

技术参数 Technical Parameters

参数 Specification	AT-1200C	AT-1600C
最大长度maximum length	1200mm	1600mm
允许最大对角线maximum diagonal	1700mm	2000mm
角度angle	±0°-180°	
最大折弯高度Maximum bending height	100-300mm	100-400mm
允许配置Allow configuration	动力合页刀/辅助折刀 Power hinge knife/auxiliary jackknife	

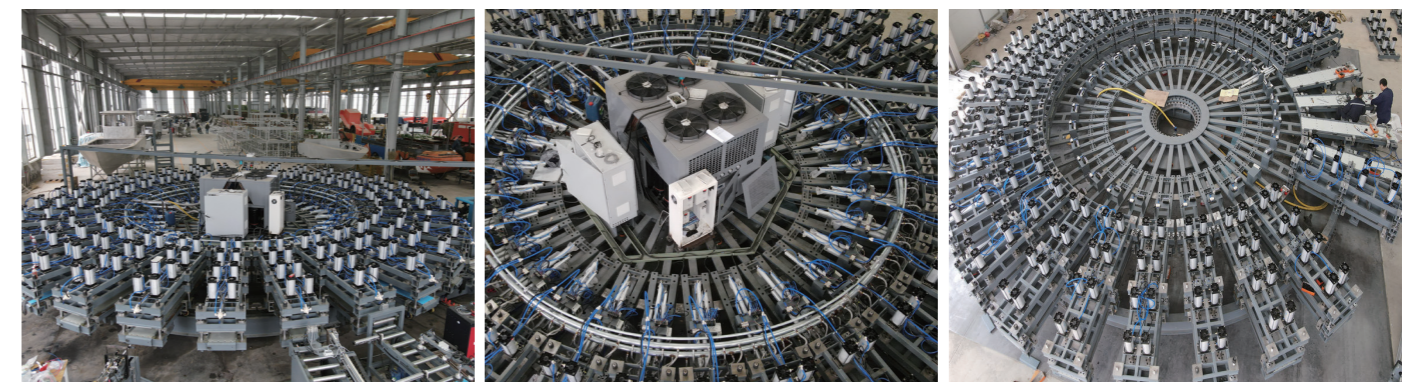


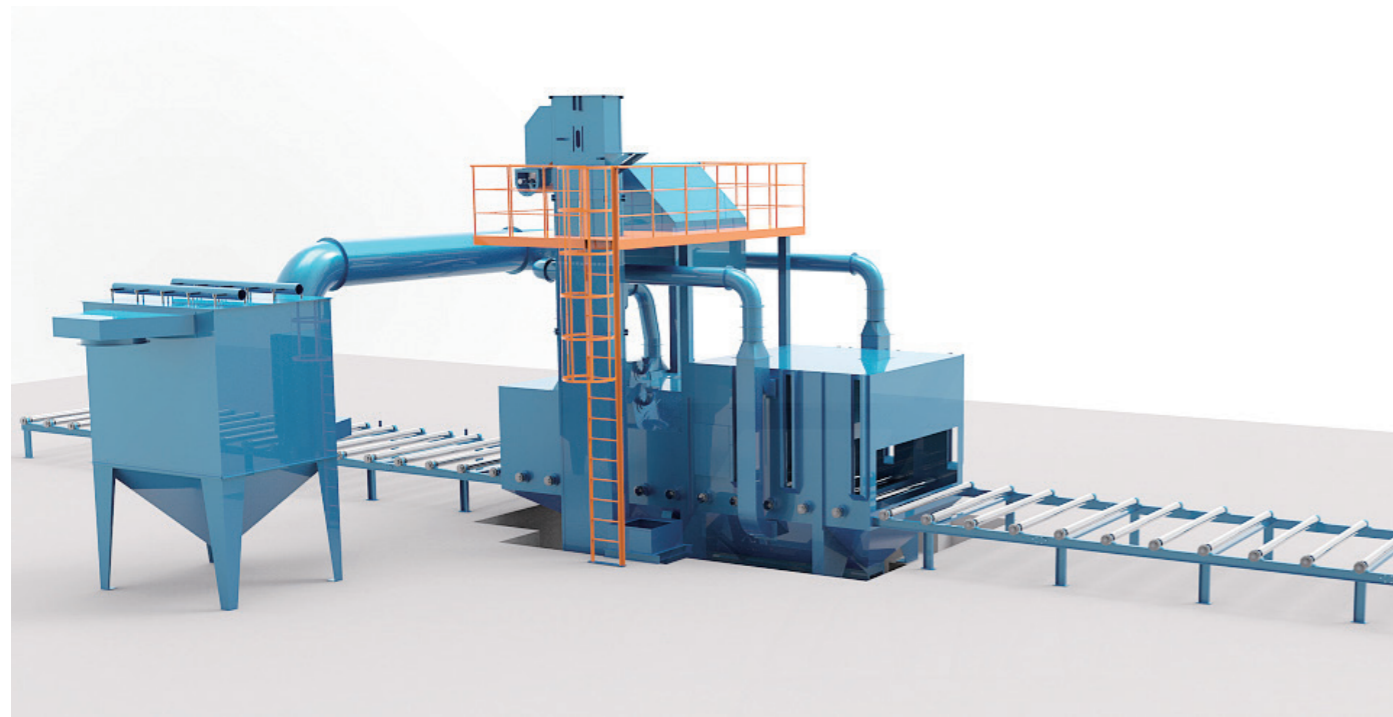
吸盘送料装置
Suction cup feeding device



门板发泡注塑系统

Door Panel Foaming and Injection System





Q69系列钢板型材抛丸清理机 Q69 Series Steel Profiles Shot Blasting Machine

产品特点 Product Features

该系列钢板、型材抛丸预处理线主要由辊道输送结构、抛丸处理、弹丸清扫工序组成。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、涂漆工艺。

The series of Q69 steel plate & Profiles shot blasting pre-treatment line is mainly consist of roller conveying mechanism, blasting processing, abrasive cleaning procedure, etc. It applies to surface rusting and painting art of shipping, car, motor-cycle, bridge, machinery, etc.

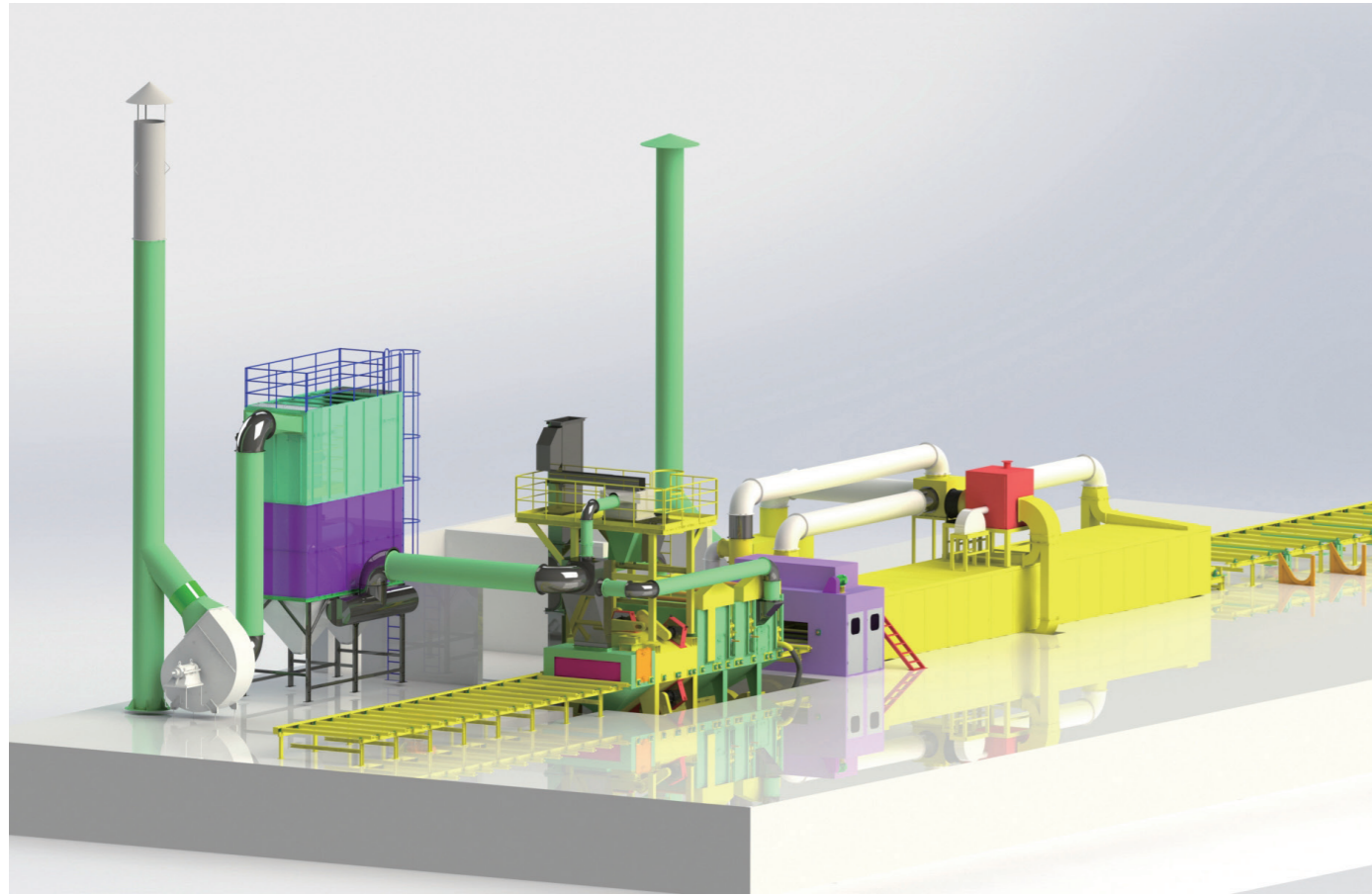
应用实例 The Instance



技术参数 Technical Parameters

参数 Parameter	型号 Type	Q698	Q6912	Q6915	Q6920	Q6925	Q6930	Q6940
有效清理宽度 (mm) The effective cleaning width		800	1200	1500	2000	2500	3000	4000
室体进料口尺寸 (mm) The room feed-in size		1000*400	1400*400	1700*400	2200*400	2700*800	3200*800	4200*400
清理工件长度 (mm) The length of cleaning workpiece		1200-12000	1200-16000	1200-12000	1200-12000	3000-12000	2400-12000	4500-18000
辊道输送速度 (无极调速) (m/min) The speed of wheel conveyor (stepless speed variation)		0.5-4	0.5-4	0.5-4	0.5-4	0.5-4	0.5-4	0.5-4
清理钢板厚度 (mm) The thickness of cleaning steel sheet		3-60	3-60	1.5-60	3-60	3-60	3-110	4.5-100
处理型材规格 (mm) The section steel specification		800*300	1000*300	1500*300	2000*300	2500*700	3000*700	4000*300
抛丸量 (kg/min) The quantity of shot blasting		4*180	4*250	4*250	6*250	6*250	6*360	8*360
首次装入量 (kg) The first enclosed quantity		4000	4000	4000	4500	4500	8000	11000
滚刷 (刮板) 调整高度 (mm) Roll brush adjusting height		200	200	350	450	600	850	900
通风量 (m³/h) Airness capacity		22000	17560	19000	19550	27758	28050	38000
外形尺寸 (mm) Exterior size		25017*4500*9015	12180*4250*7095	15200*5370*6797	30650*6850*9095	31200*8070*7500	44042*6385*7758	45000*7830*11117
总功率 (不含除尘) (kw) Total power (except for dust cleaning)		90	78.3	113.5	156.6	204.8	224.55	293.6

可根据用户钢材的尺寸及生产节拍等参数, 设计制作各种非标准钢材预处理设备。
We can design and manufacture all kinds of non-standard shot blasting machines according to customer different workpiece detail requirement, weight and productivity.



