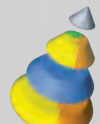
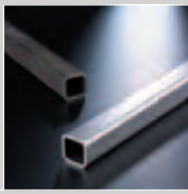
RÖSLER®
finding a better way ...

www.rosler.com

Shot Blasting Technology





finding a better way ...

When it comes to dealing with surface finishing and surface preparation problems, Rösler offers the total process solution*! Our customers can choose between two processing technologies,* Vibratory finishing or Shot blasting*, which offer virtually unlimited possibilities. Through extensive processing trials, we always find the right finishing solution for our customer's needs.*
This includes not only the development of a specific finishing process, but also the selection of the right equipment and consumables.
We deliver the total solution to satisfy your surface finishing requirements. Our success in the market proves that we are right. It is not by chance that our innovative developments and our high quality standards have established Rösler as the world technology and market leader in surface finishing and surface preparation.

In more than 60 countries we support our customers with a closely-knit network of Rösler subsidiaries and sales representatives.

We are the only company in our field operating test and demonstration centres *throughout the world. This allows us to run test trials under real production conditions close to our customers.*
This offers several advantages: Our customers save time and money, and at the same time – through our professional processing trials and advice – they are assured of receiving the best process solutions and products available on the market!

Worldwide Demonstration and Test Centres

Vibratory finishing and shotblasting test centre located at the Rösler headquarters in Untermerzbach:

- more than 95 vibratory finishing and shotblasting systems
- working space: approx. 2,700 square meters

Similar test centres are located in the United States, Great Britain, France, the Netherlands, Belgium, Switzerland, Spain, Italy, Austria, South Africa and Brazil.

The Total Process Solution

Consumables, machines and process safety in perfect combination:

- A perfect interaction between consumables, equipment, process and safety
- Cost-saving automation linking multiple process steps
- Qualified field service teams guarantee smooth installation and commissioning of your equipment
- Comprehensive training of your operators and maintenance staff
- After-sales service guarantees high uptimes for your equipment

Environmental · Quality

The consideration of environmental issues guarantees a high level of product quality and environmental protection. For example, recycling the process water is a key feature of our mass finishing technology. In this case, the positive effect on the environment is reflected in savings of compound and water of up to 95%. At the same time, a high level of process reproducibility and finishing quality is guaranteed.

Team Spirit

Rösler is a dynamic organization where the initiative and commitment of each employee plays a key role. Systematic training and a cooperative management with lean structures are essential elements of our corporate philosophy. This allows us to create a workplace environment which attracts talented young people.

RÖSLER®
finding a better way ...

The GSCE sign marks all our standard machines

ISO 9001: 2000

Furniture and hardware

Gas-, air-, plumbing fittings

Turbine components

Cutlery and knife parts

RÖSLER®

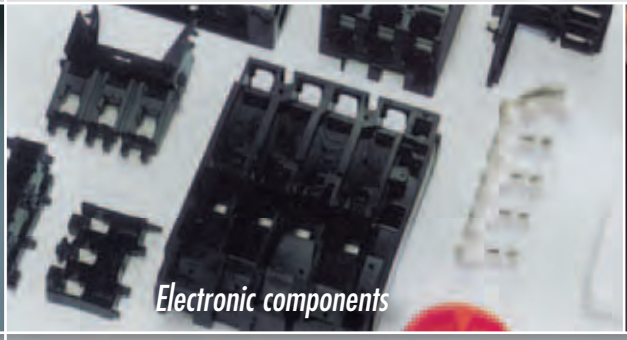
finding a better way ...

Shot blasting is a technology which directs blast media onto a parts surface at a speed of up to 120 m/sec. The media is accelerated either by blast wheels (airless), compressed air, or electric pumps (water jet cleaning). The blast results depend on the type of blast machine, processing parameters and selected blast media.

