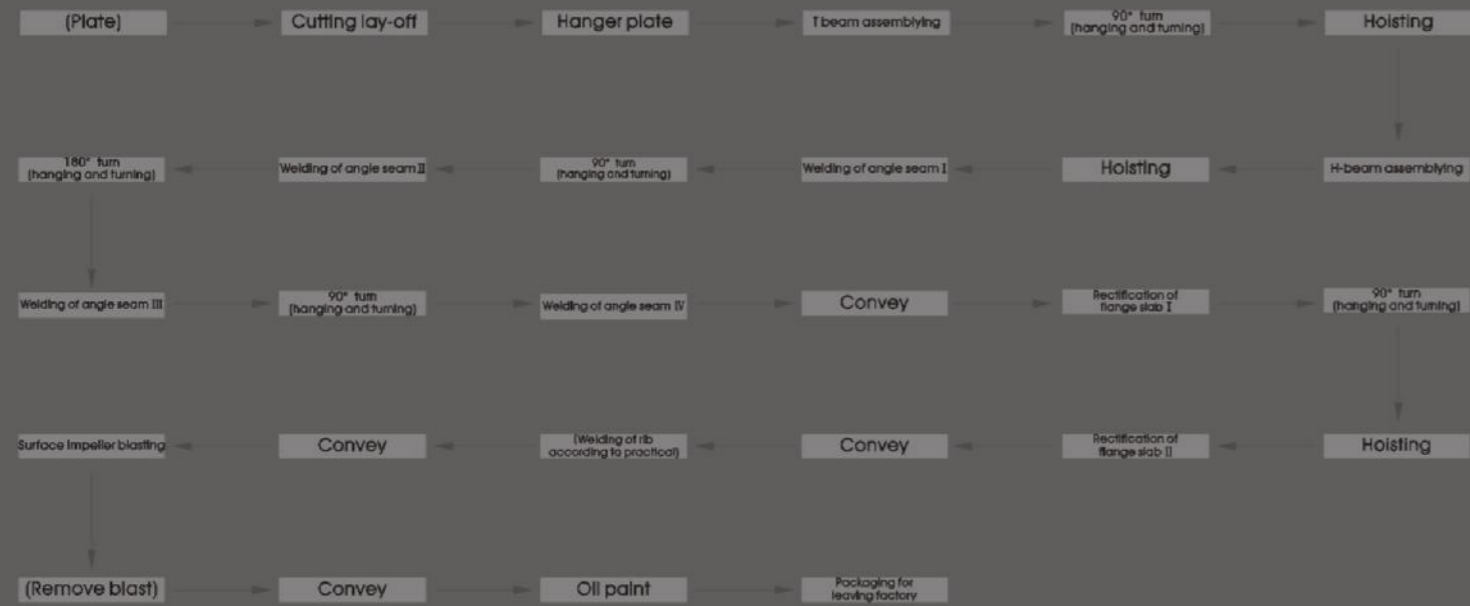


Technical process of welding common H-beam



The common H type steel production line

The production line of common H type steel is composed of some main equipments such as multiple tip gas cutting machine, H-beam assembling machine, the gantry submerged arc welding machine, straightening machine, shot blasting machine and etc. It is much flexible and can be operated independently by single machine on the manufacturing technology. In order to improve whole operating efficiency, it also can be added some device discretionarily at different parts if technology requires. But it needs to depend on hoisting equipment during the process of changing. It is required that workshop should have certain ability and amount of hoisting.



Main technical parameters

Size of web plate	Height	200-1500mm
	Thickness	6-32mm
	length	4000-15000mm
Size of flange	width	200-600mm
	thickness	6-40mm
	length	4000-15000mm
Welding speed		500-1200mm/min
Total power		8Kw(except for welding power source)
Straightening speed		500-6000mm/min

HG-1500 II H type steel automatic spot-welding machine

The assembly machine is applicable to different kinds of H type steel such as symmetry, dissymmetry, eccentricity and variable cross-section assembling and spot-weld. The machine adopts one-side manual electric adjusting and electric linking rod adjusting another side is pressed tightly by hydraulic pressure, which is very popular in the world. Different speed of welding and empty moving improves working efficiency.



Main technical parameters

Dimension of applicable H beam	Width	200-800mm
	height	200-1500mm
	length	2000-15000mm
Diameter of applicable soldering thread		3.2-5 mm
Back speed		4000mm/min
Welding speed		250-1200 mm/min
Rail span		4000 mm



MZG-2x1000 H-beam gantry submerged arc welding machine

Using cymbiform submerged arc welding; when welding, workpiece is fixed, but portal frame moves. Gantry frame adopts frequency timing; equipped a set of welding torches at each 2 groups of guiding column on the beam; use electric dynamo driving to adjust shifting up and down; use manual adjusting device to adjust shifting left and right. Lead arc device doing mechanic tracing to welding seam, which can get high quality of welding line; automatically recycle the flux and save labor.



Main technical parameters

Size of web plate	Height	200-1200mm
	Thickness	6-14mm
	length	4000-15000mm
Size of flange	width	150-300 mm
	thickness	8-20 mm
	length	4000-15000 mm
Straightening speed		500-1500mm/min
Total power		Power of assemblage 12kw (except for 2 welders)
Gas pressure		0.4-0.8Mpa

This machine can weld two parallel welding seam of one workpiece at one time. Charactered with single arc and double wire angle welding function, this model machine is applicable to light beam steel volume-production and variable cross section of beam steel welding, which is triumphantly applied to vertical girder polyline assembling welding of semi-trailer.