QXY系列钢板型材预处理线 QXY series steel plate profile pretreatment line

产品特点 Product Features

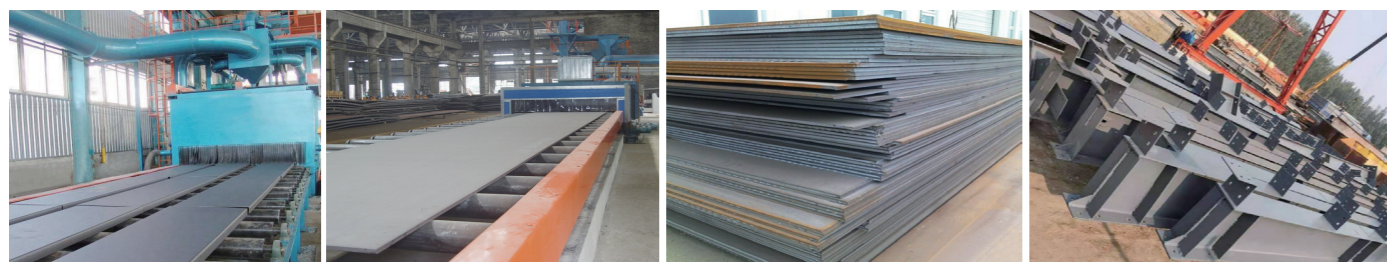
钢板预处理线主要由辊道输送系统、抛丸清理机、自动喷漆系统、烘干室、抛丸除尘系统、漆雾过滤系统和电控系统所组成，并可扩展自动上卸料系统和预热室。

钢材预处理线工艺是指钢材在加工前(即原材料状态)进行表面抛丸除锈并涂上一层保护底漆的加工工艺。钢材经过预处理可以提高机械产品和金属构件的抗腐蚀能力，提高钢板的抗疲劳性能，延长其使用寿命；同时还可以优化钢材表面工艺制作状态，有利于数控切割机下料和精密落料。此外，由于加工前钢材形状比较规则，有利于机械除锈和自动化喷漆，因此采用钢材预处理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 pretreatment line is mainly composed of roller conveyor system, shot blasting machine, automatic painting system, drying room, shot blasting system, paint mist filtration system and electronic control system, and can expand automatic loading and unloading system and pre- Hot room.

The steel pretreatment line process refers to a process in which the steel is subjected to surface shot blasting and a protective primer before the processing (ie, the raw material state). The steel can be pretreated to improve the corrosion resistance of mechanical products and metal components, improve the fatigue resistance of the steel plate and prolong its service life. At the same time, it can optimize the surface production state of the steel, which is beneficial to the cutting and precision blanking of the CNC cutting machine. In addition, due to the relatively regular shape of the steel before processing, it is conducive to mechanical rust removal and automatic painting. Therefore, the use of steel pretreatment can greatly improve the efficiency of cleaning work, reduce the labor intensity of cleaning work and environmental pollution.

应用实例 The Instance



技术参数 Technical Parameters

项目 Project	单位unit	类(class)1	类(class)2	类(class)3
处理工件宽度 Workpiece width	mm	2500以下	3500以下	4500以下(钢板)
产品型号 Product number	mm	QXY2000	QXY3000	QXY3500
	mm	QXY2200	QXY3200	QXY4000
	mm	QXY2500	QXY3500	QXY4500
钢板宽 (Max) Steel plate width (Max)	mm	QXY后数字 Number after QXY	QXY后数字 Number after QXY	QXY后数字 Number after QXY
钢板厚度 Steel thickness	mm	3~60	3~60	3~100
最短工件 Shortest workpiece	mm	2400	2400	2400
最长工件 Longest workpiece	mm	12000	12000	12000
工件输送速度 Workpiece conveying speed	m/s	1~5(注)	0.5~4(注)	4~6(注)
除锈质量等级 Descaling quality grade	标准standard	ISO8901-1,1988	GB8923-88	(Bsa2.5)
表面粗糙度 Surface roughness	μm	40-70	40-70	40-70
漆膜厚度 Film thickness	μm	15-25	15-25	15-25
涂料 Coating	种类kind	快干型富锌底漆 Quick-drying zinc-rich primer	快干型富锌底漆 Quick-drying zinc-rich primer	快干型富锌底漆 Quick-drying zinc-rich primer
装机功率 Installed power	kw	根据实际情况 According to actual condition	根据实际情况 According to actual condition	根据实际情况 According to actual condition
压缩空气消耗 Compressed air consumption	m³/min	5-7	5-7	5-7
压缩空气压力范围 Compressed air pressure range	mpa	0.4-0.6	0.4-0.6	0.4-0.6
弹丸首次加入量 Projectile first addition	T	8-10	8-10	12-16

可根据用户钢材的尺寸及生产节拍等参数，设计制作各种非标准钢材预处理设备。
We can design and manufacture all kinds of non-standard shot blasting machines according to customer different workpiece detail requirement, weight and productivity.



Q37系列吊钩式抛丸清理机

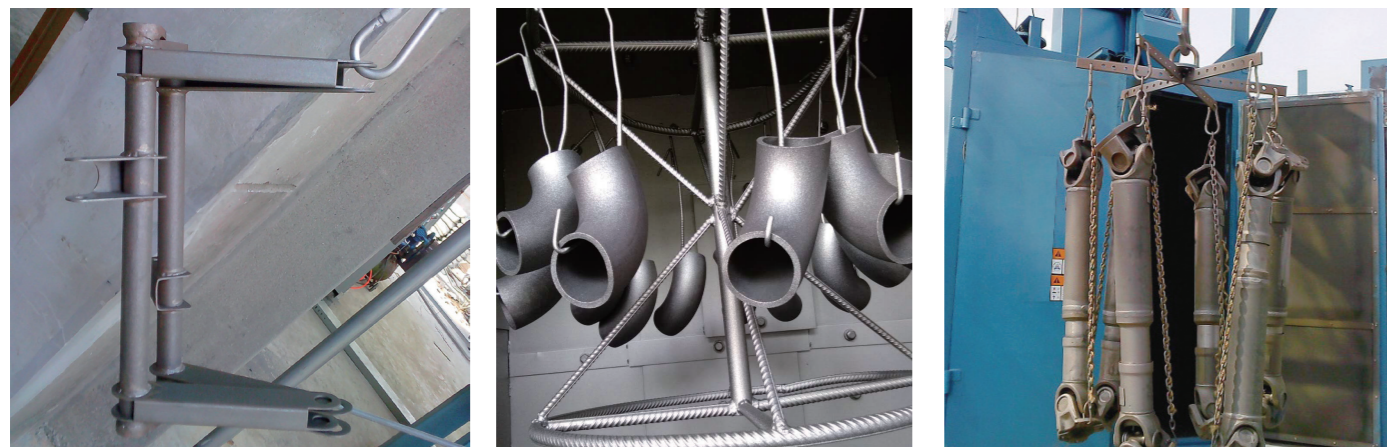
Q37Series Hook Type Shot Blasting Machine

产品特点 Product Features

该系列为吊钩式抛丸清理机，主要用于铸件、结构件、有色金属件及其他零件的表面清理，本系列抛丸清理机分单钩、双钩式，起吊、不起吊式等多种型号。它具有无地坑、结构紧凑、生产率高等优点。

This series is hook type shot blasting machine, is mainly used for surface cleaning of casting, structure, non-ferrous alloy and other parts. This series shot blasting machine have many types, such as single hook type, double hook type, lifting type, non-lifting type. It has advantage of non-pit, compact structure, high productivity, etc.

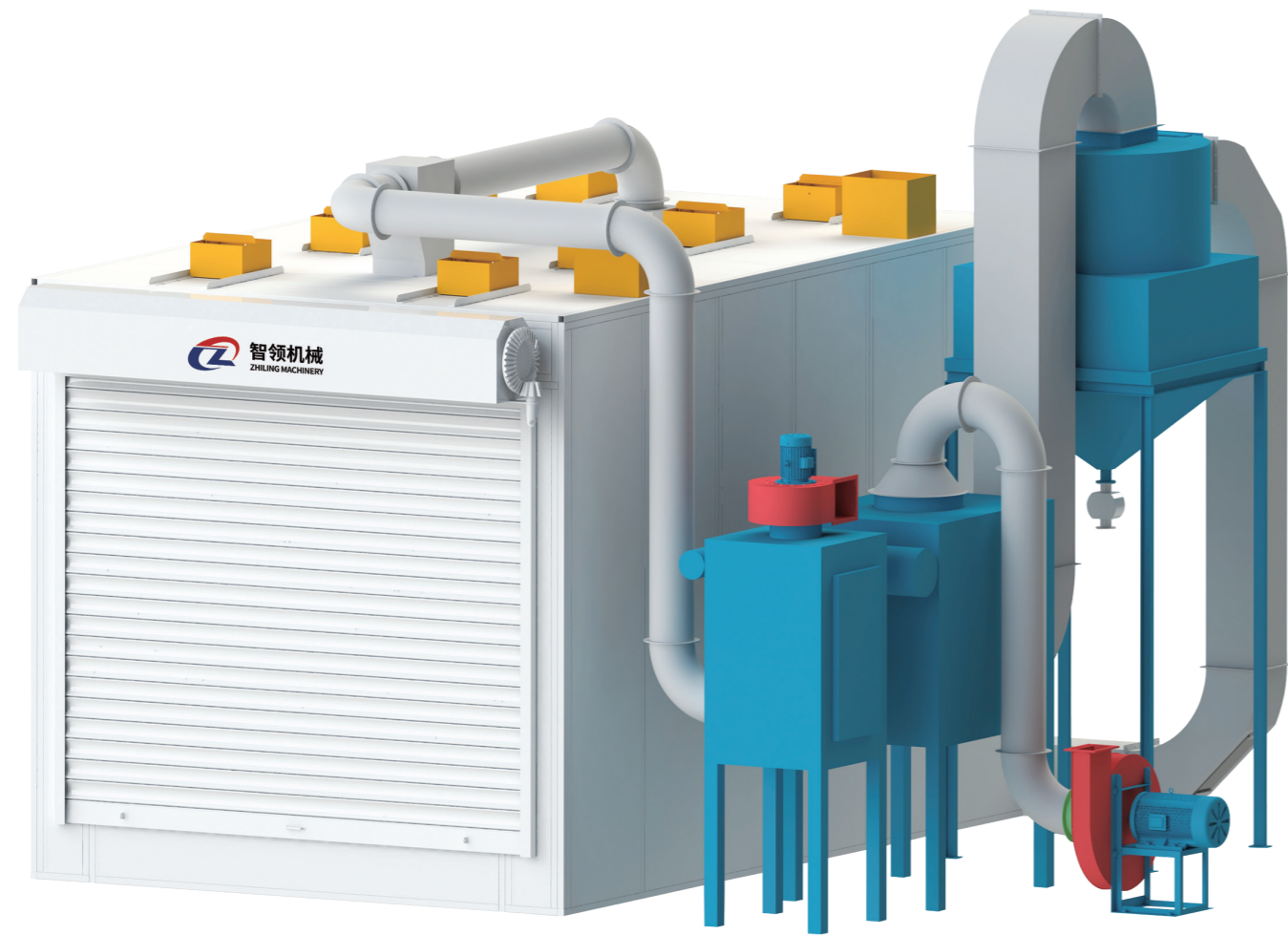
应用实例 The Instance



技术参数 Technical Parameters

型号 Type	参数 Parameter	类型 Model	清理工件尺寸 直径*高度 (mm ²) Cleaning workpieces size diameter * height	单钩载重量 (kg) The carrying capacity of unit hook
Q375		单钩 Single-hanger	500*1000	500
Q376		单钩 Single-hanger	800*1200	600
Q376E		双钩 Double-hanger	800*1200	600
Q378		单钩 Single-hanger	1000*1500	800
Q378E		双钩 Double-hanger	1000*1500	800
Q3710		单钩 Single-hanger	1200*1600	1000
Q3710E		双钩 Double-hanger	1200*1600	1000
Q3720		单钩 Single-hanger	1500*2000	2000
Q3730		单钩 Single-hanger	1500*2000	3000
Q3750		单钩 Single-hanger	2000*2500	5000

可根据用户的工件尺寸及重量，定做各种非标准吊钩式抛丸机。
We can design and manufacture all kinds of non-standard shot blasting machines according to customer different workpiece detail requirement, weight and productivity.



