



**Norton Sandblasting Equipment**

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## BLASTING CHART

### NOZZLE TYPE

Nozzle No.	#8	#7	#6	#5	#4	#3	#2
<b>Nozzle Size</b>	<b>1/2"</b>	<b>7/16"</b>	<b>3/8"</b>	<b>5/16"</b>	<b>1/4"</b>	<b>3/16"</b>	<b>1/8"</b>
CFM @ 100psi	350	260	200	150	90	49	22
<b>Air Hose</b> - 4-5 times nozzle bore size	2	1-1/2"	1-1/2"	1-1/4"	1-1/4"	1	3/4"
<b>Sand Blast Hose</b> - 3 times nozzle bore size	1-1/2"	1-1/2"	1-1/4"	1	3/4"	3/4"	1/2"
Mat. LB/HR	2200	1650	1200	900	525	320	140

### SURFACE CONDITION

### SQUARE FEET PER HOUR

#### White Metal

Loose Mill Scale	250	200	145	102	61
Tight Mill Scale	211	164	121	84	50
Pitted Paint	125	100	71	50	32
Multicoats	100	80	58	40	25

#### Near White

Loose Mill Scale	265	210	150	106	65
Tight Mill Scale	220	172	125	90	55
Pitted Paint	132	104	75	55	34
Multicoats	106	84	60	44	25

#### Commercial

Loose Mill Scale	632	495	360	255	155
Tight Mill Scale	420	320	240	170	102
Pitted Paint	316	246	181	128	76
Multicoats	210	165	120	85	50

#### Brush

Loose Mill Scale	1264	990	720	508	310
Tight Mill Scale	1264	990	720	508	310
Pitted Paint	1264	990	720	508	310
Multicoats	1264	990	720	508	310

**USE THIS CHART AS A GUIDE; INDIVIDUAL PERFORMANCE MAY VARY**

#### BRUSH-OFF

Tightly adherent mill scale and rust may remain on the surface. Mill scale and rust are considered adherent if they cannot be removed with a dull putty knife.

SSPC-SP 7  
NACE No. 4  
SA-1

#### COMMERCIAL

Evenly dispersed very light shadows, streaks and discolorations caused by stains of rust and mill scale may remain on no more that 33% of the surface.

SSPC-SP 6  
NACE No. 3  
SA-2

#### NEAR-WHITE METAL

Evenly dispersed very light shadows, streaks and discolorations caused by stains of rust and mill scale may remain on 5% of the surface.

SSPC-SP 10  
NACE No. 2  
SA-2-1/2

#### WHITE METAL

Free of all visible oil, grease, dirt, dust, mill scale and rust.

SSPC-SP 5  
NACE No. 1  
SA-3