



AM-Deburring



**Surface treatment
and machine solutions**

Blasting

DANISH
PRODUCED



Blast-Line 5.0 1000

In the program we offer 2 types in connection with blowing off surfaces

The injector type, which is used for cleaning plastic parts directly after printing, where you want to remove excess printing material.

Used subsequently for surface smoothing before final surface treatment.

Pressure blowing used for finishing all types of 3D printed parts. 5-10 times faster than injector blowing. Typically used where the process is required to be fast, while optimising the process itself.

The blowing cabinets are supplied with various equipment related to the handling of AM printed parts, which minimizes post-processing while optimizing and automating the process.

- Round table solutions
- Drum solutions, fixed or in doorway
- Microblowing
- Quick change of media

Blast media:

The blowing medium is usually either corundum or glass beads for surface blasting. For special applications, ceramic beads or iron-free products are also used as blowing media.



Brown fused alumina consists almost entirely of aluminium oxide and is almost iron-free. Brown fused alumina is less pure than white fused alumina. The special composition of this angular mineral makes it extremely stable. It is also both hard and tough. Brown fused alumina is primarily used as a blasting medium and in floorings.

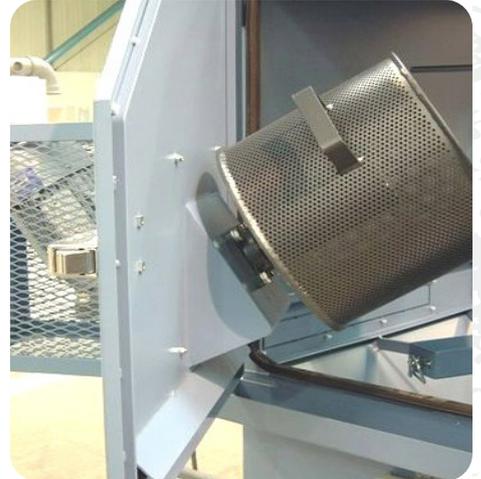


White fused alumina is a highly pure form of aluminium oxide which is suitable for use with stainless steel and aluminium. This iron-free, reusable blasting medium is angular, brittle and hard. It has a powerful abrasive effect on the surface being blasted.



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Blasting



Blast-Line:

The SL/SD or P/PD models are available as standard cabinets with free-standing filter units or as compact units with cyclone. All machines are extra grounded to minimize static electricity that can occur during use.

The cabinets can all carry up to 350 kg on the blower table. The SL/SD versions are fitted with DM nozzle holders to suit nozzle sizes from 3 to 9 mm nozzles.

| Model Type | Inside Measurement LxBxH i mm | Outside Measurement LxBxH i mm |
|----------------|-------------------------------|--------------------------------|
| Front door | | |
| 5.0-800SL/P | 750x520x660 | 950x680x1.660 |
| 5.0-1.000SL/P | 950x720x760 | 1.150x880x1.760 |
| 5.0-1.200SL/P | 1.150x920x860 | 1.350x1.080x1.860 |
| 5.0-1.400SL/P | 1.350x1.120x960 | 1.550x1.280x1.960 |
| Side Door | | |
| 5.0-1.100SD/PD | 1.100x800x840 | 1.220x1.340x1.990 |
| 5.0-1.350SD/PD | 1.350x1.100x1.070 | 1.470x1.700x2.140 |



Glass beads are a spherical, iron-free blasting medium which is suitable for use with stainless steel and aluminium. The round shape of the product makes it ideal for non-aggressive cleaning and for producing visually attractive surfaces. Micro glass beads are one of the most common reusable blasting media and are used all over the world.



Ceramic beads are made from an extremely tough zirconium oxide ceramic. They are iron-free and are therefore suitable for use with stainless steel and aluminium. The round shape of the ceramic beads means that they can be used for non-aggressive cleaning and for producing visually attractive surfaces. This blasting medium has a very long service life when compared with glass beads. **Ceramic beads are a high-tech blasting medium that meets the very highest standards.**

Nutshell granules are an organic blasting medium made from crushed walnut shells. Nutshells are soft, angular and ideally suited for non-aggressive cleaning of particularly sensitive areas. This blasting medium also burns leaving no residues when heat is applied to it.

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Turbo-Line 5.0 1000B



Turbo-Line 5.0 1400S



Turbo-Line 5.0 500

Compared to vibratory finishing vibrators, their grinding performance is up to 10 times higher, i.e. the centrifugal units deburr/polish approx. 10 times faster than round vibrators, and these machines are also extremely quiet. These machines are perfectly suited for mass-produced workpieces, although the parts must not be too large.

