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QINGDAO CHINA

# 青岛祥茂机械制造有限公司

Qingdao Xiangmao Machinery Manufacturing Co.,Ltd



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COATED SAND MOLDING

SHOT BLASTING

DUST REMOVAL

MOLD CORE SHOOTING

Qingdao Xiangmao Machinery Manufacturing Co., Ltd is a vertically integrated enterprise encompassing research, production, installation, and sales. It operates as a comprehensive company specializing in metal surface cleaning equipment, sand treatment systems, molding core injection equipment, and environmental dust removal solutions. Located in Huangdao District, Qingdao, the company enjoys excellent geographical advantages with convenient access via water, land, and air transportation.

Metal surface cleaning equipment: GT Series Tilted Drum Cleaning Machine; QXY Series Steel Plate Pre-treatment Line; Q32 Series Rubber Belt Cleaning Machine; GN Series Metal Belt Cleaning Machine; Q37 Series Hook-type Cleaning Machine; Q38, Q48, and Q58 series Hang-chain shot blasting cleaner; Q69 series roller belt pass through and section steel cleaning machine; Q25 shot blasting machine; Q35 turntable blasting machine; Q76 trolley-type shot blasting/peening machines; QGW series Steel Pipe Cleaning Machine; and other specialized non-standard shot blasting cleaning machine.

Core-forming equipment: Z14 series micro-vibration compaction molding machine; Z86 series, ZH87 series, Z94 series core shooter machines; Z95 series shell-core machines.

Complete sand processing equipment: production lines for resin sand and clay sand (with annual capacities ranging from 3,000 to 10,000 tons), as well as reclamation equipment for V-process and lost-foam casting; shell molding production lines; and design, fabrication, and installation of custom non-standard sand processing machinery tailored to specific user requirements.

Resin-coated sand molding equipment: resin-coated sand shell molding production lines, automatic iron-mold resin-coated sand casting lines, etc.

Environmental Dust Removal Equipment: xiangmao machinery boasts a professional team dedicated to the R&D, design, and manufacturing of air purification and environmental protection products, enabling us to provide comprehensive dust removal solutions to clients across various industries. By continuously incorporating the best technical practices from the industry—both domestically and internationally—we have developed over a hundred varieties of dust removal equipment, including shaker-type and pulse-jet fabric filter systems, pulse-jet cartridge systems, and spray towers.



With robust technical capabilities, advanced production processes, comprehensive testing methodologies, and a scientific management system, the company has gradually become a leader in China's casting machinery industry regarding mold design, core manufacturing, sand treatment, and shot blasting technology. It boasts a team of senior engineers with exceptional expertise and extensive experience in the field. Over the years, the company has cultivated a large pool of skilled technical personnel as well as dedicated installation and after-sales service teams. Committed to pioneering advancements in casting equipment development, the company continuously innovates and develops specialized solutions, providing high-quality supporting equipment and services for industries such as shipbuilding, automotive, defense, locomotive manufacturing, and machine tool production. Its performance in technological development, custom manufacturing capacity, product quality, installation efficiency, commissioning expertise, and delivery timelines has earned widespread customer recognition. The company is also capable of designing and manufacturing various customized casting machines tailored to specific user requirements.

## COMPANY VISION

Upholding the corporate spirit of "Quality, Integrity, Innovation, and Service," the company operates based on principles of superior manufacturing processes, rigorous quality standards, comprehensive after-sales support, a strong commitment to market reputation, and sincere service. We strive to establish ourselves as a renowned specialist in the foundry machinery industry, delivering premium, integrated solutions for metal surface treatment, sand processing, and molding, while executing high-quality, specialized projects.

### **QINGDAO XIANGMAO MACHINERY MANUFACTURING CO., LTD.**

Haixi Road, Huangdao District, Qingdao City, Shandong Province, China

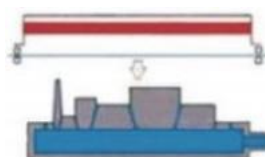
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## Vacuum process casting

### Manufacturing Process Flow:

Fixed model onto negative pressure box → vibratory compaction table's motorized roller conveyor transfers the negative pressure box onto the motorized roller conveyor → automatically unfolds and cuts the film → Heating, film application, and manual film repair → Manually set the gate and vent riser on the upper box → Spray paint → Coating Drying (Optional) → the motorized roller conveyor transfers the vacuum box to the vibrating table → the mobile vibrating table moves to the empty box capping station → a manipulator caps the empty box → the mobile vibrating table moves to the sand filling and compaction station → sand is filled and compacted → the vibrating table moves to the pattern stripping station → the backing film is manually applied, and a vacuum is automatically drawn → a manipulator strips the pattern → the bottom box is flipped and sent to the mold-closing cart → cores are manually inserted → a manipulator strips the pattern and repairs the mold shape on the top box → after core insertion, a manipulator closes the mold → the mold is manually locked → a vehicle-mounted vacuum pump transfers the locked sand box to the pouring area → the pouring basin and backing sand are manually placed, awaiting the pouring process.



