



**BLAST CLEANING AND FINISHING SYSTEMS
AIRLESS SHOT BLASTING MACHINE**

**AIRLESS SHOT
BLASTING MACHINE**

CLEANING

PEENING

DEBURRING

FINISHING

PAINTING

SPECIAL FEATURES :



These machines are sturdy, rugged and proven across wide variety of working conditions. They have been designed to carry out the multifarious jobs of cleaning and peening in faster time and of a better quality than all other makes of the machine. The latest design of blast wheel is incorporated, in order, also to keep the maintenance costs significantly low. The rubber conveyor belt is rugged and given long life. Hence the machine is most economical in operation.

Dust collector options are available i.e. Fabric, Cartridge type, as per the choice, The machine is available with various additional optional features like second door, rotary screen separator, abrasive replenisher, Program-logic Control system, Time Control, Electronic Brake system for blast, wheel, sound reducer etc. Please select the optional features as per your choice.

TECHNICAL SPECIFICATION FOR 'ABRABLAST' AIRLESS SHOT BLASTING MACHINE SWING TABLE TYPE

S.No.	Particulars	AST-750	AST-900	AST-1200	AST-1800	AST-2440
1.	Size of Blast Wheel	12.5" X 2.5"	12.5" X 2.5"	19.5" X 2.5"	19.5" X 2.5"	19.5" X 2.5"
2.	No. of Blast Wheel	One	One	One	One	Two
3.	Power of Blast Wheel	7.5 H.P.	10 H.P.	15 H.P.	25 H.P.	20 H.P.
4.	Shots Flow Rate (Kg./Hour)	6.5 Tons/wheel/hour	6.5Tons/wheel/hour	9.0Tons/wheel/hour	15.0Tons/wheel/hour	12.0Tons/wheel/hour
5.	Shot Velocity (Mtr./Second)	50.55 mtrs/sec.	70.75 mtrs/sec.	70 - 75 mtrs/sec.	70 - 75 mtrs/sec.	70 - 75 mtrs/sec.
6.	No. of Swing Table	One/Two	One/Two	One/Two	One/Two	One/Two
7.	Diameter of Swing Table	750mm (30")	900mm (36")	1200mm (48")	1800mm (72")	2440mm (96")
8.	Maximum Load on Table	350 Kg.	400 Kg.	750 Kg.	250 Kg.	4500 Kg.
9.	Loading Height (mm)	1125	1000	950	950	1200
10.	Maximum Job Height (mm)	300	500	600	1000	1060
11.	Type of Dust Collector	Fabric Bag	Fabric Bag	Fabric Bag	Fabric Bag	Fabric Bag
12.	Dust Collector Capacity (CFM)	1200	1200	2000	2000	4500
13.	Shaking of Bags	Manual	Manual	Mechanical	Mechanical	Mechanical
14.	Total H.P. Required	12	16	23	36	56
15.	Dimension of Machine with Dust Collector :	Single Door Double Door	Single Door Double Door	Single Door Double Door	Single Door Double Door	Single Door Double Door
	Length (mm)	2700 4050	3800 5500	4500 6350	6100 8500	10500 13500
	Width (mm)	3450 3450	4000 3900	4300 4300	5500 5500	6500 6500
	Height (mm)	4100 4100	4200 4200	4300 4300	5000 5500	5750 5750

Note : Above specifications are approximate and are subject to change without notice.

HANGER TYPE SHOT BLASTING MACHINE

The machine is designed for automatic efficient shot blasting of Aluminum Casting. The Job is loaded on the Hangers of Indexing Turn Table. The Job is loaded on the Hanger in the Blasting Cabinet where they are blasted inside the chamber. The speed of the Hanger driver can be regulated by AC drives. The cabinet is protected from erosion by LINERS (Hardened wear plates), mounted on the Sidewalls, top & door.



The Dust particles generated in the system are collected in a number of Plated Bags in a dust collector. Clean air is exhausted through an exhaust fan. The Plated Bags are cleaned by Pulse type Reverse Jet air cleaner controlled through Solenoid Valve and the collected dust particles fall in a dust bin and taken out for disposal from time to time.