全自动回收喷砂房

Automatic Recycling Sand Blasting Room

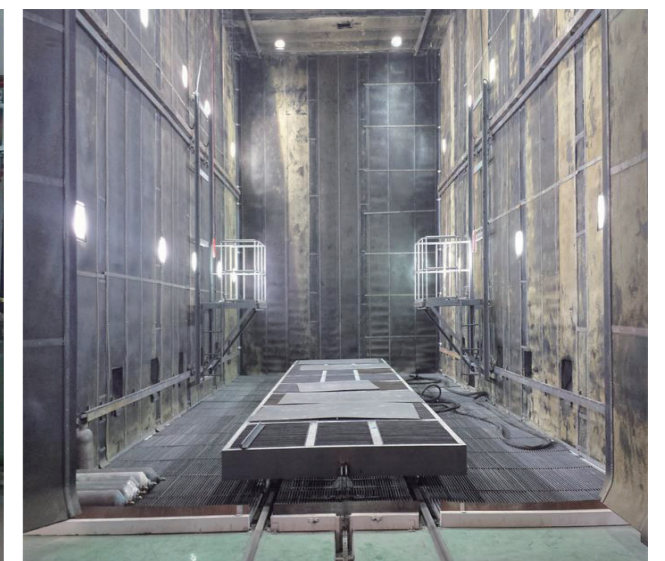
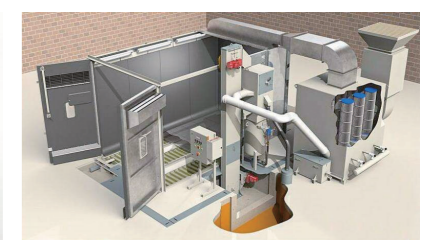
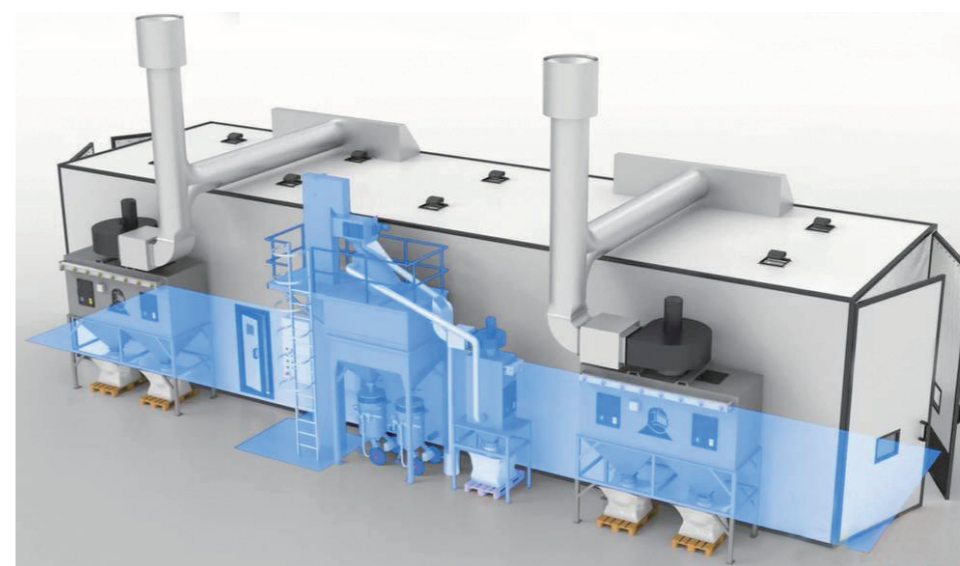
产品特点 Product Features

全自动回收喷砂房是根据产品加工工艺流程及产品本身特性而设计的,适用于大型铸件锻件、焊接钢结构、工程机械、工业锅炉、化工机械、船舶修造等表面去氧化皮、除锈、强化,提高涂层的附着力等。其结构及配套设备主要由喷丸室、喷丸系统、磨料循环系统、通风和除尘系统、照明和电气控制系统六大部分组成。

Automatic recycling sand blasting room is designed according to the product processing process and the product characteristic, it is mainly used for large forgings and castings welded steel structure, engineering machinery, industrial boilers, chemical machinery, ship building, etc, to remove surface oxide skin ,rust,and strengthen surface,to improve the coating adhesion,etc. This type machine is mainly composed of six parts: sand blasting chamber, sand blasting system, sand recycling system, ventilation and dust removal system, lighting and electrical control system.



应用实例 The Instance





喷漆房 Painting Room

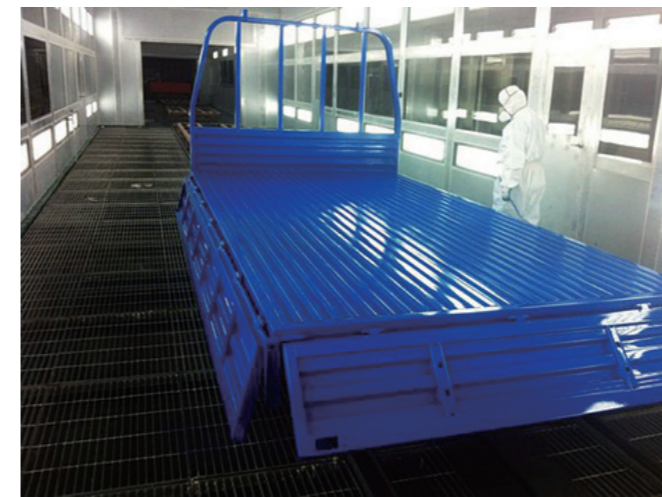
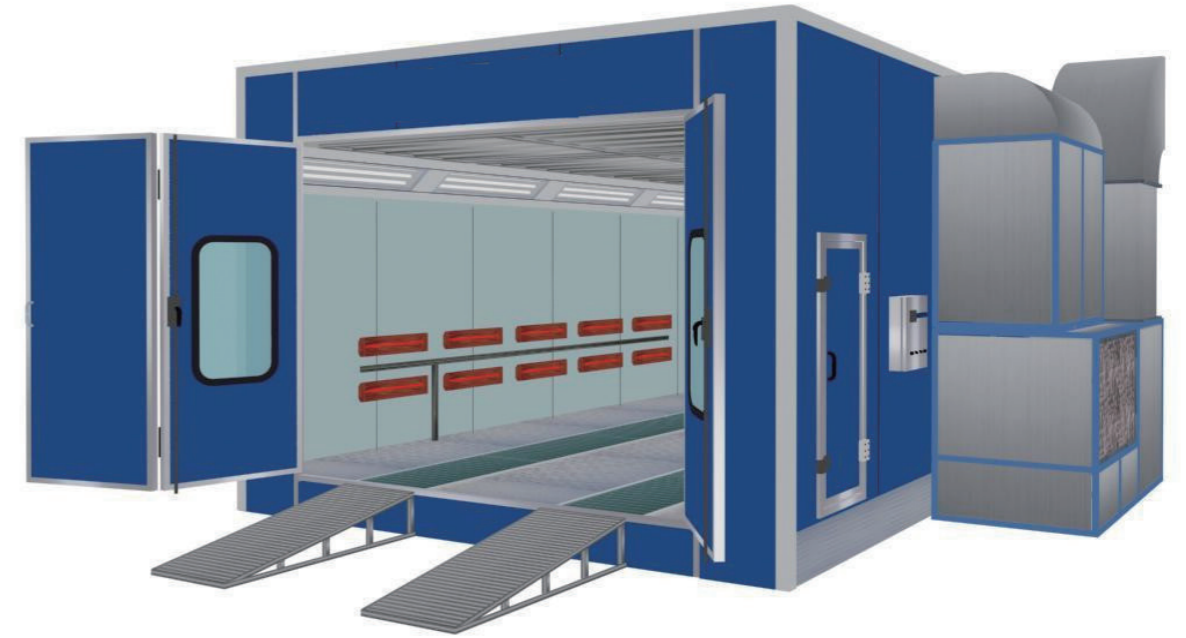
产品特点 Product Features

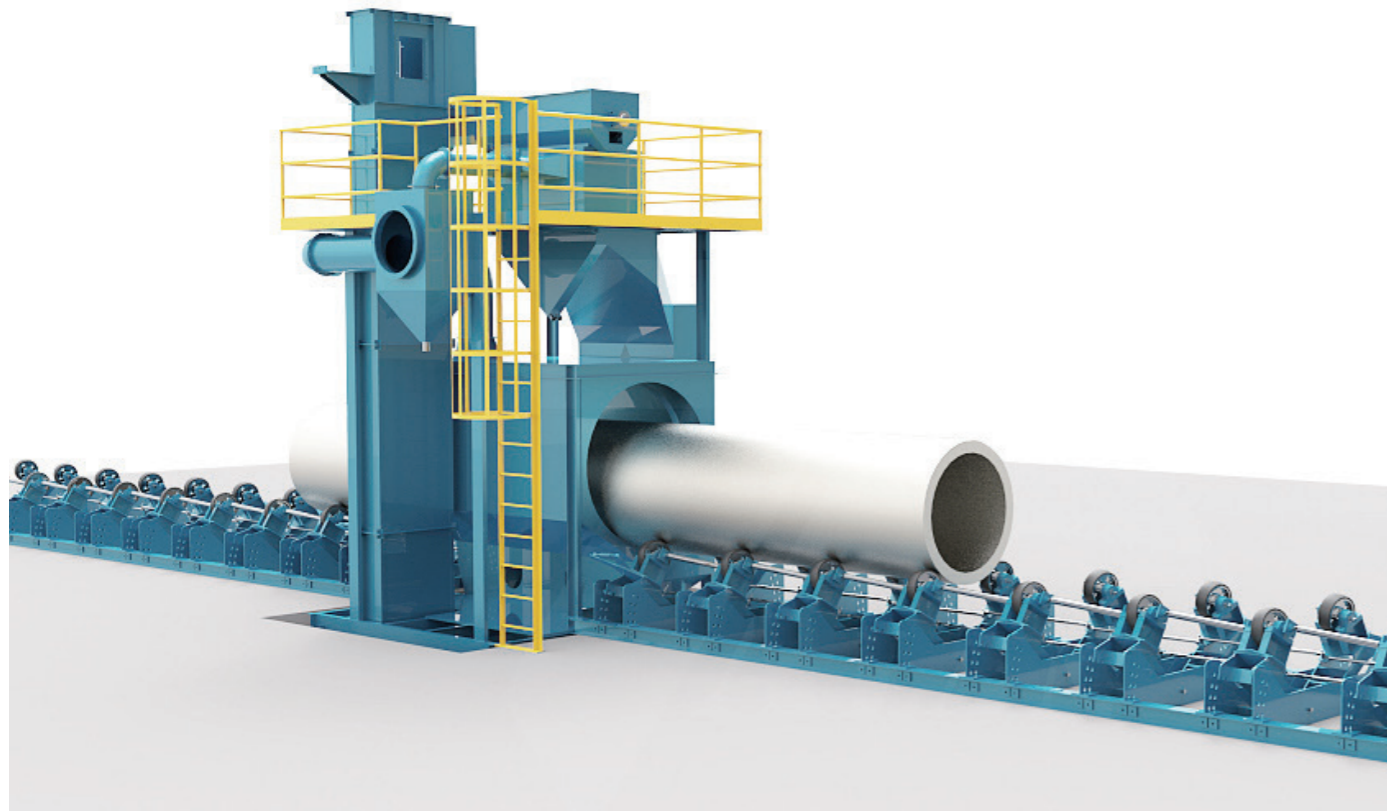
喷漆作业的作业区,能够为喷漆作业提供符合油漆工艺条件的洁净风,保证作业区的微正压环境,且能够通过喷漆雾处理达到人员保护及环保排放要求的核心设备,可根据工件尺寸、生产纲领及工厂环境作非标设计,常用类型包括:湿式水旋喷漆房、湿式文氏喷漆房、湿式水帘喷漆房、干式喷漆房。

Assignments area for painting job, it can supply clean wind in accordance with the paint process conditions, guarantee micro positive pressure environment, it is also the key equipment for meeting the requirements of personnel protection and environment protection through spray mist treatment. We can design non-standard machines according to workpiece size, production program and factory environment, common types include: Wet water rotary painting room, Wet venturi painting room, Wet curtain painting room, dry painting room.



应用实例 The Instance



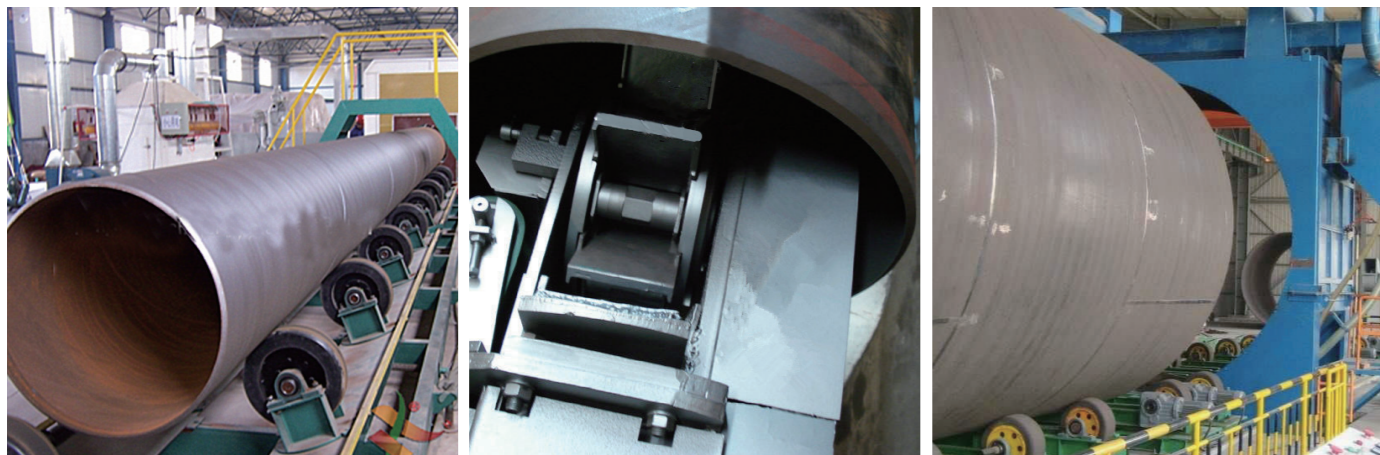


QG系列钢管内外壁抛丸清理机 QG Series Inner And Outer Wall Special Shot Blasting Machine

产品特点 Product Features

该系列钢管内外壁专用抛丸处理机适用于钢管及钢管类产品的表面处理,去除其表面氧化皮、焊渣等杂物,呈现出金属光泽,增加其表面积,以利于工件表面的喷涂及涂敷。广泛应用于石油化工、钢铁、城市集中供热、供排水等行业。

The series of QG inner and outer wall special shot blasting machine for surface treatment, wiping up the oxide coating, welding slag, appearing the metallic sheen, increasing the area of the surface, which is in favor of UV. It applies in the line of petroleum & chemical, steel, city centralized heating, centralized drainage etc.



