

VIBROBLAST

VBA-DP

VIBROBLAST
TECHNOLOGY - VBT

OUR EXPERIENCE, YOUR RESULTS





 DELTA

AUTOMATICO

ALLARMI

Ricetta
in uso

1

VIBROBLAST VBA-DP

VIBRO-BLASTING AUTOMATIC PROCESSES

RESET

RICETTE

IN CORSO

PARAMETRI

Totale tempo
impostato

min
33

sec
15

MANUALE

Totale tempo
rimanente

min
33

sec
15

IT

VIBROBLAST VBA-DP
AUTOMATIC PROCESSES
ON VALUABLE
OR DELICATE ITEMS



VIBROBLAST VBA-DP
THE ALTERNATIVE
FINISHING
NOW EXISTS

VIBROBLAST VBA-DP
COMPETITIVE
VIBRO-BLASTING
PROCESSES



| VibroBLAST AIR model | # / Ø PP . mm. | Vibr.Finishing Machine | Air cons. lt/1' (BAR) | HP cyclon | N. Nozles | Dust collector Filt.surf. m2. | Filter cleaning | Cover TOP-BLAST | PneuPORT unloading port | Control board |
|----------------------|----------------|------------------------|-----------------------|-----------|-----------|-------------------------------|-----------------|-----------------|-------------------------|---------------|
| VBA-DP-025-GM | Ø 77 | SMR-D-25-GM | 780 (6) | 1,40 | 1 | | Semi-Autom | OK - PU | - | TCS-VBA-1 |
| VBA-DP-025 | Ø 77 | SMR-D-25-GM | 780 (6) | 1,40 | 1 | | Semi-Autom. | OK - PU | - | TCS-VBA-1 |
| VBA-DP-050-TN | Ø 98 | SMR-D-50-GM | 780 (6) | 0,75 | 1 | 3 | Autom. | OK - PU | - | TCS-VBA-1 |
| VBA-DP-120-TN | Ø 98 | SMR-D-120-GM | 780 (6) | 0,75 | 1 | 3 | Autom. | OK - PU | - | TCS-VBA-2 |
| VBA-DP-220 | 125x080 | RWO-D-220-GM/Q | 780 (6) | 0,75 | 1 | 3 | Autom. | OK - Metal | - | TCS-VBA-2 |
| VBA-DP-300 | 130x190 | RWO-D-300-GM | 780 (6) | 0,75 | 1 | 3 | Autom. | OK - Metal | - | TCS-VBA-4 |
| VBA-DP-300/2 | 130x190 | RWO-D-300-GM | 1600 (6) | 0,75->2,0 | 2 | 10 | Autom. | OK - Metal | - | TCS-VBA-4 |
| VBA-DP-520 | 185x140 | RWO-D-520-GM/Q | 780 (6) | 0,75 | 1 | 3 | Autom. | OK - Metal | - | TCS-VBA-4 |
| VBA-DP-520/2 | 185x140 | RWO-D-520-GM/Q | 1600 (6) | 0,75->2,0 | 2 | 10 | Autom. | OK - Metal | - | TCS-VBA-4 |
| VBA-DP-220-PP | 125x080 | RWO-D-220-GM/Q-PP | 780 (6) | 0,75 | 1 | 3 | Autom. | OK - Metal | OK | TCS-VBA-2E |
| VBA-DP-280-PP | Ø 250 | RSC-280-PP | 780 (6) | 0,75 | 1 | 3 | Autom. | OK - Metal | OK | TCS-VBA-3E2 |
| VBA-DP-280-PP/2 | Ø 250 | RSC-280-PP | 1600 (6) | 0,75->2,0 | 2 | 3 | Autom. | OK - Metal | OK | TCS-VBA-3E2 |
| VBA-DP-300-PP | 130x190 | RWO-D-300-GM-PP | 780 (6) | 0,75 | 1 | 3 | Autom. | OK - Metal | OK | TCS-VBA-4E |
| VBA-DP-300/2-PP | 130x190 | RWO-D-300-GM-PP | 1600 (6) | 0,75->2,0 | 2 | 10 | Autom. | OK - Metal | OK | TCS-VBA-4E |
| VBA-DP-520-PP | 185x140 | RWO-D-520-GM/Q-PP | 780 (6) | 0,75 | 1 | 3 | Autom. | OK - Metal | OK | TCS-VBA-4E |
| VBA-DP-520/2-PP | 185x140 | RWO-D-520-GM/Q-PP | 1600 (6) | 0,75->2,0 | 2 | 10 | Autom. | OK - Metal | OK | TCS-VBA-4E |

| | |
|-----------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| Final Letters: -DP2 | second additional filter in the door |
| Final Letters: -WS | WS (Wear Sensor) – Techno Surface patent – to report, well in advance, that the working tank is worn and needs to be replaced or a new anti-abrasive coating |
| Final Letters: -TN | TOP-NOZZLE. STANDARD VibroBLAST machines are equipped with vertical nozzle TN (Top Nozzle) |
| Final Letters: -SN | SIDE-NOZZLE nozzle positioned laterally |
| Final letters: -SM | Mainboard SIEMENS instead of standard Mainboard (Delta) |
| Final letters: -EX | The basic vacuum filter is replaced by filter with characteristics similar to an Int. Zone 22 - 24.000 cm2 filtering surface; |
| Final letter: - EXS | As -EX with automatic shaking of filter cartridges in counter-current of compressed air - complete with microprocessor for programming cleaning intervals -90.000 cm2 filtering surface; Industrial vacuum cleaner 0,75KW |
| Final letter: - EXS2 | As -EX with automatic shaking of filter cartridges in counter-current of compressed air - complete with microprocessor for programming cleaning intervals -90.000 cm2 filtering surface; Industrial vacuum cleaner 2,2KW |
| Final Letters: - EXS2L | like -EX2; L= low (rotary motor plus motorization placed below for easy maintenance) |
| ATEX note | Our dust collector filters, unlike dust collector suction filters (AMD or PCCP versions), do not have the ATEX certification, even though they are built with the same characteristics - we are anyhow waiting for certifications even for dust collectors by 2020. |
| Final Letters: - 7 or - 15 | The standard touch panel, or HMI, is 4.3" - where required, a larger 7" or 15" HMI can be mounted - in the case of a cabin, it is mounted on the external operator side. |
| Final letters: CE-UL | The systems supplied in the USA and Canada are CE certified according to the European directive, but are completed with ELECTRICAL PANELS and appendices (sensors, connected devices) made with UL components and, as a whole, complete with UL CERTIFICATION. |
| Final letters: - AS | Antistatic system for polymers |
| Final letters: -AM | AM cabin - with 7 doors and related RFID sensors - On the operator side of the cabin, provision is made for combination with the same HMI (Touch Screen panel) provided on the machine |

