

# DURALUM P BLASTYTE® GRAIN

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## DESCRIPTION

A medium density, medium Titania regular brown fused alumina. It is superior to natural abrasives such as silica sand and flint and in some instances is preferable to chilled iron and steel shot. Lots of extremely sharp cutting points results in high power penetration, coupled with long life and reusability, due to its extreme toughness.

Duralum Blastyte's® is processed in England from Virgin Brown Fused Alumina made in closely controlled fusion plants and meet the Rolls Royce CSS-12 and MOD quality requirements. Production is controlled by the Quality Management System of BS EN ISO 9001.

## APPLICATIONS

Typical uses include: - Removal of foundry sand from castings, Preparation of metal surfaces for painting, Electroplating, Enamelling or bonding of plastics/rubber etc. Removing fillets, feather edge and metal fuzz from grinding; Etching surfaces for metal spraying; Production of opaque designs on glass and pressure blasting of granite, marble and stone.

In applications for work pieces such as aero engines or stainless steel components where an abrasive free from metallic lead and iron is required, then Blastyte P® quality must be used.

## TYPICAL CHEMICAL ANALYSIS

|                                |        |
|--------------------------------|--------|
| Al <sub>2</sub> O <sub>3</sub> | 96.12% |
| SiO <sub>2</sub>               | 0.67%  |
| TiO <sub>2</sub>               | 2.70%  |
| Fe <sub>2</sub> O <sub>3</sub> | 0.11%  |
| MgO & CaO                      | 0.40%  |

## RECOMMENDED GRIT SIZES TO USE

Coarse grit sizes 14/24,20/24, and 24/30 can be used on steels and cast iron which need cleaning or roughing up in readiness for subsequent treatment, except on plates of 1.5mm or less. Medium grit sizes 60/80, 60/120, and 80/120 can be used on brass, aluminium, alloy castings, and soft ductile metals. Fine finishes on glass, plastic moulds, and other metals can be obtained using finer grit sizes 120/220,180/220, etc. Straight grits can also be used effectively.

Best results are usually obtained if the nozzle tip is held 100-150mm from the workpiece and at an angle of 45° to the surface.

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# DURALUM P BLASTYTE® GRAIN (PG.2)

## THE CROSS GRIT SIZE RANGE FOR P® QUALITIES IS AS FOLLOWS

| GRIT SIZE     | FORMER DESIGNATION | ASTM MESH | MESH APERTURE | GRIT SIZE SPECIFICATION |
|---------------|--------------------|-----------|---------------|-------------------------|
| <b>14/24</b>  | No1                | +8        | 2.36mm        | Nil                     |
|               |                    | +12       | 1.70mm        | 20% max                 |
|               |                    | +35       | 0.50mm        | 75% min                 |
|               |                    | <35       |               | 3% max                  |
| <b>20/24</b>  |                    | +12       | 1.70mm        | Nil                     |
|               |                    | +16       | 1.18mm        | 20% max                 |
|               |                    | +35       | 0.50mm        | 75% min                 |
|               |                    | <35       |               | 3% max                  |
| <b>24/30</b>  |                    | +16       | 1.18mm        | Nil                     |
|               |                    | +20       | 0.85mm        | 25% max                 |
|               |                    | +40       | 0.42mm        | 70% min                 |
|               |                    | <40       |               | 3% max                  |
| <b>30/40</b>  | No2                | +18       | 1.00mm        | Nil                     |
|               |                    | +25       | 0.71mm        | 15% max                 |
|               |                    | +40       | 0.42mm        | 75% min                 |
|               |                    | <40       |               | 15% max                 |
| <b>40/60</b>  |                    | +20       | 0.85mm        | Nil                     |
|               |                    | +30       | 0.60mm        | 15% max                 |
|               |                    | +50       | 0.30mm        | 75% min                 |
|               |                    | <50       |               | 15% max                 |
| <b>60/80</b>  | No3                | +30       | 0.60mm        | Nil                     |
|               |                    | +40       | 0.425mm       | 15% max                 |
|               |                    | +100      | 0.15mm        | 75% min                 |
|               |                    | <100      |               | 15% max                 |
| <b>60/120</b> | No3/4              | +40       | 0.425mm       | Nil                     |
|               |                    | +50       | 0.30mm        | 30% max                 |
|               |                    | +230      | 0.063mm       | 65% min                 |
|               |                    | <230      |               | 3% max                  |

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# DURALUM P BLASTYTE® GRAIN (PG.3)

## THE CROSS GRIT SIZE RANGE FOR P® QUALITIES IS AS FOLLOWS (CONT.)

| GRIT SIZE      | FORMER DESIGNATION | ASTM MESH          | MESH APERTURE | GRIT SIZE SPECIFICATION |
|----------------|--------------------|--------------------|---------------|-------------------------|
| <b>80/120</b>  | No4                | +50                | 0.30mm        | Nil                     |
|                |                    | +70                | 0.212mm       | 15% max                 |
|                |                    | +140               | 0.106mm       | 75% min                 |
|                |                    | <140               |               | 15% max                 |
| <b>120/150</b> |                    | +80                | 0.180mm       | Nil                     |
|                |                    | +120               | 0.125mm       | 10/20%                  |
|                |                    | +230               | 0.063mm       | 75% min                 |
|                |                    | +270               | 0.053mm       |                         |
|                |                    | <270               | 0.053mm       | 3% max                  |
| <b>120/220</b> | No5                | +80                | 0.180mm       | Nil                     |
|                |                    | +120               | 0.125mm       | 15% max                 |
|                |                    | (+120 & 230)       | 0.063mm       | 75% min                 |
|                |                    | <230               |               | 15%                     |
| <b>150/220</b> |                    | +100               | 0.150mm       | Nil                     |
|                |                    | +140               | 0.106mm       | 15% max                 |
|                |                    | +325               | 0.045mm       | 70% min                 |
|                |                    | <325               |               |                         |
| <b>180/220</b> | No6                | +120               | 0.125mm       | Nil                     |
|                |                    | +170               | 0.090mm       | 15% max                 |
|                |                    | (+170, 270, & 325) | 0.045mm       | 60% min                 |
| <b>400R</b>    |                    | +200               | 0.075mm       | Nil                     |
|                |                    | +270               | 0.053mm       | 5% max                  |
|                |                    | +325               | 0.045mm       |                         |
|                |                    | <325               |               | 85% min                 |

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