1 薄膜加热  
EVA film heating



2 模型覆面膜  
cover film on the mold surface



3 放砂箱  
moulding flask



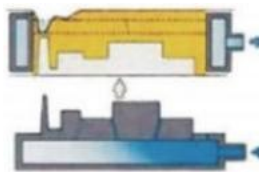
4 加砂震实  
sand compaction



8 打箱  
loose finished casting



7 待浇注的铸型  
Combine the two flasks



6 起模  
drawing the flask

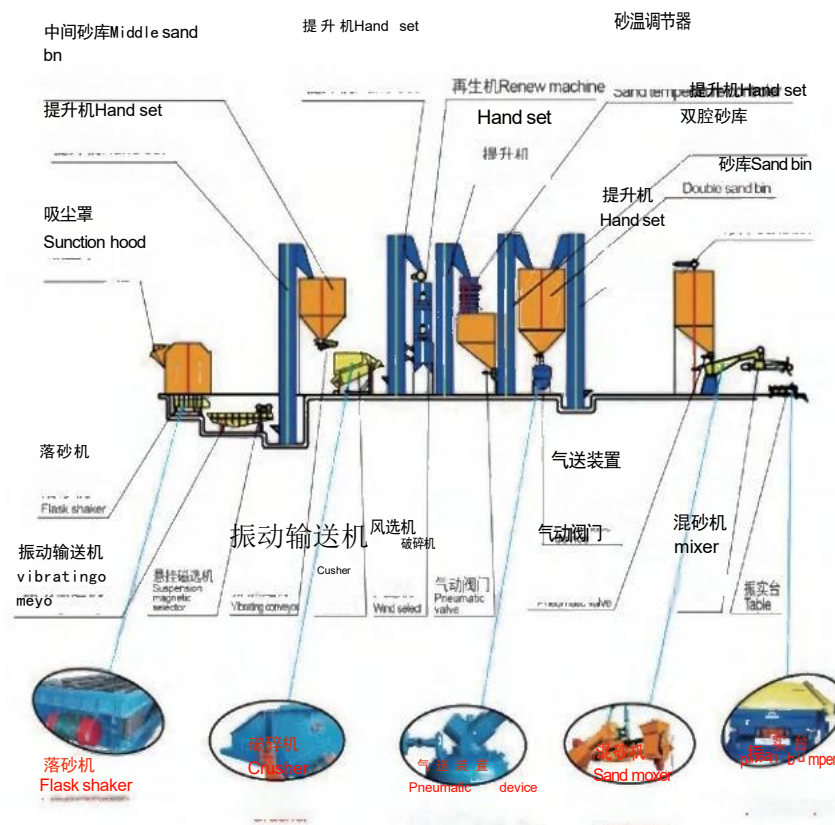


5 覆被膜  
Cover plastic film on the flask

## Resin sand production line process

The resin sand molding production line is an important component for mechanizing the sand processing process and casting production. It generally consists of a magnetic separator belt, sand silo, elevator, resin sand demolding machine, ash screening machine, vibrating crusher, pneumatic conveying tank, and resin sand mixer.

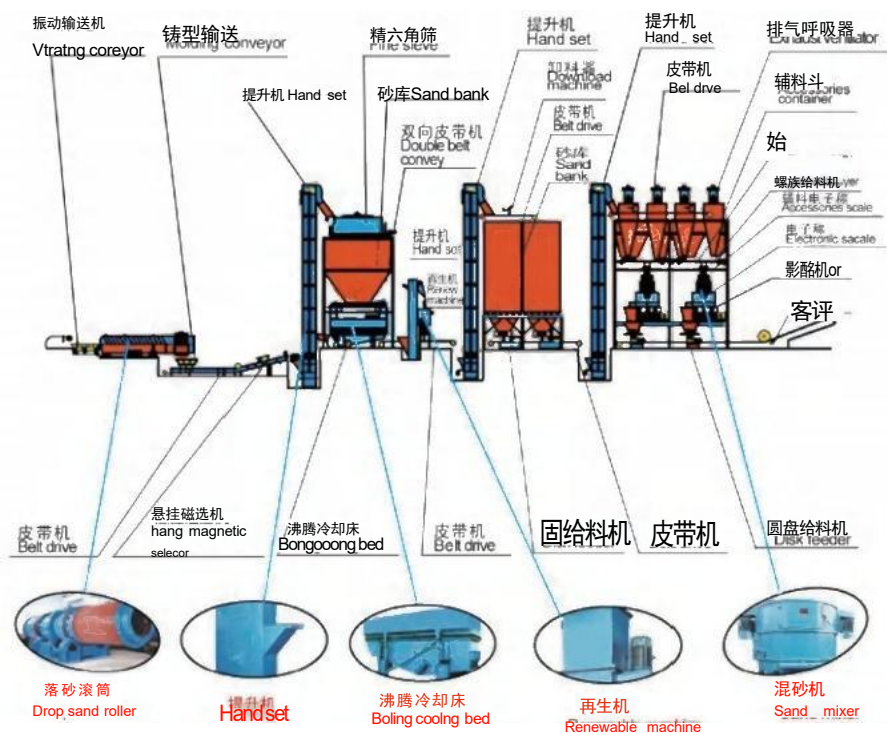
The quality of the casting process in the resin sand treatment production line directly affects the yield, quality, and cost of castings. The resin sand production line greatly reduces the labor intensity of workers in core making, molding, sand removal, and cleaning processes.



## Clay sand production line process



Clay sand is molding (core) sand prepared using clay as a binder. The quality of core sand preparation directly affects the quality and output of casting production, as well as casting costs. Due to the complexity of the sand processing process, the workload of clay sand processing and transportation is very large, and the environment is extremely harsh. Therefore, the mechanization of the sand processing process is an important component of casting production. The main task of the sand processing department is to provide qualified molding and core sand to the molding and core-making department. Therefore, achieving mechanization of the sand processing process is an important part of casting production.



## Lost foam casting production line

Lost foam casting equipment offers the following advantages::

1. Eliminates the need for mold splitting, greatly simplifying the mold structure.
2. Reduces the difficulty of mold making and shortens the mold-making cycle.
3. Enables the creation of complex internal hole or cavity structures.
4. Produces parts without internal parting marks, resulting in higher quality.
5. Significantly reduces or eliminates post-processing work.
6. Provides the final usable shape directly, reducing costs.
7. Enables the creation of structures impossible using traditional methods.
8. Significantly reduces material waste.
9. Manufacture lightweight structural components, reducing product weight.
10. Allows for flexible adjustment of cavity positions, increasing design freedom.