Priority/STANDARD solution

It will be ensured STANDARD execution priority for all VibroBLAST with vertical nozzle TN (Top Nozzle)

Exception/ON DEMAND solution

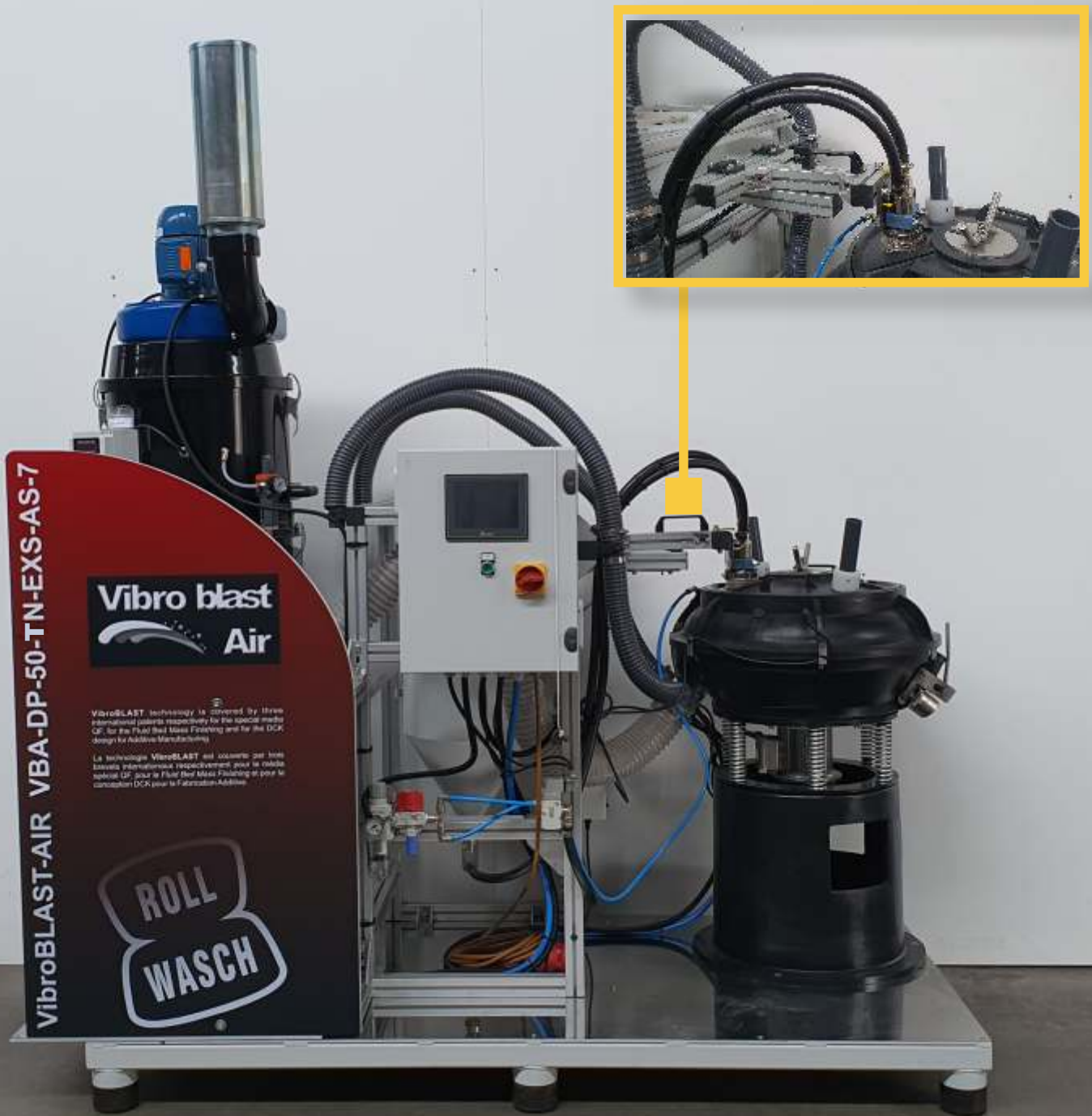
Given some qualitative results obtained in specific domains (micromechanics), it is not excluded to apply the solution with lateral nozzle SN (Side Nozzle) to all clients who will demand it or where it is priority to treat pieces with a certain delicacy.

Hence, starting from April 2024, the updated version of VIBROBLAST AIR DP catalogue will present in composition acronyms both TN and SN versions, but it is intended that TN will be the STANDARD one.

VIBROBLAST

VBA-DP

ROLL
WASCH



This machine is based on a circular 50-liter-capacity vibrator with tank in PU and lid, a depression sandblasting unit with cyclone and filter cabinet, a control panel with inverter, PLC and touch screen, a sand drain filter on the tank bottom. On the lid of the machine there is an air inlet snorkel, the blasting nozzle is placed on the cover «TN» (acronym of Top Nozzle). Finished pieces can be unloaded from a total unloading door (if they are small) or taken from the top.