HL-II H-beam welding integrative machine(special welding machine for longitudinal beam of semi-trailer)



Straightening machine distinct



Straightening locale



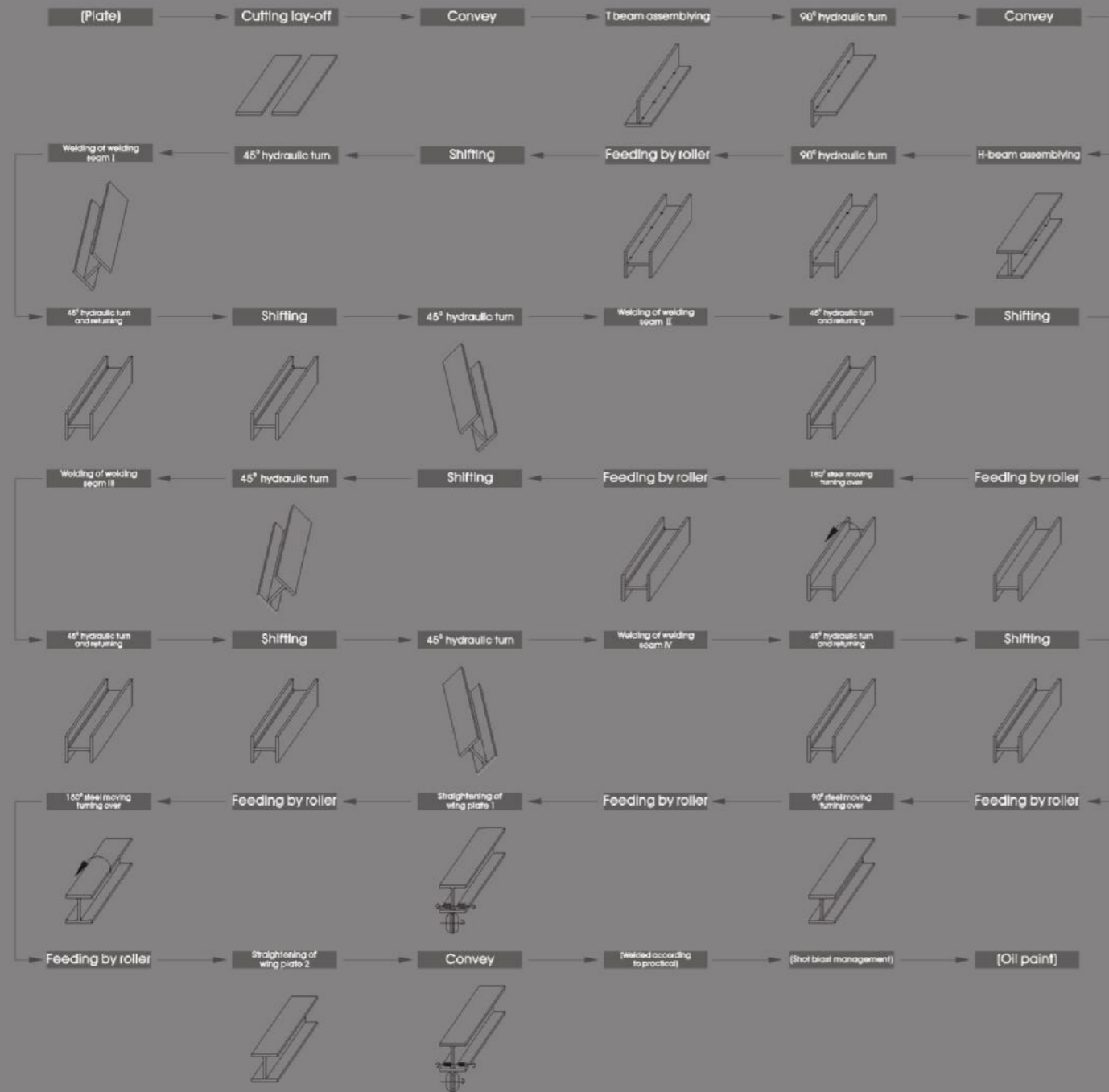
When H beam steel of welding fabrication is in the process of welding and heating, the flange plate must be bent and transfigured. The machine is a special device applied to straighten the flange plates. It can be operated easily and high-effectively. It's widely used in many trades such as metallurgy & architecture, metal structure, hydrotechnics machinery and Industrial Installation etc.

JZ type H beam flange straightening machine

Main technical parameters

styles	Width of flange	Thickness of flange	Minimum height of web plate	Straightening speed	Power source
JZ-40A	200-800mm	6-40mm	200mm	9000mm/min	AC380V 50HZ
JZ-80	140-600mm	5-30mm	180mm	7800mm/min	AC380V 50HZ

Technical process of H beam(heavy steel)automatic welding production line



H beam (heavy steel) automatic welding production line

H beam production line: This production line is developed on the base of the former common H beam production line, equipped with proper accessory equipments such as 90° hydraulic turning-over frame, 45° hydraulic turning-over frame, parallel steel conveyer, chain turning-over machine and feeding roller etc. It realized semi-automatic producing procedure of H beam. Except cutting lay-off and exchanging procedure of T beam assembling and straightening of flange plates, the whole process doesn't need hoisting. It greatly improves the producing efficiency and reduces the work intensity. This line also has the advantages such as being of good equipment and reasonable flow layout etc.