In conclusion, lost foam casting technology can greatly improve the manufacturing process and yield higher-quality products.。



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## Iron mold sand coating production line

Iron mold sand casting has the characteristics of sand casting, namely, a rigid sand mold shell, which makes the overall sand mold strong and non-deformable. It has wide adaptability, easy demolding of castings, reliable positioning and high precision.

Iron mold sand casting combines the advantages of coated sand shell casting, offering convenient and rapid molding. Regardless of the casting type, the sand mold can be completed within two to three minutes. The sand density and mold surface hardness are consistently maintained by the equipment, eliminating the need for any coating. This results in smooth castings and improves the shape and dimensional accuracy of the castings.

Iron mold sand casting also has the characteristics of metal mold casting. The iron mold has a significant cooling effect during the crystallization process of the molten metal, which can refine the grain size of the casting and thus improve the overall strength of the casting. At the same time, due to the presence of sand, the disadvantages of metal mold casting are avoided, and the casting will not produce white iron. For cast iron parts, various materials can be produced in the as-cast state without heat treatment.

The mold, composed of an iron mold and a thin sand core, has high rigidity, small deformation, and rapid cooling after locking. The resulting castings have high dimensional accuracy, small machining allowance, and dense structure, which is particularly advantageous for producing disc, rod, and shaft castings.

Generally, castings produced by iron mold sand coating have a hardness that is about 20 HB units higher than castings produced by ordinary casting methods.

江苏中力齿轮



## 江苏中力齿轮



Utilizing the residual heat of the iron mold after casting for the curing of coated sand in recycling not only reduces electricity consumption but also creates a closed-loop production process. This requires minimal production space (for example, when melting one ton of iron (steel) per hour, a molding and pouring area of two to three hundred square meters is sufficient). No sand processing equipment is needed, resulting in low investment and quick returns.

The rapid cooling of the iron mold prevents the molding sand from overheating, allowing it to be reused. Furthermore, the roasting process during pouring causes a phase change in the molding sand (quartz sand), reducing its thermal expansion coefficient from 15 to 5. Therefore, the used sand generated during production can also be recycled and reused, aligning with the development of a circular economy.

## 2. PRE-BURIED、TAP DENSITY

Pre-lay steel balls in the sand box to ensure consistent pouring height of the sand core; fill with steel balls and compact the mixture..



## 3. CASTING

Methods such as pouring machines, ring gauge pouring, and hanging bag pouring.



## 4. CAST COOLING

Upon completion of pouring, the sand box is transported to the cooling line via a transfer device, with cooling time adjusted according to actual product requirements.



## 5. AUTO BOX TRANSFORMATION

达到设置冷却时间后砂箱摆渡至翻箱工位完成自动翻箱



## 6. VIBRATORY SHAKEOUT

铸件、废砂、钢丸、铁块统一进入落砂机；铸件振动输送进入料斗



## 7. 生产线集尘方式

浇注、摆渡、翻箱、冷却等工位采取半封闭或封闭除尘/除味





## 客户案例

湖南德宝



江苏中力

十堰瑞虎



徐州天炬

## UV光氧催化废气处理设备

### UV photo oxygen catalytic waste gas treatment equipment

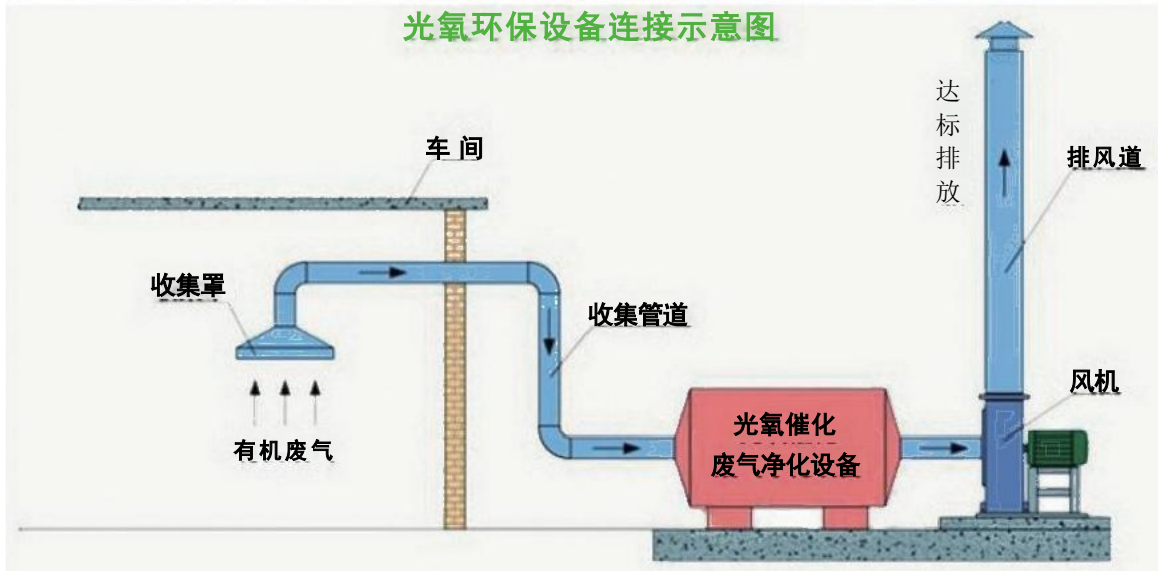
This product utilizes a light beam to irradiate malodorous gases, breaking down their molecular chains such as ammonia, hydrogen sulfide, methyl mercaptan, dimethyl sulfide, dimethyl disulfide, carbon disulfide, styrene, sulfides ( $H_2S$ ), VOCs, benzene, toluene, and xylene. Under ultraviolet light irradiation, the inorganic malodorous compound molecules are degraded and transformed into low-molecular-weight compounds such as  $CO_2$  and  $H_2O$ .



