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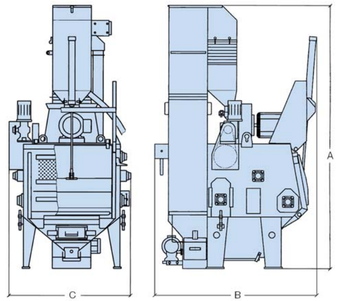
Technical Data

Type			BB 85	BB170	BB170HD	BB340	BB 680
Max. useful capacity		dm^3	85	170	170	340	680
Max. batch weight		kg	180	360	500	720	1360
Blast room inside dimensions		mm	Ø 610 x 788	Ø 700 x 988	Ø700 x 988	Ø 1068 x 980	Ø 1220 x 1473
Max. workpiece diagonal		mm	250	350	350	450	500
Max. weight per workpiece		kg	10	15	23	35	40
Number of blast wheels			1	1	1	1	2
Power per blast wheel		kW	5.5	11	11	15	11/15
Abrasive throughput, max.		kg/min	105	180	180	240	360/480
Air required for dust collection		m^3/h	1400	1600	1600	3400	4250
Installed power, approx.		kW	6,5	12,3	12,3	18,5	34/42
Dimensions, approx.	A	mm	2810	3730	3730	5000	6150
	B	mm	1680	2070	2070	3890	3570
	C	mm	1280	1610	1610	4730	5150
Weight, approx.		kg	1460	2250	2300	4310	8770/8900

The technical data is not binding and may be subject to change.



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Norican Group is the parent company of DISA and Wheelabrator.

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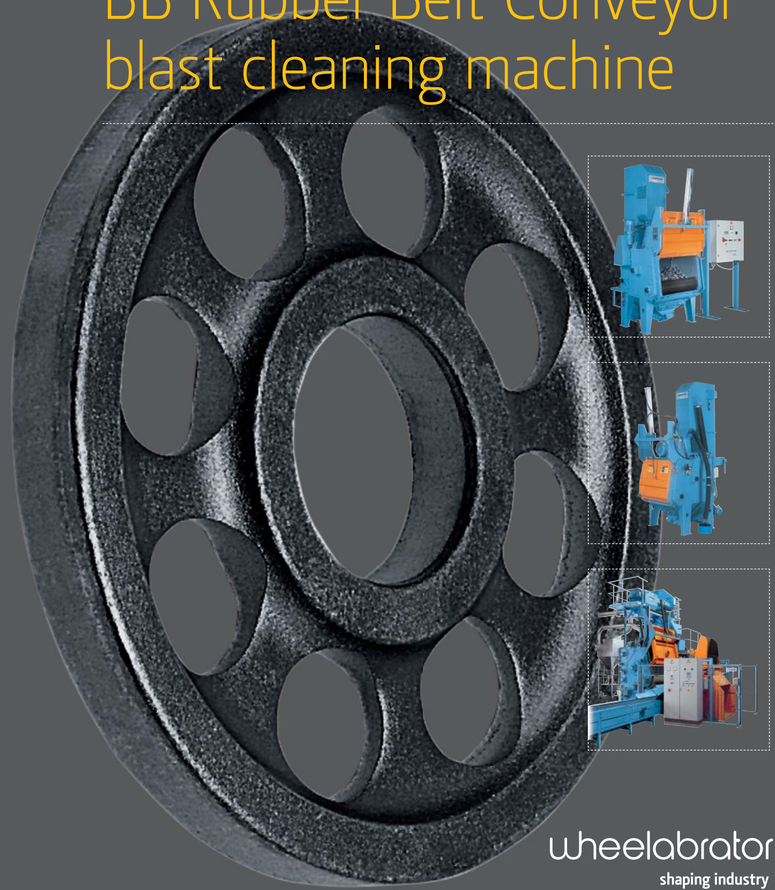
BB Rubber Belt Conveyor blast cleaning machine



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Design and operation

Rubber belt conveyor blast machine BB

The Wheelabrator BB blast cleaning machine offers favourable, convincing solutions for blast cleaning of small and medium size workpieces, in batch quantities. The BB series will accomodate batch weights of 180 kg to 1360 kg. The applications of these machines are especially variable:

- Blast cleaning of iron castings, precision castings, and die castings
- Descaling of forgings or heat-treated workpieces
- Shot peening for surface compaction
- Deburring of metallic (e.g. stampings) and non-metallic workpieces
- Surface finishing

BB blast cleaning machines have been successful over several years and in thousands of applications, often in multishift operation. The BB series have proved to be economical for low production runs, as well, assuring reliable performance and optimum blast cleaning. The BB series offers the following advantages:

- Attractive price/value ratio
- Rugged, compact design
- Ease of operation
- High blast cleaning performance
- Quick and easy replacement of wear parts

Design and sequence of operations

Depending on the weight, size, volume, and flow rate of the parts to be cleaned, the machine can be loaded in a manual, mechanical, or automatic mode. The workpieces are then tumbled inside the blast cleaning chamber consisting of a continuous troughing rubber belt conveyor and lateral discs of highly wear-resistant material. Especially designed carrier bars attached to the rubber belt conveyor assure gentle tumbling and full exposure of all surfaces of the work-pieces. The abrasive containing burrs, scale, or sand drops through the perforations of the rubber belt and is then transported to the bucket elevator and the separator. After passing through the separator for removal of impurities, the abrasive returns to the storage hopper.

Hydraulic loaders

BB 680 with loade

Hydraulic loaders are used for the machine types BB 170, BB 340 and BB 680 and, on special request, can also be provided for the smallest machine size BB 85. The shot blast machines can receive the parts to be cleaned directly or using separate transport bins of the standard sizes 800 x 600 mm or 1200 x 800 mm. Other dimensions of transport bins can be accomodated.

Technical Specifications

- Rugged welded structure fixed to the machine and to the floor
- Separate hydraulic unit
- Lifting movement of the tilting loader in two stages (one axis for lift and one for tilt) by means of lateral cylinders
- Delivery of the transport bins to the front or to the side of the tilting loader

Other types of loading equipment (such as belt conveyors, etc.) upon request.

Efficiency and precision

Directly driven blast wheel

Wheelabrator blast wheels

Wheelabrator blast wheels are renowned for high capacity and maximum energy efficiency. These blast wheels come in various power ratings, giving a high degree of flexibility. With modifications it is possible to reverse the blast wheel rotation thus allowing a greater range of applications. The amount of abrasive can be adjusted from the operator's panel. The abrasive is mechanically pre-accelerated and delivered to the blast wheel in a continuous stream. This ensures optimal utilisation of the power from the drive motors. High wear resistant material ensures maximum service life of the blast wheel. Unique design features allow for rapid and simple replacement of wear parts.