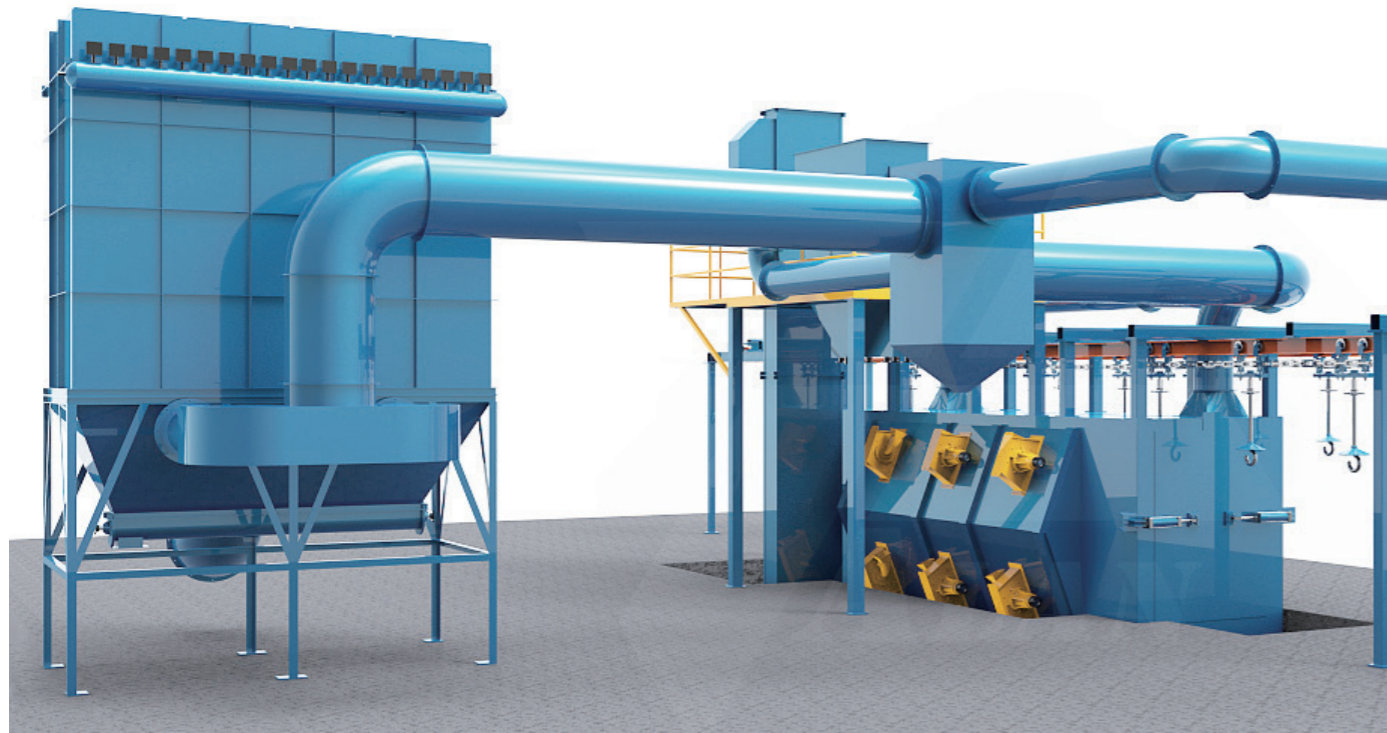
应用实例 The Instance



技术参数 Technical Parameters

型号 Type	参数 Parameter Cleaning size	清理尺寸 (mm)	清理速度 (m/min) Cleaning speed	用途 Purposes
QGW100	Φ50-300		2-10	外壁抛丸清理 Outer wall of shot Blasting machine
QGW720	Φ159-720		2-6	
QGW1200	Φ219-1016		1-6	
QGW1500	Φ325-1600		1-6	
QGW2800	Φ1016-2800		1-2	
QGN100	Φ50-300		1-4	内壁抛(喷)丸清理机 Inner wall of shot Blasting machine
QGN700	Φ325-720		1-2	
QGN1000	Φ720-1016		1-4	
QGN1500	Φ1016-1500		1-4	

可根据用户钢管的尺寸及生产节拍等参数,设计制作各种非标准钢管内外壁喷抛、喷丸设备。
We can design and manufacture all kinds of non-standard shot blasting machines according to customer different workpiece detail requirement, weight and productivity.



Q38、Q48、Q58系列悬链、积放链式抛丸清理机
Q38,Q48,Q58 Series Hanging Chain & Piled And Released Chain Type Shot Blasting Machine

产品特点 Product Features

该系列采用多工位定点旋转抛射清理的方式将铸件表面的粘砂、氧化皮去除,使铸件重现金属本色。主要用于汽车配件及机车的摇枕、侧架、车钩及钩尾框等车辆件,同时也可清理近形尺寸的铸件和批量小件。

This series machine uses the method of multistep fixed-point rotation blasting and cleaning, removing the sand and oxide skin on the casting surface, to reappear metal color. It is mainly used in car accessories and bolster, side frame, coupling, and frame of trail hook vehicle parts, at the same time also can clean the casting and small batch workpiece with similar size.



应用实例 The Instance



技术参数 Technical Parameters

参数 Parameter	型号 Type	Q383/Q483	Q385/Q485	Q4810
清理工件尺寸 (mm) Cleaning workpieces size		Φ800*1200	Φ1000*1500	Φ1000*2500
工位数 Number of work position		2	2	2
抛丸器数量 (台) Quantity of impeller head		4	4	6
抛丸量 (kg/min) Impeller head volume		4*250	4*250	6*250
抛丸器功率 (kw) Impeller head power		4*15	4*15	6*15
吊钩最大载重量 (kg) Max hanging weight		300	500	1000
生产率钩 (/h) Productivity hanger		30~60	30~60	40~60
清理室尺寸 (mm) Size of the cleaning room		7680*2000*2900	7680*2000*2900	7680*2000*3800
总通风量 (m³/h) Total airrate volume		17000	19000	19000
总功率 (不含除尘) (kw) Total power (except for dust cleaning)		73.15	73.15	114.72

可根据用户的实际生产需求,设计制作各种非标准悬链及积放链一步进及连续通过式抛丸机。
We can design and manufacture all kinds of non-standard shot blasting machines according to customer different workpiece detail requirement, weight and productivity.



QWD网带式抛丸清理机

QWD Mesh Belt Shot Blasting Machine

产品特点 Product Features

QWD系列网带式抛丸机主要用于薄壁铸件、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。QWD系列网带式抛丸机具有连续性好、清理效率高、变形小、无地坑等特点，既可单独使用，又可配线使用。

QWD series mesh belt shot blasting machine is mainly used for surface cleaning of thin-wall castings, thin-wall and fragile iron or aluminum alloy castings, ceramic, etc small parts, it can also be used for mechanical parts blasting and intensifying.

QWD series mesh belt shot blasting machine has advantages of good continuity, high cleaning efficiency, small deformation, no pit, etc, it can be used alone, also can be used in a production line.

应用实例 The Instance



可根据用户的实际生产要求，设计制作各种非标准网带连续通过式抛丸机及生产线。
 We can design and manufacture all kinds of non-standard shot blasting machines according to customer different workpiece detail requirement, weight and productivity.



Q32系列履带式抛丸清理机 Q32 Series Tumble Belt Shot Blasting Machine

产品特点 Product Features

该系列适用于各种中、小型铸件、锻件及机加工件的表面清理、除锈以及抛丸强化工艺。它适用于不同的生产规模，既可单独使用，也可多台联用，与连续输送器等配套组成生产清理流水线，是中、小型清理工作的理想清理设备。

Q32系列履带式抛丸清理机具有设计先进、结构合理、耗能小、效率高等优点。

This series is used for surface cleaning, rust removing, product intensifying for all kinds of medium and small casting, forging and machinings. It is suitable for different process scale, can work single or multiple, can also conjunction with the continuous conveyor. It is the idea equipment for cleaning workpiece of medium and small sizes workpieces.

Q32 series tumble belt shot blasting machine has advantages of advanced design, reasonable structure, low energy consumption and high efficiency.

应用实例 The Instance



技术参数 Technical Parameters

参数 Parameter	型号 Type	Q326	Q3210	QR3210
生产率(T/h) Productivity		0.6-1.2	3-5	1.5-2.5
加料量(kg) Loading weight		200	800	600
单件最大重量(kg) The maximum weight of one piece		10	30	30
端盘直径(mm) Diameter of roller		Φ650	Φ1000	Φ1000
有效容积(m ³) Available capacity		0.15	0.4	0.3
抛丸量(kg/min) Pill impelling volume		125	360	250
除尘风量(m ³ /h) Dedusting air volume		2200	6000	5000
功率消耗(kw) Power dissipation		12.6	32.6	24.3
外形尺寸(mm) Appearance dimension		3200*1520*3500	4290*1900*4500	5850*1950*4600



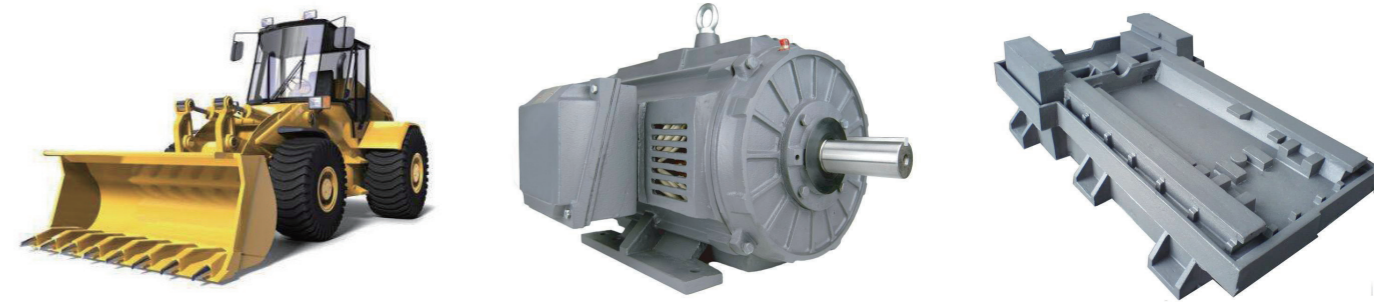
QT37系列环轨通过式抛丸清理机 QT37 Series Circular Track Through Type Shot Blasting Machine

产品特点 Product Features

该系列机型适合清理型钢、钢结构、钢板、建筑机械等大型焊接结构件，除掉其表面上的锈层、焊渣与氧化皮，消除内部的残余应力，使其获得均匀一致的金属光泽，以便提高钢材的涂饰质量与防腐效果。

The series machine is suitable for cleaning steel Profiles, steel structure, steel plate, construction machinery etc large welded structure parts, removing surface rust, welding slag and oxide skin, to eliminate the inside residual stress, and uniform metallic luster distribution, in order to improve the quality of coating in steel and anti-corrosion effect.

应用实例 The Instance



技术参数 Technical Parameters

型号 Type	QT20H	QT50H	QT3740H	QT3720H
参数 Parameter				
清理工件外形尺寸(mm) The exterior size of cleaning casting	5880*3185*957	4000*3270*1320	Φ2500*4650	Φ2000*3200
抛丸机型号 The type of impeller head	XQH400	XQH400	XQH350	XQH300
功率(kw) Power	8*18.5	8*18.5	8*15	12*11
抛丸量(kg/min) The quantity of shot blasting	8*280	8*280	8*250	12*200
总功率(不含除尘)(kw) Total power (except for dust cleaning)	187.4	187.4	148.3	168.3
总通风量(m³/h) Total airrate volume	30000	30000	19000	38000
机器外形尺寸(长*宽*高)(mm) The external dimension of machine (length*width*height)	18000*8150*11300	21000*7000*11509	14000*6200*7500 (地下1650) Under ground	19000*7200*7080 (地下2150) Under ground

可根据用户的工件尺寸及重量，定做各种非标准环轨通过式抛丸机。

We can design and manufacture all kinds of non-standard shot blasting machines according to customer different workpiece detail requirement, weight and productivity.