Automotive parts

Audio, video,
photo components

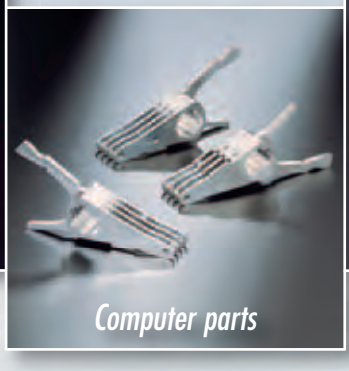
Jewellery/watch parts

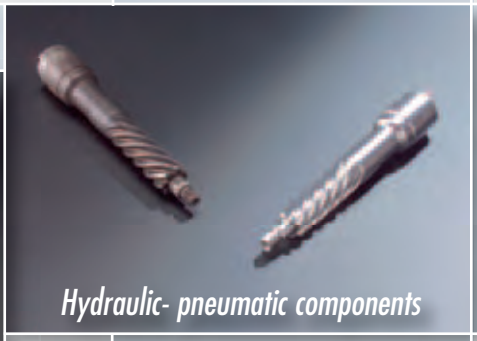


Electronic components

Steel- and ship building


Hand tools

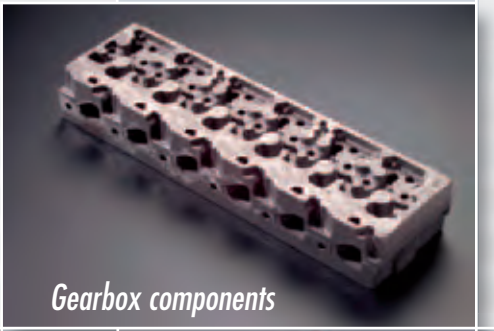

Computer parts


Hydraulic- pneumatic components

- De-scaling, De-rusting
- Paint Stripping, Coating Removal
- Core Removal, Sand Removal
- Shot Peening
- Surface Cleaning
- Deburring
- High-pressure Water Jet Blasting, Satin Finish Wet Blasting
- Painting, Rust Protection
- Surface Finishing
- Roughening


Implant
and medical instruments


Aerospace components


Gearbox components


Bearing components


Machine components


Concrete,
stone and ceramic industry

Shot Blasting

Our comprehensive product range offers modern shot blasting technologies which completely fulfill today's market requirements. In addition, we are constantly working with our customers to develop individual solutions to specific surface treatment problems.

RMBD – Continuous Through Feed Tumble Belt Machines

With the development of this continuous through feed tumble belt system, Rösler has opened up the way to fully automatic and economical shot blasting of mass produced small to mid-size bulk parts, as well as the blast cleaning of large, delicate components. All in the same machine.

Technical data	RMBD 300/2	RMBD 400/2	RMBD 500/2 (4)
Max. part size (measured diagonally in mm)	250	350	400
Tunnel diameter (mm)	300	400	500
Blast wheel types	Hurricane® 28, 32 and 42		
Number of blast wheels	2	2	2 or 4
Blast wheel power (kW)	5.5 – 11	5.5 – 11	5.5 – 11
Integrated separation	x	x	x
Machine length (mm)	4,000	5,110	5,340
Machine height (mm)	4,100	4,300	5,200

Date: 11/07

RDGE – Wire Mesh Belt Machines

This machine type is ideal for continuous, all-around shot blasting of flat, as well as large parts with complex geometry. Parts are transported through the blast machine on a highly wear-resistant wire mesh belt. Available with 2, 4 or 8 blast wheels.

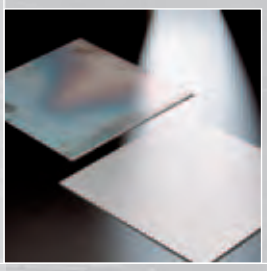
Technical data:	RDGE 800-2 (4,8)	RDGE 1000-4 (8)	RDGE 1250-4 (8)	RDGE 1600-4 (8)
Blast wheel types	Hurricane® 28, 32 and 42			
Number of blast wheels	2, 4 or 8			
Blast wheel power (kW)	5.5 – 15	5.5 – 15	5.5 – 15	5.5 – 15
Max. parts weight (kg/running meter)	100	100	100	100
Max. pass width (mm)	800	1,000	1,250	1,600
Max. pass height (mm)	400	400	500	600
Loading height (mm) [1]	1,000	1,000	1,200	1,300
Machine length (mm)	7,000	7,000	7,000	8,000
Machine height (mm)	5,300 approx.	5,300 approx.	5,300 approx.	5,600 approx.
Media cleaning systems	rotating drum screen, air wash separator, and dust collecting system			
Air volume dust collector (m^3/h)	4,000 – 10,000	4,000 – 10,000	4,000 – 10,000	5,000 –10,000

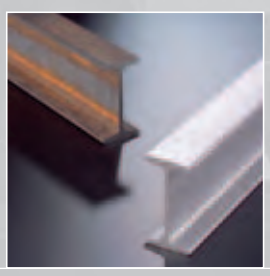
[1] Measured from floor level

Date: 03/08

RRB – Roller Conveyor Machines

Rösler roller conveyor machines are specifically designed for blast cleaning very long and flat parts, such as large area metal sheets and I-beams. They are also ideal for shot blasting low profile weldments. The components pass through the machine (usually a entrance vestibule, a blasting chamber and a blow off / brush-off chamber) on a special forced drive roller conveyor system. The travel speed is variable. Rösler offers turnkey preservation lines for spraying a welding primer or a total surface coating on the blasted components. Regardless of the condition of your raw materials, they can be pretreated, de-rusted and coated with a high gloss paint, all in a single process.





