ADM **Product Data Sheet**

ENVIROStrip® XL

(corn hybrid polymer)

AVIATION GRADE (Code 1660)

GENERAL DESCRIPTION

ENVIRO**Strip**® **XL** corn hybrid polymer is a dry stripping media derived from corn that is non-toxic and biodegradable. Careful processing and stringent quality control procedures guarantee a uniform product of high purity.

ENVIRO**Strip**® **XL** is used for many applications including stripping of metal and composite surfaces. **XL**'s moisture resistance and good flowability allow it to be used in all types of plastic media equipment

PHYSICAL & CHEMICAL SPECIFICATIONS

Appearance	Opaque, light yellow media sized 0.25 mm to 1.18mm
Density (g/cm^3)	1.45 ± 0.10
Bulk Density (kg/m^3)	641 – 769 ($40 – 48$ lb/ft^3)
Mesh (US Std), max.	10% on 16 mesh
max.	10% through 60 mesh
Hardness	80 ± 10 shore, D scale

PACKAGING

ENVIRO**Strip**® **XL** corn hybrid polymer is available in 90-kg (198.4-lb) polyethylene-lined fiberboard drums and 500-kg (1102-lb) polyethylene-lined corrugated boxes.

APPLICATION DEVELOPMENT

ENVIRO**Strip**® **XL** may be the ideal stripping process for your operation. Request a sample for process or laboratory evaluation.

ADM's Test Center and technical support team are available to tailor ENVIRO**Strip**® **XL** corn hybrid polymer's performance to your specific needs.

APPLICATION

ENVIRO**Strip**® **XL** was specifically engineered as a paint-removal abrasive media for delicate aircraft surfaces. For removal of most polyurethane topcoat and epoxy primer paint schemes from metal or composite surfaces, the ENVIRO**Strip**® **XL** operating window is summarized in the following tables.

(U.S. Standard Measurements)

ALUMINUM ALLOYS (≥ 0.032-inch thick)[1]

	(3/8-inch nozzle)	(1/2-inch nozzle)
Nozzle Pressure (psi)	**25 – 40**	**25 – 40**
Media Flow Rate (lb/min)	**5 – 8**	**10 – 16**
Stand-off Distance (inches)	**3 – 8**	**4 – 12**
Impingement Angle (degrees)[2]	**40 – 60**	**40 – 60**
Paint Removal Rate (ft^2/min)[3]	**0.2 – 0.6**	**0.4 – 1.2**

(Metric Units)

	(9.5 mm nozzle)	(12.7 mm nozzle)
Nozzle Pressure (bar)	**1.7 – 2.7**	**1.7 – 2.7**
Media Flow Rate (kg/min)	**2.3 – 3.6**	**4.5 – 7.3**
Stand-off Distance (cm)	**8 – 19**	**10 – 30**
Impingement Angle (degrees) [2]	**40 – 60**	**40 – 60**
Paint Removal Rate (m^2/hr) [3]	**1.1 – 3.3**	**2.2 – 6.7**

1. For aluminum alloys 0.63 mm (0.025-inch) and thinner, 1.4 – 1.7 bar (20 – 25 psi) nozzle pressure and 7.3 – 8.2 kg/min (16-18 lb/min) media flow rates are recommended.
2. The optimum angle for removing most polyurethane/epoxy primer coatings is 45° while blast angles greater than 70° are less efficient.
3. Paint removal rates are dependent on the condition of the coating and operator skill.

(U.S. Standard Measurements)

COMPOSITES

	(3/8-inch nozzle)	(1/2-inch nozzle)
Nozzle Pressure (psi)	**20 - 30**	**20 - 30**
Media Flow Rate (lb/min)	**5 - 8**	**10 - 16**
Stand-off Distance (inches)	**3 - 10**	**4 - 18**
Impingement Angle (degrees) [1]	**20 - 40**	**20 - 40**
Paint Removal Rate (ft^2/min) [2]	**0.2 - 0.4**	**0.3 - 0.8**

(Metric Units)

	(9.5 mm nozzle)	(12.7 mm nozzle)
Nozzle Pressure (bar)	**1.4 – 2.0**	**1.4 – 2.0**
Media Flow Rate (kg/min)	**2.3 – 3.6**	**4.5 – 7.3**
Stand-off Distance (cm)	**8 – 25**	**10 – 45**
Impingement Angle (degrees) [1]	**20 – 40**	**20 – 40**
Paint Removal Rate (m^2/hr) [2]	**1.1 – 2.2**	**1.7 – 4.5**

1. A lower angle (20 – 40°) is preferred for stripping composites in order to minimize substrate effects.
2. Paint removal rates are dependent on the condition of the coating and operator skill.

Archer Daniels Midland, 995 Mill Street, Montreal, Quebec, CANADA, H3C 1Y5,
Telephone 888-995-9722 or 514-937-9937 Fax: 514-937-9578
www.envirostrip.com