IDS - SUPPLIES & FACILITIES

IDS BLAST is a full line stocking distributor of abrasive blasting equipment, parts, safety supplies and abrasives. We stock a wide variety of hose, valves, wheels, blades, liners, fittings, couplers, nozzles, gaskets, hoods, filters and much more. Our knowledgeable sales team provides “in the field” technical analysis and solutions while our service department services most manufacturer’s blasting equipment. We pride ourselves in providing solutions to the Contractor and Industrial markets.
FOR YOU, OUR CUSTOMER

RECYCLING PROGRAM

IDS BLAST offers a recycling program on Aluminum Oxide, Steel Abrasives & Plastic Media. The recycling program allows customer’s to get paid for their “used” abrasives. By recycling “used” abrasive, we are reducing abrasive waste which is environmentally friendly.

Please contact us to discuss the possibility of a recycling program at your facility.

BLANKET ORDERS

Blanket orders enable IDS BLAST to partner with our suppliers to offer discounted prices on our complete line of abrasives. This allows us to negotiate prices which has proven to reduce our customer’s costs.

Blanket orders have been instrumental in increasing the efficiencies of our customer’s operations.

SERVICE INSPECTIONS

Our trained sales professionals at IDS BLAST provide free service inspections which have proven to increase productivity and reduce down time. We have a complete service department that can provide in-house or on-site service inspections and repairs.

We become partners with our customers to assist them in increasing their operation efficiencies and productivity. We take our customer’s success seriously.

What Can Our Service Department Do For You?

- Inspections
- Recommendations
- Equipment Installation
- Equipment Repair
- Efficiency Evaluations

WE OFFER COMPETITIVE PRICES WITH UNEQUALLED SERVICE

SERVICE DEFINES OUR REPUTATION
## ABRASIVES INDEX

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<td>Deburring, descaling, etching and surface preparation applications.</td>
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<td>Aluminum Oxide - White</td>
<td>Cleans engine heads, valves, pistons, and turbine blades.</td>
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<td>Corn Cob</td>
<td>Cleans, polishes and dries surfaces such as smoke damaged buildings and oil rigs.</td>
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<td>8</td>
<td>Crushed Glass</td>
<td>Removes rust, mill scale and coatings on concrete, structures, tanks and pipelines.</td>
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<td>Garnet</td>
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<td>11</td>
<td>Starblast® (Staurolite Mineral)</td>
<td>Removes brittle coatings and prepares surfaces with mill scale or light rust.</td>
</tr>
<tr>
<td>12</td>
<td>Steel Grit</td>
<td>Used on metal for superior adhesion of paint, epoxy, enamel and other coatings.</td>
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<td>12</td>
<td>Steel Shot</td>
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<td>Walnut Shell</td>
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</tr>
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<td></td>
</tr>
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<td></td>
</tr>
</tbody>
</table>
PACKAGING AND SHIPPING

PACKAGING OPTIONS

Abrasive media can come to you a lot of different ways; as small as a 40 lb. bag, to as large as a 50,000 lb. bulk truck (and everything in between). We can even transfer media into pails or boxes if that is what you require.

WE HAVE YOU COVERED!

These Packaging Icons are located throughout this catalog to indicate the different packaging sizes available for a given media.

SHIPPING - QUICK AND ON TIME

Abrasive arrives at our facility by the truck load where we off-load it, store it and get it ready to ship. When an order is received, all that is left to do is load it and ship it to you.

WE KNOW ABRASIVE SHIPPING!

What Can Our Shipping Department Do For You?

■ Typically In-stock / Same Day Shipping
■ Direct Shipping: From our Manufacturers
■ Logistics - On Time Arrivals
■ J.I.T. (Just In Time) Services Available

800-800-0665
Aluminum Oxide-Brown

Aluminum Oxide grit is carefully shaped and graded for pressure blasting applications. It is sharp and can be used and reused again. Absence of wasteful flats and slivers maximizes cutting efficiency in deburring, descaling, etching and surface smoothing applications. Low iron content eliminates danger of rust-staining to weather-exposed granite, marble and stainless steel.