Technical data: [1]	RRB 11/5	RRB 16/5	RRB 22/5	RRB 22/5 HD	RRB 27/6	RRB 27/6 HD	RRB 34/6	RRB 34/6 HD	RRB 52/6 HD
Range of components:	*Metal sheets, I-beams and tubes*	*Metal sheets, I-beams and tubes*	*Metal sheets, I-beams and tubes*	*Metal sheets, I-beams and tubes*	*Metal sheets, I-beams and tubes*	*Metal sheets, I-beams and tubes*	*Metal sheets, I-beams and tubes*	*Metal sheets, I-beams and tubes*	*Metal sheets, I-beams and tubes*
Max. component width (mm)	*1,000*	*1,500*	*2,000*	*2,000*	*2,500*	*2,500*	*3,200*	*3,200*	*5,000*
Max. component height (mm)	*500*	*500*	*500*	*500*	*600*	*600*	*600*	*600*	*600*
Maximum load (kg/running m)	*1,250*	*1,250*	*1,200*	*1,500*	*1,200*	*2,000*	*1,200*	*2,000*	*2,000*
Blasting efficiency at rust level B/SA 2 ½									
sheets up to m/min	*2*	*2*	*2*	*4*	*2*	*4*	*2*	*4*	*4*
profiles up to m/min	*1.5*	*1.5*	*1.5*	*3*	*1.5*	*3*	*1.5*	*3*	*3*
Max. Conveying Speed m/min	*0.8 – 10*	*0.8 – 10*	*0.8 – 10*	*0.8 – 10*	*0.8 – 10*	*0.8 – 10*	*0.8 – 10*	*0.8 – 10*	*0.8 – 10*
Number of blast wheels and power (kW) [2] *- Option*	*4xH32 7.5 kW*	*4xH42 11 kW 15 kW*	*6xH42 11 kW 15 kW*	*6xH42 22 kW*	*6xH42 11 kW 15kW*	*6xH42 22 kW*	*6xH42 11 kW 15kW*	*8xH42 22 kW*	*14xH42 22 kW*
Machine length (mm) without blow/brush-off and filter	*3,650*	*3,650*	*4,200*	*4,200*	*4,200*	*4,200*	*4,200*	*4,200*	*4,300*
Machine length with blow/brush-off (mm)	*6,450*	*6,450*	*7,200*	*7,200*	*7,200*	*7,200*	*7,200*	*7,200*	*7,300*
Machine width (mm)	*2,900*	*3,450*	*3,800*	*3,800*	*4,800*	*4,800*	*5,500*	*5,500*	*8,000*
Machine height (mm)	*4,800*	*5,300*	*6,000*	*6,000*	*7,700*	*8,300*	*7,700*	*8,300*	*9,000*
Air volume dust collector (m^3/h)	*5,000*	*7,500*	*10,000*	*15,000*	*10,000*	*15,000*	*10,000*	*15,000*	*30,000*
Foundation pit recommended	*No*	*No*	*Yes*	*Yes*	*Yes*	*Yes*	*Yes*	*Yes*	*Yes*

[1] Special dimensions on request.
[2] Pullout device for blast wheels available (optional).

Date: 09/09

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RHB – Overhead Rail Hanger Machines

Rösler overhead rail hanger shot-blast machines are recommended for processing delicate parts which cannot be processed in bulk, and for particularly complex, heavy, and / or large volume components. Available in four versions: Straight or Y-rail batch systems. Indexing or continuous monorail systems

