

## Blasting Media Additive PantaTec ULTIMATE

### Purpose

PantaTec ULTIMATE is an additive for cleaning metallic blasting media and for the improvement of blast results in blasting systems. Contamination due to grease, oils, etc. from the production process is effectively and thoroughly removed from blasting media, the blasting system and the work piece surface during the blasting process. The cleaned blasting media can then accomplish its tasks more effectively, more evenly and more consistently, e.g. material abrasion or cold work hardening. By adding ULTIMATE to the blasting media additive, metal surfaces can be blasted practically without the usual pre-cleaning (washing) and be directly coated with suitable coating systems even without cleaning afterwards.

### Product Description and Functions

ULTIMATE can break away and fix grease, oils, etc. caused by the production processes from the metal surfaces. ULTIMATE contains no solvents or tensides. The cleaning effect is achieved purely physically through the very high adhesive power of the additive. The contaminants are removed from the blasting process, together with the additive, through the usual air separator and dust collector with the filter. Alongside its enormous effectiveness, ULTIMATE has shown itself to be neutral for the following processes, e.g. for corrosion protection coatings.

Product data:

Form	super-fine grained	Composition	mineral
Colour	light blue	Granulation	0 - 1 (2) mm
Density	approx. 2.0 kg/dm <sup>3</sup>	pH value	approx. 7 (in suspension)
Bulk density	approx. 0.1 kg/dm <sup>3</sup>	Fire behaviour	non-combustible

Correct and dedicated use of PantaTec ULTIMATE does not cause any hazards. Safety data sheet must be adhered.

### Application (see also pages 3 + 4)

1. Determine the degree of contamination, e.g. through a water-penetration test on the blasting media or a wetting test with water or test ink on the blasted surfaces.
2. Vaccination of the blasting system by first addition. There for gradually pour the additive at a suitable place into the blasting media of the running machine, e.g. directly behind the air wash separator.
3. The additive and blasting media mix permanently through the circulation while the blasting system is running. ULTIMATE makes its effect immediately. In this way, one quickly obtains a base mixture and primary purification of the blasting media and the blasting system. The first effect is visible in the shot-blasting system already within 30 - 60 minutes; in air-blasting systems it is considerably slower, sometimes taking several days.
4. In the following normal operation, add the additive continuously, directly at a suitable place, ideally directly into blasting media hopper. For process reliability, an automatic dosing unit supplies the blasting system with ULTIMATE.

For a short test, manual addition is possible, provided the operator takes the utmost care.

The dosage is calculated according to the degree of contamination and the design of the blasting system.

Vaccination (first addition): 2 - 4 litres per metric ton of blasting media inside the system (operating mix).  
Small machine at least 2 litres

Normal operation, continuous addition (dosage plan see page 2):

Wheel-blasting system: 0.5 - 1.0 litre per wheel and hour of blasting  
Air blasting: 0.5 - 1.0 litre per blasting tube and hour of blasting

### Storage and Removal

Store PantaTec ULTIMATE in a dry, cool place before using.

PantaTec ULTIMATE forms compounds with abrasive dust and is to be removed together with this dust as before.

### In case of further questions and for more information, please contact:

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# Dosage Plan

## Blasting Media Additive PantaTec ULTIMATE



### 1. Vaccination of the Blasting System (first addition)

The total amount of additive for the vaccination varies according to the degree of contamination.

Reference: at least 2-4 litres per ton of blasting media inside the system (operating mix). Small machine at least 2 litres.

Pour in partial amounts about every 3 minutes over the course of 15 minutes into the running machine.

### 2. Addition in Normal Operation

Wheel-blasting system 0.5 - 1.0 litre blasting media additive per wheel and hour of blasting

Air blasting system 0.5 - 1.0 litre blasting media additive per blast tube and hour of blasting

Pour as often as possible small portions, e.g. total 4 litres / hour ==> 1 litre / 15 minutes.

Status Operation hour counter	Date	Addition given, signature	Dosage amount / remarks



1

## water penetration test

blasting media from  
air wash separator  
  
and  
  
workpiece surface



2

## 1<sup>st</sup> check

oil and grease ...?



3

## vaccinate system

keep system running

e. g. behind the air  
wash separator:  
2 - 4 litres / metric ton  
blasting media



4

## 2<sup>nd</sup> check





5

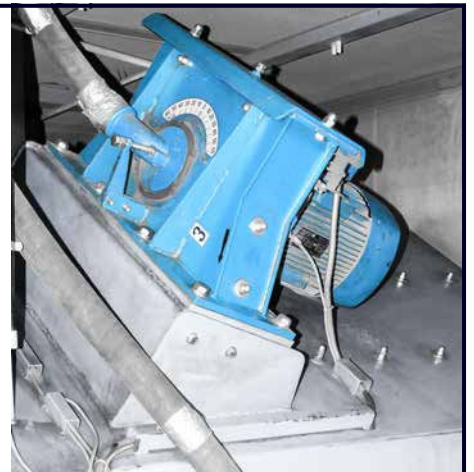
## continuous addition



per wheel and hour of blasting



per blasting tube and hour of blasting



Automatic

+

Process reliable



6

shot

10 - 60 sec.

## periodic process control

water seeps in.  
... the quicker, the better.



grit

3 - 5 min.

e. g. for corrosion protective coating



7

## important

wettability with water.

plenty of finest

clean

abrasive free from finest  
=> full performance.