15/28GN钢履带式抛丸机 15/28GN Steel Crawler Shot Blasting Machine

产品特点 Product Features

15GN钢履带式抛丸机用于清除铸、锻件、冲压件等易翻滚跌落的工件和不易撞碎的非脆性零件及型芯不深的铸件表面的粘砂、锈层与氧化皮、毛刺。主要用户是机床厂、汽车厂、纺织机械厂、热处理车间、铸钢车间和冲压车间。由于该抛丸机型防护措施好，抛丸性能强，弹丸循环系统结构合理，对难以清理的工件也能取得满意的效果。

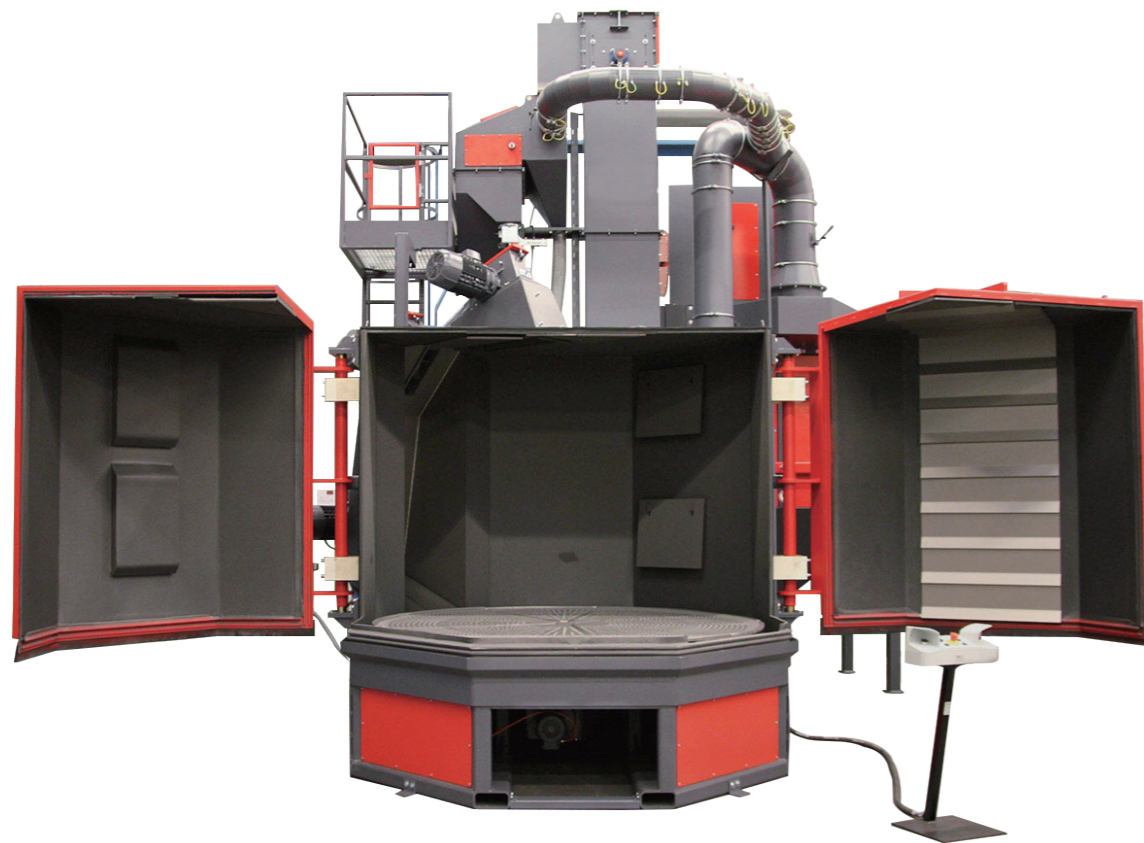
15GN steel crawler shot blasting machine is used for removing adhering sand and scale, burr, rust of castings, forgings, stamping parts and other easy to roll and drop workpiece and not easy to crush the non-brittle parts and core is not deep casting parts. The main users are machine tool plant, automobile factory, textile machinery factory, heat treatment workshop, cast steel workshop and stamping workshop. As the shot blasting machine has good protective measures, strong shot blasting performance, shot recycling system is reasonable, can also achieve satisfactory results for the workpiece that difficult to clean.

应用实例 The Instance



技术参数 Technical Parameters

参数 Parameter	型号 Type	15GN	28GN
有效工作容积 (m ³) Effective working volume (m ³)		0.43	0.79
尺寸 (直径*长) (mm) Size (Diameter*Length) (mm)		Φ1092*1245	Φ1245*1778
每桶最大装载量 (kg) Maximum loading capacity per barre (kg)		1362	3500
最大单件重量 (kg) Maximum single piece weight (kg)		227	363
卸料高度 (mm) Discharge height (mm)		1499	1545



转台式强化、抛丸清理机 Q35 turntable type strengthening shot blasting machine

产品特点 Product Features

本机主要适用于铸锻件及热处理后的扁平、薄壁怕碰撞零件的表面清理, 它可去除工件表面的粘砂、氧化皮等附着物, 获得一定粗糙度的光亮表面, 亦可用来对某些齿轮, 板簧件工件表面进行强化处理。

This machine is mainly used for surface cleaning of casting and forging parts, flat, thin-wall parts which can't be collision after heat treatment. It can remove adhering sand, scale, etc, attachments on surface of the workpiece, to obtain bright surface with a certain roughness. It can also be used for surface strengthening processing of some gear, plate spring, etc.

应用实例 The Instance



技术参数 Technical Parameters

参数 Parameter		型号 Type	Q3512	QF3512	QF3525E
清理室尺寸 (mm) Dimension of cleaning chamber			Φ1350*560	Φ1350*860	Φ2654*560
清理工件尺寸 (mm) Cleaning workpiece size			600*250*250	600*250*500	600*500*250
回转台车 Turntable car	载重量 (kg) Loading weight		400	400	1000
	直径 (mm) Diameter		Φ1200	Φ1200	Φ2500
抛丸器 Wheel blast equipment	抛丸量 (kg/min) Blasting capacity		200	2*120	2*250
	功率 (kw) Power		11	7.5*2	15*2
提升机提升量 (t/h) Lifting capacity of elevator			15	15	30
分离器分离量 (t/h) Separation quantity of separator			15	15	30
弹丸首次装入量 (kg) First loading quantity of shot			400	400	1500
通风量 (m ³ /h) Ventilation volume			2800	2800	5200
外形尺寸 (mm) External dimension			1500*3450*3780	1900*1900*4165	4260*3647*5366
功率 (不含除尘) (kw) Power (except for dust cleaning)			24.5	24.5	35.2

可根据用户的生产实际要求, 设计制作各种非标准转台步进式、转台连续式、子母转台连续式抛丸及强化机。
We can design and manufacture all kinds of non-standard shot blasting machines according to customer different workpiece Detail requirement, weight and productivity.



移动式路面抛丸清理机 Mobile Type Road Surface Shot Blasting Machine

产品特点 Product Features

路面抛丸机能够一次将混凝土的表面浮浆、杂质清理清除,并且可以对混凝土的表面进行打磨处理,使其表面均匀粗糙,大大提高了防水层和混凝土基层的黏着强度,以便防水层和桥面更好的结合,同时也能够将混凝土的裂纹充分暴露出来,起到防患于未然的作用。

Road surface shot blasting machine can successively clear away the concrete surface laitance and impurities, and can do polishing processing to the concrete surface, make its surface to achieve uniform roughness. Greatly improve the adhesive strength of the waterproof layer and concrete base, so that better combine the waterproof layer and deck, also to be fully exposed concrete cracks, achieve nip in the bud.

应用实例 The Instance



技术参数 Technical Parameters

参数 Parameter	型号 Type	PHLM-270	PHLM-600	PHLM-800
抛丸宽幅 (mm) Effective blasting width		270	600	800
行走速度 (m/min) Travelling speed		0.5-20	0.5-20	0.5-20
抛丸效率 (m ² /h) Production capacity		150	300	400
抛丸器功率 (KW) Total power		11	2*11	2*15
外形尺寸 (mm) Overall dimension		1000*300*1100	2050*780*1150	2050*980*1150
抛头数 Cast number		1	2	2



PHGT15 型倾斜滚筒式抛丸清理机 PHGT15 Tilting Drum Type Shot Blasting Machine

产品特点 Product Features

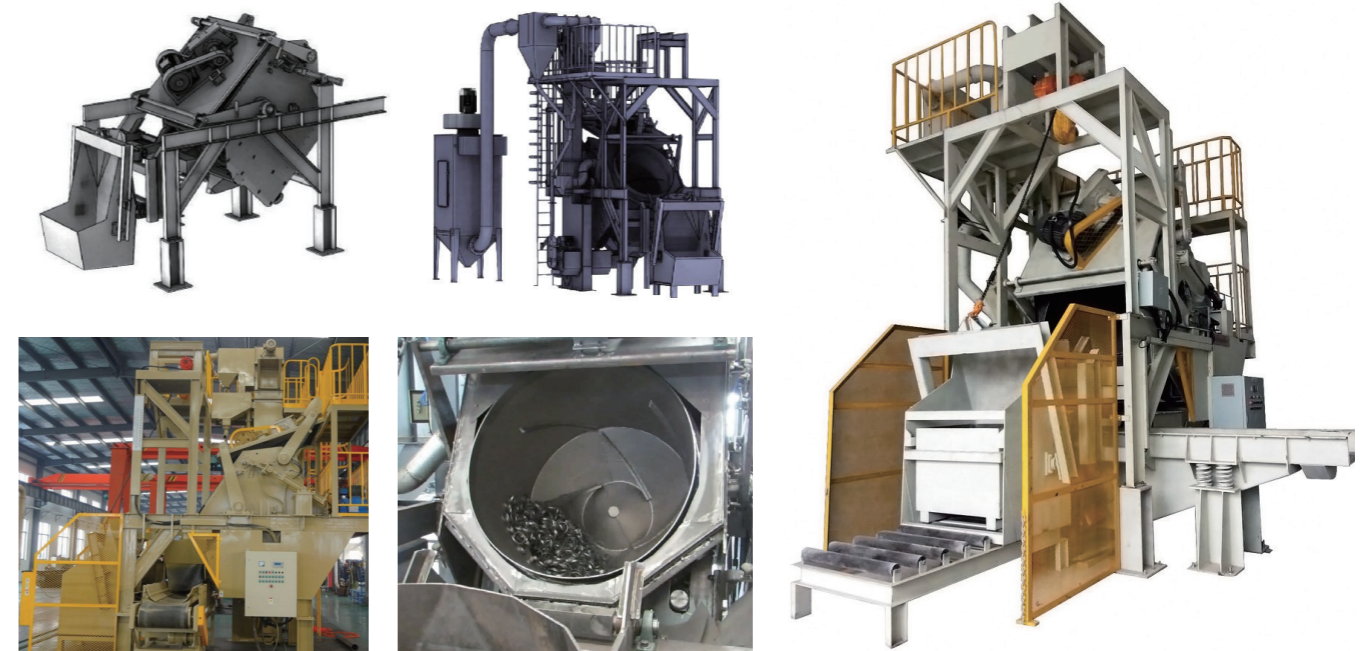
本机适用于清理易翻转滚落的工件和不易碎的非脆性零件及型芯不深的铸、锻及焊接件，可有效去除工件表面的砂粒和氧化皮。整机采用PLC控制，自动化程度高，既可单机工作，也可配线使用。本机与传统使用Q32型履带式及Q31型卧式滚筒清理机相比，具有装料量大，清理效率高，使用成本低等显著特点，可用于清理合理长度的杆状、尖状铸件而不会损伤设备或铸件。本机作为清理室的内胆铸造成型，内壁光滑，铸件在翻滚搅拌过程中不易造成损伤。

This machine is suitable for cleaning the workpieces that are easy to roll off and the non-fragile non-brittle parts and the deep core casting, taper forging and welding parts, which can effectively remove the sand and scale on the surface of the workpiece. The whole machine adopts PLC control, and the degree of automation is high. It can be used in stand-alone or production line.

Compared with the traditional Q32 crawler type and Q31 horizontal roller shot blasting machine, this machine has the characteristics of large loading capacity, high cleaning efficiency and low cost of use. It can be used to clean rods and pointed castings of reasonable length. Does not damage equipment or castings.