Technical data:	RHBE 9/13	RHBE 11/16	RHBE 15/20	RHBE 20/25	RHBE 20/30	RHBE 25/25	RHBE 25/40	RHBE 30/40
Max. hanger diameter (D x H mm)	900	1,100	1,500	2,000	2,000	2,500	2,500	3,000
Max. hanger height (mm)	1,300	1,600	2,000	2,500	3,000	2,500	4,000	4,000
Max. hook weight with Y-rail (kg)	2 x 500	2 x 1,000	2 x 1,000	2 x 1,000	2 x 1,500	2 x 1,500	2 x 1,500	2 x 2,000
Number of blast wheels and power (kW)	2 x 5.5	3 x 7.5	3 x 11	4 x 7.5	4 x 7.5	4 x 11	5 x 18.5	5 x 22
Length blast chamber (mm)	1,300	1,600	2,800	3,000	3,300	3,800	3,800	4,500
Total length (mm)	3,500	4,300	5,000	6,000	8,500	8,500	8,500	9,000
Machine width (mm)	2,000	2,500	5,200	5,400	5,900	6,400	6,400	7,000
Machine height (mm)	4,800	5,200	5,500	6,500	8,300	7,800	9,800	9,800
Air volume dust collector (m^3/h)	3,000	5,000	5,000	7,500	15,000	20,000	25,000	25,000
Foundation pit recommended	No	No	Yes	Yes	Yes	Yes	Yes	Yes

Date: 03/09

SBM/SBI – Continuous Loop Belt Conveyor Through Feed Machines

SBM/SBI blast machines are equipped with a V-shaped troughed belt. The transport cams on the belt have an auger effect and induce a gentle forward movement of the components through the blast area. This machine type is especially suitable for continuous shot blasting of high volumes of small bulk parts. SBM/SBI machines can be equipped with blast wheels or air injection or pressure blast systems.

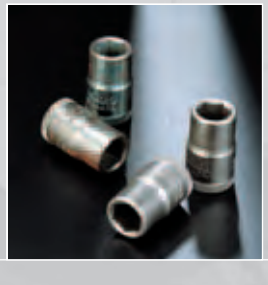
Technical data:	SBM 1010	SBM 1210	SBM 1520	SBM 2020
Max. part size (measured diagonally in mm)	100	190	190	265
Max. parts length (mm)	150	230	230	330
Blast wheel types	Hurricane® 28, 32 and 42			
Number of blast wheels	1	1	2	2
Blast wheel power (kW)	5.5	7.5	each 7.5	each 11
Capacity[1] (kg/h)	650	1,000	2,000	2,500
Integrated separation	–	x	x	x
Machine length (mm)	2,720	3,940	4,660	5,360
Machine height (mm)	4,040	4,280	4,600	5,100

[1] In reference to steel parts

Date: 11/07

RMBC – Tumble Belt Batch Machines

This machine type is ideal for batch processing of mass produced parts of all kinds of bulk parts. The RMBC offers a wide range of shot blasting applications: From small, delicate plastic components up to large, heavy forgings. Available with either rubber belt or steel slatted tumbling mill.



Technical data:	RMBC 1.1	RMBC 2.1	RMBC 4.2	RMBC 6.2	RMBC 8.2
Max. batch volume (l)	100	180	380	540	830
Max. batch weight[1] (kg)	300	600	1,000	1,500	2,000
Max. component weight (kg)	10	15 / 50	20 / 100	150	200
Number of blast wheels	1	1	1 or 2	1 or 2	2
Blast wheel power each (kW)	up to 1 x 7.5	up to 1 x 11	up to 2 x 15	up to 2 x 30	up to 2 x 30
Rubber belt	x	x	x		
Steel slatted belt		x	x	x	x
Tumble belt width	700	900	1,200	1,200	1,450
Machine height	4,130	4,190	5,990	6,080	6,630
Media cleaning systems	Vibratory screening unit, slide-in screens, air flow separation and dust collector unit				
Upgradeable for foundry applications			x	x	x

[1] Higher payloads possible (option)

Date:11/07

RDT – Rotary Table Machine

Components are placed on the rotary table which pass continuously through the blast area. This guarantees uniform blasting of the parts surface. RDT systems are available with a single rotary table or a segmented indexing table. RDT machines can be equipped with blast wheels or air injection or pressure blast systems. Table diameters from 1,000 to 2,500 mm.

Technical data:	RDT 100	RDT 150	RDT 200	RDT 250
Rotary table diameter (mm)	1,000	1,500	2,000	2,500
Max. parts height (mm)	470	600	800	800
Max. load (kg)	300	1,000	1,000	1,500
Number of blast wheels and power (kW)	1 x 5.5	1 x 7.5	2 x 7.5	3 x 7.5
Machine width (mm)	1,100	1,660	2,600	3,000
Machine length (mm)	2,250	2,280	2,300	3,000
Machine height (mm)	3,400	4,500	5,400	5,400
Air volume dust collector (m^3/h)	1,500	2,000	3,000	5,000

Date: 06/09

RTC – Drum Blasting Machine

The RTC is designed for economic and consistent shot blasting of small to medium-sized components which are too small, light and flat to be processed in a tumble belt machine.
Automatic loading and unloading systems enable the integration into a continuous production line.