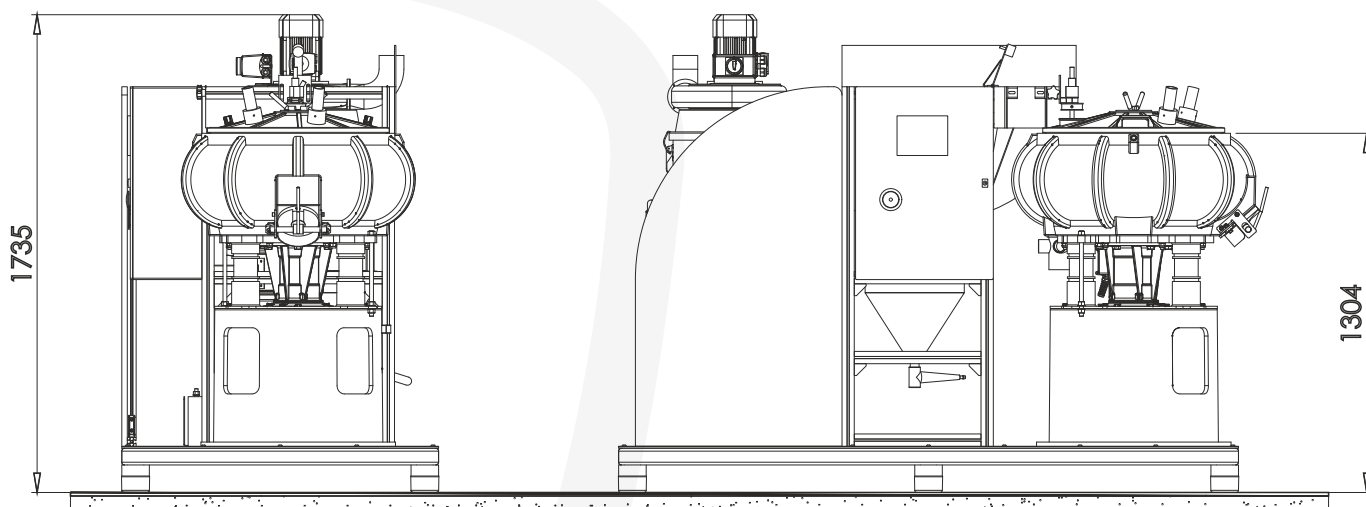


VIBROBLAST

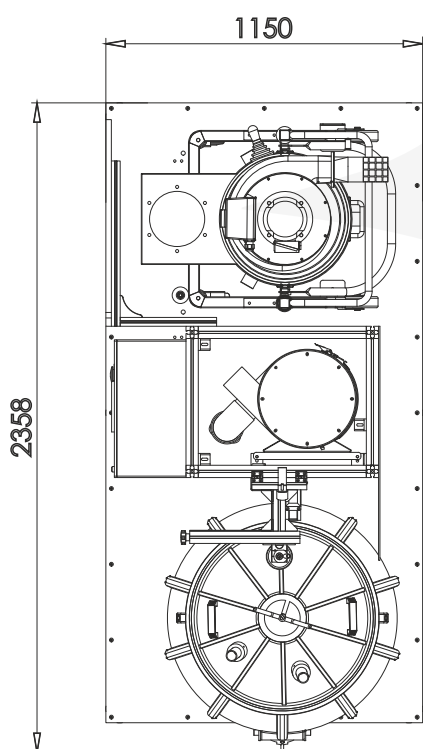
VBA-DP



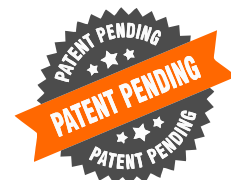
The **VibroBLAST Air DP** line is designed and manufactured to be supplied on a technological pallet, to make its installation immediate through a simple **plug-&-play** operation. It is enough to connect air (6 Bar) and the Euro socket to the line and the machine can start working as it was programmed during the try-out phase before shipment. We take particular care of manufacturing quality, safety and ergonomics.



VibroBLAST AIR [DP] VBA-DP-120-EX-X-TN



VibroBLAST AIR [DP] VBA-DP-50-EX-X-TN
2000x1000x1731h mm



All **VibroBLAST Air DP** systems are designed to ensure maximum ergonomics, functionality and safety of use. Machine dimensions do not exceed those of its technological pallet that supports the entire system configuration.

The connection during installation phase is limited to air and electricity, while, with regard to the upper exhaust manifold of the aspirator, it will be possible to convey the air outside through a fixed or flexible pipe (at customer's charge). Alternatively and according to local regulations, we can propose suction devices with an absolute filter that do not require connection to the outside.



VIBROBLAST

VBA-DP

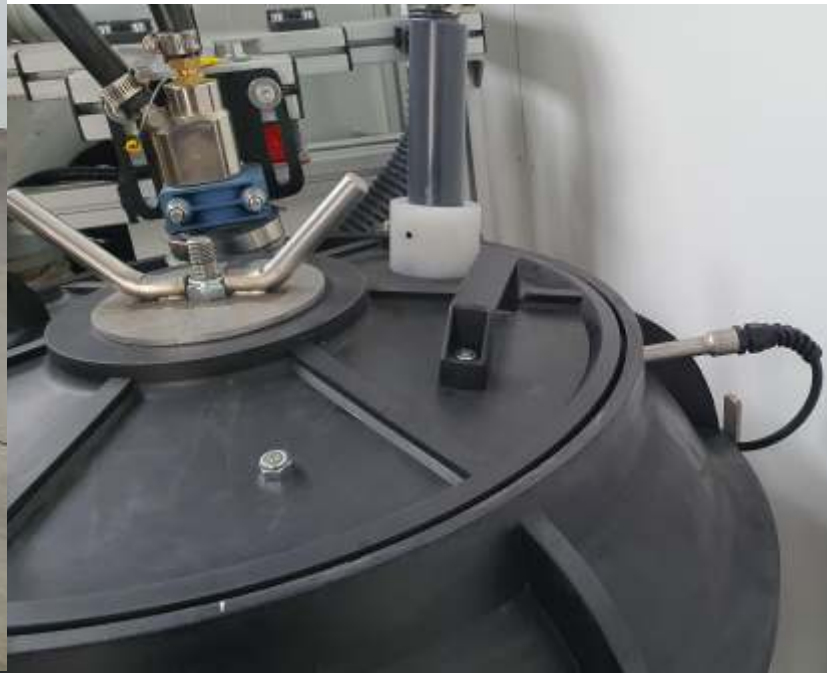


This machine with suction filter in **ATEX** version is based on a circular 50-liter-capacity vibrator with tank in PU and lid, a depression sandblasting unit with cyclone and filter cabinet, a control panel with inverter, PLC and touch screen, a sand drain filter on the tank bottom. On the lid of the machine there are two air inlet snorkel, while the blasting nozzle is placed on the cover (**TN – Top Nozzle**). Finished pieces can be unloaded from a total unloading door (if they are small) or taken from the top.

VIBROBLAST

VBA-DP

ROLL
WASCH



The **VibroBLAST Air DP** line in the above picture with suction filter in ATEX version is designed and manufactured to be supplied on a technological pallet, to make its installation immediate through a simple plug-&-play operation.

It is enough to connect air (6 Bar) and the Euro socket to the line and the machine can start working as it was programmed during the try-out phase before shipment.

We take particular care of manufacturing quality, safety and ergonomics.



VIBROBLAST

VBA-DP



VIBROBLAST

VBA-DP

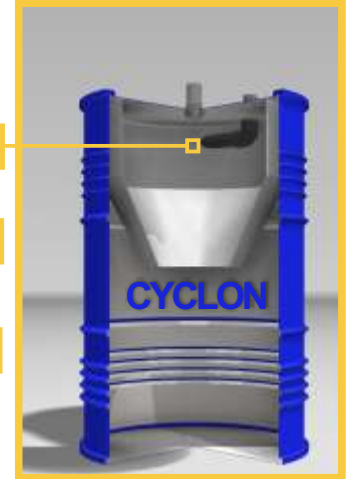


VBA-DP-025-GM



VBA-DP-025

VibroBLAST AIR [DP] VBA-DP-025 & VBA-DP-025-GM



Entry level version designed to process small batches and for discontinuous use. This version is also available with an optional soundproof cabinet for the suction unit [3]. Available both in the professional version (pictures above) and in the «GM» basic version.