**Features & Benefits**
- Recyclable
- Maximum resistance to breakdown
- Less than 1% free silica
- Low iron content
- Eliminates danger of rust-staining
- Non-skid floor coating applications

Aluminum Oxide-White

White Aluminum Oxide has higher hardness and slightly lower toughness compared to brown aluminum oxide. It is characterized by its high purity, ability to self-sharpen, better cutting, lower heat emissions, higher efficiency, acid and alkali resistance and good thermal stability.

**Features & Benefits**
- High resistance to breakdown
- Less than 1% free silica
- Liquid honing capabilities
- Allows for repeated use, less dust and less clean up
- Eliminates danger of rust-staining
- Non-skid floor coating applications
Coal Slag
Coal Slag is a fast-cutting and a good general purpose abrasive that is tough enough to get the job done. Its angular shape and hardness quickly cut away existing coatings. Use Coal Slag on buildings, tanks, castings, ships, bridges, railroad equipment, structural steel, exposed aggregate and more.

**Features & Benefits**
- Less than 1% free silica
- Chemically inert
- Low friability
- Consistent uniform weight
- Approved by the U.S. Navy’s OPL (MIL-A-222820)

**PRODUCT TYPE**
- Contractor

**US SIEVE SIZE**
- 10/40
- 12/40
- 20/40
- 30/60

**HARDNESS**
- (MOHS) SCALE
  - 6 to 7

**BULK DENSITY**
- (LBS PER CU FT)
  - 85

**HOW IT COMES**
- 30 Bags per Pallet
- 1 Bulk Bag per Pallet
- 50,000 Pounds per Bulk Truck

Corn Cob
Corn Cob is a resilient and durable abrasive that can clean, dry and polish a surface. Corn Cob granules are increasingly becoming the choice when the job calls for a softer, less dusty and environmentally safe abrasive.

**Features & Benefits**
- Cleaner and less dusty than many other abrasives
- Absorbs oils as it cleans
- Biodegradable
- Will not damage gears of equipment as sand often does
- 0% free silica

**PRODUCT TYPE**
- Contractor & Industrial

**US SIEVE SIZE**
- 1014
- 1420
- 2040
- 4060

**HARDNESS**
- (MOHS) SCALE
  - 2

**BULK DENSITY**
- (LBS PER CU FT)
  - 34 to 42

**HOW IT COMES**
- 48 Bags per Pallet
- 40 Bags per Pallet

800-800-0665
**Crushed Glass**

Crushed glass is a 100% recycled material and contains no detectable crystalline silica. Crushed Glass delivers very low particle embedment which applies a whiter finish to the substrate.

**Features & Benefits**

- 100% recycled glass
- Non-reactive, inert
- Less than 1% free silica (silica sand contains up to 99% free silica)
- White post-blast finish
- Translucent white dust for increased visibility
- QPL approved (select plants)
- CARB approved (select plants)
- SSPC AB-1 Class A, MIL-A-22262B (SH) approved

**PRODUCT TYPE**
Contractor & Industrial

**US SIEVE SIZE**
- 10-40
- 20-40
- 40-70
- 70-100

**HARDNESS (MOHS) SCALE**
6

**BULK DENSITY (LBS PER CU FT)**
80

**How it comes**
- 50 lb
- 3000 lb
- 40 Bags per Pallet
- 1 Bulk Bag per Pallet

**Garnet**

Garnet is a hard and heavy abrasive that can increase productivity while reducing the amount of abrasive used. It offers the performance of synthetic and more expensive abrasives and is environmentally friendly.

**Features & Benefits**

- Cuts fast, reduces abrasive consumption
- Better visibility while blasting, low dust
- Recyclable
- Chemically inert
- Non-toxic
- Less than 1% free silica

**PRODUCT TYPE**
Contractor & Industrial

**US SIEVE SIZE**
- 30/60/80 GAGX1
- 80
- 120
- 200

**HARDNESS (MOHS) SCALE**
7 to 8.3

**BULK DENSITY (LBS PER CU FT)**
147

**How it comes**
- 55 lb
- 2200 lb or 4400 lb
- 40 or 80 Bags per Pallet
- 1 or 2 Bulk Bags per Pallet
Glass Beads

Glass Beads are environmentally friendly and can be used in many blast applications to provide a finish with no profile. Use while working with metal, plastic or rubber materials to clean, debur and finish.