Standard Model Technical Specification :

Model Name	Blast Wheel	Envelop Size in mm. Job dia X Height	Shot Flow Rate (Kg./Wheel/Hour)	Load Carrying Capacity of Hanger (Kg.)	Wheel Size & Motor (HP)	Total Power Required (HP)
ASH-1	2	600 X 750	3000	300	12 1/2" X 5	14.5
ASH-2	2	600 X 1000	3000	300	12 1/2" X 5	14.5
ASH-3	2	600 X 1000	5000	300	12 1/2" X 7.5	22.5
ASH-4	2	750 X 750	3000	300	12 1/2" X 5	14.5
ASH-5	2	750 X 1000	5000	300	12 1/2" X 7.5	22.5
ASH-6	2	750 X 1000	3000	300	12 1/2" X 5	16.5
ASH-7	2	750 X 100	5000	300	12 1/2" X 7.5	22.5
ASH-8	2	1000 X 1200	5000	300	12 1/2" X 7.5	23.5

ESSENTIAL ELEMENT

1. Construction of Working Chamber : The heavy duty all welded cabinet is manufactured out of prime quality heavy duty steel plate and mounted on sturdy and rigid structural steel frame work. Manganese steel liners are fitted in direct and indirect blast zone of the cabinet (complete lining).

2. Blast Wheel Assembly : The rotor is made out of EN grade material duly hardened. The drive system of blast wheel (rotor) entails a set of self-lubricated and self-aligning pedestal bearings.

3. Abrasive Circulation System for continuous & trouble free operation.

4. Pulse Jet type Dust Collection System : Dust Collector is provided to suck the dust from blasting cabinet. The filter bags of dust collector are made out of a non-woven PTEE pleated bags for low dust emission level.

5. Roller Conveyor is provided at inlet and outlet of blasting cabinet driven by suitable variable AC drive.



Technical Specification Sheet of Airless Shoot Blasting Machine-Tunnel Type

S.No.	Particulars	AT-100-50-4W	AT-150-50-4W	AT-200-60-6W	AT-240-100-8W	AT-300-120-10W
1.	Passage Opening (Width x Height) in mm	1000 X 500	1500 X 500	2000 X 600	2400 X 1000	3000 X 1200
2.	Size of Blast Wheel	15 ½" X 2 ½"	15 ½" X 2 ½"	15 ½" X 2 ½"	15 ½" X 2 ½"	15 ½" X 2 ½"
3.	No. of Blast Wheel	4	4	6	8	10
4.	Power of Blast Wheel	15 HP	20 HP	20 HP	20 HP	20 HP
5.	Approx. Shots Flow Rate (Tons/Wheel/Hour)	10	12	12	12	12
6.	Shot Velocity (Mtr./Second)	70-75 Mtrs./Sec.	70-75 Mtrs./Sec.	70-75 Mtrs./Sec.	70-75 Mtrs./Sec.	70-75 Mtrs./Sec.
7.	Shots Consumption / Wheel/HP	Approx.0.15Kgs./Hr.	Approx. 0.15Kgs./Hr.	Approx. 0.15Kgs./Hr.	Approx. 0.15Kgs./Hr.	Approx. 0.15Kgs./Hr.
8.	Conveyor Speed (Variable)	0.5 - 3.0 Mtr./Min	0.5 - 3.0 Mtr./Min	0.5 - 3.0 Mtr./Min	0.5 - 3.0 Mtr./Min	0.5 - 3.0 Mtr./Min
9.	Roller Pitch	900	900	900	900	900
10.	No. of Roller Conveyor Drive	2	2	2	2	2
11.	Initial Charge of Shots	1500 Kgs.	2000 Kgs.	3000 Kgs.	4000 Kgs.	5000 Kgs.
12.	Separator 1000mm lip width	Rotary Screen Separator	Rotary Screen Separator	Rotary Screen Separator	Rotary Screen Separator	Rotary Screen Separator
13.	Separation Principal	Through Air Current	Through Air Current	Through Air Current	Through Air Current	Through Air Current
14.	Descaling Effect	SA 2 ½ to SA 3	SA 2 ½ to SA 3	SA 2 ½ to SA 3	SA 2 ½ to SA 3	SA 2 ½ to SA 3
15.	Initial Rust Degree	A-B	A-B	A-B	A-B	A-B
16.	Type of Dust Collector	Pleated Bag	Pleated Bag	Pleated Bag	Pleated Bag	Pleated Bag
17.	CFM of Dust Collector	4000	6000	10000	12000	16000
18.	Shots Blown-off Device	Provided	Provided	Provided	Provided	Provided

Note : We also design & manufacture machine as per your requirement.

