



CORE BLAST

SOLUTIONS

STEEL SHOTS SIZE SPECIFICATION

SAE NO.	BIS NO.	SIZE IN MM	2.80MM	2.40MM	2.00MM	1.70MM	1.40MM	1.18MM	1.00MM	0.850MM	0.710MM	0.600MM	0.500MM	0.425MM	0.355MM	0.180MM
S - 70	SS - 180	0.180														
S - 110	SS - 300	0.300										Allpass	10%Max		80%Min	90%Min
S - 170	SS - 425	0.425								Allpass	10%Max			85%Min	97%Min	
S - 230	SS - 600	0.600							Allpass	10%Max		85%Min	97%Min			
S - 280	SS - 710	0.710						Allpass	5%Max		85%Min	96%Min				
S - 330	SS - 850	0.850					Allpass	5%Max		85%Min	96%Min					
S - 390	SS - 1000	1.000				Allpass	5%Max		85%Min	96%Min						
S - 460	SS - 1180	1.180			Allpass	5%Max		85%Min	96%Min							
S - 550	SS - 1400	1.400			Allpass		85%Min	97%Min								
S - 660	SS - 1700	1.700		Allpass		85%Min	97%Min									
S - 780	SS - 2000	2.000	Allpass		85%Min	97%Min										
S - 930	SS - 2400	2.400		90%Min	97%Min											
Retention on Sieve Size			2.80MM	2.40MM	2.00MM	1.70MM	1.40MM	1.18MM	1.00MM	0.850MM	0.710MM	0.600MM	0.500MM	0.425MM	0.355MM	0.180MM

0.125MM

0.125MM

HAL STEEL GRIT SIZE SPECIFICATION

HAL SIZE	SAE NO.	SIZE IN MM	2.80MM	2.40MM	2.00MM	1.70MM	1.40MM	1.18MM	1.00MM	0.850MM	0.710MM	0.600MM	0.500MM	0.425MM	0.355MM	0.180MM	0.125MM
G - 0	G - 80	0.180												Allpass		65%Min	76%Min
G - 1	G - 50	0.300									Allpass				65%Min	75%Min	
G - 2	G - 40	0.425							Allpass					70%Min	80%Min		
G - 4	G - 25	0.710						Allpass			70%Min			80%Min			
G - 6	G - 18	1.00					Allpass		75%Min		85%Min						
G - 7	G - 16	1.18				Allpass		95%Min	85%Min								
G - 8	G - 14	1.40			Allpass		80%Min	90%Min									
G - 9	G - 12	1.70		Allpass		80%Min	90%Min										
G - 10	G - 10	2.00	Allpass		80%Min	90%Min											
Retention on Sieve Size			2.80MM	2.40MM	2.00MM	1.70MM	1.40MM	1.18MM	1.00MM	0.850MM	0.710MM	0.600MM	0.500MM	0.425MM	0.355MM	0.180MM	0.125MM

Chemical Analysis chart for HAL Steel Shots & Steel Grits

Content	Steel Shots (As Per IS: 4606/83)	Steel Grits
% Carbon	0.6 to 1.25	0.6 to 1.25
% Manganese	1.25 max	1.25 max
% Silicon	0.20 to 1.10	0.20 to 1.10
% Phosphorus	0.08 max	0.08 max
% Sulphur	0.08 max	0.08 max

Physical Analysis chart for HAL Steel Shots & Grits

Hardness	400-500 HV Average (Lowest & Highest individual range from 375 to 550 HV)	700 HV & above
Density	7.0gm/ml min	7.6 gm/ml min
Microstructure	Tempered Martensite	Fine & Uniform martensite