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Injection and pressure blasting

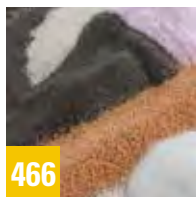




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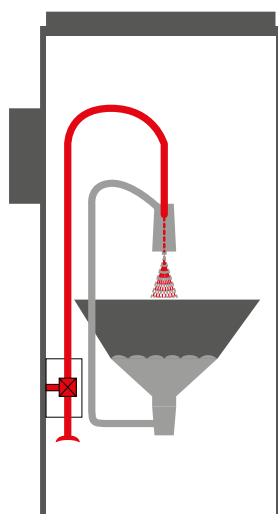
Blasting is a surface treatment in which blasting shot is aimed at the workpieces at high velocity. **Compressed air, hydraulic fluid or wheels** are available as carrier energy. The blasting result essentially depends on the type of blasting shot selected, in addition to different machine types and configuration parameters.

In selecting our blasting systems, we at joke have decided on compressed air as the carrier energy. On the one hand, the risk of possible corrosion in case of non-corrosion-resistant materials is ruled out as a result; above all however, **precise point blastings** are possible using our compressed-air fine blasting systems. For this purpose, we have compiled a selection of blasting units from the **mikromat series** on the following pages.

You will find **injector and pressure blasting systems** (on request) from us that distinctly differ in their performance and are therefore capable of catering for the most diverse applications (refer to the explanation on the left).

We offer you a matching **range of blasting shots** in many different versions.

Injection blasting



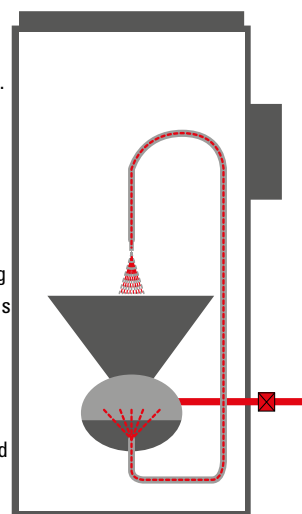
Injection blasting creates a negative pressure within a blasting gun, which sucks in the blasting shot via a separate supply line and guides it into the compressed air. The compressed air then accelerates the blasting shot up to its exit from the blasting nozzle.

Injection blasting is particularly suited to achieving uniform small to medium-sized surfaces. This method allows spot-on application (important for sensitive workpiece geometries).

During **pressure blasting**, the blasting shot is pressurised with compressed air in an enclosed container (pressure tank) from which it is forced through the attached blasting hose with blasting nozzle. Owing to this long acceleration path the blasting shot achieves a much higher blasting and impact velocity than with injection blasting.

This method is particularly suited for blasting large areas and removing stubborn impurities. Extremely light (i.e. plastic, walnut shells) or heavy (i.e. high-carbon steel grit, metallic blasting shots) blasting media can be used that do not achieve the required impact velocity or require a long blasting process with the injection method.

Pressure blasting



456 Injection fine blasting units
mikromat eco series | microblast | microjet

462 Blasting shots
Plastic granulate | Mixed grits | Glass beads | Hard blasting shot | Ruby | Silicon carbide | Ceramic beads | Walnut shells | Corundum | White corundum

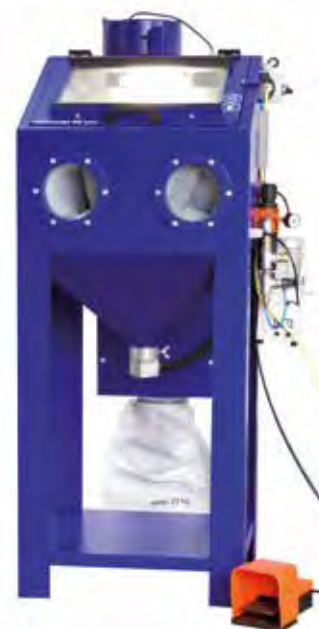
Fine blasting units Series "eco"

Fine blasting units "eco" series

The new, budget-priced entry level blasting unit offering professional quality for workshop and factory. It is highly recommended for deburring, derusting, cleaning, roughening, matting, descaling and removing of lacquer. This unit offers modern technology with many practical features at an attractive price.