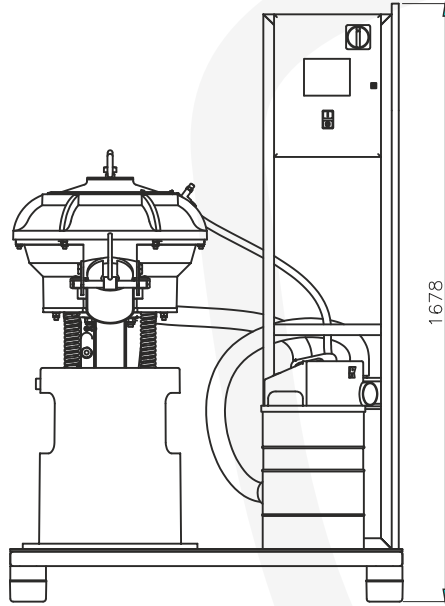
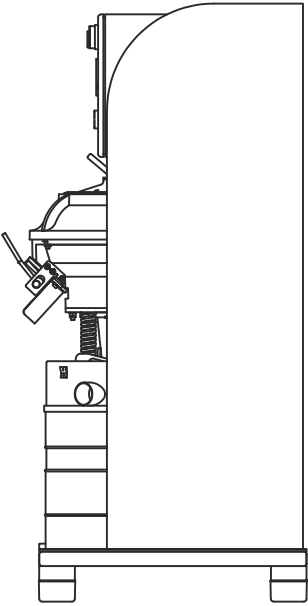
Technical features:

[1] Cover closed sensor; [2] Blasting gun with air and sand inlet; [3] Optional soundproofing cabinet; [4/6] Cyclon in small size, to recover and recycle blasting media; [5] Powerfull suction unit of 1,4 Kw; [7] VibroBLAST VBA-DP-025 completed with a soundproof cabin for the suction unit (optional).

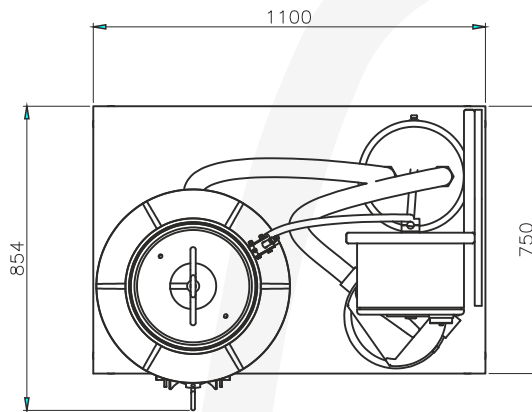
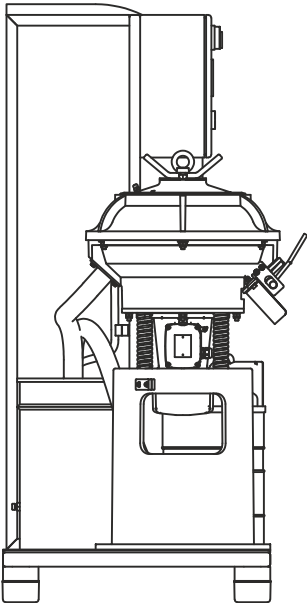


VIBROBLAST

VBA-DP

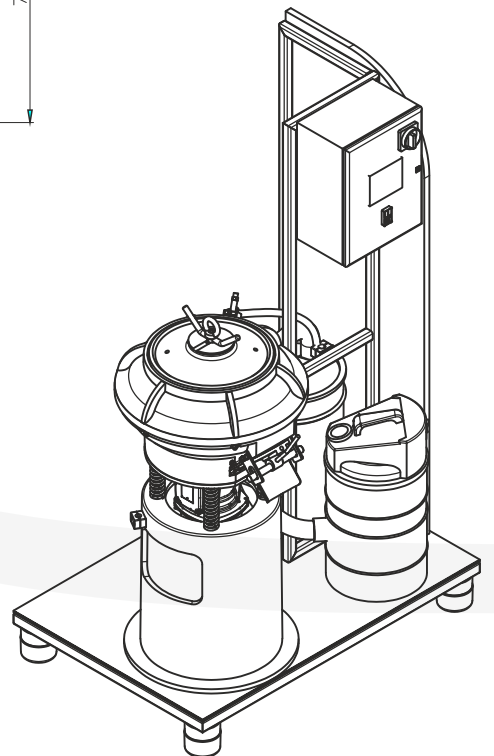


1678



1100

854



VibroBLAST AIR [DP] VBA-DP-025



The **VibroBLAST Air DP** line is composed of medium-large models too, as for example the model **VBA-DP-520/2-PP**. This machine is based on a circular 520-liter-capacity vibrator with PU tank and steel lid, a depression sandblasting unit with cyclone and filter cabinet, a control panel with inverter, PLC and touch screen, a sand drain filter on the tank bottom. In the lid of the machine there are **two (2) sandblasting nozzles** and two air inlet snorkels. Finished pieces can be unloaded through the pneumatic door on the tank bottom.

The 3D render is represented only as an indication and not exhaustive of the project, which will undergo some updates in the course of 2021.



VIBROBLAST

VBA-DP

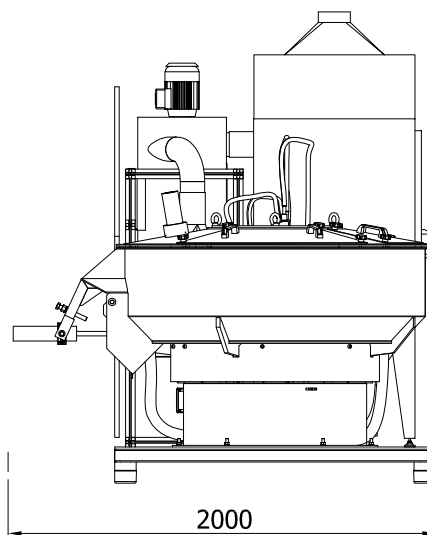
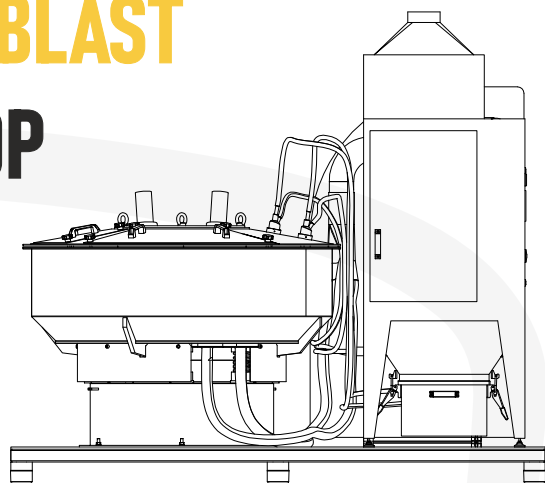


The **VibroBLAST Air DP** line is designed and manufactured to be supplied on a technological pallet, to make its installation immediate through a simple plug-&-play operation. It is enough to connect air (6 Atmospheres) and the Euro socket to the line, and the machine can start working as it was programmed during the try-out phase before shipment. We take particular care of manufacturing quality, safety and ergonomics. Under the pneumatic unloading door there can be a conveyor belt to automate the “end cycle” phase.

