

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

[illegible]

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