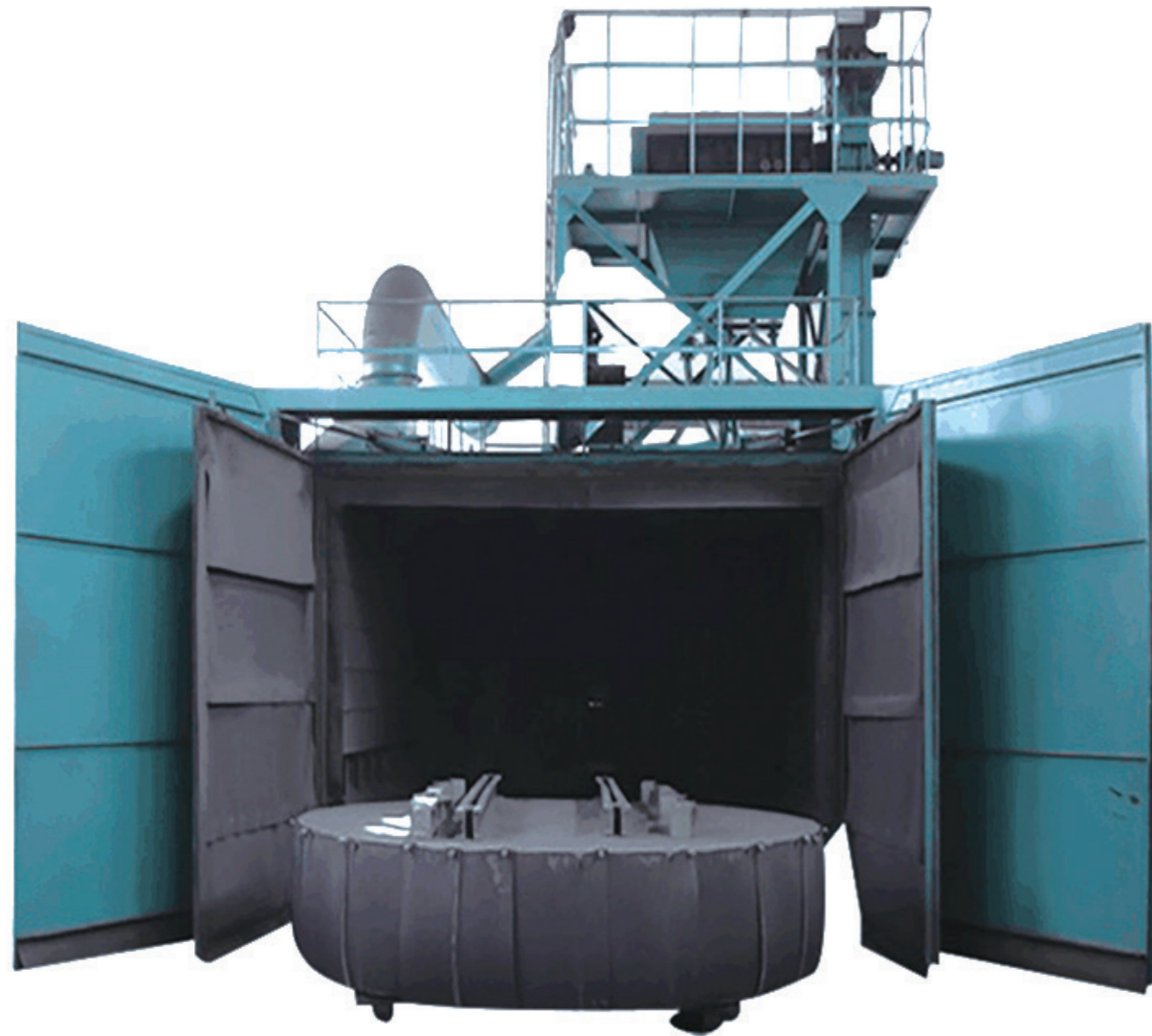
This machine is cast and molded as the inner chamber of the cleaning room, the inner wall is smooth, and the casting is not easy to cause damage during the rolling and stirring process.

应用实例 The Instance



技术参数 Technical Parameters

项 目 Item	参 数 Parameter	
整机性能 Machine performance	最大装载容量 (m ³ /time) Maximum load capacity	0.65
	最大装载质量 (kg) Maximum loading quality	1200-1500
	生产率 (kg/h) Productivity	3000-5000
	允许最大单重 (kg) Maximum single weight allowed	20
	允许最大尺寸 (mm) Maximum size allowed	500
	滚筒直径 (mm) Roller diameter	φ1500
	清理工件标准 Clean workpiece standard	GB8923-88 Sa2.5 JB/T8355-96 Sa2.5
整机数据 Machine data	整机尺寸 (含护栏) 长×宽×高 (mm) Machine size (including guardrail) Length × width × height (mm)	5415×3675×7103
	整机功率 (KW) Total power	About 50



台车式抛丸清理机 Trolley Type Shot Blasting Machine

产品特点 Product Features

该系列是台车式抛丸清理设备。利用抛丸器将高速弹丸抛向旋转台上的工件表面，清除其表面上的粘砂、氧化皮及其他杂物，使之获得一定粗糙度的光亮表面。本机主要应用于机床、冶金工业、车辆、工程机械、矿山机械和其他大型工件。

This is trolley shot blasting machine, utilize blasting wheel to throw the high-speed projectiles to the surface of workpiece on the rotating trolley, clean up the adhering sand, oxide scale and other sundries, the purpose is to obtain a certain roughness and bright surface. This machine mainly applies in machine tool, metallurgy industry, vehicle parts, construction machinery, mining machinery and other large workpiece.

应用实例 The Instance



可根据用户的工件尺寸及规格、重量及生产节拍，设计制作各种非标准大吨位台车式抛丸机。

According to users' workpiece size and specification, weight and production efficiency, we can design and manufacture all kinds of non-standard large tonnage trolley type shot blasting machines.

钢筋抛丸机(线材抛丸机) Steel Bar Shot Blasting Machine (Wire Shot Blasting Machine)



产品特点 Product Features

钢筋抛丸机是根据用户要求而设计制作的一种新型专用设备,是一种专门用于清理钢筋、线材的抛丸清理设备。它能对原始状态的钢材表面施以强力抛丸,除掉其上的锈层、焊渣及氧化皮,使之获得均匀一致的金属光泽,以提高钢材的涂饰质量与防腐效果。

The steel shot blasting machine is a new type of special equipment designed and manufactured according to user requirements. It is a shot blasting equipment specially used for cleaning steel bars and wires. It can apply strong shot blasting to the original steel surface, remove the rust layer, welding slag and oxide scale, so as to obtain a uniform metallic luster to improve the quality of the coating and anti-corrosion effect of the steel.

技术参数 Technical Parameters

清理工件范围 Cleaning product	高速工具钢 Steel bar/wire shot	
线材直径 Wire shot diameter	φ4—φ16mm	
进给速度 Feed speed	≤60m/min (调速由拉丝机或收线机决定) Speed regulation is determined by wire drawing machine or wire take-up machine	
抛丸器 Blasting wheels	抛丸量 Blasting capacity	4×280kg/min
	功率 Power	4×22KW (变频调速 Frequency)
提升机 Elevator	提升量 Lifting capacity	90t/h
	功率 Power	4KW
分离器 Separator	分离量 Separate capacity	45t/h
	分离区风速 Wind speed	4—5m/s
弹丸 Steel shot	粒度 Diameter	φ0.2—φ0.3mm
	材质 Material	高碳钢丸 High carbon steel shot
	初次弹丸装入量 First loading	约3200kg
除尘系统 Dust collector	设计风量 Air volume	5000m ³ /h
	功率 power	3KW

应用实例 The Instance

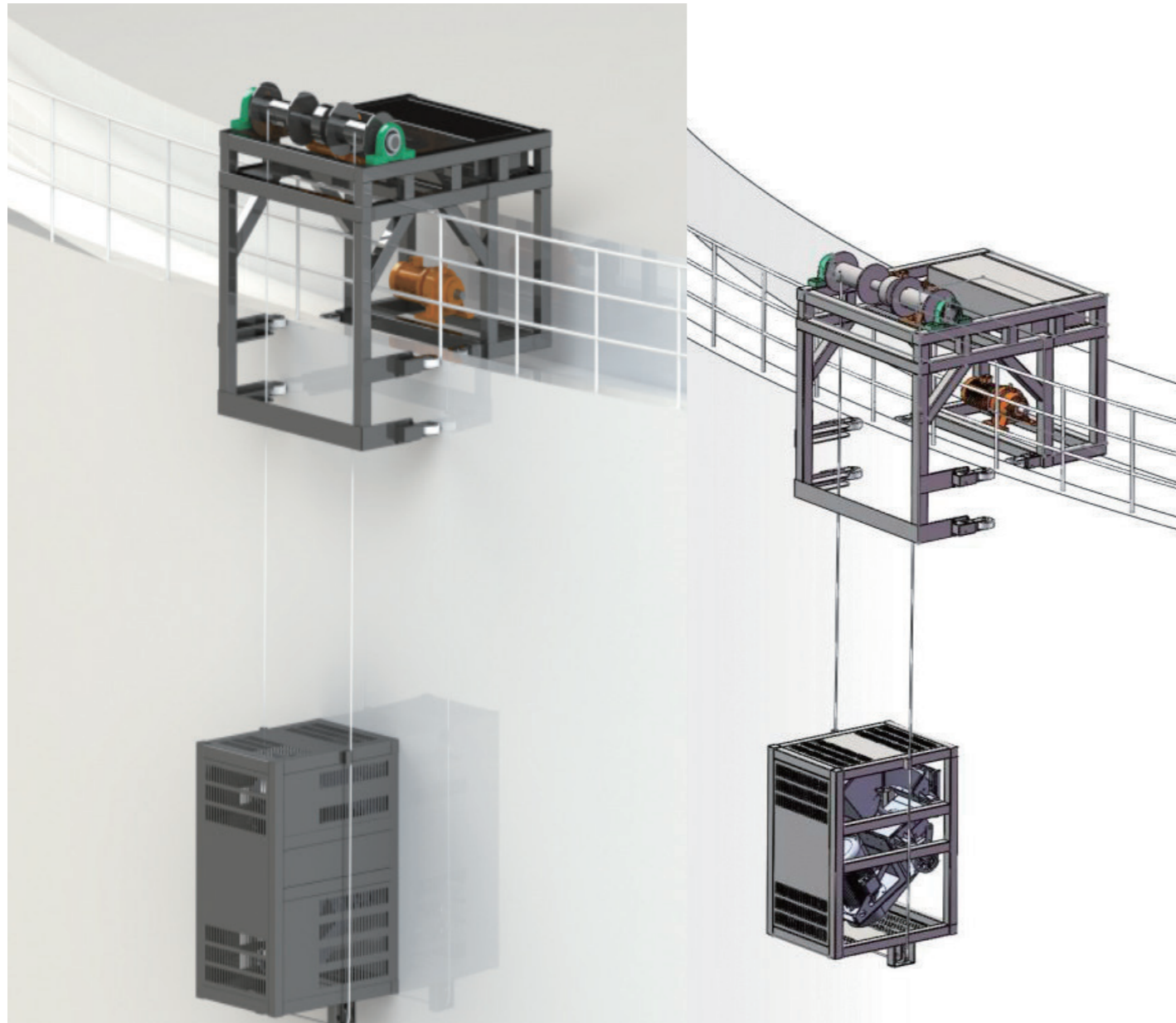


盘圆抛丸机 Coiled Wire Rod Shot Blasting Machine



技术参数 Technical Parameters

项目 Item	参数 Parameters	
处理线材规格 Size of wire rod	直径 Diameter: φ5.5-φ20mm	
工作速度 Cleaning work speed	线材处理速度 Wire processing speed: 0~60m/min	
抛丸清理质量等级 Shot blast cleaning grade	GB8923-88 A-B Sa2.5-3.0	
使用磨料(铸钢丸) Abrasives(steel shot)	Φ0.3mm-φ0.6mm	
弹丸表面覆盖率 Surface coverage of abrasives	100%	
噪音水平 Noise level	距离主机1米处≤85dB	
岗位粉尘 Dust concentration	≤50mg/m ³	
除尘效率 Dust removal efficiency	99%	
动力消耗 Power consumption	总功率 Total power	~90kw
	总耗气量 Total gas consumption	0.5m ³ /min, 0.45~0.6mpa
主机外形尺寸 Outside sizes of main machine structure	长度 Length:	~3440mm
	宽度 Width:	1575mm
	高度 Height:	4330mm
抛丸器 Impeller head HST-120	数量 Quantity	4
	功率 Power	4*15KW
斗式提升机 Hopper elevator	齿轮减速机 Gear reducer	SA67DT100M4
	功率 Power	4KW
下部螺旋输送机 Lower screw conveyor	齿轮减速机 Gear reducer	SA67DT90L4
	功率 Power	3KW



垂直移动式抛丸机

Vertical Mobile Shot Blasting Machine

产品特点 Product Features

垂直移动式抛丸清理机, 广泛用于涂料罐体、船体立面施工前的预处理, 特别适用于大型储油罐罐体立板、大型船体侧板等的喷砂处理。整个处理过程无粉尘污染, 能有效的去除表面浮浆、锈蚀、污渍等, 处理后的表面均匀平整, 清洁干净, 可以有效的提高涂料的附着性, 增强表面的防腐能力。本套设备最大的优势就是提高了劳动效率, 节约大量的人力物力, 工作效率比普通的喷砂罐提高3倍以上。

Vertical mobile shot blasting machine, widely used in pretreatment of paint cans and hull façades before construction. It is especially suitable for sand blasting of large oil storage tank body vertical plates and large hull side plates. The whole process no dust pollution, can effectively remove surface floating pulp, rust, stains, etc. The surface after treatment is even and smooth, clean and clean, can effectively improve the adhesion of the coating and enhance the anti-corrosion ability of the surface.