The conveyer turning-over machine can manage parallel conveying and 360° turning-over of the workpieces. It operates conveniently, safely and durably. The maximum hoisting capacity is 20, 10 and 5 tons, which is optional choice. The 90° and 45° turning-over rack adopt hydraulic throttle synchronization turning-over and mechanic orientation. Steel conveyer mainly has two functions of moving and lifting. There are carrying capacity of 8 and 10 tons for choice when hydraulic pressure elevating.



HG-1500III H beam middle spot-welding assembling machine



HG-1500III middle spot-welding machine uses automatic spot-welding in the middle, and makes use of transmitting positive and negative screw rod synchronistically during the process of centering to realize in centering automatically of single group clamping organ. It uses several dynamic systems to actualize centering successively among the same kind of centering organ. There are always more than two web plate claspers working on the web plate in the course of spot-welding that assure to solve end shaking to improve productivity. According to the working labor intensity, and improve productivity. According to the workers labor intensity, and improve productivity. According to the workpieces existing fringed and gap on flange plates, there is jiggle buffer oil cylinder to prevent blocking phenomenon.

Main technical parameters

Applicable range of H beam	Height of web plate	200-1500mm	Thickness of web plate	6-32mm
	Width of flange plates	150-800mm	Thickness of flange plates	6-40mm
	Length of H beam steel	4000-15000mm		
	Welding speed	500-1200mm/min	Total power	13kw(except for welding power source)
	Straightening speed	500-5750mm/min stepless speed changing		



XMHA-1600 cantilever H beam automatic submerged arc welding machine



Main technical parameters

Height of web plate	≥200mm	Thickness of web plate	6-32mm
Width of flange plates	200-800mm	Thickness of flange plates	6-40mm
Roll span	1600mm	Host power	5.1kw Except welding machine
Welding speed	350-1500mm/min	Speed without working	3500mm/min

This machine is developed to weld H beam by Hualian itself, based on taking advantages of both the domestic and oversea products, according to the market. It is mainly used in H beam submerged arc welding, especially the large scale one. The machine is compactly structured and convenient to operate.

45° /60° hydraulic turning-over organ (mechanic turning-over machine can adjust to 60°)



- 01. Feeding conveyor
- 02. 90° hydraulic turning-overmechanisms



Hydraulic turning-overmechanisms

Angle of turning-over	Maximum weight of turning-over	Height of applicable workplace	Pressure of hydraulic pressure system
90° (45° /60°)	10t/set	1800mm	6.3Mpa

Feeding roller machine

Roller load capacity	Roller-way diameter	Roller-way width
1.5t/m	φ168X12mm	2100mm



YGJ-10 steel moving machine

Maximum enduring weight for using	Moving speed of main machine	Lift displacement of workpiece table	Total power
10000Kg	7500mm/min	140mm	2.2kw

YFJS bi-directional steel conveyer turning-over machine

YFJS-10 bi-directional steel conveyer turning-over machine	1set	10t/set
YFJS-20 bi-directional steel conveyer turning-over machine	1set	20t/set



H beam hydraulic straightening machine

H beam hydraulic straightening machine: Is applicable to straighten thicker H beam flange plate. It has a large scope of application and powerful working capacity. There are hydraulic float rollers in the front and back of the main machine.

The straightening ability comparison of YJ-60B H beam steel hydraulic straightening machine

Material	Q345A										
Thickness of flange plates	8-15mm	15-22mm	23-28mm	29-32mm	33-36mm	37-40mm	41-45mm	46-50mm	50-60mm	60-70mm	70-80mm
Width of flange plates	> 200mm	> 250mm	> 350mm	> 400mm	> 450mm	> 500mm	> 550mm	> 650mm	> 750mm	> 750mm	> 800mm

The straightening ability comparison of YJ-80 H beam steel hydraulic straightening machine

Material	Q345A											
Thickness of flange plates	8-15mm	15-22mm	23-28mm	29-32mm	33-36mm	37-40mm	41-45mm	46-50mm	50-60mm	60-70mm	70-80mm	80-90mm
Width of flange plates	> 200mm	> 250mm	> 350mm	> 400mm	> 450mm	> 500mm	> 550mm	> 650mm	> 750mm	> 750mm	> 800mm	> 850mm



YJ-60B H beam hydraulic straightening machine



YJ-80 H beam hydraulic straightening machine

Main technical parameters of YJ-60B H beam hydraulic straightening machine

Total power of machine tool	18.5 kw	Power of main dynamo	18.5 kw	Pressure of principal pinch roller	1500 KN
Pressure of hydraulic system	16-18 Mpa	Maximum route of principal pinch roller	150 mm	Maximum torque of gearbox	40 KN.m
Straightening speed	5.2 m/min	Width of flange plates	200-800 mm	Height of web plate	350-1500 mm
Thickness of flange plates	8-60 mm(Q345)	Thickness of web plate	8-40 mm		