**Features & Benefits**
- Ideal “Cleaning” Abrasive
- Consumed at slow rate and can be recycled
- Will not contaminate metal being treated
- 0% free silica
- No Profile
- Uniform hardness and size

**Product Type**
- Industrial

**US Sieve Size**
- 30-40, 40-60, 40-70, 50-80, 60-120, 80-120, 100-170, 120-270, 170-235

**Hardness**
- (MOHS) Scale
  - 4.5

**Bulk Density**
- (LBS PER CU FT)
  - 85

**How it comes**
- 40 Bags per Pallet
- 1 Bulk Bag per Pallet

Plastic Media

General applications of Plastic Media include powder coating removal, stripping aircraft and aerospace components, and removal of coatings from vehicles and vehicle parts. Different types of plastic media include:
- Type II - Urea
- Type III - Melamine
- Type V - Acrylic

**Features & Benefits**
- Low dust
- Reusable
- Infinite shelf life
- Non-toxic and environmentally safe
- Low machine wear
- 0% free silica

**Product Type**
- Industrial

**US Sieve Size**
- 12/16
- 16/20
- 20/30
- 30/40

**Hardness**
- (MOHS) Scale
  - 3 to 4.0

**Bulk Density**
- (LBS PER CU FT)
  - 45-48

**How it comes**
- 20 Boxes per Pallet
- 4 Fibre Drums per Pallet

800-800-0665
Silicon Carbide

Silicon Carbide blasting grit is designed for use on super hard metals, ceramics, glass and stone. Upon impact, grits shatter to form a continuous stream of sharp, new cutting edges.

Features & Benefits

- High resistance to breakdown
- No free crystalline silica
- Liquid honing capabilities
- Allows for repeated use, less dust and less clean up
- Minimizes danger of rust-staining

PRODUCT TYPE
Industrial

US SIEVE SIZE
12, 16, 20, 24, 30, 36, 46, 54, 60, 70, 80, 90, 100, 120, 150, 180, 220, 240

HARDNESS (MOHS SCALE)
6

BULK DENSITY (LBS PER CU FT)
80

Sodium Bicarbonate

Soda blasting uses large, sharp crystals of sodium bicarbonate (baking soda) to effectively and safely remove paint, grease, process residue, or graffiti from brick, glass, rubber aluminum, galvanized metals, stainless steel, copper, engine parts or TEFC motors.

Features & Benefits

- Non-hazardous
- Water soluble
- Won’t damage most surfaces
- New uses continue to be developed
- Environmentally safe
- 0% free silica

PRODUCT TYPE
Contractor & Industrial

US SIEVE SIZE
48 (300) 58 (260) 100 (150)

HARDNESS (MOHS SCALE)
2.8

BULK DENSITY (LBS PER CU FT)
61
Soft Shot was developed for cleaning soft, delicate metal parts. It’s very durable and is made from virgin, premium-grade, cast steel shot. Soft Shot is good for cleaning, deburring and deflashing.

Features & Benefits
- Doesn’t scratch or pit surfaces
- Doesn’t damage blast machine wear parts
- Twice the life of standard SAE grades
- Environmentally friendly
- Doesn’t generate hazardous waste

<table>
<thead>
<tr>
<th>PRODUCT TYPE</th>
<th>US SIEVE SIZE</th>
<th>HARDNESS</th>
<th>BULK DENSITY</th>
</tr>
</thead>
<tbody>
<tr>
<td>Industrial</td>
<td>NS-70 NS-90 NS-110 NS-170 NS-230</td>
<td>3 to 3.5</td>
<td>225</td>
</tr>
</tbody>
</table>

HOW IT COMES
- 40 Pails per Pallet
- 3 Steel Drums and 1 Steel Drum per Pallet

Starblast® works great on light rust, brittle paint, mill scale and is an excellent abrasive for blasting new steel.

