

**KLCN-H2D1T1214 SHOT BLASTING MACHINE  
FOR INVESTMENT CASTING SHELL REMOVAL**

- SPECIAL FOR CASTING CASTING SHELL, INSULATION, CASTING SAND REMOVAL



**KHOLEE BLASTING ENGINEERING CO., LTD**

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## CASTING SHELL REMOVAL SHOT BLASTING MACHINE

There are many methods of removing casting shell, insulation and sand from casting products including impact, water-jetting, shake, shot blasting etc. Shot blasting is a surface treatment process using high velocity metal abrasives to impact the surface of metal products, which can obtain excellent cleaning and surface preparation.

Shot Blasting Machine for casting shell removal includes shot blasting chamber, blast wheel (high velocity type), work-piece lifting system, screw conveyor, bucket elevator, magnetic separator, air wash separator, dust collector, Raymond mill breaker, vibrating Screen Separator & electrical control system.

Shot Blasting Used for Casting Shell Removal in investment casting, precision casting, sand casting, lost wax casting, lost foam casting

- Remove Sand from Casting
- Remove Casting Shell & Insulation from casting
- Prepare Surface for coating, cutting, machining etc

In general, shot blasting concentrates metal abrasive at high speed (80~110m/s) at the surface of casting thereby remove casting shell due to the metal abrasives strong impact.

System features & benefits by shot blasting for casting shell removal from Kholee Blast

- Shorten Work Process Flow: no need manual shell removal or shakeout
- Reduce Loss of Steel Shots
- Reduce Labor Cost for Cast Shell Removal
- Save Electrical Energy
- Reduce repair cost compared with traditional shot blast m/c
- Reduce blast cleaning time & improve productivity
- Save Operation Cost & improve production profits: compared with traditional work process flow, the Shot Blasting Machine from Kholee Blast special for casting shell removal will save operation cost. All cost related to new technology of blasting from Kholee Blast will be around USD100,000.00~ USD120,000.00 based on casting production 15tons/day. (When labor cost and material cost are different, the result will be different).



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KLCN-H2D1T1214 SHOT BLASTING MACHINE FOR INVESTMENT CASTING SHELL REMOVAL		
SIZE OF BLASTING JOBS	MAX SIZE	Φ1,150× H1,350 MM
	MAX WEIGHT	1,000KG
BLASTING CHAMBER	SIZE	1,600×1,600×1,900MM
	LEG HEIGHT	1,550MM
	THE WHOLE BLASTING CHAMBER IS MADE MN13 STEEL PLATE BENDING AND WELDING TOGETHER, BLASTING HOT SPOT AREA IS PROTECTED BY CR18 WEARING RESISTANCE PLATE LINER AGAIN, HARDNESS ≥65HRC.	
TIME NEEDED FOR CASTING SHELL REMOVAL	INVESTMENT / LOST WAX CASTING	10~15 MIN
	SAND CASTING	3~5 MIN
	LOST FOAM CASTING	6~10 MIN
AUTOMATIC ENTRY & EXIT DOOR	EQUIPPED WITH PNEUMATIC CYLINDER PROTECTED BY MN13 STEEL PLATE LINER	
BLASTING WHEEL - DIRECT COUPLING	MODEL	KL-CN18
	SHOT BLASTING CAPACITY	250 KG/MIN ×2
	POWER	15KW ×2
	BLADE SERVICE LIFE	2 YEARS / 2000 WORKING HOURS
'Y' TRAIL SPINNER HANGER LIFTING SYSTEM	TRAIL TYPE	'Y' TRAIL
	HOIST QUANTITY	2 PCS
	LOADING CAPACITY	1000 KG
	SELF-ROTATING POWER	0.55KW
VIBRATING CONVEYOR FOR BIG SHELL SEPARATING	DELIVERY CAPACITY	30 T/H
	POWER	0.55KW ×2
BUCKET ELEVATOR - WITH CHECKING DEVICE	LIFTING CAPACITY	30 T/H ×1
	POWER	4 KW
ABRASIVE - SHELL SEPARATOR MAGNETIC + AIR WASH TYPE	SEPARATING CAPACITY	30 T/H
	FUNCTION	SEPARATING SHELL POWDER AND METAL ABRASIVE COMPLETELY
	ROTARY MAGNETIC	2.2KW×2
	AIR SPEED IN AIR WASHING AREA	4~5 M/S
BAG FILTER DUST COLLECTOR - ONLINE PULSE JET CLEANING	MODEL	KLCN-DC-96BF
	BAG FILTER	Φ130 × 1500MM
	BAG FILTER QUANTITY	96 PCS
	AIR VOLUME	12,600 M³/HR
	CENTRIFUGAL AIR FAN	11 KW
VIBRATING CONVEYOR FOR SEPARATING DIFFERENT SIZE OF POWDER	POWER	0.55KW × 2
	SHELL POWDER SIZE	< 60 #
		30~60 #