Technical data:	RTC 1.1	RTC 2.1
Drum diameter (mm)	1,100 approx.	1,400 approx.
Max. drum depth (mm)	850 approx.	1,000 approx.
Drum perforation (mm)	4 approx.	6 approx.
Max. batch weight (kg)	300	750
Blast wheel (kW)	indirect drive 1 x 15	indirect drive 1 x 22
Machine height (mm)	5,400	5,500
Media cleaning systems	Vibratory screening unit, slide-in screens, air flow separation and dust collector unit	

Date: 11/07

RSA – Rotary Indexing Satellite Table Machines

With the rotary indexing satellite table machine, delicate parts can be processed on a continuous basis without touching each other. The spectrum of blasting applications for these machines ranges from delicate deburring to shot peening. RSA machines are also used for applications in which only certain areas of the parts need to be blasted. RSA machines can be equipped with blast wheels or pressure air systems

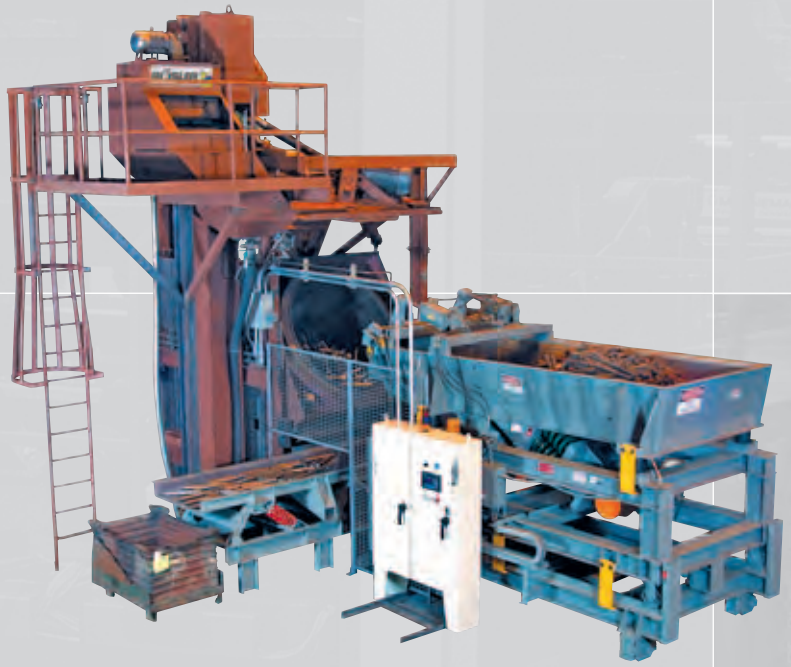
Technical data:		RSA 1400
Machine width (mm)		1,650
Machine depth (mm)		1,750
Machine height (mm)		2,500
Max. pass height (mm)		350
Rotary table diameter (mm)		1,100
Number of satellites		6, 8, 10, 12
Satellite diameter (mm)		100
Blasting gun	*Air nozzle ⌀ (mm)*	3.0 – 5.0
	Blasting nozzle ⌀ (mm)	9.0 – 14
	Nozzle material	Steel or boron carbide
Air requirement per nozzle (m^3/h)		30 – 84
Filter		RF 30/3 P/s or RF 20/2 P/s
Type		Pressure blast or air injection
Positioning accuracy of rotary table (mm)		+/- 0.5 (with indexing motor)

Date: 11/07

MT – Rotary Barrel Blast Machines

The MT rotary barrel machines are ideal for shot blasting of extremely small parts which are too small to be blasted in a tumblast machine. However, MT machines are also usable for blast cleaning of large bulky parts with weights of up to 300 kg.
Automatic loading and unloading systems enable the integration into a continuous production line.