With oxygen molecules to produce ozone.  $UV + O_2 \rightarrow O^- + O$  (active oxygen)  $O + O_2 \rightarrow O_3$  (ozone). As is well known, ozone has a strong oxidizing effect on organic matter and is effective against malodorous gases and other irritating odors. Thirdly, after the malodorous gases are introduced into this purification equipment through exhaust ventilation, the equipment uses C-wave light and ozone to carry out a synergistic oxidation reaction on the malodorous gases, degrading and transforming them into low-molecular-weight compounds, water, and carbon dioxide, which are then discharged outdoors through exhaust ducts.



光氧环保设备连接示意图





## HL系列脉冲反吹滤筒除尘器

### HL series cartridge back pulse dust catcher

Our company's self-designed and manufactured vertically installed cartridge-type automatic back-flushing dust collector features small size, low power consumption, low operating resistance, and excellent dust removal effect, achieving a dust removal rate of 99.9%. Dust emissions are far below national environmental protection standards, fully meeting environmental protection requirements.



脉冲反吹滤筒式除尘器



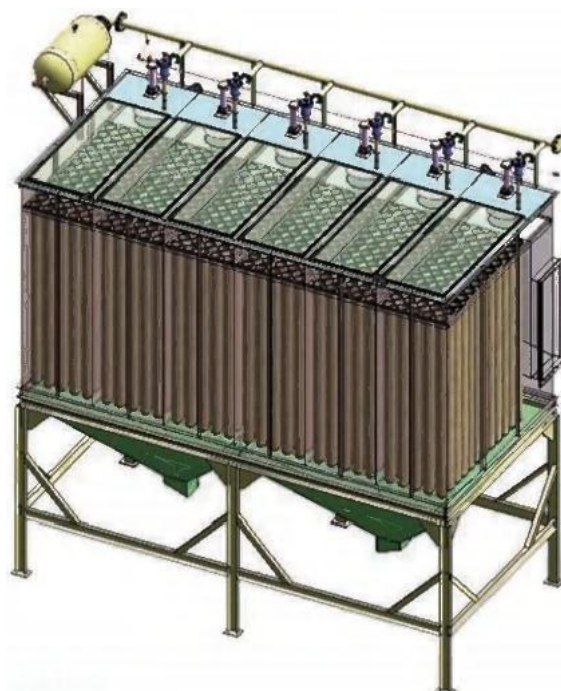
垂直滤筒式除尘器





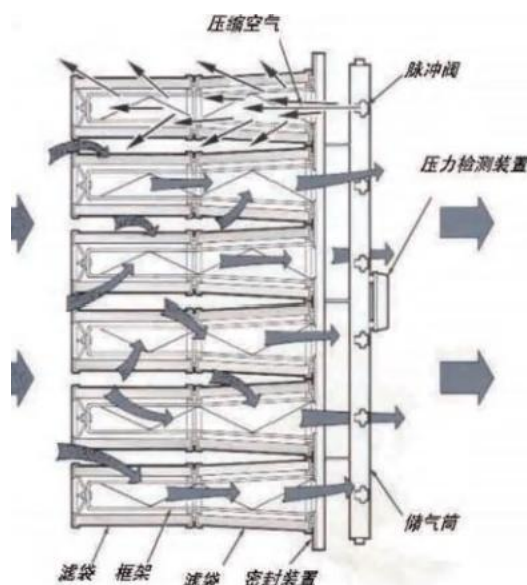
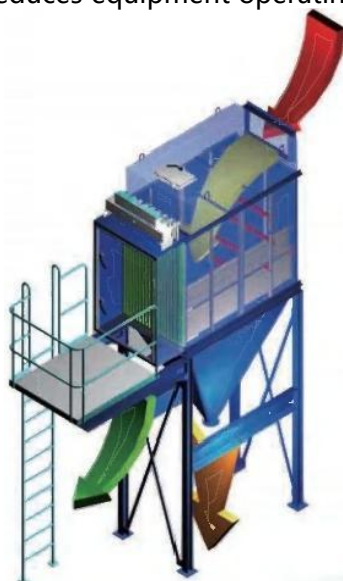
## PPW series of pulse gas box chamber blowback bag filter

The pulse jet baghouse dust collector evolved from the vertical pulse jet baghouse dust collector. It divides the dust collector into several independent compartments, each connected by a pneumatic valve located at the top. During cleaning, one compartment is closed for offline pulse jet cleaning, while the other compartments continue normal filtration and dust removal. This avoids secondary adsorption caused by backflow of air.



## FD series near the back pulse type dust collector

Our company uses the latest dust collector manufactured with technology from the German company NEOTECHNIK. It adopts a co-current airflow working principle with top air inlet, middle filtration, and bottom air outlet. The dust settling direction is consistent with the airflow direction, which is conducive to dust settling, greatly reduces equipment resistance, enhances dust removal effect, and reduces equipment operating costs.