- Starblast - <3% Free Silica (typically <2%)
- Starblast XL - <1% Free Silica
- Starblast Ultra - <5% Free Silica (typically <3%)

Features & Benefits
- Lower coating consumption
- Lower abrasive consumption
- Low dust and recyclable
- <1%-3% free silica (see above)
- More uniform blasting pattern
- Electrically non-conducting

<table>
<thead>
<tr>
<th>PRODUCT TYPE</th>
<th>US SIEVE SIZE</th>
<th>HARDNESS</th>
<th>BULK DENSITY</th>
</tr>
</thead>
<tbody>
<tr>
<td>Contractor &amp; Industrial</td>
<td>One size (Ultra slightly larger)</td>
<td>6.5 to 7</td>
<td>128-134</td>
</tr>
</tbody>
</table>

HOW IT COMES
- 80 Bags per Pallet
- 1 Bulk Bag per Pallet
- 50,000 Pounds per Bulk Truck

800-800-0665
ABRASIVES

Steel Grit

Steel Grit works well in many tough applications. Common applications are railcars, structural steel and in foundries. Steel Grit is used in airblast rooms and airless wheel blast machines for surface preparation.

Features & Benefits

- Long lasting
- Can be recycled many times
- Low dust
- Does not fracture easily
- Produces an etched surface on metal for superior adhesion of paint, epoxy and other coatings

Steel Shot

Steel Shot is commonly used in applications such as railcars, structural steel and foundries. It is also used in airless wheel blast machines for surface polishing and shot peening. Another common use is in portable trackblast airless wheel blast machines for profiling and concrete floor preparation.

Features & Benefits

- Long lasting
- Can be recycled many times
- Shot peening applications
- Low dust
- Results in a smoother and more polished surface
Walnut Shell

Walnut shell provides an excellent finish without scratching or pitting the surface. It’s relatively dust-free and can be used for deburring, deflashing and tumbling.

Features & Benefits
- Recyclable
- Low dusting

PRODUCT TYPE
Industrial

US SIEVE SIZE
6-10
8-12
12-20
18-40

HARDNESS (MOHS SCALE)
3

BULK DENSITY (LBS PER CU FT)
45

Special Notes, Precautions & Disclaimer

The information contained in this brochure is believed to be accurate but is not warranted with respect to the accuracy of the information or recommendation. Purchasers of the materials listed in this brochure are advised to confirm in advance of need that the information is current and applicable to their circumstances and usage. Variations from tested samples may occur. As the information contained herein may be applied under conditions beyond our control, we assume no responsibility for the use of the materials listed in this brochure.
TECHNICAL DATA

APPROXIMATE STRIPPING RATES (SQ FT PER HOUR)