The Inside of MT's barrel

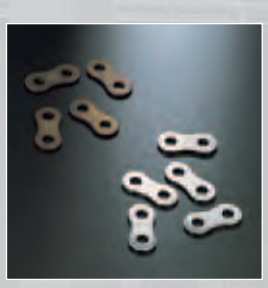


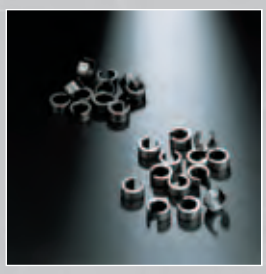
Technical data:	MT 3	MT 6B	MT 8A	MT 8HL	MT 14B	MT 22	MT 34
Barrel diameter (mm)	740	740	860	860	1,130	1,190	1,560
Perforation of barrel screens (mm)	5	5	10	10	10	10	10
Max. batch weight (kg)	200	400	720	1,000	1,180	2,000	3,000
Blast wheel (kW)	11	11	11	11	22 / 37	22 / 37	37 / 45
Machine height (mm)	3,530	3,530	5,000	5,000	5,670	6,230	6,230
Machine width (mm)	2,110	2,110	2,100	2,100	4,400	4,950	4,950
Barrel working capacity (l)	85	170	225	225	400	620	970

Date: 11/07

ST – Blast Cabinets

Pressure and pressurized injector blast cabinets are ideal for blasting a wide variety of small parts. The cabinets can be equipped with turntables, baskets, blast nozzles, pressure blasting systems, oscillators and other special auxiliary blast units.





Technical data:		ST 700 PS	ST 1000 PS	ST 1400 PS
Machine width (mm)		1,270	1,530	2,000
Machine depth (mm)		1,050	1,385	1,480
Machine height (mm)		1,640	1,900	2,000
Blasting chamber width (mm)		740	990	1,390
Blasting chamber depth (mm)		760	1,000	1,230
Blasting chamber height (mm)		490	710	810
Blasting gun	*Air nozzle ⌀ (mm)*	2.0 – 3.0	3.0 – 5.0	3.0 – 5.0
	Blasting nozzle ⌀ (mm)	6.5	9.0 – 14	9.0 – 14
	Nozzle material	ceramic / boron carbide	steel / boron carbide	steel / boron carbide
Air requirement at 5 bar/h (m^3/h)		13 – 30	30 – 84	30 – 84
Absorption area (m^2)		2.5	5	10
Exhaust power (m^3/h)		150	300	600
Fan power (kW)		0.25	0.55	0.75
Filter cleaning		automatic		

Date: 11/07

RROB Roboblaster

Applications for this amazing, high performance shot blast system with one-arm robot include deburring, shot peening, and surface cleaning of large-sized delicate components. Compared with conventional shot-blasting systems, the RROB systems offer very short time cycles with absolute process reliability and repeatability blast results.
Precise horizontal and rotary parts movement by the patented gripper provides a uniform finish and complete removal of the blast media.
RROB systems are ideal for integration into automated production lines or manufacturing cells.

RWK - Oscillating Chamber Systems

This versatile shot blast system was developed to meet high performance blast requirements, and can be used for a wide variety of applications, especially for "rotation-symmetrical" components. This dual chamber system allows for the largest possible handling space when loading and unloading parts. The advantage of this shot blast system is that parts can be safely loaded and unloaded in the open chamber, while other components are being blasted.

RDR – Tube and Bar Blasting Machines

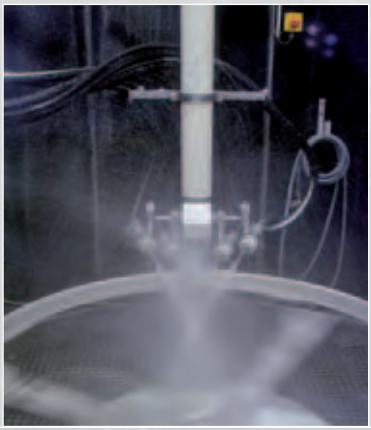
This continuous blast machine with special – skewed roller – parts transport allows the comprehensive and uniform shot blast treatment of tubes and round bars in a continuous process. Ideal for integration into a continuous production line.

Shot Peening

Shot peening is an important and essential process for improving component fatigue life in many industrial sectors, primarily in the aerospace and automotive industries. Drive components (i.e. gears) are often subjected to the shot peening process in order to induce compressive stresses, which considerably reduces the risk of fatigue cracks during their operation. The service life of many components such as gearbox components, drive and crank shafts, springs, turbine blades and turbine components in general and many others can be extended multiple times with shot peening.

Wet Blasting

The wet blasting process is used for surface improvement, cleaning, stripping and shot peening of delicate, high-precision components. The main advantages are that no dust is created, the ability to use very fine abrasives, the reduced media fragmentation due to the water film (ideal for shot peening using with glass beads) and the reduced risk of inclusions (especially on soft metal) as water has a cleaning effect. Wet blasting is also used for blast cleaning parts partially covered with grease or oil.



