



# TECHNICAL BULLETIN

## ABRASIVE BLAST CONSUMPTION, PRODUCTION and CLEANING RATES

The following informational data is provided as an estimating tool for dry abrasive blast operation in the preparation of steel and concrete substrates

### ABRASIVE BLAST AIR/MEDIA CONSUMPTION and PRODUCTION RATES

*\* Cubic feet per minute at pressures shown - recommend 90 psi - 100 psi using #5 or #6 nozzles \**

NOZZLE ORIFICE SIZE	50 psi	60 psi	70 psi	80 psi	90 psi	100 psi	ABRASIVE CONSUMPTION (LBS/HR)	BLAST RATE (FPM)
3/32"	8	9	11	12	13	15	70-100	0.5
1/8" #2	15	17	19	21	24	26	125-175	1-1.5
5/32"	26	30	34	38	43	47	175-250	2-2.5
3/16" #3	33	38	43	48	53	58	275-400	3-3.5
1/4" #4	58	67	76	85	94	103	500-700	4-4.5
5/16" #5	91	105	119	133	146	161	800-1100	5-5.5
3/8" #6	130	151	171	191	211	232	1200-1600	6-6.5
7/16" #7	178	206	233	260	286	315	1700-2200	7-7.5
1/2" #8	232	268	304	340	376	412	2300-2800	8-8.5



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## ABRASIVE BLAST PROFILE, CONSUMPTION and CLEANING RATES

*\*Three tests conducted on mill scale bearing carbon steel using a #4 venturi nozzle, 1/2" metering valve setting, 18" nozzle-to-surface distance, and 100 psi nozzle pressure\**

ABRASIVE	SIZE/ BLEND	PROFILE (MILS)	CONSUMPTION RATE (LBS/SQ FT)	CLEANING RATE (SQ FT/MINUTE)
LAPIS GOLD SILICA SAND	30	2.5	11.0	0.95
		2.6	11.0	0.94
		2.8	12.0	0.86
KLEEN BLAST CLASSIC ABRASIVE	16/30	4.1	16.9	0.56
		3.7	15.0	0.63
		3.7	12.5	0.75
KLEEN BLAST CLASSIC ABRASIVE	35	3.7	8.8	0.83
		2.9	8.0	1.33
		3.7	7.4	1.37
KLEEN BLAST CLASSIC ABRASIVE	30/60	3.3	8.9	1.32
		3.4	6.0	1.53
		3.4	7.8	1.11
GREEN DIAMOND NICKEL SLAG	16/30	3.8	16.7	0.45
		3.9	15.4	0.51
		3.7	16.4	0.47
10X KINETIX SUPEROXALLOY	20/70	4.0	13.5	0.73
		4.1	15.0	0.962
		4.1	14.3	0.65

Blast area coverage per minute and abrasive consumption are approximate guidelines.  
Abrasive material (media) and surface blasted may alter results