Main technical parameters of YJ-80 H beam hydraulic straightening machine

Total power of machine tool	27 kw	Power of main dynamo	22 kw	Pressure of principal pinch roller	2000 KN
Pressure of hydraulic system	18-25 Mpa	Maximum route of principal pinch roller	150 mm	Maximum torque of gearbox	60 KN.m
Straightening speed	5.2 m/min	Width of flange plates	200-800 mm	Height of web plate	350-1500 mm
Thickness of flange plates	8-80 mm(Q345)	Thickness of web plate	8-50 mm		

Main technical parameters

Height of web plate	200-2500mm	Width of flange plates	200-1000mm
Thickness of web plate	6-60mm	Thickness of flange plates	6-100mm
Length of web plate	4000-15000mm	Length of flange plates	4000-15000mm
Assembling speed	500-6000mm/min	Welding speed	500-1200mm/min
Total power	13kw Except electric welding machine		



This machine is technically developed for heavy and high H beam assembling spot-welding, based on HG-II assembling machine. The characteristic is that the adjustment of the press wheel's height is managed by screw rod driving the screw nut to make H beam easily.



HG-2000 II H beam heavy steel assembling machine



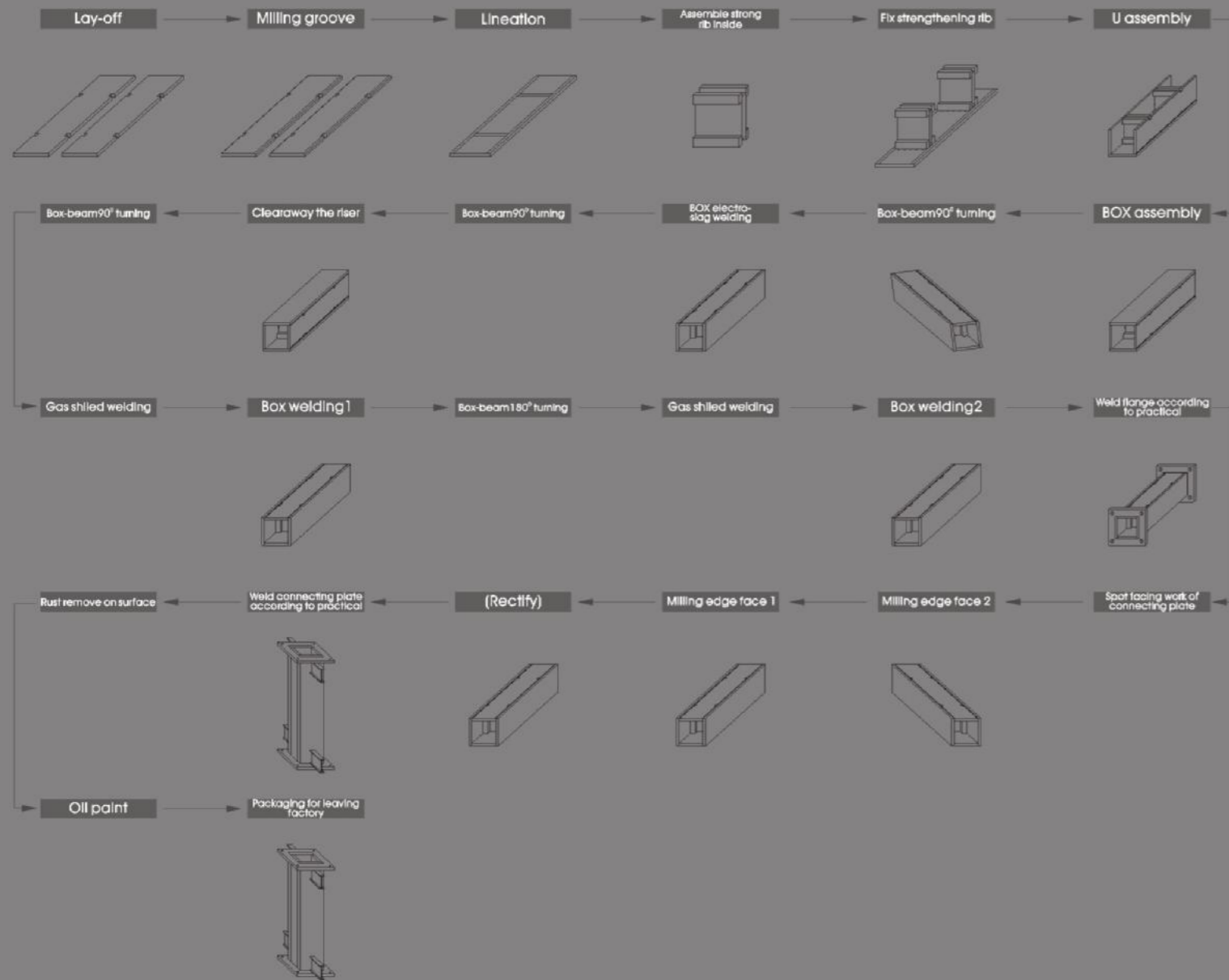
This machine is double-cantilever trolley structure and cymbiform shaped submerged arc welding, applicable to large-scale H beam welding and can weld two pieces of H beam together, which is of high efficiency. The host machine adopts bilateral drive, operating stably.

