

41155 Joy Road Canton, MI 48187-2056

TEL: 734-459-7900 FAX: 734-459-7907

SAE SHOT SIZE SPECIFICATIONS

			S-780	S-660	S-550	S-460	S-390	S-330	S-280	S-230	S-170	S-110	S-70
ASTM Mesh	Oper	ning		400		4	A Cherical Control						
No.	mm	in.	Shot	Shot	Shot	Shot	Shot	Shot	Shot	Shot	Shot	Shot	Shot
7	2.83	0.111	All Pass										
8	2.38	0.0937		All Pass									
10	2.00	0.0787	85% min.		All Pass	All Pass							
12	1.68	0.0661	97% min.	85% min.		5% max.	All Pass						
14	1.41	0.0555		97% min.	85% min.		5% max.	All Pass					
16	1.19	0.0469			97% min.	85% min.		5% max.	All Pass	7			
18	1.00	0.0394				96% min.	85% min.		5% max.	All Pass			
20	.84	0.0331					96% min.	85% min.		10% max.	All Pass		
25	.71	0.0280						96% min.	85% min.		10% max.		
30	.60	0.0232	· · · ·				-		96% min.	85% min.		All Pass	
35	.50	0.0197								97% min.		10% max.	
40	.42	0.0165									85% min.		All Pass
45	.35	0.0138									97% min.		10% max.
50	.30	0.0117										80% min.	
80	.18	0.007										90% min.	80% min.
120	.12	0.0049							/				90% min.
200		0.0029											
325	.04	0.0017							1				

METALTEC Cast Steel Shot Specifications

CHEMICAL ANALYSIS

(SAE J-2175)

 Carbon
 .10 - .15%

 Manganese
 1.20 - 1.50%

 Silicon
 .10 - .25%

 Sulphur
 .035% MAX

 Phosphorous
 .035% MAX

DENSITY

ast steel shot shall not weigh less than 7 grams per cc nor contain more than 10% hollows. The method by which one determines density may be a displacement method or an actual count of the hollows in a mounted polished specimen.

BLENDS

Special blends of two or more sizes of Metaltec cast steel shot are available at no extra charge. Preblended operating mixes for new equipment installations are also available at no extra charge.

BAINITE MICROSTRUCTURE

Intermediate structure (Bainite), a mechanical mixture of Ferrite and Cementite particles. Random feather-like appearance (upper Bainite) and Accicular (lower Bainite) with little or no free carbon particles.

HARDNESS

Ninety percent of the hardness checks performed on a representative sample shall fall within the range of Rockwell C 40 - 50. The hardness may be determined by any of the various methods applicable to small sections, such as a tukon tester with a Vickers indenter, at loads determined to provide a reliable conversion to Rockwell C.

GENERAL APPEARANCE

The cast steel shot shall be as nearly spherical as is commercially possible with a minimum of elongated or compound particles, tails, hollows, broken pieces, slag and dirt.

PACKAGING

Standard forms of packaging are: 2000-lb. drums, banded and palletized, and 50-lb. bags, boxed, banded, and palletized. Other special packaging available at extra cost.

SAE SHOT SIZE (J-444)	APPROXIMATE PELLETS PER POUND
S780	17,000
S660	20,000
S550	32,000
S460	55,000
S390	93,000
S330	153,000
S280	250,000
S230	420,000
S170	1,200,000
S110	3,400,000
S70	17,000,000

Test After Test, METALTEC Shot Blasts the Competition Away!