		16~30 #
		>16 #
	POWDER SHELL STORAGE	4 BOXES
	QTY	1 SET
ELECTRICAL CONTROL SYSTEM	VOLTAGE/FREQUENCY	380V/50HZ/3PH
	OPERATION TYPE	AUTO + MANUAL CONTROL
TOTAL POWER	~ 56KW	
OVERALL SIZE OF MACHINE	6500MM×6500MM×7500MM	

**Note:**

- KHOLEE BLAST ALSO DESIGNS AND MANUFACTURES NON-STANDARD CASTING SHELL REMOVAL SHOT BLASTING MACHINE ACCORDING TO CLIENTS' REQUIREMENTS AND WORK-PIECES SIZE.
- WE HAVE THE POLICY TO IMPROVE OUR EQUIPMENT CONTINUOUSLY & SHALL RESERVE THE RIGHTS TO CHANGE THE DIMENSIONS AND SPECS WITHOUT PRIOR NOTICE.

**VIDEO OF SHOT BLASTING MACHINE FOR CASTING SHELL REMOVAL**

[HTTPS://WWW.YOUTUBE.COM/WATCH?V=JR2VTDt1ID4](https://www.youtube.com/watch?v=JR2VTDt1ID4)

[HTTPS://WWW.YOUTUBE.COM/WATCH?V=GKIjVH0D66C](https://www.youtube.com/watch?v=GKIjVH0D66C)

[HTTPS://WWW.YOUTUBE.COM/WATCH?V=H7WH133\\_RJE](https://www.youtube.com/watch?v=H7WH133_RJE)



BEFORE BLASTING



AFTER BLASTING

**KHOLEE BLAST • YANCHENG DAFENG SANXING MACHINERY CO., LTD • Blasting & Painting Solutions**

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## HIGH CARBON CASTING STEEL SHOT

