

Typical Profile Characteristics Achievable with Various Steel Shot and Grit

	Maximum Profile (mil, microns, inches)		
	Mils	Microns	Inches
GP 50	2.2	55	0.0022
GP 40	3.0	75	0.0030
GP25	3.2	80	0.0032
GP 18	3.9	100	0.0039
GP 16	4.5	115	0.0045
GL 80	1.4	35	0.0014
GL 50	2.1	52	0.0021
GL 40	3.0	75	0.0030
GL 25	2.8	70	0.0028
GL 18	3.9	100	0.0039
GH 50	3.4	85	0.0034
GH 40	3.9	100	0.0039
GH 25	5.5	140	0.0055
S 110	1.6	40	0.0016
S 170	2.2	55	0.0022
S 280	2.4	60	0.0024
S 390	3.0	75	0.0030
S 550	3.5	90	0.0035

Indicative results obtained on low alloy, low hardness construction steel

Only an actual test can determine the optimal process parameters for a specific case

Conditions of the Test:

For grit Blasting

- 10 mm nozzle
- Pressure at nozzle = 5.5 bar (80 psi)
- Blasting distance = 600 mm (24 inches)

For shot wheel Blasting

- Throwing wheel = 80 m/sec (260 ft/sec)

Instrument Setting

- Cut-off = 2.5 mm (0.1 inch)
- Pc section level = 0.75 micron (0.00003 in)