Highlights:

- Compact, space-saving design
- Integrated dust exhaust for perfect visibility during the blasting process
- Blasting shot is processed in a closed loop, i. e. only dust etc. is removed, the blasting shot is recycled
- High-performance filter cartridge (up to 8 m² filter space)
- Large window
- Adjustable blasting pressure via pressure regulator
- Easy exchange of blasting shot thanks to steep funnel
- Grid with high loading capacity
- Integrated safety device
- LED work chamber illumination
- Easy self-installation of the optional equipment, even as retrofitting



mikromat 50 eco

Working chamber dimensions (W x D x H)	approx. 500 x 450 x 470 mm
Device dimensions (W x H x D)	approx. 705 x 760 x 1,520 mm
Load bearing capacity of work area	50 kg
Air consumption	approx. 700 l/min at 7 bars
Compressed-air connection	Rapid-release coupling 1/2"
Compressed-air adjustment range	0.5 – 10 bars
Fan output	approx. 350 m ³ /h
Filter area	4.0 m ²
Lighting	LED
Weight	approx. 85 kg
Supply voltage	230 V / 50–60 Hz Euro plug
Scope of delivery	Blasting nozzle made of hardened steel (Ø 7 mm), safety switch (no blasting shot supply when hood open), pressure controller with water separator, foot switch for starting and stopping the blasting process
Order No.	0 951 100-8
Price	














Fine blasting units

The right accessories at a glance

	Dimensions	mikromat 50 eco	mikromat 1000 eco	mikromat 600 pro	mikromat 1100 pro	Order No.	Price from 1 piece
Blow-out gun		x	x	x	x	0 952 023	
							
Blasting gun holder		x				0 952 039	
							
			x	x	x	0 952 112	
Micro fine blasting unit microblast A		x	x	x	x	0 951 110-1	
	Dimensions (W x D x H): approx. 110 x 240 x 270 mm Weight: approx. 3 kg Compressed-air range: 3 – 6 bars Application of blasting shot: 150 – 250 µm (GPM)						
	Supplied with: handpiece with 1.2 mm tungsten carbide blasting gun, foot switch, blasting shot container (2 kg), pressure controller, pressure gauge and air filter (Order-No. 0 951 110 with carrier straps)						
Push-through system							
	150 x 150 mm	x		x		0 952 113	
	250 x 250 mm		x		x	0 952 828	
Blasting shot acceleration				x	x	0 952 111	
Mobile design				x		0 952 114	

Fine blasting units

The right accessories at a glance

	Dimensions	mikromat 50 eco	mikromat 1000 eco	mikromat 600 pro	mikromat 1100 pro	Order No.	Price from 1 piece
Dust bag for micromat							
		x	x	x	x	0 952 037	
Air nozzle							
	Ø 2.5 mm	x	x	x	x	0 952 010-1	
	Ø 3.5 mm	x	x	x	x	0 952 010	
Blasting nozzle							
	Ø 5.0 mm	x	x	x	x	0 952 011-1	
	Ø 7.0 mm	x	x	x	x	0 952 011	
Boron carbide blasting nozzle							
	Ø 7.0 mm	x	x	x	x	0 952 018	
Gloves, pair, size 10							
		x		x		0 952 024	
Glove, left only, size 10							
		x		x		0 952 025	
Filter cartridge							
	230 x 620 mm	x	x	x	x	0 952 012	
Glass pane							
	420 x 205 mm			x		0 952 034	
	420 x 320 mm	x	x		x	0 952 026	
Plexiglass pane							
	420 x 205 mm			x		0 952 035	
	420 x 320 mm	x	x		x	0 952 027	

**joke recommendation:****Only use glas beads!!!**

We recommend the following blasting nozzles:

Ø 0.8 mm	glass beads	GPF 70 – 40 µm
Ø 1.0 mm	glass beads	GPF 110 – 70 µm
Ø 1.2 mm	glass beads	GPM 200 – 100 µm


Fine blasting unit microblast

Micro fine blasting unit microblast Basic

The compact solution for finest blasting jobs. The microblast fine blasting unit allows you to work on finest contours, narrow ribs, slots etc.

Available in two versions:

- The mobile version with carrying straps (order no. 0 951 110) as an open system without its own blasting chamber lends itself to fine work in the field of renovation for stripping wall painting
- With the add-on version (order no. 0 951 110-1), the blasting chamber, extraction and illumination of the large device are used to carry out highly intricate work with the microblast.