High Pressure Water Jet Systems

High pressure water jet systems blast with pure water at a pressure of up to 60000 psi. This water jet is projected onto the component to be treated by one or multiple nozzles mounted on a rotating nozzle holder. The rotation of the nozzle(s) generates a milling or grinding effect on the parts. This is a "soft" method to treat parts from which tenacious, very hard coatings have to be removed.

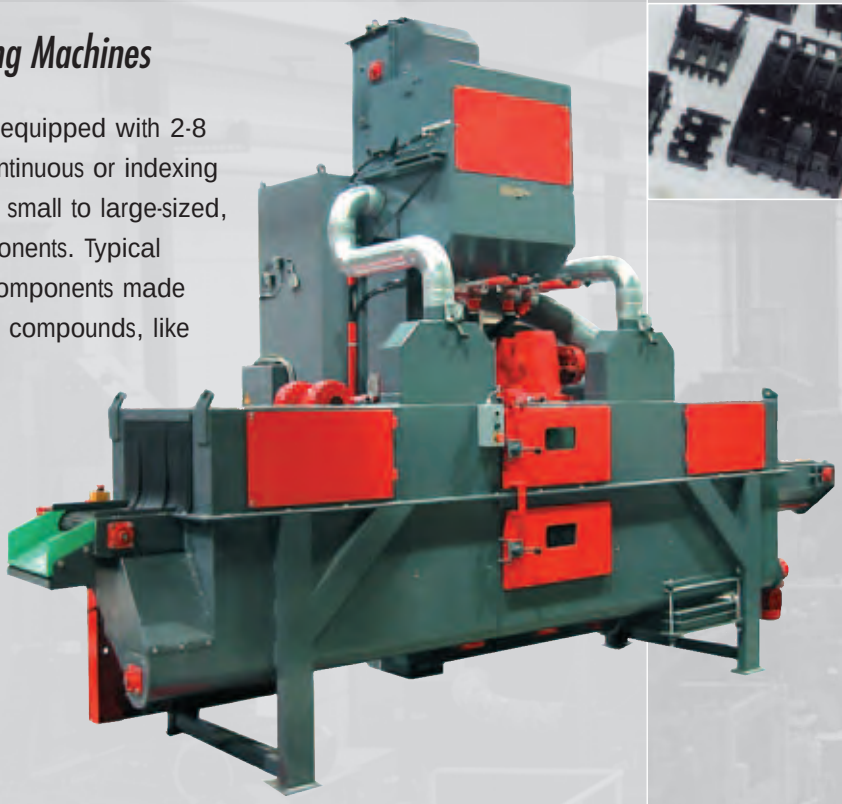
Blasting with water has many advantages like no deformations and an insignificant abrasion at the component, the process water can be re-used in the closed circuit, no subsequent cleaning of the components necessary, no abrasive wear and anticorrosives may be utilised.

This technology has many applications in different industrial sectors, like removal of thermal coatings (e.g. plasma coatings) or paint stripping of a variety of different components. Also, removal of residual slag from welding seams or removal of sand or ceramic residuals from castings.

Deflashing Machines

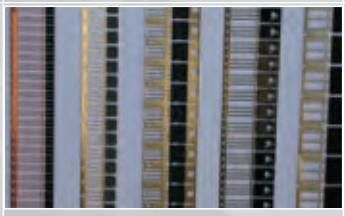
SAB – Through-Feed Deflashing Machines

The high-performance SAB series is equipped with 2-8 blast wheels and suitable for the continuous or indexing high-volume automatic deflashing of small to large-sized, especially delicate, thermoset components. Typical applications are the deflashing of components made from unsaturated polyester moulding compounds, like control panels, etc.



Deflashing of Lead Frames

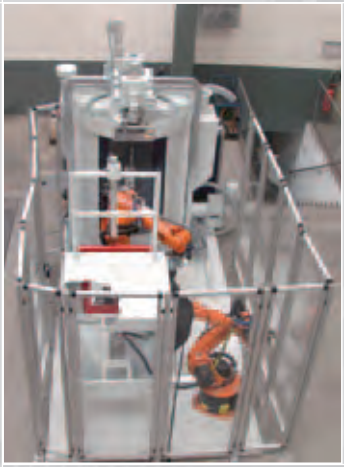
In addition to the standard range of machines, Rösler also designs and builds custom made systems for special applications, such as deflashing machines for lead frames with automatic load, unload and restack systems.