<table>
<thead>
<tr>
<th>FINISH</th>
<th>SURFACE CONDITION</th>
<th>1/2” Nozzle</th>
<th>7/16” Nozzle</th>
<th>3/8” Nozzle</th>
<th>5/16” Nozzle</th>
<th>1/4” Nozzle</th>
</tr>
</thead>
<tbody>
<tr>
<td>WHITE METAL</td>
<td>LOOSE MILL SCALE</td>
<td>250</td>
<td>200</td>
<td>145</td>
<td>102</td>
<td>61</td>
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<tr>
<td></td>
<td>TIGHT MILL SCALE</td>
<td>211</td>
<td>164</td>
<td>121</td>
<td>84</td>
<td>50</td>
</tr>
<tr>
<td></td>
<td>PITTED PAINT</td>
<td>125</td>
<td>100</td>
<td>71</td>
<td>50</td>
<td>32</td>
</tr>
<tr>
<td></td>
<td>MULTICOATS</td>
<td>100</td>
<td>80</td>
<td>58</td>
<td>40</td>
<td>25</td>
</tr>
<tr>
<td>NEAR WHITE METAL</td>
<td>LOOSE MILL SCALE</td>
<td>265</td>
<td>210</td>
<td>150</td>
<td>106</td>
<td>65</td>
</tr>
<tr>
<td></td>
<td>TIGHT MILL SCALE</td>
<td>220</td>
<td>172</td>
<td>125</td>
<td>90</td>
<td>55</td>
</tr>
<tr>
<td></td>
<td>PITTED PAINT</td>
<td>132</td>
<td>104</td>
<td>75</td>
<td>55</td>
<td>34</td>
</tr>
<tr>
<td></td>
<td>MULTICOATS</td>
<td>106</td>
<td>84</td>
<td>60</td>
<td>44</td>
<td>25</td>
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<tr>
<td>COMMERCIAL</td>
<td>LOOSE MILL SCALE</td>
<td>632</td>
<td>495</td>
<td>360</td>
<td>255</td>
<td>155</td>
</tr>
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<td></td>
<td>TIGHT MILL SCALE</td>
<td>420</td>
<td>320</td>
<td>240</td>
<td>170</td>
<td>102</td>
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<tr>
<td></td>
<td>PITTED PAINT</td>
<td>316</td>
<td>246</td>
<td>181</td>
<td>128</td>
<td>76</td>
</tr>
<tr>
<td></td>
<td>MULTICOATS</td>
<td>210</td>
<td>165</td>
<td>120</td>
<td>85</td>
<td>50</td>
</tr>
<tr>
<td>BRUSH-OFF</td>
<td>LOOSE MILL SCALE</td>
<td>1264</td>
<td>990</td>
<td>720</td>
<td>508</td>
<td>310</td>
</tr>
<tr>
<td></td>
<td>TIGHT MILL SCALE</td>
<td>1264</td>
<td>990</td>
<td>720</td>
<td>508</td>
<td>310</td>
</tr>
<tr>
<td></td>
<td>PITTED PAINT</td>
<td>1264</td>
<td>990</td>
<td>720</td>
<td>508</td>
<td>310</td>
</tr>
<tr>
<td></td>
<td>MULTICOATS</td>
<td>1264</td>
<td>990</td>
<td>720</td>
<td>508</td>
<td>310</td>
</tr>
</tbody>
</table>

SURFACE FINISH STANDARDS

SSPC-SP10 NEAR-WHITE METAL

A Near-White Blast Cleaned Surface, when viewed without magnification, shall be free of all visible oil, grease, dirt, dust, mill scale, rust, paint, oxides, corrosion products, and any other foreign matter, except for staining. Staining shall be limited to no more than 5 percent of each square inch of surface area and may consist of light shadows, light streaks, or minor discolorations caused by stains of rust, stains of mill scale, or stains of previously applied paint.

REFERENCE: SSPC-SP10, Steel Structures Painting Council (U.S.A.)
NACE No. 2, National Association of Corrosion Engineers (U.S.A.)
SA-2-1/2, Swedish Standards Organization
2nd, Quality, United Kingdom Standards (BS 4232)

SSPC-SP5 WHITE METAL

A White Metal Blast Cleaned Surface, when viewed without magnification, shall be free of all visible oil, grease, dirt, dust, mill scale, rust, paint, oxides, corrosion products, and other foreign matter.

REFERENCE: SSPC-SP5, Steel Structures Painting Council (U.S.A.)
NACE No. 1, National Association of Corrosion Engineers (U.S.A.)
SA-3, Swedish Standards Organization
1st, Quality, United Kingdom Standards (BS 4232)

NOTE: Consult with local standards organization to obtain complete specifications on degrees of surface cleanliness.