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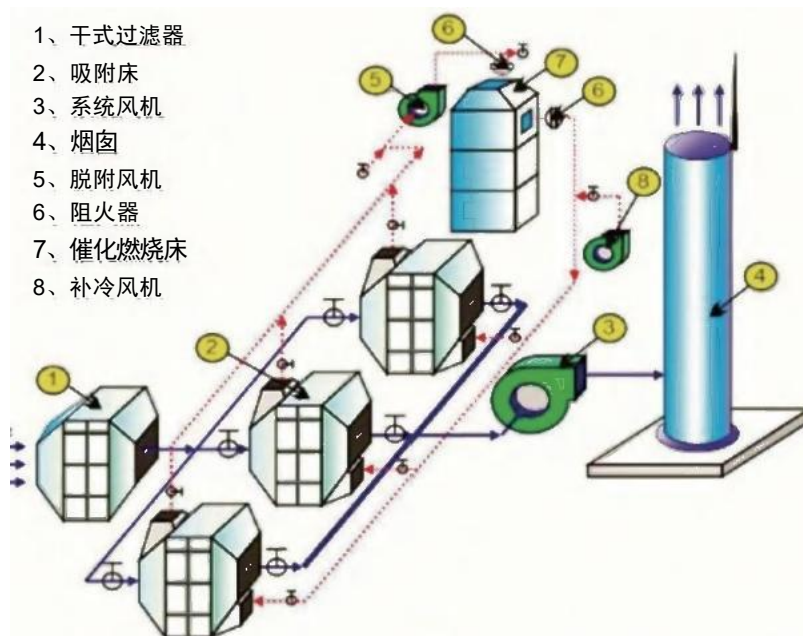


## Activated carbon adsorption, desorption, concentration, and catalytic combustion

This equipment is designed based on two fundamental principles: adsorption (high efficiency) and catalytic combustion (energy saving). It employs a dual-gas-path continuous operation, with one catalytic combustion chamber and two or more adsorption beds used alternately. First, the organic waste gas is adsorbed by activated carbon. When it is nearly saturated, adsorption stops. Then, a hot gas stream desorbs the organic matter from the activated carbon, regenerating it. The desorbed organic matter is concentrated (more than ten times the original concentration) and sent to the catalytic combustion chamber for catalytic combustion into carbon dioxide and water vapor, which are then discharged.



When the concentration of organic waste gas reaches 2000 ppm or higher, the organic waste gas can be maintained naturally in the catalytic bed without external heating. A portion of the exhaust gas after combustion is released into the atmosphere, while the majority is sent to the adsorption bed for activated carbon regeneration. This satisfies the heat energy required for combustion and desorption, achieving energy conservation. The regenerated activated carbon can be used for the next adsorption cycle; during desorption, the purification operation can be carried out using a separate adsorption bed, suitable for both practice and intermittent operation.



## Micro vibration compaction molding machine

This machine can be used for upper and lower mold molding of clay sand in various foundry workshops. It can be used as a standalone machine or as part of a mechanized production line, or as part of a semi-automatic line. The machine adopts a spring-loaded, fully buffered pneumatic micro-vibration mechanism, therefore requiring no special foundation. The mold lifting mechanism uses a linkage synchronous shaft structure with pneumatic and hydraulic speed regulation, ensuring good synchronization and flexible speed control.

Pneumatic multi-contact molding machine:

1. Using pneumatic multi-contact compaction, there is no problem of oil leakage; the specific pressure is moderate, no special requirements for molding sand, and the number of contacts is large (48-120 in any combination), suitable for complex model modeling.

2. When the machine is pressing, the frame is not under stress. Instead, the worktable is hooked by four tie rods hanging down from the side of the multi-contact body. As the multi-contact body extends downward, the compaction is carried out. If the contact, hook, sand box, mold plate and worktable are regarded as a system, this kind of compaction is internal force or internal force compaction.

3. Vibration compaction: The contact head compacts the sand mold while simultaneously vibrating along with the worktable (detached from the frame, so the frame is not vibrated). Therefore, the vibration compaction effect is excellent, resulting in high and uniform sand mold hardness (average hardness reaches 85-90, B-type hardness value). The sand intake can be as small as 20-30 mm, with a sand intake ratio of H:B=2-3, and the hardness of the vertical surface of the cavity can still reach over 80.



| 名称     | 单位  | Z143WB      | Z145WB      | Z146WK      | Z147WK      | Z148WK       | Z149WK       |
|--------|-----|-------------|-------------|-------------|-------------|--------------|--------------|
| 砂箱最大尺寸 | Mm  | 500×400×200 | 550×450×200 | 600×500×250 | 800×600×250 | 1000×630×300 | 1050×930×300 |
| 工作台尺寸  | Mm  | 560×420     | 600×550     | 700×550     | 800×600     | 1200×730     | 1200×1030    |
| 震击负荷   | Kgf | 200         | 300         | 400         | 400         | 1200         | 1200         |
| 压实力    | KGF | 4200        | 5500        | 7500        | 8000        | 16000        | 16000        |
| 压实行程   | Mm  | 100         | 160         | 160         | 150         | 200          | 200          |
| 起模行程   | Mm  | 160         | 180         | 220         | 220         | 300          | 350          |
| 生产率    | 箱/时 | 40-60       | 40-60       | 40-60       | 40-60       | 40-60        | 40-60        |

## Z86 series hot core box core shooter

The Z86 series hot core box core shooting machine is a sand core shooting device that uses coated sand. It can shoot solid sand cores within various template sizes and maximum sand shooting weight ranges. The machine involves two shooting heads that use a reciprocating linear movement of the sand injection cylinder to complete the sand adding and shooting actions. Depending on the user's mold, the two shooting heads can operate simultaneously or individually. It can accommodate two identical molds simultaneously or one different mold on each side for production, offering convenient and fast operation and high productivity. The use of hot core box coated sand ensures the quality of the sand core. The machine uses a vertical parting mold opening and closing method, with a central fixed mold and left and right opening and closing molds. Each side of the moving mold has a set of opening and closing cylinders or hydraulic cylinders, allowing for the installation of two molds, with the moving mold closing from left to right. Upon reaching the mold opening position, the sand core is ejected by hitting the ejector rod. Customization is available upon request.