"ABRABLAST" has a wide range of Airless Shot Blasting Machine Tunnel Type with numbers of Blast Wheels to suit the Job Size and according to Production output required. This is the mostly used to Blast Clean long structural members, channels, angles, gratings, pipe fabricated components etc. for large production output for removing rust and to achieve superior quality (approx. Sa2/Sa2.5 SSPC standards) finish after blast cleaning prior to painting.

The opening of the tunnel & required number of blast wheels depends upon the structure of job for attaining homogeneous finish. Major assemblies of the machine are blast wheels for giving high production output, roller conveyor for job conveying & media recovery consists of bucket elevator, screw conveyors, rotary screen separator, abrasive storage hopper etc. & pulse jet type dust collection for dust collection. The dust emission level from dust collector is less than 10 milligram per cubic meter.

The work piece is to be placed as far as possible in the center of the guides of rollers on in feed conveyor when the rollers are not in rotating. The position of work piece is in such a way that it can rolled easily horizontal as shown in photograph, to avoid the accumulation of shots. After then it passes through entry vestibule tunnel and then enters into the blasting chamber for blast clean process. If the prefabricated structure cannot be rolled on the rollers, then it has to be kept either on predesigned fixture or a tray enabling it to travel & pass through the blast cabinet.

Blast wheel stations are arranged strategically around and located on the top of cabinet propels abrasives on the rolling work pieces. The blower arrangement continuously blow-off abrasive accumulated on the top side of the work piece. After shot blasted homogeneously finished all around air washed work piece rolls out from exit vestibule tunnel to the out feed conveyor rollers, from where it is to be unloaded manually. The operation of sequence is detailed programmed for ease of operation and to achieve the required performance.



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TECHNICAL SPECIFICATION FOR 'ABRABLAST' AIRLESS SHOT BLASTING MACHINE TUMBLAST TYPE

Particulars		ATB - 20"x27"	ATB - 27"x36"	ATB - 36"x42"
Tumbler (Basket) Size Size in mm.	Drum dia Drum length	500 675	675 900	900 1050
Size of Wheel (dia x width)		12 1/2" X 2 1/2"	15 1/2" X 2 1/2"	19 1/2" X 2 1/2"
No. of Wheel		One	One	One
Work Load Capacity	Max. Volume (Cubic Feet)	2	5	10
	Max. Weight (Kgs.)	100	250	500
	Max. Weight of Each Piece (Kgs.)	8	15	50
H.P. of Blast Wheel		7.5	15	20
Shots Flow Rate (Ton/Wheel/Hour)		6.5 Tons/Wheel/Hour	12 Tons/Wheel/Hour	14 Tons/Wheel/Hour
Type of Dust Collector		Fabric Bag	Fabric Bag	Fabric Bag
Dust Collector Capacity		1200 cfm	2000 cfm	3000 cfm
Shaking of Bags		Manual / Mechanical	Mechanical	Mechanical
Total Power Consumption		14 HP	26 HP	36 HP
Dimension of Machine with Dust Collector	Length	3400 mm	5200 mm	5400 mm
	Width	1600 mm	3400 mm	4400 mm
	Height	4000 mm	5100 mm	6700 mm
Floor Space Required For Machine with Dust Collector :	Length	4200 mm	5500 mm	6700 mm
	Width	2000 mm	2500 mm	3000 mm

Note : Above specifications are approximate and are subject to change without notice.

APPLICATION

“ABRABLAST”

ABRABLAST EQUIPMENT PRIVATE LIMITED

We treat each project individually which guarantees design that suits the requirement of final user.

Quality together with most competitive price is our huge advantage.

Being the manufacturer of machines we know very well the economy and practical constraints of new investments by our valued customers.

Your Trust Is Our Strength

Application

“ABRABLAST” has served in almost every industries till now and has created vast knowledge database on the bases of which “ABRABLAST” providing the best solution to all customers :

- Foundry
- Pharma
- Iron/steel
- Textile
- Food
- Plastics
- Rubber
- Cement
- Pipe Manufacturing
- Machining
- Grinding
- Glass Manufacturing
- Welding
- Solar Pannel Manufacturing
- Diamond/jewellery



AIRLESS SHOT BLASTING MACHINE

- ✦ SWING TABLE TYPE
- ✦ TUMBLAST TYPE
- ✦ TUNNEL TYPE
- ✦ HANGER TYPE
- ✦ APPLICATION

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assured to deliver excellence

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