



Optimising Blast Performance with GMA Garnet™

Optimising blast performance

– Easy as **ABC**

These tips will allow you to attain the most efficient and effective blast operation with all GMA Garnet™ abrasives.

A

✓ **ABRASIVE SELECTION**



A1 Select garnet grade based on technical specification

✓ TIP:

- The substrate, coating type, coating thickness and required anchor profile should influence your garnet grade selection.

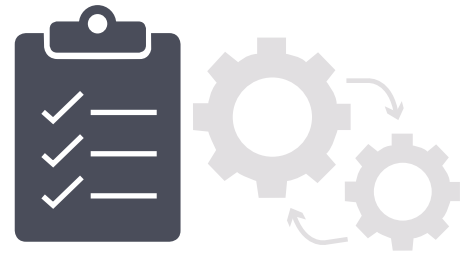
A2 Store your garnet in a dry location for an effective blast result

✓ TIP:

- Moisture in your garnet can cause blockages in your blast pot.



B



✓ BLAST EQUIPMENT

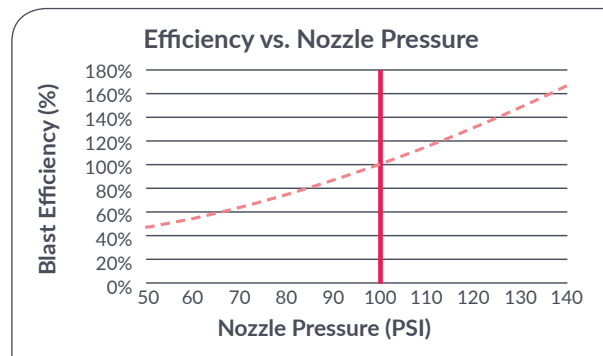
B1 Optimal pressure is instrumental to success

✓ TIP:

- Pressure at the blast nozzle should be set at a minimum of 100 psi.
- Blasting efficiency drops 1.5% for every 1 psi below 100.
- When attaching additional equipment, the compressor should be sized appropriately to maintain sufficient air pressure at every nozzle (minimum 100 psi).



100 PSI
MINIMUM
PRESSURE



B2 Proper valve control ensures optimal garnet consumption

✓ TIP:

- Having the right abrasive metering valve is crucial. Avoid using a ball, flat or pancake metering valve.
- Open and close the valve by a few turns to ensure accurate metering. Test production rate by blasting on the surface.
- The right abrasive metering can help reduce garnet consumption by 25%.

B3 Use a partner to achieve optimal blast results

✓ TIP:

- Have a separate person adjusting the metering valve in line with the blaster's instructions.
- Hearing a chugging sound means too much abrasive is being used.
- The abrasive exiting the nozzle should be almost invisible.



B4 Nozzle size and its condition affects blast efficiency

✓ TIP:

- Nozzle sizing should be dependent on project specification and air availability.
- A small increase in nozzle size will result in a large increase in air and abrasive consumption.
- Check for nozzle wear with a nozzle-sizing gauge prior to each shift. Replace nozzle when it is worn to 2mm of its original size.

B5 Blast with cool, dry compressed air

✓ TIP:

- Cool, dry compressed air blasts up to 15% faster.
- Increased moisture can increase garnet consumption by 25% or more.