The 3D render is represented only as an indication and not exhaustive of the project, which will undergo some updates in the course of 2021.

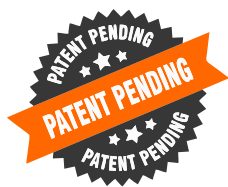
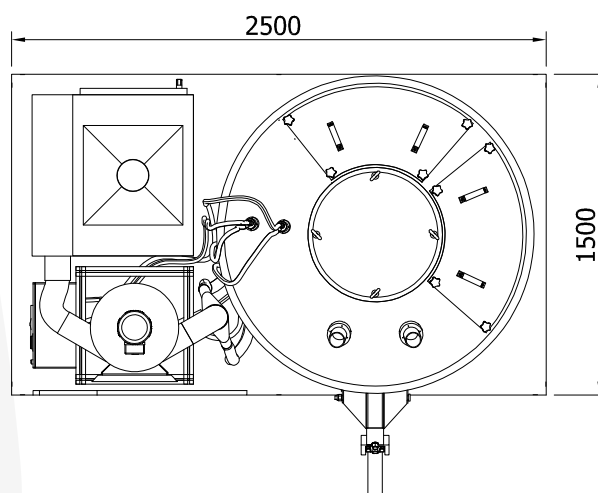
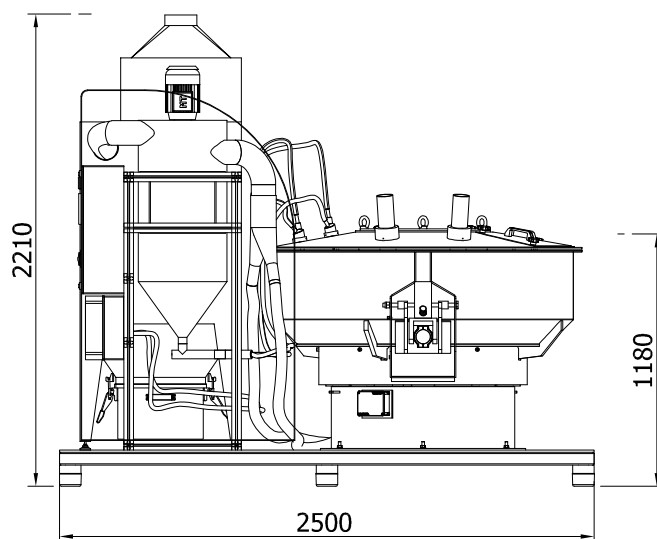
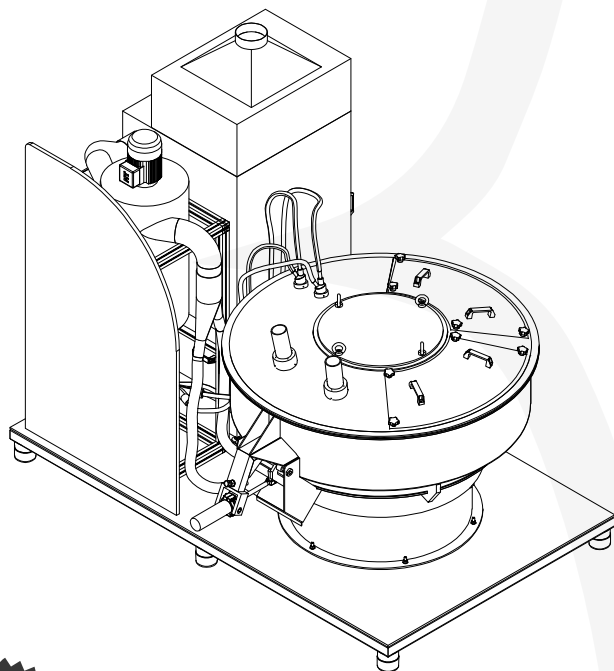
VIBROBLAST

VBA-DP



ROLL
WASCH

VibroBLAST AIR [DP] VBA-DP-520/2-PP



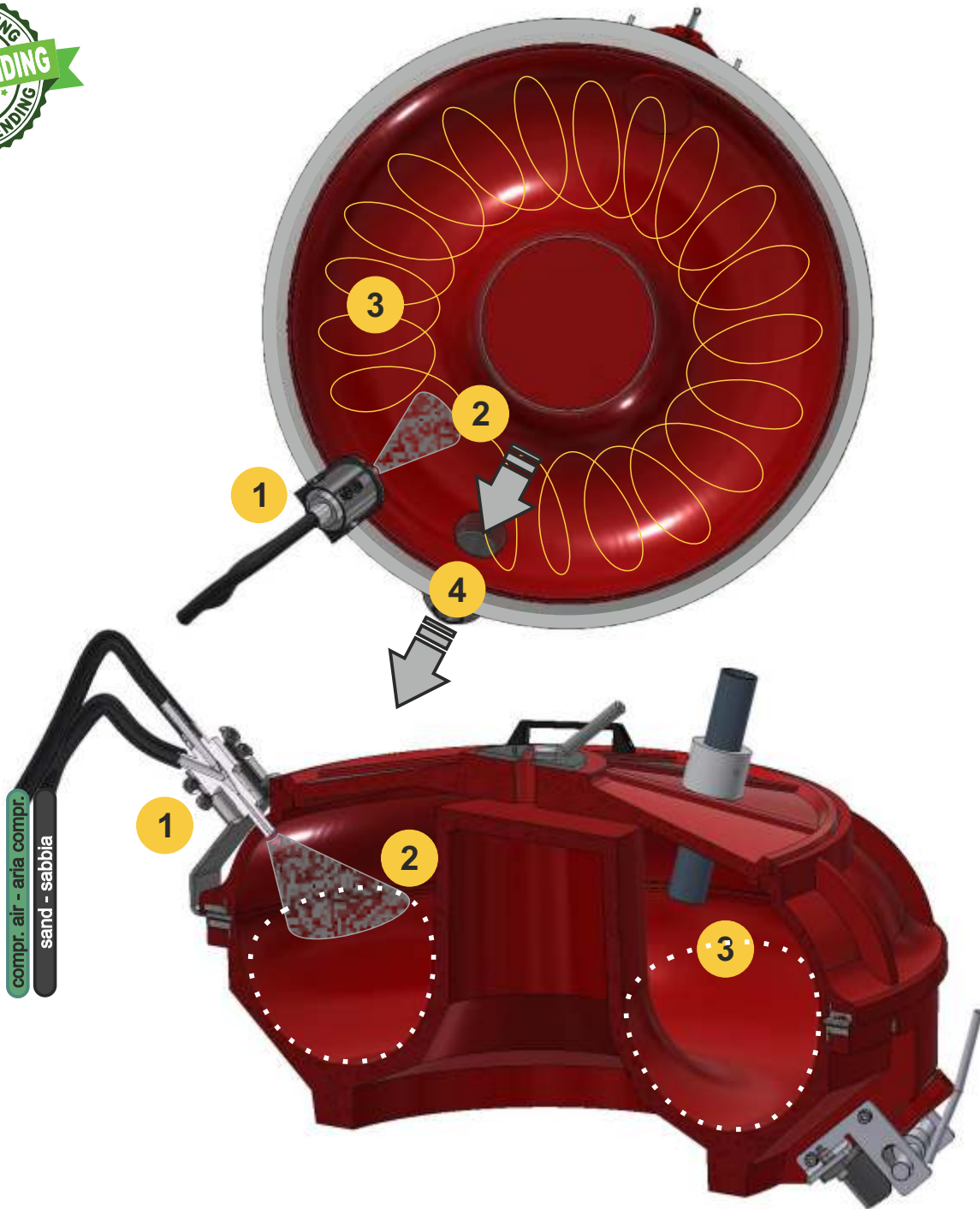
All **VibroBLAST Air DP** systems are designed to ensure maximum ergonomics, functionality and safety of use. Machine dimensions do not exceed those of its technological pallet that supports the entire system configuration.

