

# Understanding Sanding Operation

## Average Stock Removal

Grit	Depth of Cut
60	.035-.045
80	.020-.030
100	.015-.020
120	.010-.012
150	.006-.008
180	.004-.005
220	.003-.004

## Average Depth of Scratch

Grit	Depth of Scratch
60	.022-.025
80	.015-.018
100	.010-.012
120	.008-.010
150	.005-.006
180	.004-.005
220	.003-.004

## Example of 1/32" or .031 Stock Removal

### **Grit Sequence**

Grit	100	120	180
Stock removal	.018	.010	.004
Depth of scratch	.011	.008	.004

Do not skip more than one abrasive grit at a time (ex. 60-120). This will put excessive wear on belt and shorten belt life; also scratches from previous grit may not be removed.