The biggest advantage of this equipment is that it improves labor efficiency, saves a lot of manpower and material resources, and the work efficiency is more than three times higher than that of ordinary sand blasting tanks.

应用实例 The Instance



技术参数 Technical Parameters

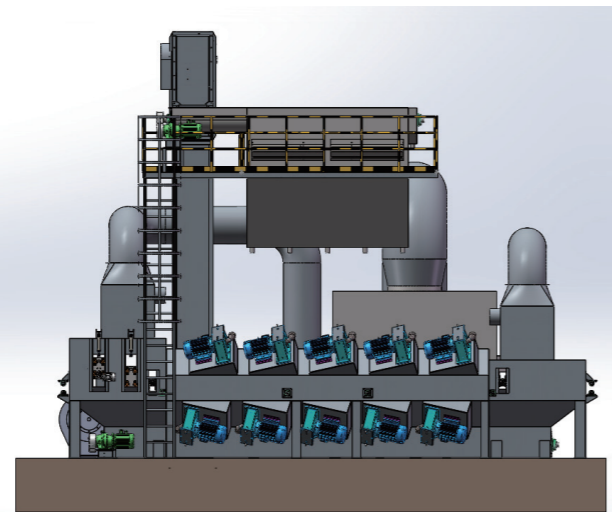
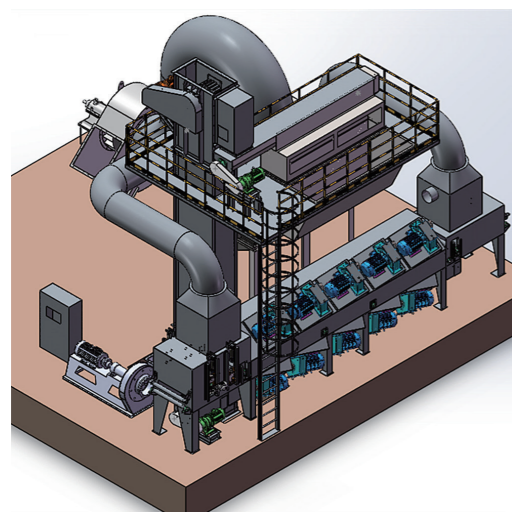
型号 Model	HST-H550
电压 Voltage	380V
总功率 Total power	30KW
工作宽度 Working width	550mm
表面吸附 Surface adsorption	电磁铁 Electromagnet
驱动方式 Drive mode	自动 Automatic
抛丸器数量 Number of blasting machines	2台 (2 sets)



高速带钢抛丸机

Steel Strip Shot Blasting Machine

应用实例 The Instance



产品特点 Product Features

带钢抛丸机主要应用于退火后碳素带钢或不锈钢的表面除锈及清理氧化皮, 亦可使用于退火后碳合金带钢的表面除锈及清理氧化皮, 是冶金行业及焊接钢管制造业表面处理的前工序。带钢抛丸机其实就是通过式抛丸机, 通过式抛丸机主要用于生产量大、要求高且结构单一的产品。

常规通过式抛丸机主要分为有清扫装置和无清扫装置(其他功能完全一样)。有清扫装置的主要用于大批量的衡器、钢板、带钢、挂车托盘等单一平面产品, 防止输送出来表面有残留的钢丸磨料。无清扫装置的主要用途范围很广泛, 车桥、车架、暖气片、石材、圆管、棒材、型材、型钢、钎具等宽而不高的产品。另外, 在宽度和高度范围内的任何有长度的产品都适用。通过式抛丸机能连续不间断地工作, 对各类钢材料, 如钢板, 钢材, 钢梁, 型钢, 钢管和铸钢件等以一种连续通过方式进行除氧化皮、清理和预处理。操作简便, 只需将带钢放到传送链上, 按下启动按钮, 带钢被匀速送入抛丸室进行抛丸处理, 抛丸结束后再送出抛丸室, 系统会将处理好的材料自动卸下, 即完成了整个清理过程, 清除掉所有粉尘和残余丸料。通过式抛丸机的抛丸速度可达到110m/s的速度, 连续高速击打, 在表面产生压应力的同时, 还可以将表面材料晶组织中的残余奥氏体转化为马氏体, 从而增加表面硬度, 提高抗疲劳性能, 延缓了零部件因疲劳造成的断裂, 延长零部件的安全使用寿命。通常选用的钢丸的直径要小于零部件过渡区的圆角半径, 表面清洁度可达到Sa2.5--3.0级标准, 确保钢丸的大小均匀度就能达到稳定的抛丸强化效果。

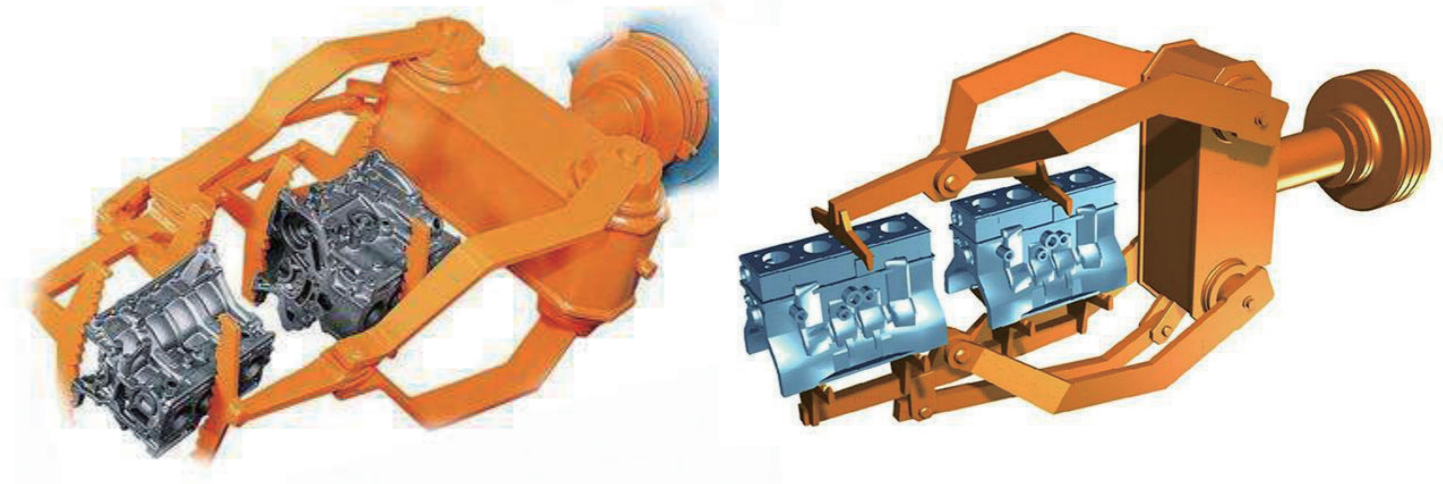
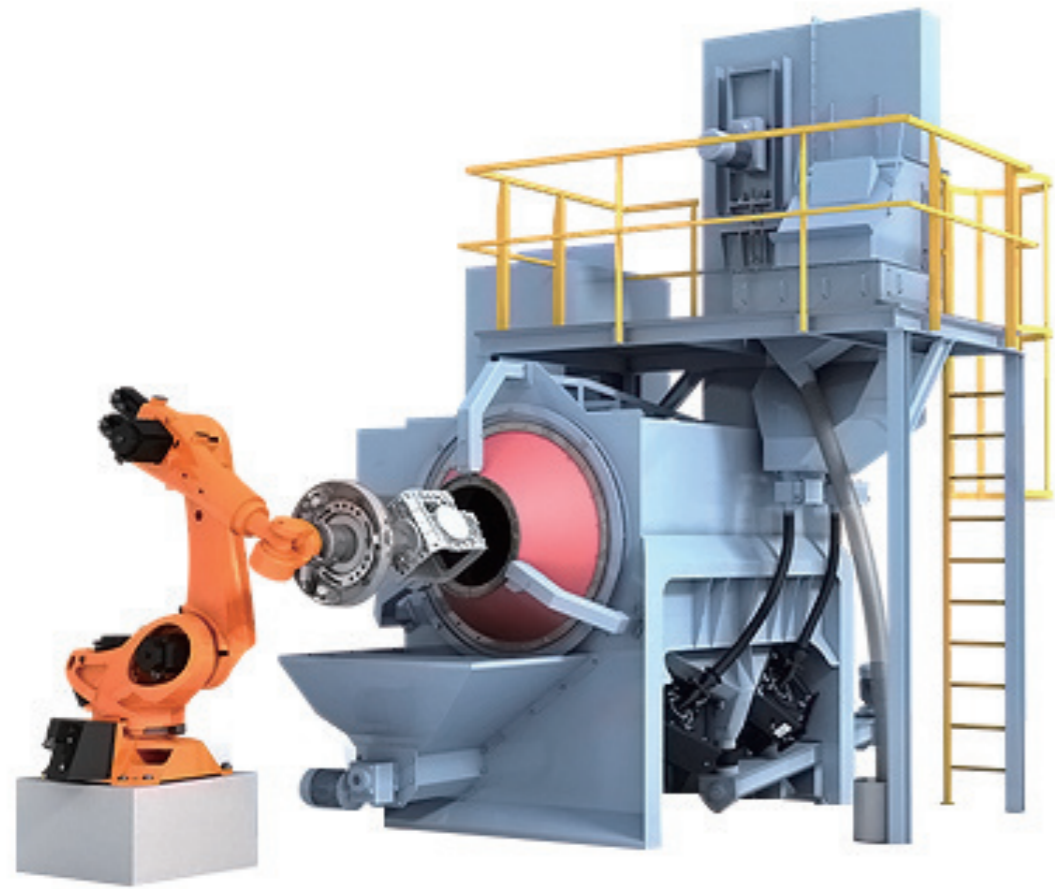
Strip shot blasting machine is mainly used for surface rust removal and cleaning of scale after carbon strip or stainless steel strip after annealing. It can also be used for surface rust removal and cleaning of scale after carbon alloy strip steel after annealing. The pre-process of surface treatment in the industry and welded steel pipe manufacturing. The strip shot blasting machine is actually a through-type shot blasting machine. The through-type shot blasting machine is mainly used for products with large production volume, high requirements and single structure.

The conventional pass type shot blasting machine is mainly divided into a cleaning device and a non-cleaning device (other functions are exactly the same). The cleaning device is mainly used for large-scale single-plane products such as scales, steel plates, strip steels, trailer pallets, etc., to prevent residual steel ball abrasives on the surface. The main purpose of the non-cleaning device is a wide range of products, such as axles, frames, radiators, stone, round pipes, bars, profiles, sections, and drills. In addition, any length of product in the width and height range is suitable. Through the type shot blasting machine, it can work continuously and uninterruptedly, and descaling, cleaning and pre-treating all kinds of steel materials, such as steel plates, steel, steel beams, steel sections, steel pipes and steel castings, in a continuous passing manner. Easy to operate, just put the strip on the conveyor chain, press the start button, the strip is sent to the shot blasting chamber at a uniform speed for shot blasting, and after the shot blasting, the blasting chamber is sent out, and the system will process the processed material. Automatic removal, which completes the entire cleaning process, removes all dust and residual pellets.

The shot blasting speed of the shot blasting machine can reach 110m/s, continuous high-speed hitting, and the compressive stress on the surface can also convert the retained austenite in the crystal structure of the surface material into martensite. Thereby increasing the surface hardness, mentioning the fatigue resistance, delaying the fracture of the parts due to fatigue, and prolonging the safe service life of the parts. The diameter of the commonly used steel shot is smaller than the fillet radius of the transition zone of the component, and the surface cleanliness can reach the Sa2.5--3.0 standard, ensuring the uniformity of the steel shot to achieve a stable shot peening effect.

技术参数 Technical Parameters

参数 Parameter	型号 Type	QDJ-4/600	QDJ-4/1600	QDJ-4/2100
钢带宽度最大 (mm) Maximum width of Band steel		600	600-1600	800-2100
抛丸器数 Blasting wheels		4	4	4
每个抛丸器功率 Power of each shot blaster		45	90	90
每个抛丸器抛丸量 (kg/min) Blasting capacity		600	1200	1200
功率 KW Power		230	480	480
清理速度 m/min Cleaning speed		20	20	15



机械手抛丸机 Manipulator Shot Blasting Machine

产品特点 Product Features

机械手式抛丸系统适用于对大型系列动力总成铸件或锻件进行抛丸加工和清理。如今,该系统已成为铸造业和锻造业不可或缺的一部分。机械手式抛丸清理系统能满足较高的生产需求,其卓越的抛丸处理效果众所周知:即使是很难处理的工件内表面也能清理得十分到位,而不会残留任何磨料。

The robotic shot blasting system is suitable for shot blasting and cleaning of large series powertrain castings or forgings. Today, the system has become an integral part of the foundry and forging industries. The robotic shot blasting system can meet the high production requirements, and its excellent shot blasting effect is well known: even the inner surface of the workpiece that is difficult to handle can be cleaned up in place without any abrasive residue.