SSPC photographs are shown courtesy of SSPC: The Society for Protective Coatings. The digital photographs provided do not sufficiently depict the photographs that are available in the actual physical SSPC reference photographs and should not be used in the field for comparison. The SSPC-VIS 1 may be purchased at http://www.sspc.org/marketplace
### TECHNICAL DATA

#### PHYSICAL CHARACTERISTICS OF ABRASIVES

<table>
<thead>
<tr>
<th>MATERIAL</th>
<th>HARDNESS (MOHS SCALE)</th>
<th>GRAIN SHAPE</th>
<th>SPECIFIC GRAVITY</th>
<th>COLOR</th>
<th>FREE SILICA CONTENT</th>
<th>FREE IRON CONTENT</th>
<th>DURABILITY</th>
</tr>
</thead>
<tbody>
<tr>
<td>Corn Cobs</td>
<td>2</td>
<td>Cubical</td>
<td>1.3</td>
<td>Tan</td>
<td>None</td>
<td>None</td>
<td>Good</td>
</tr>
<tr>
<td>Sodium Bicarbonate</td>
<td>2.8</td>
<td>Angular</td>
<td>2.2</td>
<td>White</td>
<td>None</td>
<td>None</td>
<td>Poor</td>
</tr>
<tr>
<td>Walnut Shells</td>
<td>3</td>
<td>Cubical</td>
<td>1.3</td>
<td>Light Brown</td>
<td>None</td>
<td>None</td>
<td>Good</td>
</tr>
<tr>
<td>Soft Shot</td>
<td>3 to 3.5</td>
<td>Spherical</td>
<td>7.0</td>
<td>Steel Gray</td>
<td>None</td>
<td>99%</td>
<td>Excellent</td>
</tr>
<tr>
<td>Plastic Media</td>
<td>3 to 4.0</td>
<td>Angular</td>
<td>1.2</td>
<td>Multi-colored</td>
<td>None</td>
<td>&lt;.002%</td>
<td>Good</td>
</tr>
<tr>
<td>Glass Beads</td>
<td>4.5</td>
<td>Spherical</td>
<td>3.0</td>
<td>Crystal</td>
<td>None</td>
<td>None</td>
<td>Good</td>
</tr>
<tr>
<td>Crushed Glass</td>
<td>6</td>
<td>Angular</td>
<td>3.2</td>
<td>Clear-Brown</td>
<td>None</td>
<td>None</td>
<td>Fair</td>
</tr>
<tr>
<td>Coal Slag</td>
<td>6 to 7</td>
<td>Angular</td>
<td>2.7</td>
<td>Black</td>
<td>&lt;.1%</td>
<td>N/A</td>
<td>Fair</td>
</tr>
<tr>
<td>Steel Shot</td>
<td>6 to 7</td>
<td>Spherical</td>
<td>7.2</td>
<td>Steel Gray</td>
<td>None</td>
<td>99%</td>
<td>Excellent</td>
</tr>
<tr>
<td>Steel Grit</td>
<td>6 to 7</td>
<td>Angular</td>
<td>7.5</td>
<td>Steel Gray</td>
<td>None</td>
<td>99%</td>
<td>Excellent</td>
</tr>
<tr>
<td>Staurolite Mineral</td>
<td>7 to 7.5</td>
<td>Rounded</td>
<td>3.6 to 3.9</td>
<td>Brown</td>
<td>1&lt;% to 3%</td>
<td>1&lt;% to 3%</td>
<td>Fair</td>
</tr>
<tr>
<td>Garnet</td>
<td>7 to 8.3</td>
<td>Cubical</td>
<td>4</td>
<td>Pink to Dark Red</td>
<td>&lt;1%</td>
<td>None</td>
<td>Good</td>
</tr>
<tr>
<td>Aluminium Oxide</td>
<td>9</td>
<td>Cubical</td>
<td>3.8</td>
<td>Brown or White</td>
<td>&lt;1%</td>
<td>&lt;1%</td>
<td>Very Good</td>
</tr>
<tr>
<td>Silicon Carbide</td>
<td>9</td>
<td>Cubical</td>
<td>3.1</td>
<td>Black</td>
<td>&lt;1%</td>
<td>&lt;1%</td>
<td>Good</td>
</tr>
<tr>
<td>Diamonds</td>
<td>10</td>
<td>Cubical</td>
<td>3.5</td>
<td>White-Yellow</td>
<td>&lt;1%</td>
<td>&lt;1%</td>
<td>Very Good</td>
</tr>
</tbody>
</table>

#### ABRASIVES - BULK DENSITY

All direct pressure blast machines are filled by “volume”, not “pounds”, of abrasive. The weight of each type of abrasive is different per Cubic Foot of “volume”. The weight is called the “Bulk Density” of that abrasive.

