

De-burring

Section 2

Factors enabling Pressure Blast to remove burrs without excess stock removal or loss of finish:

- Abrasive size
- Velocity
- “Water cushion” Affect on Surface

Abrasive size:

Wet blast will be able to achieve a finer surface finish than dry blast. The water can be mixed with various mesh size up to 5000 mesh on the fine side. Abrasives in the larger sizes will generally hold tolerances to .0001” and micro-inch finishes as low as 4 RMS since they are microscopic, relatively soft and do not have any tendency to etch heavily.

Velocity:

In high velocity pressure blasting the slurry stream can reach 1700FPS for faster cleaning. Regular velocity (suction) slurry stream can reach 680FPS for lighter or a more delicate blast application.

“Water Cushion” Affect on Surface:

Generally, wet blasting cleans surface preps and de-burrs with a scrubbing action verses impingement and abrasion with dry blasting.

Pressure blast as a burr removal method is basically effective only on true burrs resulting from machining operations.