| MODEL                        | Z8610       | Z8613      | Z8615      | Z8616      | Z8618      |
|------------------------------|-------------|------------|------------|------------|------------|
| TEMPLATE SIZE (mm)           | 620*300     | 660*330    | 620*400    | 760*460    | 900*600    |
| MAX WEIGHT OF SAND CORE (KG) | 20          | 20         | 20         | 20         | 20         |
| SAND VOLUME (KG)             | 200         | 200        | 200        | 200        | 200        |
| HEATING METHOD               | ELECTRIC    | ELECTRIC   | ELECTRIC   | ELECTRIC   | ELECTRIC   |
| HEATING POWER (kW)           | 25          | 25         | 25         | 25         | 25         |
| SYSTEM PRESURE (Mpa)         | 0.55-0.65   | 0.55-0.65  | 0.55-0.65  | 0.55-0.65  | 0.55-0.65  |
| OPERATIONAL APPROACH         | MANUAL/AOTO | MANUAL/AOT | MANUAL/AOT | MANUAL/AOT | MANUAL/AOT |



## Horizontal parting core shooter (dual purpose cold and hot)



| 项 目         | ZH750   | ZH870   | ZH1080   | ZH1580   |
|-------------|---------|---------|----------|----------|
| 模板尺寸 (mm)   | 780*600 | 930*750 | 1150*950 | 1400×800 |
| 模具最小厚度 (mm) | 280     | 280     | 280      | 280      |
| 合模行程 (mm)   | 300     | 300     | 300      | 500      |
| 最大砂芯重量 (kg) | 20      | 25      | 35       | 40       |
| 砂斗容积 (kg)   | 200     | 200     | 300      | 300      |
| 加热方式        | 电加热/三乙胺 | 电加热/三乙胺 | 电加热/三乙胺  | 电加热/三乙胺  |
| 电加热功率 (kW)  | 25      | 30      | 45       | 50       |
| 操作方式        | 半自动/自动  | 半自动/自动  | 半自动/自动   | 半自动/自动   |

A hot-box core shooter is a molding machine that uses the sudden expansion of compressed air to uniformly inject coated sand into a core box, where it is heated and solidified to form a sand mold. This process offers fast molding and solidification speeds, resulting in castings with smooth surfaces and high precision. This technology represents the mainstream of current core-making technology.

With the improvement of core-making equipment and the gradual maturation and enhancement of the production level of required casting materials, core-making technology has begun to develop rapidly and has become widely known and accepted by users. It is currently widely used in foundries in industries such as automobiles, auto parts, engines, various valves, and power components.

This core shooting machine can achieve three different modes of operation: fully automatic cycle, single-cycle automatic, and manual. It allows for flexible setting of various parameters and one-button automatic molding. It has the advantages of convenient operation, high productivity, stable operation, low energy consumption, and low noise. The labor intensity of operators is low, and they only need to undergo simple operation training to become competent. One person can operate 1-3 machines (depending on the sand mold curing time and the user's workflow).

Equipment can be selected according to the workpiece, including swivel tray, removal, double-sided sandblasting, and core pulling.

## Z95 series fully automatic shell core machine

A core-making machine is a device that uses a hot core box process to produce coated sand cores. Its working process involves simultaneous sand injection and compaction, with immediate hardening in a hot core box. This reduces labor intensity, is flexible and easy to operate, and is easy to master. It uses electric heating, allowing for automatic temperature control, and the work area is easy to keep clean, creating conditions for the mechanization and automation of the core-making process. A single cycle takes only tens of seconds to produce a sand core for casting. Cores produced by a core-making machine have precise dimensions and a smooth surface. It is widely used in the foundry machinery industry.



|          | Z954K     | Z955K     | Z956K     | Z957K     | Z958K     | Z959K     |
|----------|-----------|-----------|-----------|-----------|-----------|-----------|
| 模板最大尺寸mm | 450*400   | 550*400   | 650*400   | 750*500   | 850*600   | 950*600   |
| 定模厚度mm   | 150       | 150       | 180       | 180       | 200       | 250       |
| 动模最小厚度mm | 150       | 200       | 200       | 200       | 250       | 250       |
| 合模行程mm   | 400       | 400       | 400       | 400       | 400       | 400       |
| 最大砂芯重量kg | 15        | 20        | 20        | 25        | 30        | 40        |
| 砂斗容积kg   | 200       | 200       | 200       | 250       | 250       | 250       |
| 加热方式     | 电加热       | 电加热       | 电加热       | 电加热       | 电加热       | 电加热       |
| 电加热功率kW  | 20        | 25        | 30        | 40        | 50        | 60        |
| 系统压力Mpa  | 0.55-0.70 | 0.55-0.70 | 0.55-0.70 | 0.55-0.70 | 0.55-0.70 | 0.55-0.70 |
| 操作方式     | 手动/自动     | 手动/自动     | 手动/自动     | 手动/自动     | 手动/自动     | 手动/自动     |



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Qingdao Xiangmao Machinery Manufacturing Co.,Ltd



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金属表面处理设备（各种抛丸机及喷砂房）

METAL SURFACE TREATMENT EQUIPMENT

## Tilting drum type shot blasting machine

This machine is a newly upgraded product manufactured using advanced Japanese technology. It employs a roller oscillation mechanism, where the roller not only rotates continuously but also oscillates up and down during shot blasting, ensuring complete tumbling and mixing of the workpiece inside for a uniform and thorough cleaning effect. The shot blasting roller features a unique construction that can clean general castings, forgings, and cast steel parts, even thin and small special parts without damage. The loading and unloading mechanism operates smoothly, preventing workpiece collisions and allowing for gentle and complete loading and dust removal, facilitating operation. Its simple structure and few vulnerable parts reduce maintenance costs.