COOL

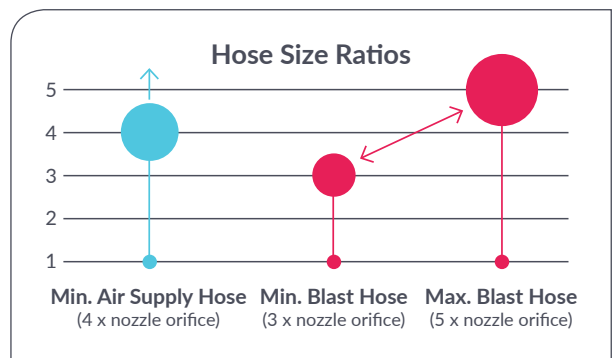


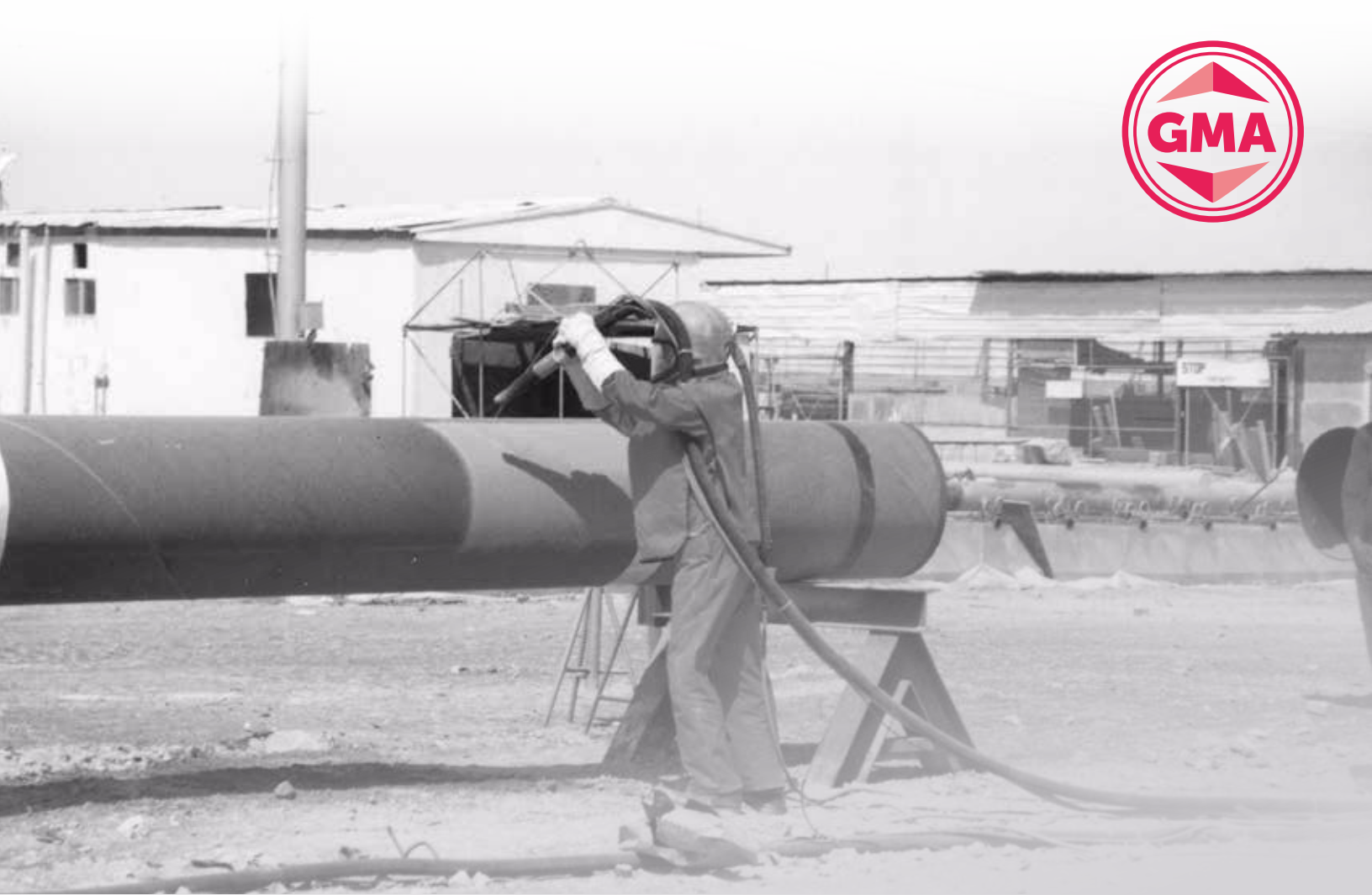
DRY

B6 Shorter air supply hose and the correct hose size will minimise pressure drops

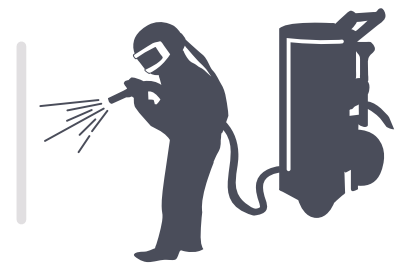
✓ TIP:

- Minimum diameter for air supply hose – 4 times the blast nozzle orifice.
- Minimum diameter for blast hose – 3 times the blast nozzle orifice.
- Maximum diameter for blast hose – 5 times the blast nozzle orifice.





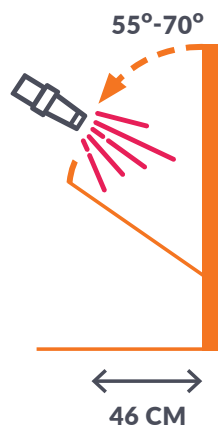
✓ CORRECT TECHNIQUE



C1 Ensure proper standoff distance

✓ TIP:

- Approximately 18 inches (46 cm), depending on nozzle type and application.
- Stand off distance varies by circumstance and other blasting parameters.



C2 Optimise nozzle angle

✓ TIP:

- The nozzle should be angled between 55° and 70° to the substrate surface.

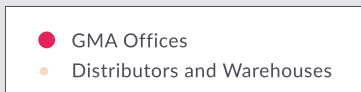
C3 Use a consistent blast motion

✓ TIP:

- Apply uniform strokes for consistent blasting.
- Allow proper overlap in blasting per application.
- Check blasted surface profile using Testex Tape with a spring micrometer or an approved digital device.

Worldwide Distribution

Offices



Worldwide Distribution

GMA Garnet™ is used as a blast cleaning abrasive across a wide range of industries. We offer a complete range of garnet abrasives for any surface preparation requirement, from removing resistant coatings and heavy rust, to delicate restoration work.

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Why blast with GMA Garnet?

Throughout the world, GMA Garnet™ is recognised as the leading high performance, cost effective and safe blast abrasive for a variety of applications.



Higher Productivity
Superior cleaning rate against other abrasives.



Superior Surface Finish
Exceptionally clean surface & uniform profile.



Cost Effective
Lower garnet consumption, labour, clean up and disposal cost.



Safer
Meets all industry safety and environmental standards.



more than just garnet