- METAL ABRASIVES FOR SHOT BLASTING MACHINE WORKING



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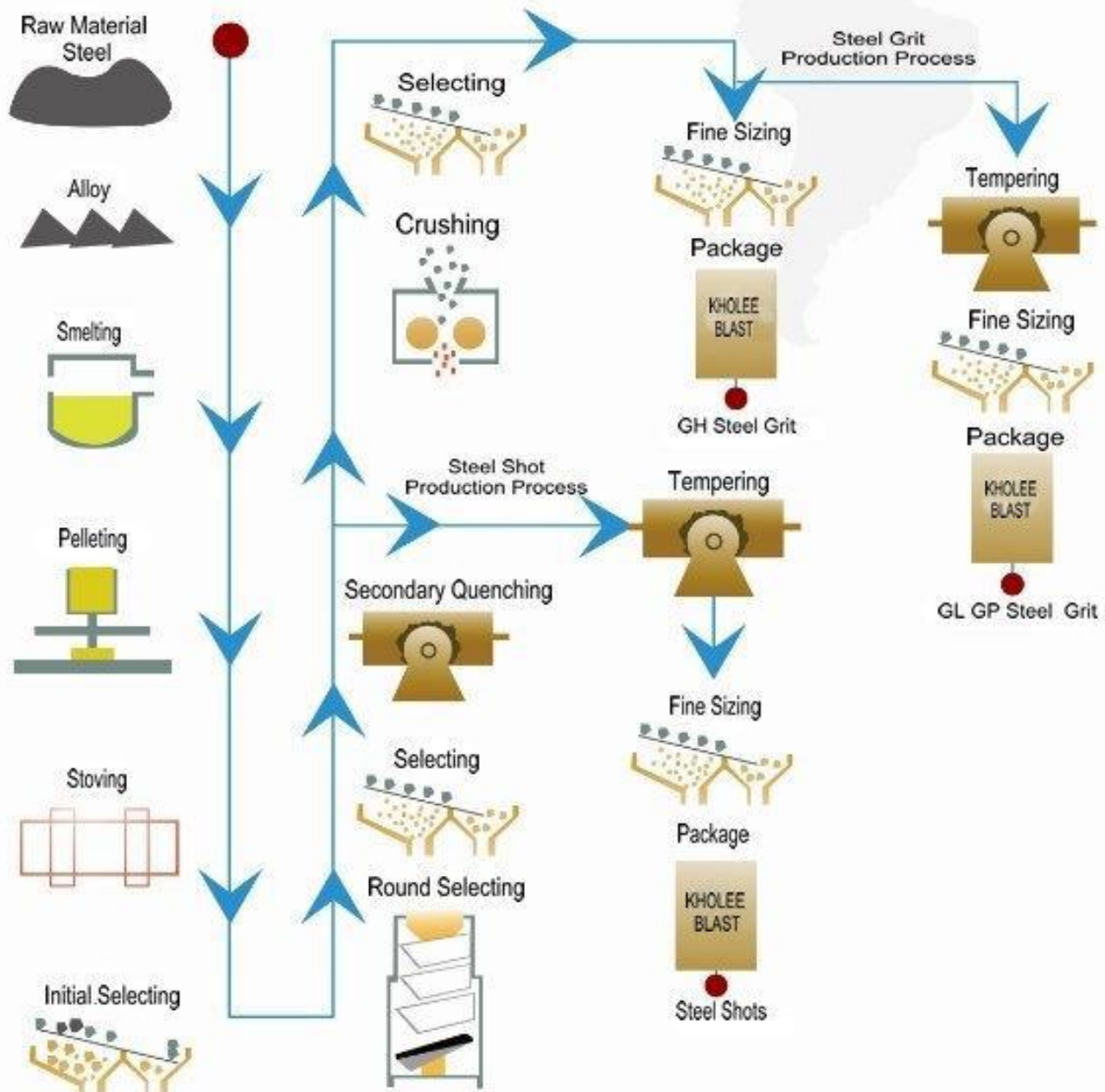
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HT Abrasives, one of three companies in China have two quenching equipment, has the capacity to produce high quality steel shots and grits. KHOLEE BLAST, as a GOLDEN Distributor of HT metal abrasives in China, assists our clients in PEB manufacturing industry to select the right steel shots & grits and analyzing the working max and production process in order to maximize the efficiency. All our steel shots & grits are subject to a rigorous quality control to ensure supply the best available abrasives in its class.



## Operative Standards:

In accordance with standards of GB/T18838.3—2008 Steel Shot and Steel Grit, SFSA20-66 Cast Steel Abrasive, SAE J827 Cast Steel Shot YB/T5149-1993 Cast Steel Shot, ISO11124-3 High Carbon Cast Steel Shot