The chart to the right shows the “Bulk Density” (weight per cubic foot) of several common blast cleaning abrasives.

As a general rule, it can safely be figured that a typical air blast machine can only hold abrasive in about 75% of its inside space. So a typical 650 pound (6.5 Cu. Ft.) machine will only freely hold 488 pounds of abrasive that weighs 100 pounds per Cu. Ft. (Bulk Density). But, that same machine can hold 1219 pounds of Steel Grit, but only 219 pounds of Walnut Shells. But it is still as full as it possibly can be due to its filling angle of repose.

### CONVERSION MULTIPLIERS FACTOR CHART

<table>
<thead>
<tr>
<th>From/To</th>
<th>cm</th>
<th>mm</th>
<th>um</th>
<th>in</th>
<th>mils</th>
</tr>
</thead>
<tbody>
<tr>
<td>cm</td>
<td>1</td>
<td>10</td>
<td>10000</td>
<td>.3937</td>
<td>.03937</td>
</tr>
<tr>
<td>mm</td>
<td>.01</td>
<td>1</td>
<td>1000</td>
<td>.0394</td>
<td>39.37</td>
</tr>
<tr>
<td>um</td>
<td>0.0001</td>
<td>0.001</td>
<td>1</td>
<td>.0000394</td>
<td>.0394</td>
</tr>
<tr>
<td>in</td>
<td>2.54</td>
<td>25.4</td>
<td>25400</td>
<td>1</td>
<td>1000</td>
</tr>
<tr>
<td>mils</td>
<td>0.00254</td>
<td>0.00254</td>
<td>2.54</td>
<td>.0001</td>
<td>1</td>
</tr>
</tbody>
</table>

Example: 4.5 miles - 4.5 x 25.4 = 114.3 millimeters

cm=Centimeter  um=Micron (micrometer)  mm=Millimeter  in=Inch  mils=Thou (1/1000 of an inch)
Most abrasive blast equipment requires a minimum pressure of 100 PSI in order for the control system to function properly. To maintain the 100 PSI minimum and lower the CFM requirement of blasting, a pressure regulator can be installed downstream of the control air connection. Example: if blasting with a #5 nozzle, the CFM requirement can be lowered from 140 to 115 by regulating the pressure to 80 PSI.

When calculating your CFM requirements, the air used by each respirator must be taken into account. A general rule is each respirator will require an additional 6-16 CFM. PSI and type of control device will affect the CFM used. Consult the owners manual for your respirator for more on specific PSI and CFM requirements.

This table is to be used as reference only. Actual results may vary depending on specific abrasive media used. This table is based on abrasive with a bulk density of 100 pounds per cubic foot.