The connection during installation phase is limited to air and electricity, while, with regard to the upper exhaust manifold of the aspirator, it will be possible to convey the air outside through a fixed or flexible pipe (at customer's charge). Alternatively and according to local regulations, we can propose aspiration devices with an absolute filter that do not require connections to the outside.



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All **VibroBLAST Air DP** systems have the **SN (Side Nozzle)** sandblasting nozzle placed in the upper area of the corolla, to involve the treated components from above, while they rotate three-dimensionally, clockwise, inside the circular vibro-blasting bowl.

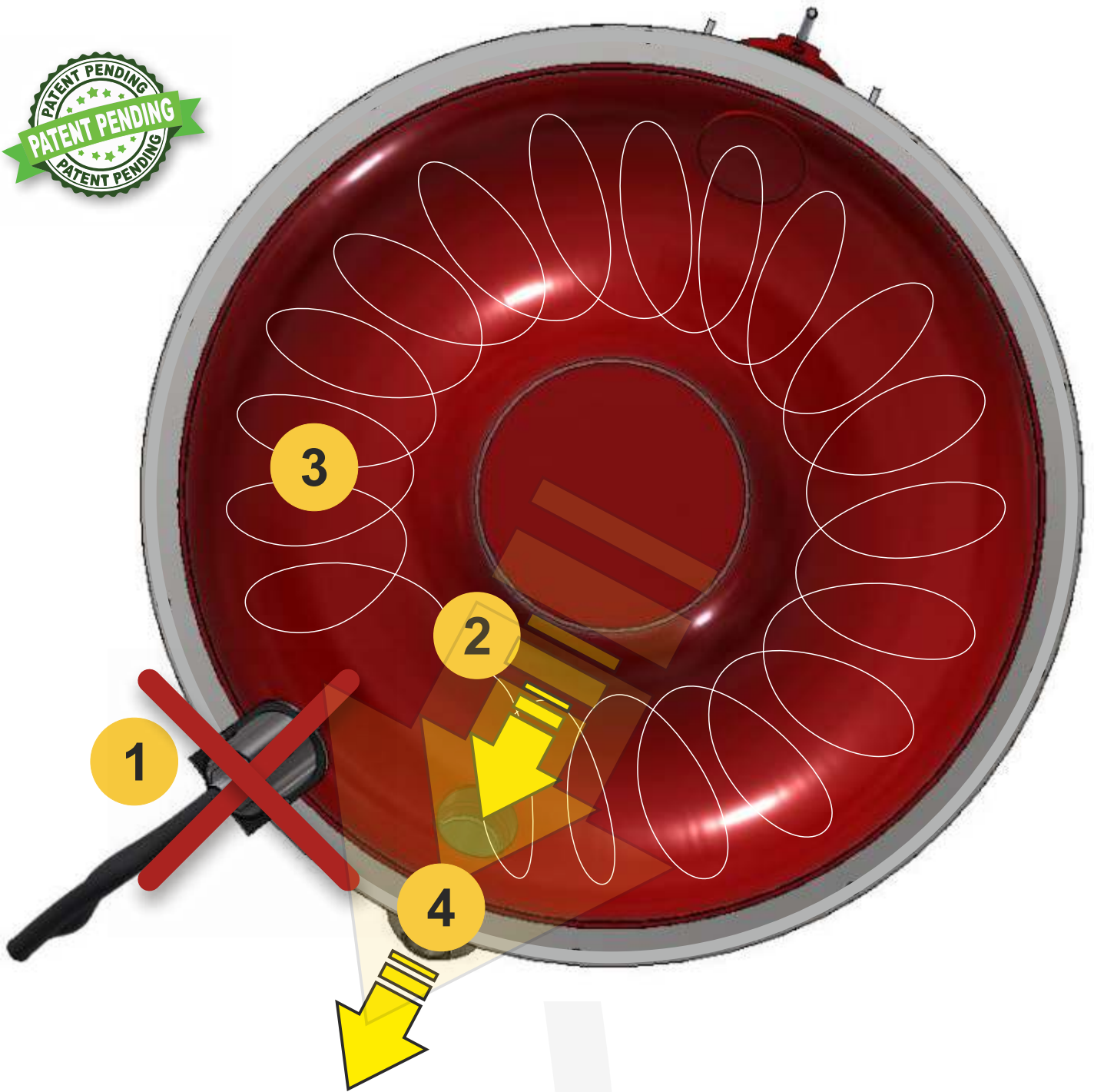
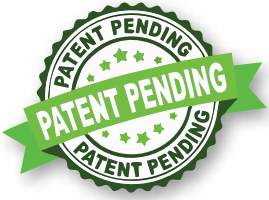
At the apex of the corolla we therefore have the nozzle [1] with shot angle adjustment [2], placed above the mass being processed [3].