	Design	Order No.	Price from 1 piece
Micro fine blasting unit microblast A			
	Dimensions (W x D x H): approx. 110 x 240 x 270 mm Weight: approx. 3 kg Compressed-air range: 3 – 6 bars Application of blasting shot: 150 – 250 µm (GPM)	for connecting with mikro- mat 50, 600, 1000, 1100	0 951 110-1
	Supplied with: handpiece with 1.2 mm tungsten carbide blasting gun, foot switch, blasting shot container (2 kg), pressure controller, pressure gauge and air filter (Order-No. 0 951 110 with carrier straps)		
Micro fine blasting unit microblast basic			
	Dimensions (W x D x H): approx. 110 x 240 x 270 mm Weight: approx. 3 kg Compressed-air range: 3 – 6 bars Application of blasting shot: 150 – 250 µm (GPM)	for maximum mobility	0 951 110
	Supplied with: handpiece with 1.2 mm tungsten carbide blasting gun, foot switch, blasting shot container (2 kg), pressure controller, pressure gauge and air filter (Order-No. 0 951 110 with carrier straps)		

microblast A adapted to mikromat 50 eco



Tabletop fine blasting device microjet

Tabletop fine blasting device joke-microjet

The microjet is a blasting device developed for surface treatment of metals. Particularly suitable for removing residues and oxide layers or when using glass beads for polishing the precious metal surfaces

Highlights:

- Depending on equipment, a choice of one, two or three blasting shots is available during work.
- Handpiece can be used with a Ø 0.8, 1 or 1.2 mm fine blasting nozzle.
- Wide viewing window with easily replaceable protective film.
- Steel housing with stove-enamel finish
- Pneumatic foot switch
- Tank with 2 kg capacity (approx. 1 litre)
- Compact, space-saving construction
- Switches for light and external extractor provided.



joke recommendation:

Only use glass beads!!!

We recommend the following blasting nozzles on Page 452:

Ø 0.8 mm	glass beads	GPF 70 – 40 µm
Ø 1.0 mm	glass beads	GPF 110 – 70 µm
Ø 1.2 mm	glass beads	GPM 200 – 100 µm



The possibilities are numerous...

The blasting shot containers listed below are supplied as standard. A selection of other blasting shot container combinations is also available.

Please consult us!



**Tabletop fine blasting device
joke-microjet 1,**
cabin with 1 blasting shot container



**Tabletop fine blasting device
joke-microjet 2,**
cabin with 2 blasting shot container




**Tabletop fine blasting device
joke-microjet 3,**
cabin with 3 blasting shot container


	Tabletop fine blasting device joke-microjet 1, cabin with 1 blasting shot container	Tabletop fine blasting device joke-microjet 2, cabin with 2 blasting shot container	Tabletop fine blasting device joke-microjet 3, cabin with 3 blasting shot container
Design	cabin with 1 blasting shot container	cabin with 2 blasting shot container	cabin with 3 blasting shot container
Device dimensions (W x H x D)	approx. 380 x 570 x 280 mm	approx. 380 x 570 x 280 mm	approx. 380 x 570 x 280 mm
Air consumption	max. 80 l/min at max. 6 bars	max. 80 l/min at max. 6 bars	max. 80 l/min at max. 6 bars
Compressed-air adjustment range	0.5 – 6 bars	0.5 – 6 bars	0.5 – 6 bars
Lighting	9 W (fluorescent tubes in housing)	9 W (fluorescent tubes in housing)	9 W (fluorescent tubes in housing)
Weight	approx. 9 kg	approx. 11 kg	approx. 13 kg
Supply voltage	230 V, 50/60 Hz	230 V, 50/60 Hz	230 V, 50/60 Hz
Scope of delivery	1 handpiece with Ø 1.2 mm blasting nozzle made of hardened steel, foot switch, 1 container for blasting shot of grit size 150–250 µm, compressed air controller with filter and gloves (installed)	2 handpieces with Ø 1.2 mm blasting nozzle made of hardened steel, foot switch, 1 container respectively for blasting shot of grit size 90–120 µm and 150–250 µm (switchable), compressed air controller with filter and gloves (installed)	3 handpieces with Ø 1.2 mm blasting nozzle made of hardened steel, foot switch, 1 container respectively for blasting shot of grit size 50–80 µm, 90–125 µm and 150–250 µm (switchable), compressed air controller with filter and gloves (installed)
Order No.	0 951 210	0 951 220	0 951 223
Price			

Tabletop fine blasting device microjet

joke-microjet S table-top fine blasting unit with additional circulation blasting device

		Design	Order No.	Price from 1 piece
joke-microjet S table-top fine blasting unit, incl. circulation blasting device				
 <p>Contains an additional blasting nozzle Ø 4 mm for larger grit sizes as well as a pressure gauge, pressure regulator and foot regulator.</p> <p>ONLY suitable for glass beads as an abrasive!</p>	cabin with 1 blasting shot container	0 951 241		
	cabin with 2 blasting shot container	0 951 242		
	cabin with 3 blasting shot container	0 951 243		