| 型号                  | QGT10             | QGT15             |
|---------------------|-------------------|-------------------|
| 滚动直径*长度 (mm)        | Φ 1000x1300L      | Φ 1500x1600L      |
| 最大外形尺寸长 (mm)        | 450               | 600               |
| 单间最大质量 (kg)         | 30                | 40                |
| 最大回转直径 (mm)         | 300               | 350               |
| 抛丸器功率 (kW)          | 22                | 30                |
| 处理容量 m <sup>3</sup> | 0.5m <sup>3</sup> | 0.6m <sup>3</sup> |
| 最大载重量 (kg)          | 800               | 1500              |
| 总功率 (kW)            | 48kW              | 57kW              |



江苏东海模具



GT15抛丸机



十堰瑞虎

## Hook type shot blasting machine

The hook-type shot blasting machine is an equipment that uses an electric hoist and chain hoist to suspend workpieces in a sealed chamber for shot blasting. It is suitable for cleaning the surfaces of large and medium-sized castings, forgings, cast steel parts, structural components, heat-treated parts, and for surface strengthening of pipes and profiles. A single hook can weigh 0.5-30 tons, and the workpiece size can range from  $\phi 800$ -4000 mm. Various specifications and models are available, including straight rail, herringbone rail, and circular rail, and non-standard designs can also be customized to meet user needs. The hoist rails come in various structures such as straight rail, circular rail, and herringbone rail, allowing for both step-by-step cleaning and mobile shot blasting.



| 型号             | Q376     | Q378      | Q3710     | Q3720     | Q3730     | Q3750     |
|----------------|----------|-----------|-----------|-----------|-----------|-----------|
| 清理最大重量 (kg)    | 600      | 800       | 1000      | 2000      | 3000      | 5000      |
| 挂件最大外形尺寸 (mm)  | 700*1200 | 1000*1600 | 1200*1800 | 1400*2200 | 1600*2400 | 1700*2500 |
| 抛丸量 (kg/min)   | 2*200    | 2*250     | 2*250     | 3*250     | 3*250     | 4*250     |
| 提升机提升量 (t/h)   | 24       | 30        | 30        | 45        | 45        | 60        |
| 分离器分离量 (t/h)   | 24       | 30        | 30        | 45        | 45        | 60        |
| 整机功率 (约计) (kW) | 23.5     | 39.65     | 47.5      | 56.2      | 65.45     | 85.45     |



常州卡斯特铝



Q37系列吊钩式抛丸机 (安徽应流集团)

## Rubber track type shot blasting machine

This machine is suitable for cleaning sand, oxide scale and other adhering substances from the surface of small castings, forgings, stampings, gears, springs and other parts, as well as thin-walled and impact-sensitive parts in heat treatment workshops. It can also be used for surface strengthening treatment of some parts.

(Note: Do not directly clean high-temperature parts or parts with burrs or flash, otherwise the tracks may be damaged.)

This machine is a new product designed and developed by integrating domestic and international technologies. It is a cleaning device with good cleaning effect, compact structure, and low noise, and has the following characteristics:

1. This machine adopts a cantilever centrifugal shot blasting unit, which features long service life and simple structure.
2. It uses a BE-type full-curtain air-classifying shot and sand separator, which has good separation effect and high productivity, and plays a positive role in improving blade life.
3. It uses a bag filter dust collector, and the dust emission concentration is lower than the national standard, improving the working environment for workers.
4. It uses wear-resistant rubber tracks, reducing workpiece collision damage and lowering machine noise

### 技术参数

| 型号<br>model                                | Q326 | Q3210 | Q3220 |
|--------------------------------------------|------|-------|-------|
| 履带端盘直径 (mm)<br>Track end disc diameter     | 650  | 1000  | 1200  |
| 最大单件重量 (KG)<br>Maximum single piece weight | 10   | 30    | 40    |
| 滚筒最大载重量 (KG)<br>Maximum loading capacity   | 200  | 600   | 1000  |
| 总装机容量POWER<br>(kW)                         | 13   | 26.5  | 60    |



Q3210



Q3220

## Metal track type shot blasting machine

15 GN and 28 GN metal track shot blasting machines can perform shot blasting cleaning and surface strengthening on non-brittle workpieces that are easy to tumble and not easy to break. They can effectively remove surface sand particles and oxide scale from complex castings, forgings, cast steel parts and welded parts.

### 技术参数

| 型号model                 | 15GN        | 28GN        |
|-------------------------|-------------|-------------|
| 滚筒尺寸（直径mm×长mm）          | Φ 1092×1245 | Φ 1245×1778 |
| 最大装载量（kg）               | 1362        | 3500        |
| 滚筒装载容积（m <sup>3</sup> ） | 0.43        | 0.79        |
| 最大单件重量（kg）              | 227         | 363         |



15 GN金属履带抛丸机



28 GN金属履带抛丸机

## Through-type shot blasting machine

### Steel Pipe Shot Blasting Cleaning Machine

The shot blasting process for the outer wall of steel pipes utilizes a high-speed rotating shot blaster to propel and accelerate shot, simultaneously striking the outer wall of the steel pipe to remove surface oxides, residues, etc. This process relieves welding stress, increases the depth of anchor patterns on the steel pipe surface, enhances the adhesion of the steel pipe surface, and significantly improves the bonding strength of the outer wall of the steel pipe, ensuring a tight bond between the steel pipe and the insulation layer in the thermal insulation material.



