

Abrasive Blast Data Card

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

- This DC to be used along with FW71169-TP2-01 Rev 1, OIS-6PII-FW71169-01 Rev 1 and FW71169-TP2-01 Rev 1.

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^{*}Agreed for External Laboratory Rolls-Royce
- Approval subjected to Approval Plan# 249067-2024-001140 Issue 1 and Deviation Plan# DP03565 Issue 2.

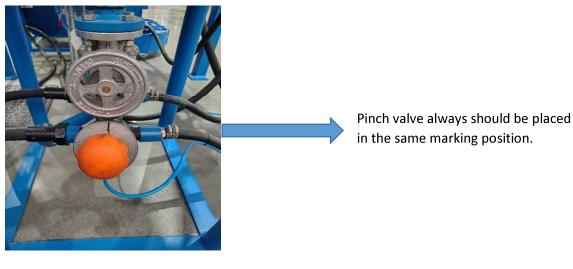


FIGURE-1

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 FW71	FW71160	FW71169- Above	0.7	4	4 10±5	Refer	Refer		The blasting area should be placed facing towards the top side.
	FVV/1169	FW71169- Below	0.7	4	4	10±5	FW71169 TP2-01		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.
- **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.

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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

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