Main technical parameters

Height of web plate	200-2500mm	Thickness of web plate	8-40mm
Width of flange plates	200-800mm	Thickness of flange plates	10-100mm
Roll span	2000mm		
Welding speed	350-1500mm/min	Speed without working	3000mm/min
Flux recycle machine	100Kg×2	Host power	11kw Except welding machine

MZGT-2000 double-cantilever trolley submerged arc welding machine

Technical process of welding BOX beam



The sight of Zhejiang Dadi Net Frame

BOX beam welding production line (cantilever form)



The sight of Anhui Fuhuang Steel Structure

BOX beam welding production line

As the development of steel structure market, box-beam will be used more and more widely in many fields like bridge, power station, boiler and high building etc.

This production line is proceeding from technological point such as lay-off cutting, manufacturing groove, assembling claspboard inside, U style assembling, box assembling, electro-slag welding, box welding, manufacturing edge face, shot blasting and so on. Meanwhile, equipped with the main process equipment, box-beam is always big and heavy, so we must add the conveyor by roller and steel conveyor turning-over equipments to realize the part of automatic operation in the process of technical production. We can produce gate form and cantilever form, depending on the customers' requirement.



XBJ series of edge milling machine: this machine use craftwork of milling and supersede former planing. It is applicable to mill straight edge, sloping edge and V type groove of plate before welding the slab. It greatly improves production efficiency and quality, meanwhile reduces the cost. It is the first choice of products in many trades, such as pressure vessel, shipping, electric power, petroleum, chemical industry and mechanism etc.

The machine is mainly composed of lathe bed and pressing beam accessories, flexing organ, milling tip, tool tip adjusting organ and hydraulic and electric control system. Hydraulic lifting mechanism of steel plates is added on the lathe bed, convenient to feed and recede the material; the upper pressing beam assembly, which is safe to operate, is made of full hydraulic compaction. Moving feed organ use FC stepless timing, which can actualize easily to adjust the feeding rate of milling. Tool tip can be adjusted from 0° to 45° and the height of tool tip can be adjusted by electric elevating.

XBJ series of edge milling machine

Main technical parameters

Parameters	Style	XBJ-6	XBJ-9	XBJ-12	XBJ-15	XBJ-26SB
Items						
Thickness of plate by milling		6-60 mm				
Maximum depth of milling one time		4 mm				4 mm
Length of tool tip milling		0°~45°				0°~45°/45°~45°
Effective length of milling		6 m	9 m	12 m	15 m	25 m
Transmission of milling tip		80-400 rpm				
Feed rate of milling		0.25-0.6 m/min				
Velocity of fast forward		2.0 m/min				
Numbers of hydraulic cylinder		9	13	17	21	26
Amount of the manual screw pressure foot		/				25
Operation pressure of hydraulic system		2.5 Mpa				
Whole power of assembling machine		12.7 kw				17.2 kw
Outline dimension		8700X2000X2000 mm	11700X2000X2400 mm	14700X2000X2400 mm	17700X2100X2600 mm	30100X3100X2900 mm
Weight of machine		12 T	16 T	19 T	24 T	57 T



DX Models of Face Milling Machines: This line of face milling machines are provided with special milling power spindle high-strength welded body and elevating column, frequency conversion driving system and PLC process control system which enable autoatic milling operation. Equipped with standard or profile milling cutters, this line of milling machines can be satisfied for all kinds of face milling processes. Various types of work tables may be available for respective workpieces. It is also applicable in face milling for large-size work piece, such as H-shaped steel, Box beams and the like which are mostly used in the Industries of electricity, petrochemical, bridge building power station and boilers.

DX series of face milling machines

Main technical parameters

Parameters	Style	DX0816	DX1224	DX1416	DX2828
Items					
Height of milling part		800 mm	1200 mm	1400 mm	2800 mm
Width of milling part		1600 mm	2400 mm	1600 mm	2800 mm
Maximum depth of milling on time		5 mm			
Level Working speed		200-650 mm/min			200-500 mm/min
Vertical working speed		200-650 mm/min			200-500 mm/min
Diameter of milling cutter head		φ 200mm			
Level quick forwards speed		1500-2000 mm/min			1170 mm/min
Vertical quick forwards speed		1500-2000 mm/min			1040 mm/min
Main milling power		5.5 kw			7.5 kw
Level feed power		4 kw			7.5 kw
Vertical feed power		3 kw			4 kw
Hydraulic working pressure		4 Mpa			
Weight		8.5 T	9 T	10 T	26 T
Main overall dimension		4500X1200X3200 mm	5100X1200X3500 mm	4500X1200X3800 mm	6800X1800X6100 mm



This machine is composed of host machine, feeding roller, web plate straightening and centering clamping organ and hydraulic and electric control system. This machine is manually operated. The workpiece remains while the host moving, which is more correct in orientation.

ZUZB-1200 U type BOX assembling integrative machine

Main technical parameters

Width of applicable box-beam	Length	5-15 m
	Height	300-1200 mm
	Width	300-1200 mm
	Thickness	16-60 mm
Pressure of mainframe system		10 Mpa
Mainframe speed		8000mm/min
Feeding speed of roller		5000mm/min
Load capacity of roller		2.5 T/m
Length of table roller		15000 mm
Total power		15 Kw
Outline dimension		2275x5250x3325 mm



Stiffening plate assembling machine

DZ-1200X Electro-slag welding machine



The machine is composed of moving platform, lengthwise elevating mechanism, widthwise moving mechanism (manual operating) etc. It can be equipped with water-cooled fuse wire style or nozzle-consumable style electro-slag welding machine.

