

Abrasive Mesh Sizes Required to Produce These MILS of Anchor Pattern

Abrasive Type & Hardness	<u>½MIL</u>	<u>1 MIL</u>	<u>1 ½MILS</u>	<u>2 MILS</u>	<u>2½ MILS</u>	<u>3 MILS</u>	<u>4 MILS</u>
<i>Silica Sand 5-6 (MOHS)</i>	80/120	30/50	20/40	16/30	12/15	10/20	8/16
<i>Mineral Sands 7 (MOHS)</i>	90	80	55
<i>Industrial Garnet 7-8(MOHS)</i>	100	80	60	40	36	24	16
<i>Flint 6 ½ (MOHS)</i>	30/60	20/50	16/35	10/30	8/25	6/20
<i>Boiler Slags 7(MOHS)</i>	50/100	40/70	30/60	20/40	16/30	12/20
<i>Copper/Nickel Slags 7-7½ (MOHS)</i>	70/100	60/80	40/80	30/50	20/40	16/30
<i>Aluminum Oxide 8 (MOHS)</i>	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						
<i>Silicon Carbide 9 (MOHS)</i>	150	100	80	54	40	36	30
	See aluminum oxide for reuse data.						
<i>Nut Shells 3-3½ (MOHS)</i>	35/60	14/30	6/10
	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.						
<i>Plastic Grit 3-4 (MOHS)</i>	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, 40/60 and 60/80 mesh sizes.						
<i>Corn Cobs 4½ (MOHS)</i>	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, 18/40 35/60, and 40/100 mesh						
<i>Glass Beads 5-6 (MOHS)</i>	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)						
<i>Chilled Iron & Steel Grit (40-68 Rc)</i>	G-200	G-120	G-80	G-50	G-40	G-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.						
<i>Chilled Iron & Steel Shot 940-68 Rc)</i>	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.						

MOHS=Mohs scale of mineral hardness;

Rc=Rockwell Hardness (C) Scale

The recommendations above are based on a constant air pressure of 90-95 PSI nozzle pressure, using a long Venturi blast nozzle held 18-24" from the surface at an 85-90 degree angle to 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