<table>
<thead>
<tr>
<th>NOZZLE# ORIFICE SIZE</th>
<th>AIR &amp; ABRASIVE RATES</th>
<th>NOZZLE PRESSURE</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>AIR</td>
<td>50 PSI (3.5 BAR)</td>
</tr>
<tr>
<td>#2 1/8 inch (3.2 mm)</td>
<td>AIR (cu ft/min)</td>
<td>12</td>
</tr>
<tr>
<td></td>
<td>(cu m/min)</td>
<td>.34</td>
</tr>
<tr>
<td></td>
<td>ABRASIVE (lb/hr)</td>
<td>70</td>
</tr>
<tr>
<td></td>
<td>(kg/hr)</td>
<td>32</td>
</tr>
<tr>
<td>#3 3/16 inch (4.8 mm)</td>
<td>AIR (cu ft/min)</td>
<td>25</td>
</tr>
<tr>
<td></td>
<td>(cu m/min)</td>
<td>0.71</td>
</tr>
<tr>
<td></td>
<td>ABRASIVE (lb/hr)</td>
<td>150</td>
</tr>
<tr>
<td></td>
<td>(kg/hr)</td>
<td>68</td>
</tr>
<tr>
<td>#4 1/4 inch (6.35 mm)</td>
<td>AIR (cu ft/min)</td>
<td>50</td>
</tr>
<tr>
<td></td>
<td>(cu m/min)</td>
<td>1.42</td>
</tr>
<tr>
<td></td>
<td>ABRASIVE (lb/hr)</td>
<td>270</td>
</tr>
<tr>
<td></td>
<td>(kg/hr)</td>
<td>122</td>
</tr>
<tr>
<td>#5 5/16 inch (8 mm)</td>
<td>AIR (cu ft/min)</td>
<td>80</td>
</tr>
<tr>
<td></td>
<td>(cu m/min)</td>
<td>2.27</td>
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<tr>
<td></td>
<td>ABRASIVE (lb/hr)</td>
<td>470</td>
</tr>
<tr>
<td></td>
<td>(kg/hr)</td>
<td>213</td>
</tr>
<tr>
<td>#6 1/8 inch (9.5 mm)</td>
<td>AIR (cu ft/min)</td>
<td>110</td>
</tr>
<tr>
<td></td>
<td>(cu m/min)</td>
<td>3.12</td>
</tr>
<tr>
<td></td>
<td>ABRASIVE (lb/hr)</td>
<td>675</td>
</tr>
<tr>
<td></td>
<td>(kg/hr)</td>
<td>306</td>
</tr>
<tr>
<td>#7 7/16 inch (11.1 mm)</td>
<td>AIR (cu ft/min)</td>
<td>150</td>
</tr>
<tr>
<td></td>
<td>(cu m/min)</td>
<td>4.25</td>
</tr>
<tr>
<td></td>
<td>ABRASIVE (lb/hr)</td>
<td>900</td>
</tr>
<tr>
<td></td>
<td>(kg/hr)</td>
<td>408</td>
</tr>
<tr>
<td>#8 1/2 inch (12.7 mm)</td>
<td>AIR (cu ft/min)</td>
<td>200</td>
</tr>
<tr>
<td></td>
<td>(cu m/min)</td>
<td>5.66</td>
</tr>
<tr>
<td></td>
<td>ABRASIVE (lb/hr)</td>
<td>1200</td>
</tr>
<tr>
<td></td>
<td>(kg/hr)</td>
<td>544</td>
</tr>
<tr>
<td>#10 5/8 inch (16 mm)</td>
<td>AIR (cu ft/min)</td>
<td>300</td>
</tr>
<tr>
<td></td>
<td>(cu m/min)</td>
<td>8.50</td>
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<tr>
<td></td>
<td>ABRASIVE (lb/hr)</td>
<td>1900</td>
</tr>
<tr>
<td></td>
<td>(kg/hr)</td>
<td>862</td>
</tr>
<tr>
<td>#12 3/4 inch (19 mm)</td>
<td>AIR (cu ft/min)</td>
<td>430</td>
</tr>
<tr>
<td></td>
<td>(cu m/min)</td>
<td>12.18</td>
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<tr>
<td></td>
<td>ABRASIVE (lb/hr)</td>
<td>2700</td>
</tr>
<tr>
<td></td>
<td>(kg/hr)</td>
<td>1225</td>
</tr>
</tbody>
</table>

*100 PSI MIN/REDUCE CFM REQUIRED
Most abrasive blast equipment requires a minimum pressure of 100 PSI in order for the control system to function properly. To maintain the 100 PSI minimum and lower the CFM requirement of blasting, a pressure regulator can be installed downstream of the control air connection. Example: if blasting with a #5 nozzle, the CFM requirement can be lowered from 140 to 115 by regulating the pressure to 80 PSI.

**RESPIRATOR REQUIREMENTS**
When calculating your CFM requirements, the air used by each respirator must be taken into account. A general rule is each respirator will require an additional 6-16 CFM. PSI and type of control device will affect the CFM used. Consult the owners manual for your respirator for more on specific PSI and CFM requirements.

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