Accessories / spare parts

	Size	Packing quantity	Order No.	Price from 1 piece	1 pack
Tungsten carbide blasting gun					
	Ø 0,8 mm		0 951 112		
	Ø 1,0 mm		0 951 113		
	Ø 1,2 mm		0 951 114		
	Ø 1,5 mm		0 951 147		

Suction unit EUR

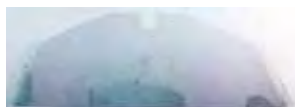


Dust extractor with paper bag and polyester filter. Suction power continuously adjustable

0 951 224

Dimensions (B x H):
approx. Ø 360 x 580 mm
Weight: approx. 8 kg
Noise level: max 71 dB(A)
(at 1 m distance)
Voltage: 230 V, 50 Hz
≠(s. specification plate)

Protective sheet for acrylic glass



10 pieces **0 951 222**

Blasting shots



Blasting shots

We have the right blasting shot for every application. For almost all blasting shots, you have a choice between the handy 5-litre can and the economical bag containing 25 kg. We carry other blasting shots too in the range in addition to the selection indication on the following pages.

Consult us!

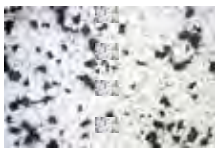
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Plastic granulate with antistatic agent

Applications / Materials:


- Cleaning of Steel and aluminium moulds, GFK-parts, wooden surfaces, copper, bronze, marble, granite etc.
- Paint stripping of powder coated parts, automotive parts, aluminium rims, aircraft parts
- Deburring of zinc die casting and aluminium parts
- Paint preparation of plastic surfaces
- No electrostatic charge

Perfectly suitable for use of pressure blasting systems!

	Grit size	Content	Type	Order No.	Price from 1 piece
Blasting shots plastic granulate with antistatic agent					
	250 - 150 µm	25 kg bag	Premium	0 955 266	
	500 - 250 µm	25 kg bag	Premium	0 955 267	
	800 - 500 µm	25 kg bag	Premium	0 955 265	
	1200 - 800 µm	25 kg bag	Premium	0 955 268	
	1500 - 1200 µm	25 kg bag	Premium	0 955 269	

Mixed grits

Improving of surfaces, cleaning, deburring, descaling and preparation of surfaces.

	Grit size	Content	Type	Order No.	Price from 1 piece
Blasting shots mixed grits					
	50 - 40 µm	5 l can	MK 300	0 955 142	
	150 - 75 µm	5 l can	MK 90/150	0 955 122	
		25 kg pail	MK 90/150	0 955 122-1	
	200 - 100 µm	5 l can	RM K	0 955 202	
		25 kg pail	RM K	0 955 205-1	
	300 - 150 µm	5 l can	MK 60/90	0 955 112	
		25 kg pail	MK 60/90	0 955 112-1	
	500 - 150 µm	5 l can	MK 40/90	0 955 102	
25 kg pail		MK 40/90	0 955 102-1		

Blasting shots Glass beads

Polishing, decorating, deburring, surface hardening of all materials including non-ferrous and precious metals and plastics.

	Grit size	Content	Type	Order No.	Price from 1 piece
Blasting shots glass beads					
	50 - 0 µm	5 l can	GP/0 - 50	0 955 352	
		25 kg bag	GP/0 - 50	0 955 354	
	70 - 40 µm	5 l can	GPFF	0 955 342	
		25 kg bag	GPFF	0 955 344	
	110 - 70 µm	5 l can	GPF	0 955 332	
		25 kg bag	GPF	0 955 334	
	200 - 100 µm	5 l can	GPM	0 955 322	
		25 kg bag	GPM	0 955 324	
	400 - 300 µm	5 l can	GPG	0 955 312	
		25 kg bag	GPG	0 955 314	
	600 - 400 µm	5 l can	GPSG	0 955 302-1	
		25 kg bag	GPSG	0 955 304-1	

Hard blasting shot

Cleaning, descaling, deburring of metals, mainly steels – no formation of dust.

	Grit size	Content	Type	Order No.	Price from 1 piece
Hard blasting shot					
	150 - 100 µm	5 l can	HST 120 (round)	0 955 402	
		25 kg bag	HST 120 (round)	0 955 404	
	200 - 100 µm	5 l can	HST 121 (edged)	0 955 412	
		25 kg bag	HST 121 (edged)	0 955 414	

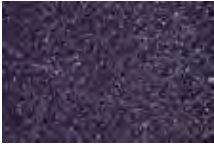
Ruby

For deburring, cleaning and descaling.