The sandblasting grit, before being discharged from the evacuation filter [4], completes almost 360 ° degrees in the vibratory bowl, involving the pieces both by shot and by vibration in a sort of «fluid bed mass finishing» dynamic.

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All **VibroBLAST Air DP** systems are equipped with control panel with touch screen human-machine interface (HMI) and a software suitable to manage process variables such as times and vibratory frequencies of the various cycle phases (and many other programmable parameters). A typical phase of vibro-blasting cycles is the final suction. Once the sandblasting phase is complete, the jet stops while the suction continues for a programmable time in order to remove the residual abrasives.



VIBROBLAST

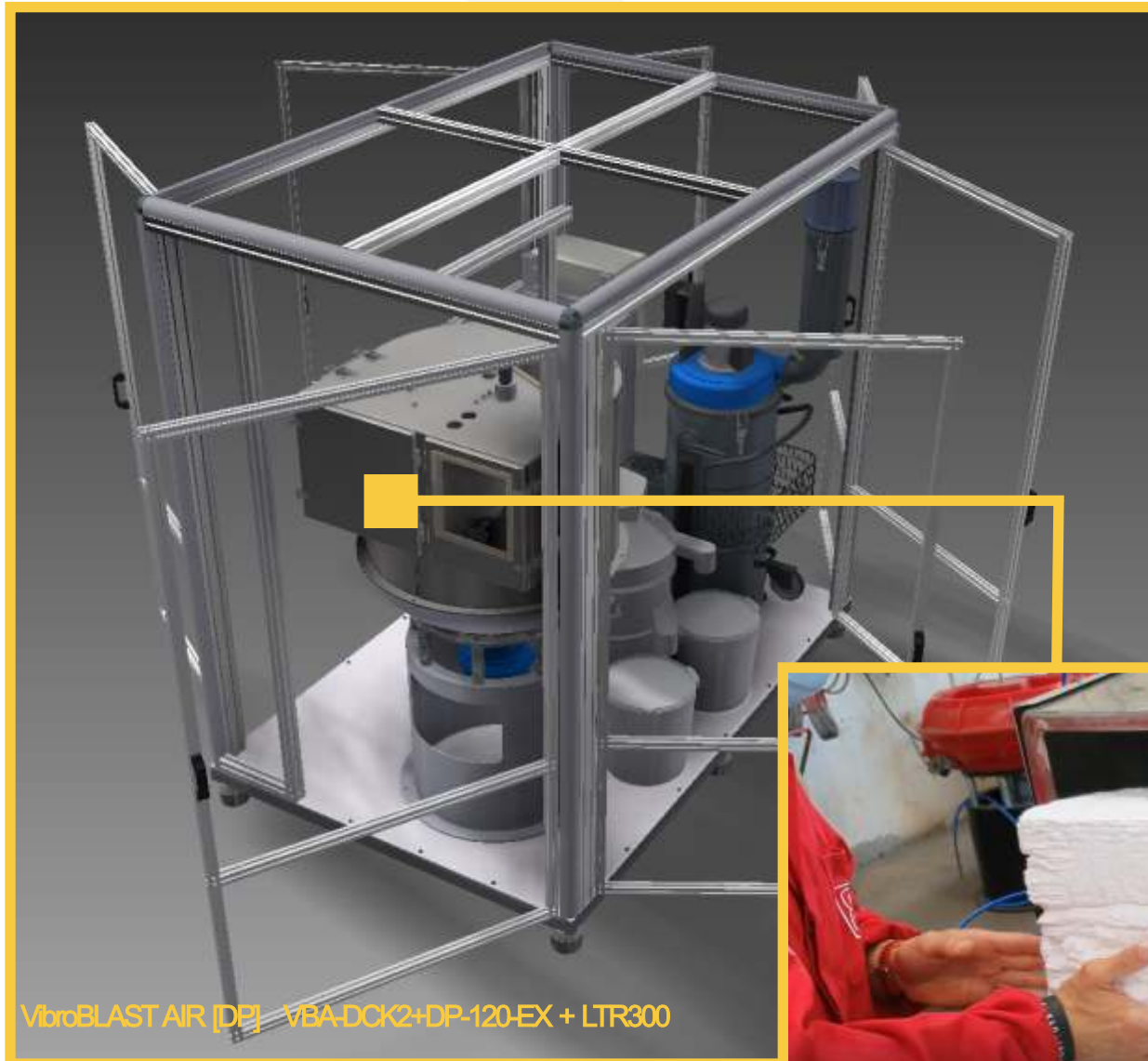
VBA-DP



The operating dynamics with the **VibroBLAST-VBA-DP** - depressure version - machines are quite simple:
[1] With the machine stopped and the lid open, the workpieces are loaded (if the media are already in the tank) or the media and the pieces to be processed are loaded.

[2] Once the working tank is loaded, the lid, which is equipped with a safety sensor, can be closed - without the lid closed, sandblasting task is inhibited.

[3] With the lid closed, the safety conditions exist for the machine to operate, so the first phase of the vibro-blasting process begins, while in the second phase only the vibration and suction remain active for the programmed time.

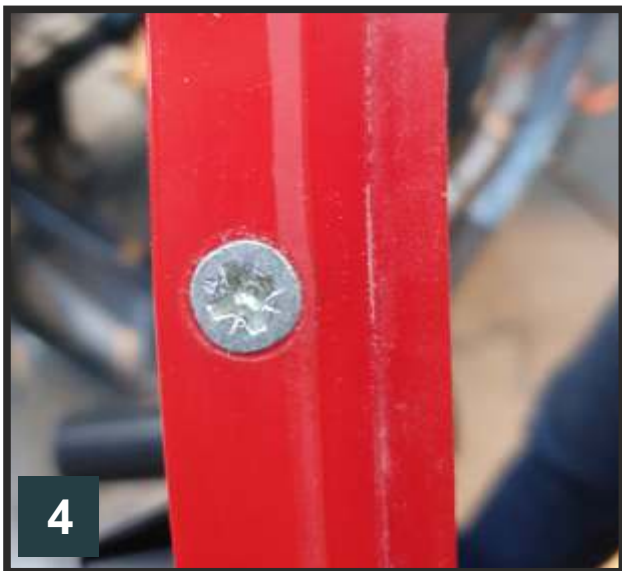
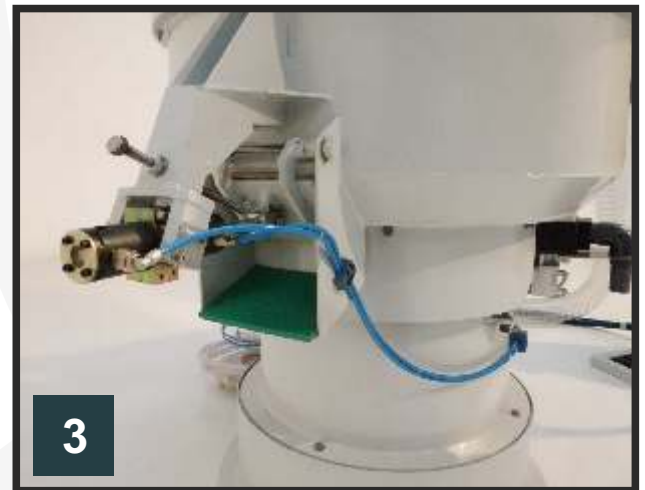


VibroBLAST AIR [DP] VBA-DCK2+DP-120-EX + LTR300

The **VibroBLAST Air [DP] DCK** line of machines, is designed to assure a wide **MULTITASKING** process suitable for **POST-PROCESS** after **SLS** Selective Laser Sintering machines.

