

ABRASIVE/PROFILE COMPARATIVE CHART

The following chart should be used only for approximating the abrasive size required to obtain a specified anchor pattern. The standard metal used to obtain these results was hot rolled steel with tightly adhering mill scale. The resulting depth of anchor pattern will vary with the method used for measuring depths as well as any one of numerous other variables (type and hardness of steel, thickness of mill scale, degree of cleaning specified, etc.). This information can be used for centrifugal wheel as well as pressure blasting. Pressure blasting should be done using 90-100 psi nozzle pressure. The depth of anchor pattern used in this chart is an average and not a minimum or maximum depth obtainable. Consult local abrasive suppliers for specific technical data.

1 Mil Profile

30/60 Mesh Silica Sand
G-80 Steel Grit
S-110 Steel Shot*
80 Mesh Garnet
100 Aluminum Oxide
Clemtex #4
Black Beauty 3060

1.5 Mil Profile

16/35 Mesh Silica Sand
G-50 Steel Grit
S-170 Steel Shot*
36 Mesh Garnet
50 Grit Aluminum Oxide
Clemtex #3
Black Beauty 3060

2 Mil Profile

16/35 Mesh Silica Sand
G-40 Steel Grit
S-230 Steel Shot*
36 Mesh Garnet
36 Grit Aluminum Oxide
Clemtex #3
Black Beauty 2040

2.5 Mil Profile

8/35 Mesh Silica Sand
G-40 Steel Grit
S-280 Steel Shot*
16 Mesh Garnet
24 Grit Aluminum Oxide
Clemtex #2
Black Beauty 2040

3-4 Mil Profile

8/20 Mesh Silica Sand
G-25 Steel Grit
S-330 or 390 Steel Shot*
16 Mesh Garnet
16 Grit Aluminum Oxide
Clemtex #2
Black Beauty 1240

*Steel shot alone will not give a good angular anchor pattern and should be used in combination with steel grit for best results.