	Grit size	Content	Type	Order No.	Price from 1 piece
Blasting shots ruby					
	74 - 53 µm	5 l can	RUB 220	0 955 522	
		25 kg bag	RUB 220	0 955 525-1	
	100 - 75 µm	5 l can	RUB 150	0 955 512	
		25 kg bag	RUB 150	0 955 515-1	
	150 - 125 µm	5 l can	RUB 100	0 955 502	
		25 kg bag	RUB 100	0 955 505-1	


Blasting shots Silicon carbide

Aggressive shot, high stock removal. Cleaning of hardened surfaces.

	Grit size	Content	Type	Order No.	Price from 1 piece
Blasting shots silicon carbide					
	25 - 21 µm	5 l can	SIC 360	0 955 932	
		25 kg bag	SIC 360	0 955 935	
	75 - 53 µm	5 l can	SIC 220	0 955 922	
		25 kg bag	SIC 220	0 955 925	
	90 - 63 µm	5 l can	SIC 180	0 955 912	
		25 kg bag	SIC 180	0 955 915-1	
	106 - 63 µm	5 l can	SIC 150	0 955 902	
		25 kg bag	SIC 150	0 955 905-1	


Ceramic beads

Synthetic, pearl-shaped zirconbased blasting shot. Hardness and density much higher than glass beads, resulting in a significantly longer service life. Ceramic beads are particularly suitable for cleaning, hardening, smoothing, deburring and polishing of various surfaces.

	Grit size	Content	Type	Order No.	Price from 1 piece
Blasting shots ceramic beads					
	125 - 70 µm	5 l can	KPFF	0 955 380-1	
		25 kg can	KPFF	0 955 380	
	250 - 125 µm	5 l can	KPF	0 955 381-1	
		25 kg can	KPF	0 955 381	
	425 - 250 µm	5 l can	KPM	0 955 382-1	
		25 kg can	KPM	0 955 382	


Walnut shells

Cleaning and deburring of soft metals and plastics, especially duroplastics.

	Grit size	Content	Type	Order No.	Price from 1 piece
Blasting shots walnut shells					
	<= 300 µm	5 l can	WS 3	0 955 722	
		25 kg bag	WS 3	0 955 725-1	
	750 - 300 µm	5 l can	WS 2	0 955 712	
		25 kg bag	WS 2	0 955 715-1	


Blasting shots Corundum

General cleaning jobs, descaling, decorating, matting, good stock removal, medium hard.

	Grit size	Content	Type	Order No.	Price from 1 piece
Blasting shots corundum					
	75 - 53 µm	5 l can	KOR 220	0 955 622	
		25 kg bag	KOR 220	0 955 625-1	
	90 - 63 µm	5 l can	KOR 180	0 955 612	
		25 kg bag	KOR 180	0 955 615-1	
	106 - 63 µm	5 l can	KOR 150	0 955 602	
		25 kg bag	KOR 150	0 955 605-1	
	150 - 106 µm	25 kg bag	KOR 100	0 955 875-1	
	250 - 180 µm	25 kg bag	KOR 70	0 955 874-1	
	355 - 250 µm	25 kg bag	KOR 54	0 955 873-1	
	425 - 300 µm	25 kg bag	KOR 46	0 955 872-1	
	850 - 600 µm	25 kg bag	KOR 24	0 955 871-1	
	2000 - 1400 µm	25 kg bag	KOR 12	0 955 870-1	

White corundum

Abrasive blasting shot for surface preparation. Particularly suitable for non-ferrous metals. Steel-free blasting, long service life.

	Grit size	Content	Type	Order No.	Price from 1 piece
Blasting shots white corundum					
	7.5 - 5.5 µm	20 kg bag	EKW 800	2 002 383-1	
	14 - 12 µm	5 l can	EKW 500	0 955 822	
		25 kg bag	EKW 500	2 002 382-1	
	25 - 21 µm	5 l can	EKW 360	0 955 812	
		25 kg bag	EKW 360	2 002 381-1	
	38 - 35 µm	5 l can	EKW 280	0 955 802	
		25 kg bag	EKW 280	2 002 380-1	
	75 - 53 µm	25 kg bag	F 220	0 955 857	
	125 - 90 µm	25 kg bag	EKW 120	0 955 850	
	150 - 106 µm	25 kg bag	EKW 100	0 955 845	
	180 - 125 µm	25 kg bag	EKW F 70	0 955 844	
	212 - 150 µm	25 kg bag	F 80	0 955 848	
	300 - 212 µm	25 kg bag	EKW 060	2 002 387-1	
	500 - 250 µm	25 kg bag	EKW M 0,50-0,25	0 955 851	
1400 - 1000 µm	25 kg bag	F 16	0 955 846		