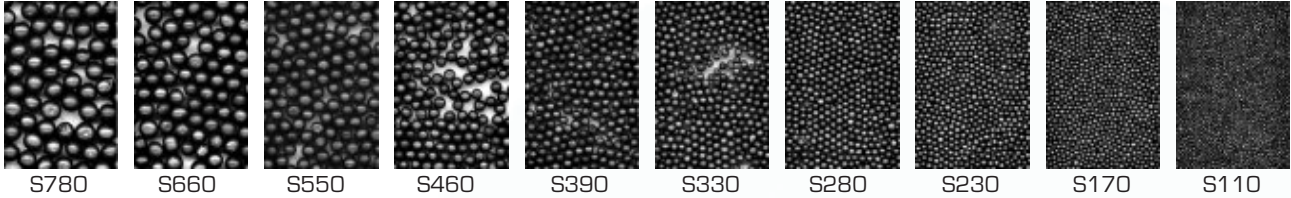


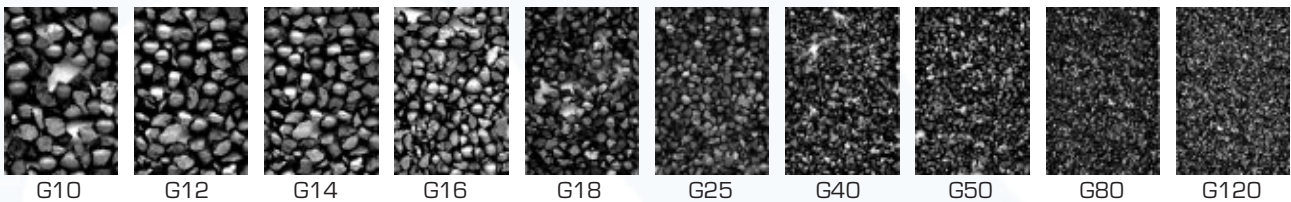
CAST STEEL

Cast Steel Shot



mesh	mm	Specification										
		SS 2.5	SS 2.0	SS 1.7	SS 1.4	SS 1.2	SS 1.0	SS 0.8	SS 0.6	SS 0.5	SS 0.3	SS 0.2
7	2.80	all pass										
8	2.36		all pass									
10	2.00	85% min		all pass	all pass							
12	1.70	97% min	85% min		5% max	all pass						
14	1.40		97% min	85% min		5% max	all pass					
16	1.18			97% min	85% min		5% max	all pass				
18	1.00				96% min	85% min		5% max	all pass			
20	0.850					96% min	85% min		10% max	all pass		
25	0.710						96% min	85% min		10% max		
30	0.600							96% min	85% min		all pass	
35	0.500								97% min	85% min	10% max	
40	0.425									97% min		all pass
45	0.355										80% min	10% max
50	0.300										90% min	
80	0.180											80% min
120	0.125											90% min
200	0.075											
325	0.045											
SAE		S 780	S 660	S 550	S 460	S 390	S 330	S 280	S 230	S 170	S 110	S 70

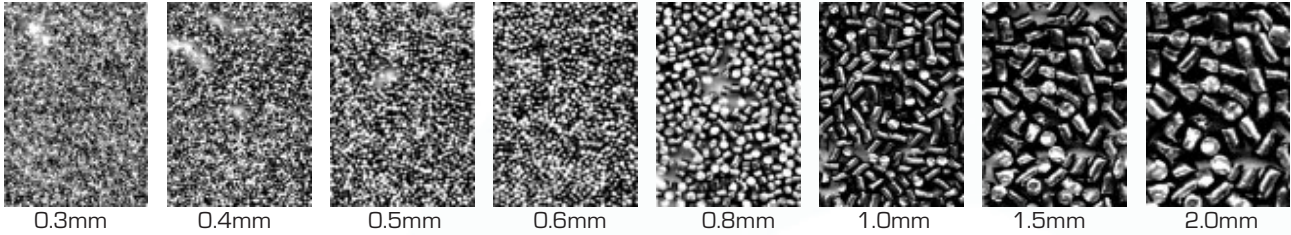
Cast Steel Grit



mesh	mm	Specification										
		SG,H,L,P 2.5	SG,H,L,P 2.0	SG,H,L,P 1.7	SG,H,L,P 1.4	SG,H,L,P 1.2	SG,H,L,P 1.0	SG,H,L,P 0.7	SG,H,L,P 0.4	SG,H,L,P 0.3	SG,H,L,P 0.2	
7	2.80	all pass										
8	2.36		all pass									
10	2.00	85% min		all pass								
12	1.70	97% min	85% min		all pass							
14	1.40		97% min	80% min		all pass						
16	1.18			90% min	75% min		all pass					
18	1.00				85% min	75% min		all pass				
20	0.850											
25	0.710					85% min	80% min		all pass			
30	0.600											
35	0.500						80% min					
40	0.425							70% min		all pass		
45	0.355											
50	0.300							80% min	65% min		all pass	
80	0.180								75% min	65% min		
120	0.125									75% min	60% min	
200	0.075										70% min	
325	0.045											
SAE		G 10	G 12	G 14	G 16	G 18	G 25	G 40	G 50	G 80	G 120	

CUT WIRE

Carbon Steel Cut Wire Shot and Stainless Steel Cut Wire Shot



Composition of the abrasives

Products		Cast Steel Shot	Cast Steel Grit	Carbon Steel Cut Wire Shot	Stainless Steel Cut Wire Shot
Chemical Composition	(C)	0.70 - 1.20%		0.45 - 0.75%	< 0.12%
	(Mn)	0.60 - 1.20%		0.40 - 1.20%	(Cr) 17 - 19%
	(Si)	0.40 - 1.20%		0.10 - 0.30%	(Ni) 7 - 10%
	(S)	< 0.05%		< 0.04%	< 0.03%
	(P)	< 0.05%		< 0.04%	< 0.03%
Hardness		40 - 50 HRC 52 - 56 HRC 56 - 60 HRC	GP: 42 - 50 HRC GL: 56 - 60 HRC GH: 63 - 66 HRC	1.0mm: 51 - 53 HRC 1.5mm: 41 - 45 HRC	35 - 48 HRC
Hardness Deviation		Max Deviation \pm 3.0 HRC			
Microstructure		Tempered Martensite or Sorbite		Deformed Pearlite	Deformed Austenitic
Density		7.4g/cm ³	7.6g/cm ³	7.8g/cm ³	7.8g/cm ³

Abrasive life under the same condition, comparison between the abrasion ratio and comprehensive cost

Products	Chilled Shot (grit)	Anneal Iron Shot	Cast Steel Shot (grit)	Steel Cut Wire Shot
Hardness	55 - 64	25 - 30	40 - 50	41 - 53
Ervin Life	150	600	2800	3200
Abrasion ratio of throwaway unit	10 - 15	1.5 - 2.0	1	2 - 3
Relative price	1.0	1.0	2.0 - 2.5	2.0 - 2.5