

Sandpaper



1. Scope

This standard covers the requirements for sandpaper.

This standard applies to the Seattle City Light (SCL) stock numbers listed in Section 7.

2. Application

Sandpaper is also referred to as abrasive paper and cloth. Sandpaper is used to remove material from surfaces or sometimes to make a surface rougher.

3. Information

3.1 Abrasive Materials

Aluminum oxide: A tough manufactured product suitable for cutting steels and materials of high tensile strength.

Crocus: A fine ferric oxide powder used primarily for polishing.

Emery: A fine-grained mineral, primarily aluminum oxide, largely being replaced by artificial abrasives which are harder and can be graded for uniformity.

Garnet: A natural mineral which may have either paper or cloth backing. It is used extensively for woodworking.

Silicon Carbide: An artificial abrasive of processed coke, sand, salt and sawdust. It is a very hard abrasive but very brittle. Used for cutting or grinding of cast iron, bronze, aluminum, marble, and materials of low tensile strength.

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3.2 Grain Size

Grain size designates exact size of sieve opening through which grains of abrasive will pass.

In specifying any abrasive, except flint or emery only, the grain size must be given.

Table 3.2 Sandpaper Grit Classification and Grain Size

Grit	Grain
Very Fine	400
	320
	280
	240
	220
Fine	—
	180
	150
	120
	—
Medium	100
	—
	80
	—
	60
Coarse	50
	—
	40
	—
	36
Very Coarse	30
	24
	20

3.3 Backing

Cloth backing is made in three different weights as follows:

Designated Letter	Type	Yards Per Pound
J	Jeans	3.75
X	Drill	2.75
H	Twill	1.85

Paper backing is made in the following weights:

Designated Letter	Weight per Ream (lb)
A	40
C	70
D	100
E	130

3.4 Coating

Closed Coating - An abrasive coating applied in such quantities that the entire backing is covered. This type is used where a rugged surface is needed for a tough job.

Open Coating - An abrasive is applied to approximately 50% of backing leaving open spaces between grains. This type is used where a flexible paper or cloth abrasive is needed, or to prevent quick filling between the abrasive grains.

4. Requirements

Sheets shall be 9 inch by 11 inch.

Rolls shall be 1 inch by 50 yards.

Abrasive cloth shall have the characteristics shown in Table 4a.

Table 4a. Abrasive Cloth Characteristics

Stock No.	Material	Grit	Grain	Backing	Coating
722316	Emery	Fine	150	J	Closed
722320	Aluminum Oxide	Medium	80	J	Closed
722336	Crocus	Fine	-	J	-
722340	Aluminum Oxide	Medium	100	J	Closed
722344	Aluminum Oxide	Fine	150	J	Closed

Abrasive paper shall have the characteristics shown in Table 4b.

Table 4b. Abrasive Paper Characteristics

Stock No.	Material	Grain	Backing	Coating
723040	Silicon Carbide	150	A	Open
723044	Aluminum Oxide	120	C	Open
723046	Garnet	100	A	Open
723048	Aluminum Oxide	80	C	Open
723121	Silicon Carbide	220	A	Open
723108	Silicon Carbide	280	A	Closed
723114	Silicon Carbide	320	A	Closed
723120	Silicon Carbide	400	A	Closed

5. Packaging

Sandpaper shall be packaged to prevent damage during shipping, handling, and storage.

Packages shall be legibly marked with:

- Manufacturer name
- Manufacturer part number
- Product description
- SCL stock number

Shipping containers shall be legibly marked with:

- SCL purchase order number

6. Issuance

<u>Stock No.</u>	<u>Stock Unit</u>
All except 722340, 722344	SH
722340 and 722344	RL

7. Approved Manufacturers

<u>Stock No.</u>	<u>Description</u>	<u>Manufacturer</u>	<u>Part No.</u>
722316	Cloth abrasive, emery, fine grit, 9" x 11", J-Wt.	JISCO	J73-5
722320	Norton Metalite cloth sheet, 9" x 11", P80 Grit, aluminum oxide	Norton	66261126340
722336	Evencut Crocus cloth sheets – 9" x 11"	Evencut	66485
722340	3M utility cloth roll 314D, 1 in x 50 yd P100 J-weight, 5 per case	3M	19791
722344	3M utility cloth roll 314D, 1 in x 50 yd P150 J-weight, 5 per case	3M	19789
	Norton Metalite cloth roll, 1"W x 50 Yds., P150 Grit, aluminum oxide	Norton	66261126273
723040	3M Tri-M-ite Fre-Cut 405N, 150 A-weight, 9 in x 11 in, 100 per inner, 1000 per case	3M	10248
723044	3M aluminum oxide paper sheet 336U, 120 C-weight, 9 in x 11 in, 100 per inner, 1000 per case	3M	02113
723046	3M garnet paper sheet 110N, 100 A-weight, 9 in x 11 in, 1000 per case	3M	10006
723048	3M aluminum oxide paper sheet 346U, 80 D-weight, 9 in x 11 in, 500 per case	3M	02115
723121	3M Tri-M-ite Fre-Cut 405N, 220 A-weight, 9 in x 11 in, 100 per inner, 1000 per case	3M	10246
723108	3M Wetordry abrasive sheet 413Q, 02005, 280, 9 in x 11 in, 50 sheets per carton, 5 cartons per case	3M	02005
723114	3M Wetordry abrasive sheet 413Q, 02004, 320, 9 in x 11 in, 50 sheets per carton, 5 cartons per case	3M	02004
723120	3M Wetordry abrasive sheet 413Q, 02002, 400, 9 in x 11 in, 50 sheets per carton, 5 cartons per case	3M	02002

8. Sources

SCL Stock Catalog page 72-7; July 28, 2011

Lu, Curtis; SCL Standards Engineer and originator of 7612.15

<http://www.3m.com>

<http://www.jiscodirect.com/>

<https://evencut.com/>

<https://www.nortonabrasives.com/>