Steel Shot	Application
S780/SS2.5 S660/SS2.0	Sand removal of large sized castings, scale removal of large sized products from forging, stamping, die forging, drawing and rolling or after heat treatment (e.g. pipes, sections, plates, fittings, wire).
S550/SS1.7 S460/SS1.4	Sand removal of large and medium sized castings, scale removal of forging and heat-treated work pieces, surface blast cleaning of steel plates, sections and steel structures, shot peening of work pieces, cutting of granite.
S390/SS1.2 S330/SS1.0	Sand removal of medium and small sized castings, surface blast cleaning of forgings, heat-treated pieces, steel pipes, sections and steel structures, surface treatment before painting, shot peening of work pieces.
S280/SS0.8 S230/SS0.6	Surface blast cleaning of small sized castings, forgings and heat-treated pieces, aluminium and copper alloy castings, steel plates, steel pipes, sections and steel structures, shot peening of work pieces.
S170/SS0.5 S110/SS0.3	Surface blast cleaning of stainless steel plates, thin steel plates, non-ferrous alloys, dacromet coat.

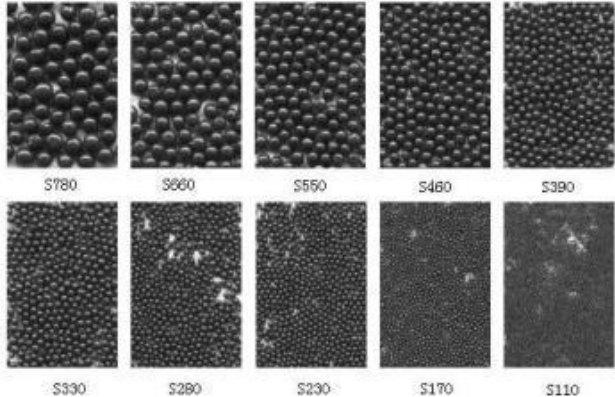
## Application Equipment

### ● Shot Blasting Machine (Auto Wheel Blasting Machine)

Steel Plate Shot Blasting Machine | Steel Structure Shot Blasting Machine | Steel Pipe Shot Blasting Machine | Hanger Type Shot Blasting Machine | Turntable Shot Blasting Machine | Tumble Belt Shot Blasting Machine | Overhead Conveyor Shot Blasting Machine | Steel Cylinder Shot Blasting Machine | Trolley Type Shot Blasting Machine | Wire Mesh Shot Blasting Machine etc.

- Blasting Room
- Sand Blasting Machine, Blasting Pot
- Shot Peening Machine

### Specification of High Quality Steel Shots

Item	C	Si	Mn	S	P
HQ Steel Shots	0.85-1.20%	0.40-1.20%	0.60-1.20%	<0.05%	<0.05%
Hardness	40 ~ 50HRC   52 ~ 56HRC   56 ~ 60HRC, Max Deviation ±3.0 HRC				
Density	7.4 g/cm <sup>3</sup>				
Bulk Density	4.4 g/cm <sup>3</sup>				
Ervin Cycle Times	2800~3300 times				
Micro-Structure	Homogeneous Tempered Martensite or Troostite				
Color	Dark Black				
Size of HQ Steel Shots					

### Distribution of High Quality Steel Shots

Mesh	mm	Specification of Steel Shot mm										
		SS-2.5	SS-2.0	SS-1.7	SS-1.4	SS-1.2	SS-1.0	SS-0.8	SS-0.6	SS-0.5	SS-0.3	SS-0.2
7	2.80	all pass										
8	2.36		all pass									
10	2.00	85%min		all pass	all pass							
12	1.70	97%min	85%min		5%max	all pass						
14	1.40		97%min	85%min		5%max	all pass					
16	1.18			97%min	85%min		5%max	all pass				
18	1.00				96%min	85%min		5%max	all pass			
20	0.850					96%min	85%min		10%max	all pass		
25	0.710						96%min	85%min		10%max		
30	0.600							96%min	85%min		all pass	
35	0.500								97%min	85%min	10%max	
40	0.425									97%min		all pass
45	0.355										80%min	10%max
50	0.300										90%min	
80	0.180											80%min
120	0.125											90%min
200	0.075											
325	0.045											
SAE		S-780	S-660	S-550	S-460	S-390	S-330	S-280	S-230	S-170	S-110	S-70

#### Packaging

- 25kgs /bag, 40 bags in big bag or 80 bags in big bag • 1000 kgs in big bag

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