

BLAST PROCEDURES FOR MAGIC[®] II 30/60 ON ALUMINUM & COMPOSITE SUBSTRATES

These procedures are set as starting points for different types of substrate. Due to thickness or sensitivity of the substrate, or thickness of the coatings, they may be varied to optimize performance.

BARE ALUMINUM SUBSTRATES:

1/2" or 3/8" double venturi nozzle
30 psi - maximum
0° - 90° angle - drop to 30° angle to selective strip coatings
1"-18"standoff
450 to 600 lbs./hour flow rate depending on nozzle used - this can be achieved by adding differential pressure to the top of the pot by adjusting choke valve

AL CLAD ALUMINUM SUBSTRATES:

1/2" or 3/8" double venturi nozzle
10 - 25 psi - maximum
0° to 90° angle - drop to 30° angle to selective strip coatings
1"-18"standoff
450 to 600 lbs./hour flow rate depending on nozzle is used

THIN SKINS:

1/2" or 3/8" double venturi nozzle
Pressure determined by starting at 10 psi, increasing to no more than 30 psi
25 psi normally best on thin skins
0° - 90° angle
1"-18"standoff
450 - 600 lbs./hour flow rate depending on nozzle used

COMPOSITE SUBSTRATES:

1/2" or 3/8" double venturi nozzle
Pressure determined by starting at 10psi, increasing to no more than 30psi
15 - 20 psi normally best on composites
0° - 90° angle - drop to 30° angle to selective strip coatings
1" - 18" standoff
450 to 600 lbs./hour flow rate depending on nozzle used