Main technical parameters

Width of applicable box-beam	300-1200 mm
Height of applicable box-beam	300-1200 mm
Moving speed	3200 mm/min
Total power	1.5 Kw

MDZ-1200 Electro-slag welding machine

This machine adopts the gate structure, with good rigidity and stability. The welding machine is on the top of the gate which is space saving.

Main technical parameters

Width of applicable box-beam	300-1200 mm
Height of applicable box-beam	300-1200 mm
Moving speed	7500 mm/min
Total power	2.7 Kw



Thread pole electro-slag controller



This machine adopts cantilever structure that the welding machine and welding thread can be put on it to save space.



Main technical parameters

Width of applicable box-beam	300-1200 mm
Height of applicable box-beam	300-1200 mm
Welding speed	250-2500mm/mln
Returning speed	4000mm/mln
Welding position	Horizontal welding
Total power	6Kw

XMHQ-1200 cantilever double thread gas shiled welding padding machine

This machine is composed by moving organ, machine rack, longitudinal and horizontal moving system, welding machine, gas and electric system and arc- guiding organ.

Main technical parameters

Width of applicable box-beam	300-1200 mm
Height of applicable box-beam	300-1200 mm
Welding speed	250-2500mm/mln
Returning speed	4000mm/mln
Welding position	Horizontal welding
Total power	9Kw



MHQ-4000 gate double thread gas shiled welding padding machine



This machine adopts cantilever structure, which has the advantages of compact structure, space saving and light weight etc.

Main technical parameters

Width of applicable box-beam	300-1200 mm
Height of applicable box-beam	300-1200 mm
Welding speed	250-2500mm/mln
Returning speed	4000mm/mln
Welding position	Horizontal welding
Total power	14Kw



XMHJ-1200 BOX cantilever welding machine

The main characteristic of this machine is that the elevating of the guiding column and the transverse moving are mechanic. It adopts small scope pneumatic follow-up. The welding torch is three-dimensional adjusted with light lathe bed, so it can follow up large scope.

Main technical parameters

Width of applicable box-beam	300-1200 mm
Height of applicable box-beam	300-1200 mm
Welding speed	250-2500mm/mln
Returning speed	4000mm/mln
Welding position	Horizontal welding
Total power	15Kw



MHJ-4000C BOX welding machine



This machine is a parallel steel conveying and turning-over integrative one.

Main technical parameters

Maximum carrying capacity	20t/set
Turning-over speed	1m/min
Moving speed	6m/min
Hydraulic system pressure	16Mpa
Total power	16Kw

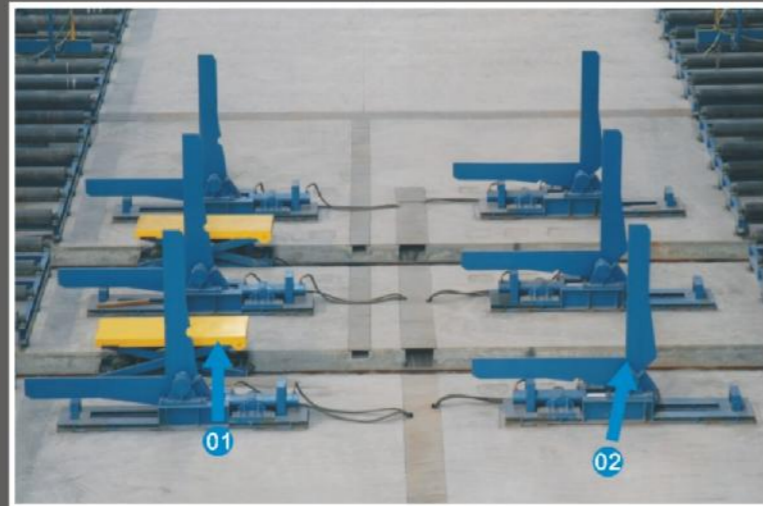
YFJS-20T steel conveyer turning-over machine

YGJ-15 steel-moving machine

Maximum weight capacity	30t/set
Moving speed	7.5m/min
Elevating routine of the platform	140mm

90° hydraulic turning-over rack

Turning-over angle	90°
Maximum weight capacity	20t/set
Hydraulic system pressure	16Mpa



