lacksquare		All IV	equirei	nents e	Aprasi	ve con	sumption
Nozzle Orifice	Pressure At The Blast Nozzle (psi)						Air, Power and Abrasive
	60	70	80	90	100	125	Requirements
No.2 1/8"	13	15	17	18.5	20	25	Air (CFM)
	77	88	101	112	123	152	Abrasive (lb/hr)
	3	3.5	4	4.5	5	5.5	Compressor (hp)
No.3 3/16*	30	33	38	41	45	55	Air (CFM)
	171	196	216	238	264	319	Abrasive (lb/hr)
	7	8	9	10	10	12	Compressor (hp)
No.4 1/4"	54	61	68	74	81	98	Air (CFM)
	312	354	408	448	494	608	Abrasive (lb/hr)
	12	14	16	17	18	22	Compressor (hp)
No.5 5/16"	89	101	113	126	137	168	Air (CFM)
	534	604	672	740	812	982	Abrasive (lb/hr)
	20	23	26	28	31	37	Compressor (hp)
No.6 3/8"	126	143	161	173	196	237	Air (CFM)
	764	864	960	1052	1152	1393	Abrasive (lb/hr)
	28	32	36	39	44	52	Compressor (hp)
No.7 7/16"	170	194	217	240	254	314	Air (CFM)
	1032	1176	1312	1448	1584	1931	Abrasive (lb/hr)
	38	44	49	54	57	69	Compressor (hp)
No.8 1/2*	224	252	280	309	338	409	Air (CFM)
	1336	1512	1680	1856	2024	2459	Abrasive (lb/hr)
	50	56	63	69	75	90	Compressor (hp)

## Rust Grade A

Steel surface completely covered with adherent mill scale. Little or no rust.

### Rust Grade B

Steel surface covered with both mill scale and rust.

### Rust Grade C

Steel surface completely covered with rust. Little or no pitting is visible.

### Rust Grade D

Steel surface completely covered with rust. Pitting is visible.

### **Brush Off**

Blast Cleaning of all except tightly adhering residues of mill scale, rust and coatings, while uniformly roughening the surface. Reterence AS1627.4 Class 1, NACE 4, SSPC-SP7 Swedish Standard (S, Sa), Sa 1

### Commercial

Blast Cleaning until at least 66% of the surface is free of all visible residues with only staining permitted on the remaining 33%. For conditions where a thoroughly cleaned surface is required. Reference AS1627.4 Class 2, NACE 3, SSPC-SP6 Swedish Standard (St. Sa).

### Near White Blast

Blast Cleaning nearly to White Metal cleanliness, until at least 95% of the surface is free of all visible residues with only staining permitted on the remainder. For High humidity, chemical atmospheres, marine and corrosive environments. Reference AS 1627.4 Class 2-1/2, NACE 2, SSPC-9F10 Swedchis Standard (\$5, 50, 50-2-1).

### White Blast

Removal of all visible rust, mill scale, paint and foreign matter by Blast Cleaning by wheel or nozzle (dry or wet) using Garnet, Gri or Shot. For very corrosive atmospheres where high cost of cleaning is warranted. Reference 1516274 Class 3, MCE, 15, 58PC-SP5

# Disclaimer:

einformation on this ABSS Surface Proporation Chart is to be used as a guide only. This must not be used as a replacement to any Surface Preparation Standards. It is the responsibility of the user and/or reader to accurately determine the required Surface Preparation requirements by other means. Reference Australian Standards AS 1627 A NMCE, SSPC and Swedish Standards (SS).

# ABSS Visual Comparator Guide Degrees of Cleanliness

# **Abrasive Blasted Steel Substrates**

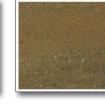




Rust

Grade D

















Turbine Wheel Machines



Blast Room Recovery Systems and Dust Collectors



**Blast Cabinets** 



**Blast Rooms** 



Mega Blast Vessels



Blast Pots, Helmets, Hoses and Accessories