TURBO-LINE.:

| Model Type | Diameter mm. | Weight kg. | Power kW | Effect | Coating mm. | Measurement mm. |
|------------|--------------|------------|----------|--------|-------------|-------------------|
| 5.0-500 | 480 | 300 | 2.2 | 50-180 | 22 | 1.000 x 850x1.250 |
| 5.0-1000S | 550 | 680 | 2.2 | 50-180 | 25 | 1.400x1.000x1.950 |
| 5.0-1400S | 660 | 890 | 4.0 | 50-180 | 30 | 1.700x1.000x2.200 |



Consumables media:

Whether you are talking about 3D plastic or metal printed parts, you will be able to use different abrasive media to achieve a perfect surface. In the Turbo or Vibra-Line machines, plastic or ceramic bonded abrasives are usually used



Ceramic for metal:

Ceramic media, shaped as a triangle straight or as oblique cut is used as universal consumables for surface deburring of metal alloys. Can also be used on plastic printed parts if the part design allows this. (Density 2,5-3,5)

Size depends on machine type and material type. Normally sizes from 5x5 up to 15x18 mm will be used. Grinding effect (Coarseness of the sandpaper) Editions from very coarse grinding down to fine polishing



Special media:

In connection with special surfaces we have many other special process media in the program.

- Dry granules, corn walnut shells etc.
- Zirconium oxide and porcelain media.
- 3 Y media



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Vibra-Line 5.0 3000



Vibra-Trough 5.0 1450

Trough vibrators are usually used when the size of the workpieces exceeds the application possibilities of large round vibrators. The chamber-shaped design allows several large parts to be processed simultaneously without contact.

Sensitive workpieces are either fixed in special clamping devices or loosely processed in separate separation chambers. In this way, damage to the workpieces during processing is ruled out.

VIBRA-LINE.:

| Model Type | Diameter mm | Weight kg | Power kW | Effect | Coating mm | Measurement mm. |
|------------|-------------|-----------|----------|-----------|------------|-----------------|
| 5.0-800M | 800/260 | 105 | 1.5 | 1.500/650 | 24 | Ø 800x1.200 |
| 5.0-1500M | 1.200/180 | 650 | 2.2 | 1.500/650 | 22 | Ø 1.300x1.250 |
| 5.0-3000M | 1.400/225 | 725 | 4.0 | 1.500/650 | 26 | Ø 1.450x1.400 |
| 5.0-1450T | 550xØ500 | 390 | 1.5 | 1.500/650 | 30 | 1.000x900x1.300 |

Compound:

To keep both the workpiece and the grindstone surface clean, compound is used in the liquid phase.

Many use the water in a closed system, where the compound is added automatically when the water is filled.

If a closed system is not used, cleaning can be run as needed. May not want to mix 3D printed parts that are inked. In this case it is advantageous to add compound as system cleaner.

The same applies with 3D printed metal alloys, where you do not want metal mixing.

Compound products that are used:

VM 1040 S in combination with machine types like Vibra-Line

VM 1040 TS-K in connection with machine types Turbo-Line



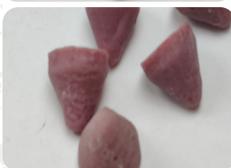
Plastic:

Cone or pyramid shape is typically what is used. Used for both grinding and polishing of 3D printed surfaces. Can be used on all plastic and metal surfaces.

Typical types used.

10-15 mm plastic cones for gentle deburring of plastic materials such as SLS .

The plastic media is also used for fine grinding of both stainless and titanium printed surfaces. Leaves the surfaces in polished finish with a low surface roughness (specific gravity 1,6-2,1)



Ovens

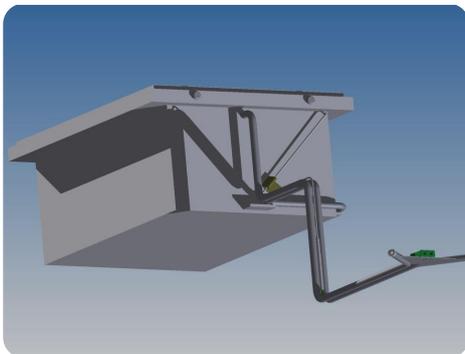


Chamber furnace for heat treatment of 3D printed parts produced by additive manufacturing technology, ensuring correct metallurgical properties of metal alloys. Type of material treated: high-strength steel, stainless steel, cobalt-chromium. Metal components, nickel and cobalt-chromium alloys produced using AM technology are treated in a protective atmosphere at a maximum temperature of 850 °C. SNOL 1100G furnaces up to 1100 °C are suitable for thermal treatment of metals, e.g. annealing, solution heat treatment, soft annealing, tempering and quenching.

The standard furnace equipped with protective unit, can be used with automatic gas supply system of protective atmosphere during the heating process in the box.

SNOL-Oven.:

| Model Type. | Liter L. | Operating temperature | Chamber material.kW. | Effekt mm. | Gasbox dim. LxBxH | Chamber dim. mm. LxBxH | Outside dim. mm. LxBxH |
|-------------|----------|-----------------------|----------------------|------------|-------------------|------------------------|------------------------|
| 50-1150G | 50 | 50-1.100 | Brick/fiber | 10 | 100x100x150 | 150x150x150 | 500x600x900 |
| 145-1150G | 150 | 50-1.100 | Brick/fiber | 18 | 200x200x150 | 300x300x250 | 650x700x900 |
| 274-1150G | 274 | 50-1.100 | Brick/fiber | 30 | 500x500x500 | 650x650x650 | 1.200x1.500x1.600 |



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Ovens



Economical low temperature ovens are designed for thermal treatments such as drying, heating, thermal tests, ageing and similar purposes in a natural air flow environment up to 350°C. Good technical parameters guarantee high-quality results.