01、YGJ-15 steel-moving machine

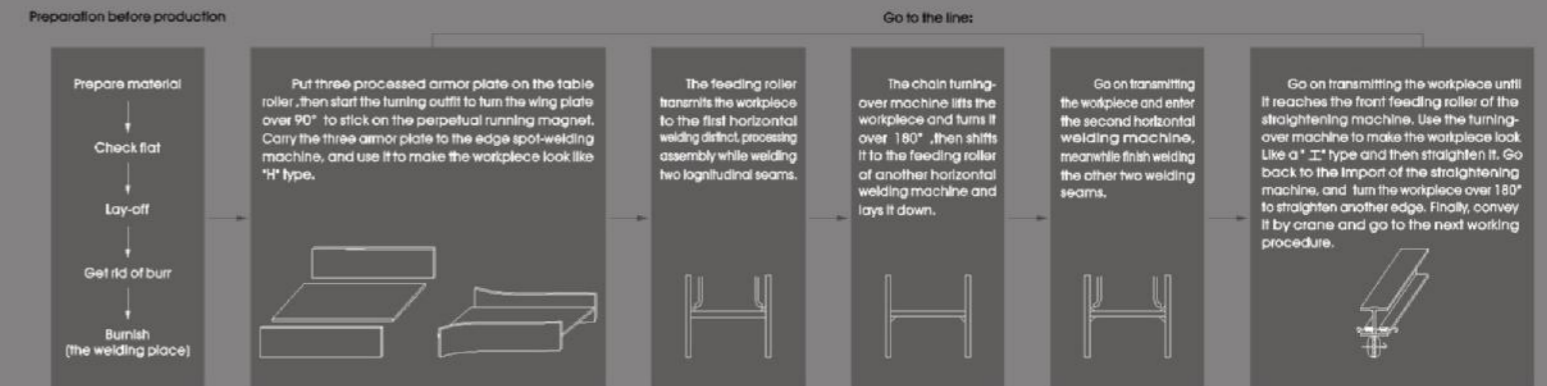
02、90° hydraulic turning-over rack

Horizontal assembly welding machine production line



This production line uses horizontal assembly, and it can weld two longitudinal seams at the same time. You only need weld the flange plate of the H-beam steel with the head of web plate, and it can accomplish both the horizontal assembly of H-beam steel and the welding of two welding seams at one time. This greatly increases the automatization and improves labor productivity; Secondly, this machine can achieve the bevel edge welding with small angle (weld the variable cross-section). So it's the ideal equipment for light steel production line.

Technical process of horizontal assembly welding machine production line



★ Notice: From the end of assembling to the end of straightening, the operation process needn't use moving crane to sling the workpiece.



MWZ-1000 Horizontal H beam steel assembling machine

Main technical parameters

Applicable production specification for H beam(Line)	Basic dimension of H beam steel (reference dimension)	
	Width of flange plate	100-500 mm
	Thickness of flange plate	5-20 mm
	Height of workpiece	300-1200 mm
	Thickness of web plate	5-12mm
	Length of workpiece	3000-15000mm
	Weight of workpiece	< 4t/piece
Angle of variable cross-section	< 10°	



The composing of horizontal assembly welding machine production line

The type and name of machine	GSZ-4000 numerical control multiple heads cutting machine	MWZ-1000 edge spot-welding machine	MWZ-1000 Horizontal assembling machine	FZM-4 door turning-over machine	JZ-30 straightening machine
Quantity (set)	1	1	2	2	1

Series of shot blasting machine



HGP series of roller way shot blasting machine

HGP series roller way shot blasting machine is designed and developed according to steel structure character, which can clean H beam steel and other structure workpiece; cleaning device and shot blasting device layout is reasonable, shot blasting scope is extensive and clean workpiece completely. Adopting frequency conversion timing feeding makes it easy and highly efficient to clean. This machine can be equipped with pulse bag/pulse filter cleaning device.

HP series of dolly way shot blasting machine

HP series dolly way shot blasting machine is designed and developed according to steel structure character, which can clean H beam steel and other structure workpiece; cleaning device and shot blasting device is set reasonably, shot blasting scope is extensive and clean workpiece completely. Adopt frequency conversion timing winch to lead trolley for workpiece feeding. This machine can be equipped with pulse bag/pulse filter cleaning device.



LGP series of steel plate shot blasting machine

LGP series steel plate shot blasting machine is one kind of roller way steel plate cleaning machine, which is only applicable to steel plate. Cleaning room and shot blasting layout is reasonable, shot blasting scope is extensive and clean workpiece completely. During cleaning, use feeding system of roller controlled by frequency conversion timing to convey steel plate standing on the roller to cleaning room. After shot blasting, convey out workpiece through the other end. There is no retained steel ball on the workpiece. This machine can be equipped with pulse bag/pulse filter cleaning device.