Automation

The Rösler Roboblaster RROB 350/1200-4 was designed for fully automatic de-sanding, de-burring and surface finishing of cylinder heads. A cylinder head passes through the entire finishing process in 36 seconds, of which only 10 seconds are utilized for the actual shot-blasting process.

The RMBC 8.2 tumblast machine was developed to meet the most stringent blast cleaning requirements for foundry and forge applications. This system can finish parts weighing up to 200 kg in batches of up to 800 l (max. batch weight 2000 kg).



For fully automatic surface finishing of the outer surfaces and inner channels of mid-sized components, Rösler developed the Complete-Desander (RCD). In a RWH 6/12-2 oscillating chamber shot blasting system the outer surface is treated and in a secondary air blast cabinet a robot - equipped with blast nozzles - blast cleans difficult-to-reach surfaces such as inner channels and hidden surfaces.

Modern Roller Conveyor Machines RRB 27/6 with dual-inclined blast wheel units (3 above and 3 below the blast cabin). RRB machines are usually equipped with our proven Hurricane wheels with 11, 15 or 22 kW. For special high-performance applications we offer wheels with a power of 55 kW.

Test Centers and Service

Finding a better way…a commitment to our customers

Test Centers worldwide

Throughout our worldwide organization we adhere to strict quality control procedures. This applies especially to our test centers where we develop process solutions for all kinds of surface finishing problems. Each branch of the Rösler group features its own test centre equipped with the latest Rösler finishing equipment. This equipment is utilized exclusively for processing trials with our customer's sample parts.

For Rösler service is not just an empty promise

Professional advice, short turn-around times and prompt and reliable service: Rösler offers single-source surface finishing solutions, worldwide!

- *Installation and training*
  Machine installations and operator training are performed by our team of highly skilled and experienced service engineers
- In-House Manufacturing
  In line with our corporate philosophy to be a true "single source" supplier, Rosler engineers and manufactures all equipment components like vibratory motors; load/unload systems, control panels, welding constructions, laser cut parts, etc., in-house.

- *Spare parts service for all recognized shot blast systems*
  Surface finishing equipment generally is subject to a considerable amount of wear. For this reason preventive maintenance and prompt supply of spare parts are a key requirement for any surface finishing installation. Rösler maintains a complete inventory of spare parts in every branch, ensuring local supply and fast availability, be it wire mesh belts, blast wheels, pressure vessels or any kind of nozzles, etc. To minimize downtime, parts are either delivered and installed by our own field service personnel or shipped to our customer's location overnight.
- *Maintenance and repair service*
  Rösler maintains a well trained staff of professional field service engineers providing prompt, reliable maintenance and repair service as well as overhaul of your older equipment.

Rösler Special Surface Finishing Solutions

We would like to draw your attention to other publications for special machines and processes.

Aero Engine/Airframe Preparation and Finishing

Special processes for surface treatment such as shot peening, Paint stripping, water-jet cleaning, peen forming.

Conservation Lines

Complete preservation lines with pre-heating, shotblasting system, patented painting line and dryer from a single source.

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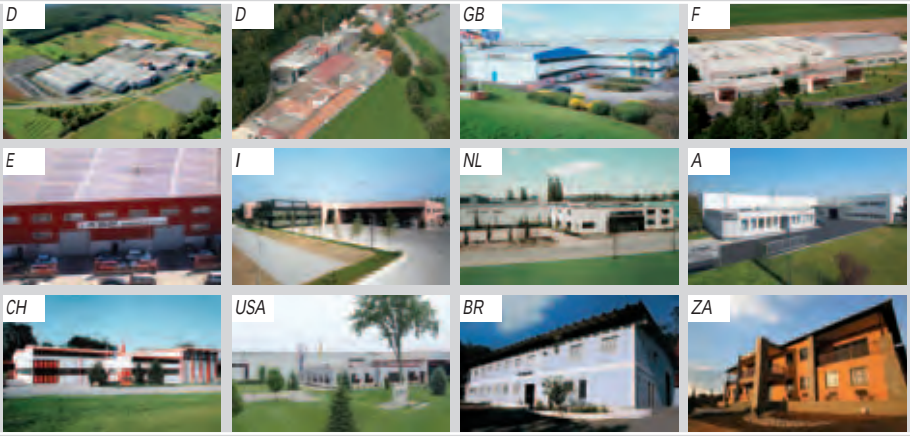

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