These ovens can be used in scientific laboratories, educational institutions, medicine and industry.

Cleaning

Clean-Line Optimal water-based cleaning of AM printed surfaces

Clean-Line ultrasonic cleaning tank provides optimal cleaning of both plastic and metal AM manufactured parts. The ultrasonic cleans and loosens particles right down to the pores. This leaves the parts completely free of dust and particles from the previous process / operation. Clean-Line 270U and larger can be supplied with circulation pump and integrated filter system to retain fine particles from the fluid.

Clean-Line ultrasonic systems are supplied up to 2500 ltr capacity as single stage up to 7 stage systems.

| Model Type. | Liter L. | Operating temperature | Heating effekt W. | Ultrasonic effekt W. | Basket dim. mm. LxBxH | Chamber dim. mm. LxBxH | Outside dim. mm. LxBxH |
|-------------|----------|-----------------------|-------------------|----------------------|-----------------------|------------------------|------------------------|
| 5.0-15U | 15 | 10-60 | 500 | 600 | 250x150x125 | 300x175x150 | 400x300x300 |
| 5.0-30U | 30 | 10-60 | 800 | 750 | 300x400x250 | 300x200x300 | 600x400x250 |
| 5.0-270U | 270 | 10-60 | 2.700 | 2.500 | 600x400x400 | 800x500x600 | 1.200x1.000x900 |
| 5.0-480U | 480 | 10-60 | 3.500 | 3.500 | 1.000x600x600 | 900x700x700 | 1.400x1.200x1.200 |



Clean-Line 5.0 480 L.

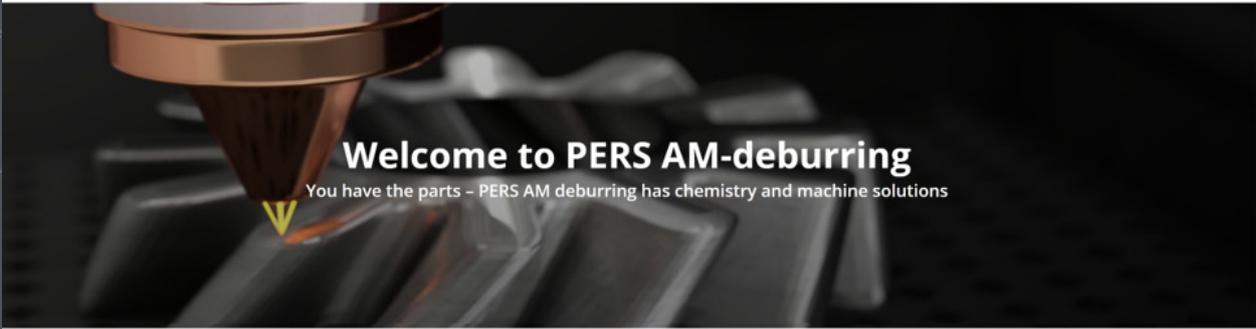


Clean-Line 5.0 30 L.

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Welcome to PERS AM-deburring

You have the parts - PERS AM deburring has chemistry and machine solutions

Ovens



Your professional partner when it comes to ovens for industries, furnaces for laboratories. Furnaces /ovens for use in the heat treatment of metal-printed parts and for curing powder coated parts.

[Read more](#)

Blasting



Your professional partner when it comes to blasting and we more than 50 years of experience in portable sandblasting equipment, sandblasting accessories, manual sandblast cabinets, personal protective equipment and compressed air preparation equipment.

[Read more](#)

Deburring



Your professional partner when it comes to deburring - Pers AM-deburring has extensive experience with deburring machines and consumables. The required finishing results, machine size and weight of the treated parts are important aspects to select the right media composition and size to achieve the optimum process. Different types of media with different amounts of abrasives are needed for the different processes.

[Read more](#)

Shop



AM-Deburring WEBSHOP

Your professional partner both develops new products and cooperates with renowned international manufacturers, and we can therefore offer highly developed process chemicals. These process chemicals fully meet the requirements of the high-tech industry.

Ordering of the most common process compounds and consumables can be found here.

[Read more](#)

INFORMATION

Pers AM Deburring
Member of PERS GROUP
Industrivej 12-16
7120 Vejle Øst
Denmark
VAT: DK19629945

CONTACT US

E-mail: info@am-deburring.dk
Phone: +45 7582 6633
Telefac: +45 7582 6007

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If you have any questions, please contact our customer support department

AM-Deurring is member of Pers-Group

Area sales manager

Jens Brietzke

+45 2819 2874

jens@pers-group.com

Business manager

Torben Pers

+ 452819 2875

torben@pers-group.com