Starting from a **SLS cake** before the un-packing or de-caking operation, normally made by hand and followed by hand or rotary barrel blasting, the new range of machines **VibroBLAST Air [DP] DCK** can automatically provide:

1. un-packing or de-caking
2. additive powder recover and automatic vibro-selection with possible option of ultrasonics, for top efficiency
3. vibro-blasting of the sintered components afterwards
4. if required, additional smoothing of the components

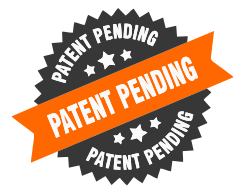
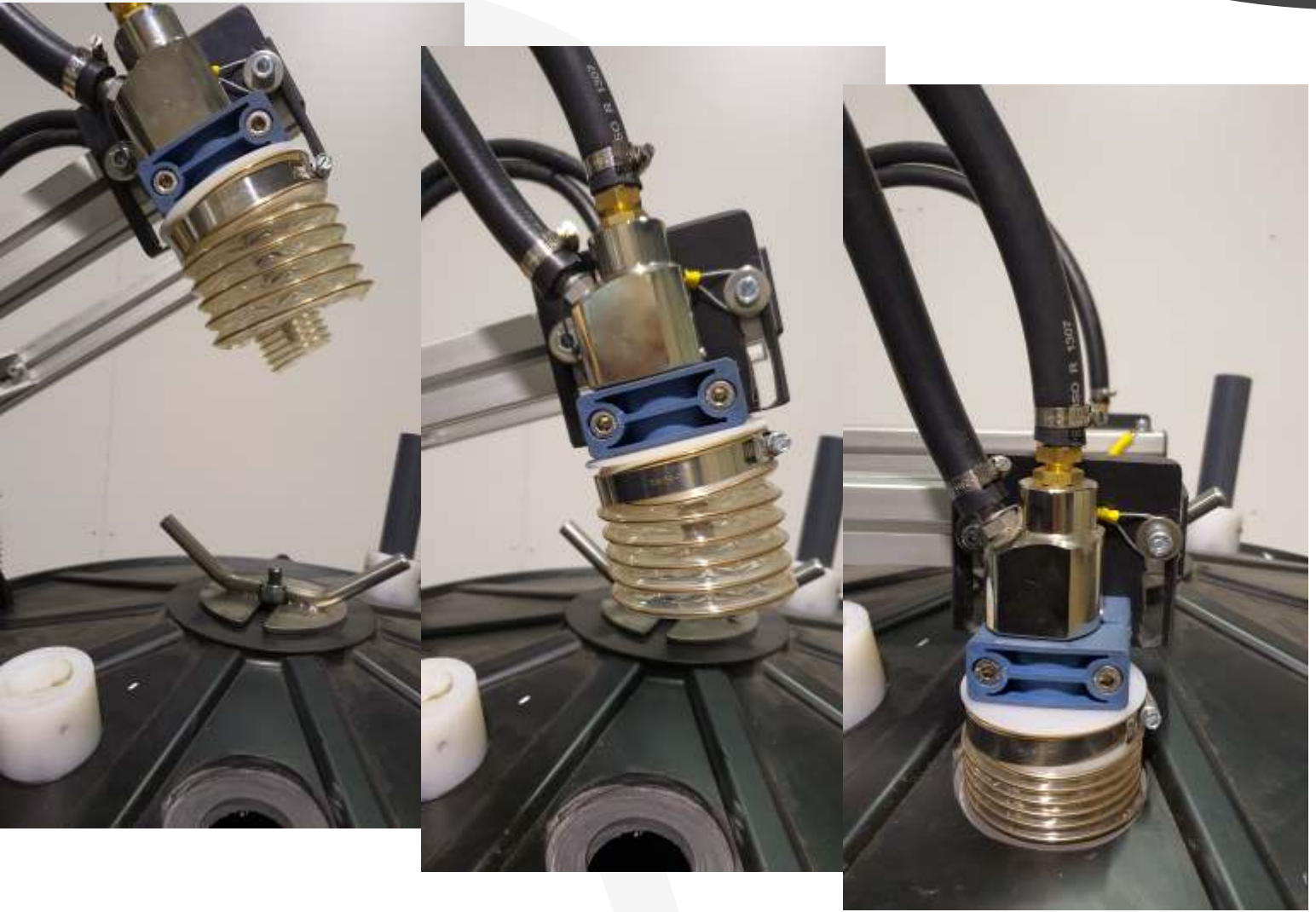


Rollwasch® informs that the choice of **VibroBLAST AIR DP** systems cannot be accidental and must be guided by a careful risk analysis. **Rollwasch®** offers two important alternative solutions: on the one hand **VBA -...- EX** vacuum cleaners built with criteria similar to the **internal ATEX Zone 22** standards (in the certification phase by 2021) and on the other standard **VBA** aspirator filters with automatic cleaning. Some examples of components of the **VibroBLAST Air** line: [1] Mainboard with HMI Touch Screen Delta (Siemens on request); [2] Vacuum cleaner **VBA -...- EX**; [3] pneumatic unloading port; [4] Bowl lid with metal striker compatible with the lid closing sensor.

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The VibroBLAST Air DP system includes one tilting bar to support the sandblasting nozzle. In this representation the bar is raised, an operation performed manually by the operator only at the end of the work cycle - in this case the safety interlock releases the constraint to be able to tip over the bar upwards. The operator will thus be able to open the access cover to the work tank and start it where required for loading and unloading operations, without the risk to activate the sandblasting nozzle – it is in fact inhibited by the interlock sensor.

Once the cover is closed and the bar is lowered with the interlock active, the sandblasting nozzle can be activated in complete safety - there is a protective bellow around the cover upper hole;



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