

Airblast data - HG steel grit

The below figures are given as a guide, but the actual consumption rate, cleaning rate and surface roughness profile will vary between blasting operations depending upon factors such as air pressure and nozzle size and type. It will also be dependent upon the angle of blasting, the distance of the nozzle to the work piece and the size grading of the abrasive operating mix.

Abrasive consumption per grade at 6 bar pressure 10mm long venturi nozzle

	kgs/m ²
HG80	0.18
HG50	0.20
HG40	0.25
HG25	0.30
HG18	0.35

Cleaning rate per grade at 6 bar pressure 10mm long venturi nozzle

	m ² /hr
HG80	24
HG50	22
HG40	20
HG25	18
HG18	15

Abrasive consumption in relation to blast pressure - HG40

Bar	kgs/m ²
5.0	0.23
5.5	0.24
6.0	0.25
6.5	0.27
7.0	0.29
7.5	0.31
8.0	0.33

Surface roughness profile per grade at 6 bar pressure 10mm long venturi nozzle

	Ra (0.25 mm cut-off)		Rz (0.25 mm cut-off)	
	HG80	5 µm	8 µm	35 µm
HG50	7 µm	11 µm	50 µm	70 µm
HG40	10 µm	14 µm	65 µm	95 µm
HG25	12 µm	17 µm	80 µm	110 µm
HG18	14 µm	20 µm	95 µm	130 µm