

## Abrasive Blast Data Card

<b>Title</b>  Abrasive Blasting as per RRP56006	<b>Doc Refer No:</b> DCGB-FW71169-01
	<b>Issue:</b> 01
<b>Material Group:</b> <u>Nickel and Steel based materials:</u> (Blast cabinet 1: 2A1024MSB01 Blast cabinet 2: 2A0325MSB02) <b>IAMPL Vendor code:</b> 249067	<b>Date:</b> 04-04-2025
<b>Customer:</b> Rolls Royce	

### 1. Blasting Parameters: Refer Tables 1 & 2.

**Table-1**

Description	Details
Blasting Mode	Auto
Process type	Dry Blasting
Equipment type	Direct Pressure
Media size and type	18-24 size - White Alumina
Nozzle Type & diameter	Tungsten carbide lining with Aluminum Body & Diameter 5.7-9 mm
Gun to work distance	135-165 mm
Angle of blast	Approximately 65-85°
Surface roughness	5-10.25 microns
Operating Pressure	10 -40 psi
Media flow setting	Through control setting. ( Refer Figure-1 )

\*Agreed for External Laboratory Rolls-Royce  
- Approval subjected to Approval Plan# 249067-2024-001140 Issue 1  
and Deviation Plan# DP03565 Issue 2.  
- This DC to be used along with FW71169-TP2-01 Rev 1,  
OIS-6PII-FW71169-01 Rev 1 and FW71169-TP2-01 Rev 1.

Retention category  A	Prepared by  Sathish kumar T	Approved by	Page 1 of 1
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Pinch valve always should be placed in the same marking position.

**FIGURE-1**

**Table-2**

SI/No	Part Number	Program name or Job Code	Traverse Speed (mm/sec)	No. of Passes	Table Rotation (In RPM)	Blasting Time (in mins)	Special Tool/Fixture	Masking	Remarks
1	FW71169	FW71169-Above	0.7	4	4	10±5	Refer FW71169 TP2-01	Refer FW71169 TP2-01	The blasting area should be placed facing towards the top side.
		FW71169-Below	0.7	4	4	10±5			The blasting area should be placed facing towards the bottom side.

2. **Part Cleaning method:** After blasting all traces of dust or Grit shall be removed from the surface by means of clean Soft brush followed by air blast.
3. **Program Verification:** Before starting, ensure distance between the Test coupon and nozzle, Angle with frozen parameters mentioned in program.
4. **Inspection Requirement per RRP 56006:**
  - All component surfaces to be coated shall have been blasted to give a uniform matt gray appearance and coverage, with no evidence of contamination.

Retention category <b>A</b>	Prepared by Sathish kumar T	Approved by	Page 1 of 1
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- Component surfaces that have not been uniformly blasted and show evidence of surface contamination shall undergo re-blasting.
- Operator to ensure Residual grits must be removed by soft brush followed by air blast.
- Operator to ensure that blast unit is operating efficiently to give an acceptable finish. If grits are contaminated or the unit required cleaning consult supervision.
- There must be no visible pulsation in the flow of media when blasting components.
- Operator must wear clean cotton gloves during subsequent handling of blasted components.
- If the surface roughness is exceeding the limit specified in the above table replace the abrasive media.
- The re-blasting is allowed for only one time.

#### **Revision History**

Issue No.	Change Note	Date
01	Initial Issue	04-04-2025

Retention category <b>A</b>	Prepared by Sathish kumar T	Approved by	Page 1 of 1
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