

ARMEX® Blast Media
Profile Formula XL2+® with SupraKleen™
Product Code 69091
NSN 5350-01-414-1901

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ARMEX® Blast Media, Profile Formula XL2+® with SupraKleen™ Rinse Accelerator is specially formulated for use with the ACCUSTRIP SYSTEM™ Delivery Devices. The media is based on sodium bicarbonate (baking soda) which is a natural, water soluble, inorganic compound. The media contains about 10% hard abrasive and can be used to remove rust, mill scale and any hard to remove coating. It can also be used to achieve a white metal surface providing a 1.5 - 2 mils profile on steel. Additionally, it provides superior rinsing properties resulting in a cleaner surface vs. traditional methods.

Key Features and Benefits

- Optimized crystal size significantly improves cleaning & depainting performance
- Removes rust, mill scale and any hard to remove coatings
- Achieves a white metal surface providing 1.5-2 mils profile on steel
- Superior rinsing properties provides a cleaner surface
- Free flowing qualities reduce flow problems associated with other baking soda-based blast medias
- 90% water soluble - reduces waste volume and disposal costs
- Nontoxic & nonhazardous as defined by EPA & OSHA
- Contains no free silica and is nonflammable* resulting in significant worker safety advantages
- Contains no solvents or caustic chemicals - reduced air pollution
- USDA-approved as an A-1 cleaner and suitable for use in FDA-regulated facilities

** Caution: may cause thermal sparks when striking the work piece. Not for use in potentially explosive or flammable areas.*

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Information on Ingredients

- Contains sodium bicarbonate that meets USP (United States Pharmacopeia) standards and typically has less than 50 ppm each of chloride & sulfate ions.
- Contains proprietary hard abrasive for heavy duty depainting and surface preparation
- Contains a flow aid that has a surface area greater than 220 m²/gm for greatly improved flow properties
- Contains a patented rinse aid system to aid in the rinsing of spent media and process residues from the surface

Particle Size

The media has an optimized particle size distribution as follows:

- Retained on 40 mesh sieve (425 microns): 25% max.
- Retained on 60 mesh sieve (250 microns): 65% min.
- Retained on 100 mesh sieve (150 microns): 90% min.
- Retained on 170 mesh sieve (90 microns): 95% min.

Blast Media Type	Rinsing Characteristics	Amount of Grease/Oil Deposited
Profile Formula XL2+® with SupraKleen™	Water sheets off metal surface, indicating absence of grease/oil.	Not Detectable
Competitive Blast Media	Water beads on metal surface, visible grease/oil left behind	>0.1 gm/ft ²

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Flow Characteristics

Flow characteristics of the media were determined using a Hosokawa Powder Tester and results are summarized in the table below. Any media that has a total flowability index of more than 80 is considered to have very good flow properties.

Type of Test (Max. Score)	Flowability Index (Typical Values)
Angle of Repose (25)	18-20
Compressibility (25)	23
Angle of Spatula (25)	18-20
Uniformity (25)	23-24
Total (100)	82-87

Corrosion Data

Aluminum and carbon steel coupons were immersion tested in saturated solutions at 120 F for 14 days. Corrosion rates of the media were found to be significantly lower than those of distilled water.

Product	Immersion Corrosion Rate (mils/yr.)		
	AL-7075	AL-5050	CS-1020
Distilled Water	1.15	1.11	9.0
ARMEX® Blast Media	0.25	0.20	0.17

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Paint Adhesion

New carbon steel panels were blasted, rinsed, and dried. The panels were then coated with two coats of Tnemec Series 66 Hi-Build Epoxy paint and passed the following paint adhesion tests:

Elcometer Adhesion Test (ASTM D-4541)

All panels exceeded the 1,000 psi min. specified by Tnemec.

Measuring Adhesion By Tape Test (ASTM D-3359)

All panels were classified 5B, indicating no flaking of the paint.

Typical Operating Conditions

The media is specially formulated for use with the ACCUSTRIP SYSTEM™ Delivery Devices. Typical operating conditions are summarized as follows:

Air Pressure:	50-100 psi (3.5-7 bar)
Air Volume:	100-300 cfm (2,800-8,500 liters/min)
Media Flow Rate:	0.5-3 lbs/min. (0.2-1.4kg/min.)
Water Flow Rate:	0-2 gpm (0-7.6 liters/min.)

Packaging

The media is packaged in 50-lb (22.7 kg) multi-walled bags with tuck-in sleeve valves.

Safety

ARMEX® Blast Media has an excellent health and safety profile. It presents minimal risk to workers from either short term acute exposure or long term (chronic or subchronic) exposure. Please refer to MSDS for details.

Testing and Approval

- USDA approved as A-1 cleaner
- Suitable for use in FDA-regulated facilities
- ISO 9002 certified

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General Properties

Appearance.....White crystalline powder

Bulk Density..... 60 lbs/ft² (1 g/cc)

Taste.....Slightly alkaline

Specific Gravity.....2.2

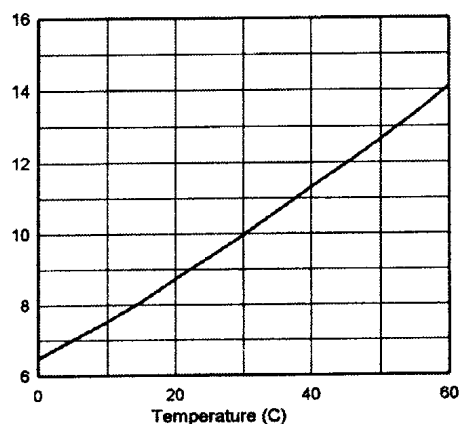
Solubility in Water.....See Figure 1

Solubility in Alcohol.....Insoluble

pH (8% solution)..... 8.2

Mohs Hardness.....2.5

Figure 1 Solubility in Water



Patents

ARMEX® Blast Media, Profile Formula XL2+® with SupraKleen™ is covered by the following patents:

US Patent #'s 5,081,799; 5,083,402; 5,160,547; 5,230,185; 5,308,403;
 5,316,587; 5,338,323; 5,439,493;
 other patents pending.

For additional information, please call 1-800-221-0453.

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