

Starblast™

Blasting Abrasive

Starblast™ Guidelines



Where to Use Starblast™

Starblast™ is a unique mineral abrasive that is especially valuable in industries where blasting applications are common. Users of Starblast™ in the steel fabricating industry, for example, find it very effective in removing mill scale and rust from steel. Paints of all types are removed effectively by Starblast™. Power companies use Starblast™ for maintenance work where critical equipment, such as electric motors, cannot tolerate exposure to large volumes of dust.

Regardless of the industry, operators of blasting equipment prefer Starblast™. They find that Starblast™ offers excellent accuracy in cutting and confined spot preparation. Also, the precise control and manageability enables them to do an excellent job at feathering edges. White metal finishes, which are difficult to achieve with many abrasives, are readily available with Starblast™. Near white, commercial or brush-off finishes are also

easily achievable using Starblast™. Operators can simply accomplish this by working faster or using a greater “nozzle-to-work” distance.

Starblast™ often is chosen to clean vital equipment such as pipe used in hydraulic applications. Here, the rounded grains of the product eliminate costly problems caused by abrasive embedding in metal and eventually coming loose.

Starblast™ XL is used for applications requiring abrasives containing less than 1% free silica.

How to Use Starblast™ Effectively

Starblast™ works in all air-blast equipment designed for loose abrasives at a much leaner abrasive/air ratio. Adjusting the correct amount of feed is done by starting the blast operation with the abrasive feed valve in the closed position. Slowly open the feed valve until the abrasive stream is just visible. At this point, slowly close the feed valve until the abrasive stream can no longer be seen. (Generally, it is better to feed too little Starblast™ than too much.) With this proper abrasive/air mixture, blasting can now begin. (**Table 1** shows the relationship of air volume to nozzle diameter.)

Starblast™ can make a good blasting operation even better. It cannot, however, produce maximum value if poor blasting practices are used, such as low air pressure, incorrectly sized or worn nozzles, or improper abrasive feed rates. The correct abrasive/air mixture is important, especially when using Starblast™. Slight movement of the feed valve can cause large changes in abrasive consumption. **Table 2** shows recommended Starblast™ flow rates at various nozzle pressures.

Table 1. Air (in cubic feet per minute) as a function of nozzle diameter and nozzle pressure

Nozzle diameter in fractions of an inch (cubic feet per minute)	Nozzle Pressure, psi							
	50 PSI	60 PSI	70 PSI	80 PSI	90 PSI	100 PSI	120 PSI	140 PSI
1/4	47	54	61	68	74	81	105	121
5/16	77	89	101	113	126	137	160	185
3/8	108	126	143	161	173	196	235	270
7/16	147	170	194	217	240	254	315	360
1/2	195	224	252	280	309	338	410	470
5/8	308	356	404	452	504	548	640	740
3/4	432	504	572	644	712	784	925	1060

- To protect the compressor, allow intermittent operation by using only 70–80% of its rated output.
- Pressure drops as hose length increases, and more volume is needed to run a given nozzle at a desired pressure. Use hypodermic gauges to find nozzle pressures.

Table 2. Recommended Starblast™ Flow Rates, lb/hr*

Nozzle Pressure, psi				
80	90	100	110	120
500	550	720	800	900

* Based upon the use of a No. 6 (3/8 in) nozzle. Approximate flow rates only. For best performance, adjust abrasive valve until optimum cleaning rate is achieved.

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Replaces: H-69480-4
C-10409-1 (7/17)