## Roller conveyor shot blasting machine

This series of products is mainly suitable for workpieces such as sheet metal, profiles, and pipes transported by roller conveyors. It features non-standard design based on the length and width of the workpiece, infinitely adjustable processing speed, and simultaneous processing of both top and bottom surfaces. After processing, the workpiece surface can achieve the Sa2.5-Sa3 standard, eliminating internal stress and increasing paint adhesion.

A complete surface pretreatment line can be equipped with a preheating chamber, shot blasting chamber, cleaning chamber, painting chamber, and drying chamber, etc., according to user needs. An automatic loading and unloading device can also be added to achieve fully automated production.



## Suspension chain shot blasting machine



The overhead conveyor shot blasting machine is suitable for shot blasting small cast iron parts, steel castings, forgings, and stampings. It is particularly suitable for cleaning forgings and castings to remove adhering sand, rust, scale, and dirt from the workpiece surface, revealing the natural metallic color, eliminating internal stress, improving fatigue resistance, increasing paint adhesion, and ultimately improving both the surface and internal quality of the workpiece. It also enhances the corrosion resistance of machinery and metals, improves the fatigue resistance of steel, extends its service life, and optimizes the surface finish of steel, achieving complete cleaning.

### Q326

The overhead conveyor shot blasting machine, which moves along the conveyor chain, is available in continuous, stepping, and accumulating types. This machine is suitable for surface cleaning and shot blasting strengthening of various types of cast iron, cast steel, forgings, and steel structural components in small to medium batches. It is particularly effective for cleaning engine blocks and cylinder heads, motor housings, etc. It is an ideal choice for the automotive, tractor, diesel engine, motor, and valve industries.

# 网带式抛丸机

## Mesh belt shot blasting machine

The mesh belt shot blasting machine transports workpieces to a closed shot blasting chamber via a mesh belt conveyor system. A high-speed rotating impeller propels shot onto the workpiece surface, removing rust, weld slag, and oxide scale, resulting in a uniform metallic luster and improving the coating quality and corrosion resistance of the steel. The mesh belt features variable frequency speed control for satisfactory cleaning results. It is constructed from  $\phi 6\text{mm}$  rolled Mn13 wire rod, ensuring a longer service life. This equipment is primarily used for shot blasting the surface of thin-walled castings or fragile aluminum alloy castings, as well as small ceramic parts in the automotive, aerospace, railway, and machinery manufacturing industries. It can also be used for shot blasting strengthening of mechanical parts.



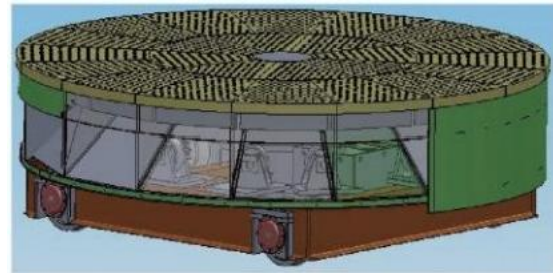
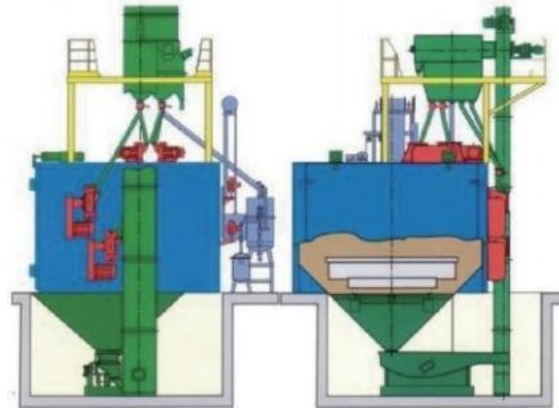
|                                     |       |       |        |        |
|-------------------------------------|-------|-------|--------|--------|
| 型号model                             | QWD60 | QWD80 | QWD100 | QWD120 |
| 网带宽度 (mm) Mesh belt width           | 600   | 800   | 1000   | 1200   |
| 清理速度 (m/min) Cleaning speed         | 0.5-4 | 0.5-4 | 0.5-4  | 0.5-4  |
| 抛丸量 (kg/min) Shot blasting quantity | 4×120 | 4×120 | 4×180  | 4×250  |



## Trolley type shot blasting cleaning machine

This series of equipment is mainly used for shot blasting cleaning of large and medium-sized castings and structural parts. It removes sand, rust, oxide scale and dirt from the surface of the workpiece, so that the workpiece can show its metallic color, eliminate internal stress, improve the fatigue resistance of the workpiece, increase the adhesion of paint film when the workpiece is painted, and ultimately improve the surface and internal quality of the workpiece.

For complex workpieces with hard-to-reach areas, a quick touch-up spraying method is typically used, equipped with air-conditioned protective clothing, air purifiers, and temperature controllers.



## Sandblasting room

Sandblasting booths are mainly used for large parts or workpieces that have not been thoroughly blasted by shot blasting machines.

The abrasive recovery system uses a combination of pneumatic scraper, screw conveyor, elevator conveyor, separator, and blasting tank.

The abrasive conveying method is another highlight of this equipment design. Besides the well-known flat conveyor surface requiring minimal installation depth, it boasts extensive experience in screw conveyors and vibrating crossbeam abrasive conveying technologies. For large workpieces, open-type sandblasting is generally employed.

According to process requirements, the sandblasting system selects manual sandblasting method, and special sandblasting tanks are equipped for products of different materials. The pressure and flow rate of the sandblasting tanks can be adjusted at any time as required.





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