应用实例 The Instance



技术参数 Technical Parameters

机器型号 Type	PE0313
生产效率 Cleaning efficiency	80件/小时(单件外形尺寸mm 1010×530×540) 80pcs/hour (single workpiece size:1010*530*540mm)
工件输送方式 Workpiece feed way	机动辊道输送进出抛丸室 Motorized roller conveyor into and out of the blasting chamber
工件尺寸 (mm) Workpiece size	6缸(较大1010×530×540, 较小730×380×300) 6 cylinder block(Maximum 1010×530×540, Minimum 730×380×300) 4缸(较大590×330×540, 较小400×330×250) 4 cylinder block(Maximum 590×330×540, Minimum 730×380×300)
机械手夹持重量 Robot grip weight	350kg
机械手夹持工件数量 Number of workpieces held by the robot	1个6缸缸体或2个四缸缸体 1 set of 6 cylinder block or 2 sets of four cylinder blocks
抛丸器功率 Shot blasting wheels power	6×37KW
抛丸轮速度 Shot Blasting wheel speed	2500rpm
料丸流量 Abrasive flow capacity	440kg/min(每台抛丸器each blasting wheels)
除尘器型号 Dust collector type	PE20
排风量 Exhaust air volume	16000m ³ /h

带连抛丸器

Belt Driven Shot Blasting Turbine



技术参数 Technical Parameters

参数 Parameter 型号 Type	叶轮直径 Diameter of impeller(mm)	叶轮转速 Rotating speed of impeller(r/min)	最大抛丸量 Maximum capacity abrasive flow (kg/min)	电机功率 Motor power(KW)
Q034	420	2600	250	11-15
Q035	320	2600	360	22
Q038	500	2370	970	75

产品特点 Product Features

皮带抛丸机是一种传统的抛丸器,具有抛丸量大、清理效果好等优点,是大型清理设备的必备件。

Belt driven shot blasting turbine is a conventional shot blasting wheel , the advantage is large rate abrasive flow and good cleaning effect, etc. It is the essential part of the large shot blasting cleaning equipment.

直联抛丸器

Direct-Driven Shot Blasting Turbine



技术参数 Technical Parameters

参数 Parameter 型号 Type	叶轮直径 Diameter of impeller(mm)	叶轮转速 Rotating speed of impeller(r/min)	最大抛丸量 Maximum capacity abrasive flow (kg/min)	电机功率 Motor power(KW)
ZLQ034	380	2940	120	7.5
Q065	440	2940	550	37

产品特点 Product Features

直联抛丸器是一种新型、高效的抛丸器,具有外形美观、结构紧凑、噪音低、节能环保等特点。

Direct-driven blasting turbine is a high-efficient blast wheel ,the advantage is the beautiful appearance, compact configuration , low noise, economy and environmental protection. Has the largest power and largest abravis flow rate . It is widely used in all kinds of shot blasting cleaning machine .

脉冲反吹式布袋除尘器

Pulse Blowback Bag Type Dust Collector



产品特点 Product Features

脉冲反吹式布袋除尘器,是我公司在消化吸收英国先进技术的基础上设计制造的新型除尘器。可根据用户处理的含尘气体的特点,选用具有针对性的滤袋; 解决高温、粘性、含湿量大及有尘爆危险的粉尘过滤问题,广泛应用于冶金、化工、机械、木业、建材、轻工、制药、粮食等产业。

This kind of the dust collector is a new type and is designed through introducing UK advanced technology. We could choose special sieve bag to solve some relevant problems of high temperature ,viscous moisture content and dust filtration. This kind of dust collect is used for metallurgy, chemical ,machinery, wood industry ,light industry ,pharmacy industry ,and food industries and so on.

技术参数 Technical Parameters

参数 Parameter	型号 Type	MC200	MC250	MC300	MC350	MC400
过滤面积 (m ²) Filtration area		200	250	300	350	400
处理风量 (m ³ /h) Disposal air quantity		26400	33000	39600	46200	52800
滤袋规格 Sieve bag specification	直径 (mm) Diameter	130	130	130	130	130
	长度 (mm) Length	2500	2500	2500	2500	2500
滤袋数量 (条) Sieving bag quantity		200	250	300	350	400
过滤风速 (m/min) Filtration wind speed		1.2~2.0				
除尘效率 (%) Removing dust efficiency		99.5				

SZ25系列中速混砂机

SZ25 Series Medium Speed Sand mixer

产品特点 Product Features

本机适用于连续混制树脂砂、水玻璃砂、赤泥水玻璃砂、有机脂水玻璃砂的设备,适用于铸造行业中小件树脂自硬砂的制芯和造型,主要由大臂、小臂、底转盘、树脂桶、固化剂桶、电气系统、砂定量装置、气液系统等组成,混制均匀、连续、高效。

This machine is used for mixing system prototype resin sand, sodium silicate sand, red mud glass sand, organic fat sodium silicate sand equipment, suitable for small and medium foundry industry a resin from hard sand core production and modelling, and the main arm, forearm bottom wheel, resin barrel, curing agent barrel, electrical system, sand dosing device, gas liquid system, etc, mixed system uniform, continuous, high efficiency.



Z14系列微震式造型机

Z14 Series Microseism Moulding Machine



产品特点 Product Features

本款机器可用于一般铸造车间,也可用于机械化或半机械化的铸工车间。适用于批量生产的小型铸件,单面型板单箱造型,可造上箱或下箱。设计优化后的机身结构采用方箱框架结构,大幅度提高机身的刚性。机器采用震压造型工艺,可大幅度提高压实力,使砂型硬度可达HB90以上,表面光洁度提高一个等级,稳定其产品质量。

机器震击部分采用弹垫微震,可有效降低对地基的影响,大大降低了噪音;起模机构采用油缸、曲柄、连杆、同步轴实现同步起模;机器全部采用气动元件来实现整体功能,气路系统简洁,操作简单、灵活、使用保养方便;视砂型情况,操作程序可人性化,大大地提高了生产效率。

This machine can be used in general foundries, also in mechanized or semi-mechanized foundries. It is suitable for small castings produced in batches single-sided and single-box, and can be used to make upper or lower boxes.

The optimized fuselage structure adopts a square box frame structure, which greatly improves the rigidity of the fuselage. The machine adopts shock molding technology, which can greatly increase the compaction force, make the sand mold hardness above HB90, improve the surface finish by one level, and stabilize the product quality.

The vibration part of the machine adopts spring cushion micro-vibration, which can effectively reduce the impact on the foundation and greatly reduce the noise; the mold ejection mechanism uses oil cylinders, cranks, connecting rods, and synchronous shafts to realize synchronous mold ejection; the machine uses pneumatic components to realize the overall function. The air system is simple, the operation is simple and flexible, and the use and maintenance are convenient; depending on the condition of the sand mold, the operation procedure can be humanized, which greatly improves the production efficiency.

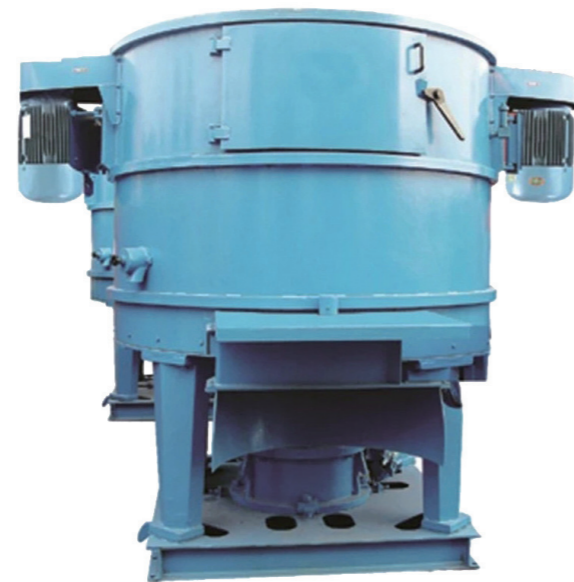
GS系列高速转子混砂机

GS Series High Rotor Mixer

产品特点 Product Features

该机主要用于铸造车间型砂的混制,即可混制机器造型用的单一砂,又可混制干磨砂、自硬砂、面砂和背砂,也可以用于玻璃、陶瓷、耐火材料等行业混制各种粉粒状物料。

It is mainly used foundry sand mixing, mixing machines can be used in a single sand shape, but also mixing dry scrub, since the hard sand, sand veil and back, can also be used for glass, ceramics, refractories, etc. mixing of powder industry granular materials.



树脂砂处理工艺生产线

Resin Sand Production Line Process

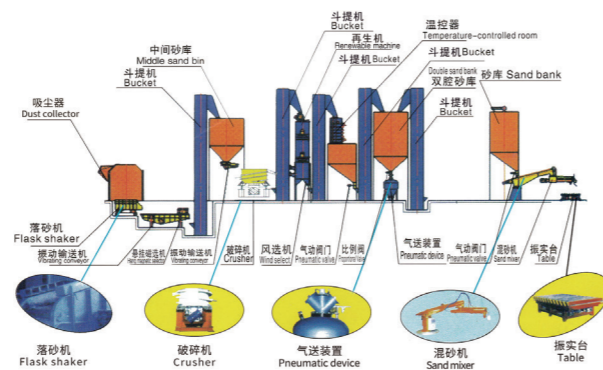
产品特点 Product Features

本再生线在消化吸收国外先进技术的基础上，研制开发了呋喃树脂砂、自硬化水玻璃砂、CO₂吹气硬化造型、制芯多规格的再生成套设备及各类输送设备。设备制造精良，主要电气化元件选用国内名牌产品，其性能达到国外同类产品先进水平。根据用户需求提供各类生产线成套设备的安装、调试等交钥匙工程。

该系列再生线用于树脂砂旧砂再生，有S523、S524、S528、S5216等各种规格，可提供各种型号、规格的树脂砂混砂设备。

The renewable-line digestion and absorption in the advanced foreign technology, based on research and development of the furan resin sand, since the hardening water glass sand, CO₂ inflatable hardening modeling, multi-core system-standard equipment and all kinds of renewable sources of transportation equipment. Sophisticated equipment manufacturers, the main selection of the domestic brand of electric components, the performance of advanced level of similar products abroad. Various types of user needs based on the production line to provide complete sets of equipment installation debugging and other turnkey projects.

Line in the series for regeneration of resin-bonded sand Sand reclamation the S523, S524, S528, S5216 and other specifications, can provide a variety of models, standard equipment, resin sand mixer.



粘土砂处理工艺生产线

Clay Sand Producing Line Process

产品特点 Product Features

粘土砂是以粘土为粘结剂配置的型(芯)砂，砂处理工部是铸造车间的重要组成部分，其主要的任务就是为造型制芯工部提供合格的型砂和芯砂。型芯砂制备的好坏直接影响铸造生产的质量和产量的提高以及成本的降低，由于砂处理工艺过程复杂，粘土砂处理和运输工作量非常大，而且环境十分恶劣，因此实现砂处理过程机械化是铸造生产的一个重要组成部分。

Clay sand clay-based binder configuration(core)sand, sand casting and Industry is an important component of the workshop, whose main task is to design the system to provide qualified and Industry core sand and core sand Preparation of mold and core sand casting a direct impact on production quality and yield improvement and cost reduction. due to the complex process of sand, clay sand handing and transportation of the workload is very large, but very poor environment, so the realization of the process of mechanization sand Casting production is an important component.



全自动粉末涂料喷涂系统

Automatic Powder Coating Steel Structure Spray Painting System



产品特点 Product Features

- 1) 输送系统:粉末涂料闭路高架输送机。
- 2) 自动粉末室:带旋风分离器或过滤器回收级,由钢材制成。
- 3) 自动喷枪和往复运动器:用于均匀一致的粉末涂层。
- 4) 自动筛分机:最大限度地提高送粉、清洗和控制的性能。
- 5) 养护隧道:加热温度均匀,保证养护效果的质量。

- 1) Conveying system: closed-circuit overhead conveyor for powder coating.
- 2) Automatic powder booth: with cyclone or filter recovery stage, made of steel material.
- 3) Automatic spray gun and reciprocator: for consistent and uniform powder coating.
- 4) Automatic sieving machine: maximize the performance of powder feeding, cleaning and control.
- 5) Curing tunnel: uniform heating temperature ensure quality cured results.