Abrasive Mesh Sizes Required to Produce These MILS of Anchor Pattern

Abrasive Type & Hardness	½MIL	1 MIL	1 ½MILS	2 MILS	2½ MILS	3 MILS	4 MILS
Silica Sand 5-6 MOHS	80/120	30/50	20/40	16/30	12/15	10/20	8/16
Mineral Sands 7 MOHS	90	80	55	….	….	…..	…….
Industrial Garnet 7-8 MOHS	100	80	55	…..	……	……	……
Flint 6 ½ MOHS	…..	30/60	20/50	16/35	10/30	8/25	6/20
Boiler Slags 7 MOHS	…..	50/100	40/70	30/60	20/40	16/30	12/20
Copper/Nickel Slags 7-7½ MOHS	…..	70/100	60/80	40/80	30/50	20/40	16/30
Aluminum Oxide 8 MOHS	120	80	54	40	36	24	16
	Should only be used in enclosed blast rooms or blast cabinet where it can be contained, recycled and reused						
Silicon Carbide 9 MOHS	150	100	80	54	40	36	30
	See aluminum oxide for reuse data.						
Nut Shells 3-3½ MOHS	35/60	14/30	10-Jun	…..	…..	…..	…..
	Generally used for cleaning or deburring, not for anchor patterns. They should be used in blast rooms or cabinets so they can be contained, recycled, and reused.						
Plastic Grit 3-4MOHS	Generally used to remove paint etc., from delicate surfaces such as aircraft and fiberglass with no anchor pattern. Available in 12/16, 16/20, 20/30, 30/40, and 60/80 mesh sizes 3-3.5-4 MOHS						
Corn Cobs 4½ MOHS	Will develop minor anchor patterns, but are generally used to clean delicate surfaces like electric motors, brick, stone, wood, etc. Available in 6/10, 8/12, 12/20, 14/30, 35/60, and 40/100 mesh						
Glass Beads 5-6 MOHS	Should be used in blastrooms or cabinets so they can be contained recycled and reused. These round balls of glass produce a satin or matte finish Available in mesh sizes from course (20/30) to super fine (170/325)						
Chilled Iron & Steel Grit 40-68 Rc	G-200	G-120	G-80	G-50	G-40	F-25	G-16
	Should only be used in enclosed blast rooms or cabinets so they can be contained, recycled and reused. The Least expensive abrasive available if the correct facilities can be provided.						
Chilled Iron & Steel Shot 40-68 Rc	Round abrasives generally used in automatic blast cleaning facilities using centrifugal wheels to propel them against a surface. Can be used in other types of facilities. We will only list the available sizes as many factors need to be considered in their use. From S-780 Course to S-70 Fine.						

The recommendations above are based on a constant air pressure of 90-95 PSI nozzle pressure; use of a long Venturi blast nozzle held 18-24" from the surface at an 80-90 degree angle of the workpiece on mild steel products. The anchor pattern produced on harder metals will be less unless air pressure and/or abrasive mesh sizes are adjusted