Series of shot blasting machine



Filter roller



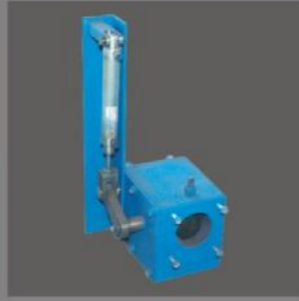
leaf wheel



Shot blasting machine



Dust catcher



Steel shot adjusting valve

Main technical parameters

Name	HP0812-6	HP0812-8	HP0816-6	HP0816-8	HP1218-8	HP1220-8	HP2020-8(10)
Workpiece shape	H beam steel	H beam steel	H beam steel	H beam steel	H beam steel	H beam steel	H beam steel
Workpiece size(width x height x length)	800x1200x1500mm	800x1200x1500mm	800x1600x1500mm	800x1600x1500mm	1200x1800x1500mm	1200x2000x1500mm	2000x2000x1500mm
Feeding way	Trolley passing model	Trolley passing model	Trolley passing model	Trolley passing model	Trolley passing model	Trolley passing model	Trolley passing model
Workpiece moving speed	0.6-3mm/min	0.6-3mm/min	0.6-3mm/min	0.6-3mm/min	0.6-4mm/min	0.6-3mm/min	0.6-3mm/min
Shot blasting device model	Q034	Q034	Q034	Q034	Q034	Q034	Q034
Shot blasting rate	180kg/min	180kg/min	180kg/min	180kg/min	180kg/min	220kg/min	220kg/min
Motor power	11kw	11kw	11kw	11kw	11kw	15kw	15kw
Quantity	6 set	8 set	6 set	8 set	8 set	8 set	8(10) set
Elevating bucket machine rate	90t/h	120t/h	90t/h	120t/h	120t/h	120t/h	120t/h
Motor power	7.5kw	7.5kw	7.5kw	7.5kw	7.5kw	7.5kw	7.5kw
Screw machine feeding rate	90t/h	120t/h	90t/h	120t/h	120t/h	120t/h	120t/h
Power	4+5.5kw	4+5.5kw	4+5.5kw	4+5.5kw	4+5.5kw	4+5.5kw	3+5.5kw
Dust cleaning model	Filter dust cleaning device LLT3-16 (pulse cloth bag)				Filter dust cleaning device LLT3-22 (pulse cloth bag)		
Dust cleaning square	320m				440m		
Filter roller quantity	16 set				22 set		
Dust cleaning air rate	9210-18418m/h	9210-18418m/h	9210-18418m/h	9210-18418m/h	9210-18418m/h	9210-18418m/h	17463-32380m/h
Air pressure	2176-1380pa	2176-1380pa	2176-1380pa	2176-1380pa	2176-1380pa	2176-1380pa	1816-2478pa
Power	15kw	15kw	15kw	15kw	18.5kw	18.5kw	18.5kw
Whole machine power	110.5kw	132.5kw	110.5kw	132.5kw	132.5kw	164.5kw	182kw
Main machine outer size(length x width x height)	6600x2700x7700mm	6600x2700x7700mm	6600x2700x8300mm	6600x2700x8300mm	7000x3500x9420mm	7000x3500x9420mm	7420x4370x9000mm
Crane passing height	5900mm	5900mm	6500mm	6500mm	7000mm	7000mm	7125mm
Underground depth	1900mm	1900mm	1900mm	1900mm	2575mm	2575mm	1875mm

Main technical parameters

Name	HGP0612-4	HGP0812-6	HGP0816-8	HGP1218-8	HGP2025-12	GP800-4	LGP2200
Workpiece shape	H beam steel	H beam steel	H beam steel	H beam steel	H beam steel	H beam steel	Steel plate
Workpiece size(width x height x length)	600x1200x1200mm	800x1200x1500mm	800x1600x1500mm	1200x1800x1500mm	2000x2500x1500mm	600x300x8000mm	2200x5-50x15000mm
Workpiece passing MAX short distance	2000mm	3000mm	3000mm	3000mm	3000mm	2000mm	3000mm
Roller speed	0.6-3mm/min	0.6-3mm/min	0.6-3mm/min	0.6-3mm/min	0.6-4mm/min	0.6-3mm/min	0.6-4mm/min
Roller load weight	1000kw	1000kw	1000kw	1000kw	1000kw	500kw	1000kw
Roller power	2.2x2.2kw	2x2.2kw	2x2.2kw	2x2.2kw	2x3kw	2x2.2kw	2x2.2kw
Shot blasting device model	Q034	Q034	Q034	Q034	Q035	Q034	Q034
Shot blasting rate	180kg/min	180kg/min	180kg/min	220kg/min	220kg/min	120kg/min	180kg/min
Motor power	11kw	11kw	11kw	15kw	15kw	7.5kw	11kw
Quantity	4 set	6 set	8 set	8 set	12 set	4 set	6 set
Elevating bucket machine rate	60t/h	120t/h	90t/h	120t/h	160t/h	90t/h	120t/h
Motor power	7.5kw	7.5kw	7.5kw	7.5kw	11kw	5.5kw	7.5kw
Screw machine feeding rate	60t/h	120t/h	120t/h	120t/h	160t/h	90t/h	120t/h
Power	4+5.5kw	4+5.5kw	4+5.5kw	4+5.5kw	7.5+5.5+5.5kw	4+5.5kw	4+5.5kw
Dust cleaning model	Filter roller dust cleaning LLT3-16(cloth bag)			Filter roller dust cleaning LLT3-22(cloth bag)		Filter roller dust cleaning LLT3-22(cloth bag)	Filter roller dust cleaning LLT3-16(cloth bag)
Dust cleaning square	320m			440m		240m	360m
Filter roller quantity	16 set			20 set		12 set	16 set
Dust cleaning air rate	9210-18418m/h	9210-18418m/h	9210-18418m/h	9210-18418m/h	9210-18418m/h	9210-18418m/h	17463-32380m/h
Air pressure	2176-1380pa	2176-1380pa	2176-1380pa	2176-1380pa	2176-1380pa	2176-1380pa	1816-2478pa
Power	15kw	15kw	15kw	15kw	18.5kw	18.5kw	18.5kw
Whole machine power	110.5kw	132.5kw	110.5kw	132.5kw	132.5kw	164.5kw	182kw
Main machine outer size(length x width x height)	900x3120x7700mm	9600x3420x7700mm	9600x3420x8300mm	10180x4200x9420mm	8000x5000x10570mm	5000x2350x7000mm	7000x2542x8000mm
Crane passing height	5800mm	5800mm	6500mm	6900mm	8500mm	5100mm	7000mm
Underground depth	1900mm	1900mm	1900mm	2575mm	2900mm	1605mm	1550mm

Shot material circulating and deparating system

