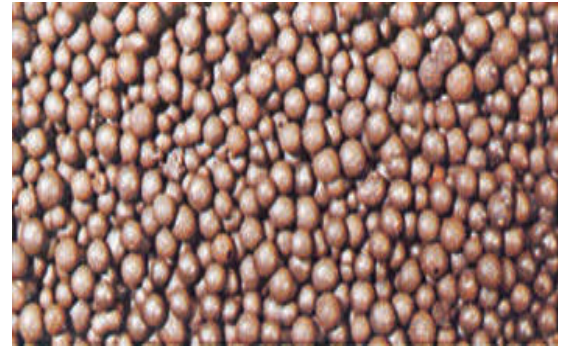


ABRASIVE BLAST MEDIA

Steel Shots

Steel shot refers to spherical grains made of molten steel through an atomization ("granulation") process, available in different sizes and hardnesses. These are widely used for shot blasting and shot peening applications. With our quality products we serve various industries like Automotive industry, Metallurgy and Petrochemical industry.



Specification As Per Is 4606 of 1983 Chemical Composition

Carbon	0.6-1.25%
Silicon	0.2-1.1%
Manganese	1.25%Max
Sulphure	0.08%Max
Phosphorus	0.08%Max

Shape	Round
Density	7 gm/ml Min. contains hollow shots of 10% max
Hardness	400-500 HV
Micro Structure	Tempered Martensite

Application

Shot Blasting of Cast Steel
Sand Remova
Surface Preparation
Scale Removal

Custom Hardness Shots HrC

SS	40-50
SL	50-60
SH	63+

Size Distribution as per IS 4606 of 1983

Screen No.	Screen Size	Metric Size Std. mm	Shot Number													
			S930	S780	S660	S550	S460	S390	S330	S280	S230	S170	S110	S70		
6	0.132	3.35	All Pass													
7	0.111	2.80		All Pass												
8	0.0937	2.36	85% Min		All Pass											
10	0.787	2.00	12% Max	85% Min		All Pass	All Pass									
12	0.0661	1.70		12% Max	85% Min		5% Max	All Pass								
14	0.0555	1.40			12% Max	80% Min		5% Max	All Pass							
16	0.0469	1.18				12% Max	80% Min		5% Max	All Pass						
18	0.0394	1.00					11% Max	80% Min		5% Max	All Pass					
20	0.0331	0.85						11% Max	80% Min		10% Max	All Pass				
25	0.028	0.71							11% Max	80% Min		10% Max				
30	0.0232	0.60								11% Max	75% Min		All Pass			
35	0.0197	0.50									12% Max		10% Max			
40	0.0165	0.425										75% Min		All Pass		
45	0.0138	0.355										12% Max		10% Max		
50	0.0177	0.300											75% Min			
80	0.007	0.18												10% Max	75% Min	
120	0.0049	0.125													10% Max	
200	0.0029	0.75														
Pan			3% Max	3% Max	3% Max	3% Max	4% Max	4% Max	4% Max	4% Max	3% Max	3% Max	5% Max	5% Max		



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ABRASIVE BLAST MEDIA

Steel Grits

Steel grits characterizes grains with a predominantly angular shape. These grains are obtained by crushing steel shot, therefore they exhibit sharp edges and broken sections. Harder than steel shot, it is also available in different sizes and hardnesses.



Specification As Per Is 4606 of 1983 Chemical Composition

Carbon	0.6-1.25%
Silicon	0.2-1.1%
Manganese	1.25%Max
Sulphure	0.08%Max
Phosphorus	0.08%Max

Shape	Angular
Density	7 gm/ml Min. contains hollow shots of 10% max
Hardness	400-500 HV
Micro Structure	Tempered Martensite

Application

Pipe coating
Surface preparation
Stone cutting
Air blasting

Custom Hardness Grits HrC

GP	40-50
GL	50-60
GH	63+

Size Distribution as per IS 4606 of 1983

Screen No.	Screen Size	Metric Size Std. mm	Grit Number											
			G10/G10	G12/G9	G14/G8	G16/G7	G18/G6	G25/G4	G40/G2	G50/G1	G80/G0	G120		
7	0.111	2.80	All Pass											
8	0.0937	2.36		All Pass										
10	0.787	2.00	85% Min		All Pass									
12	0.0661	1.70	12% Max	85% Min		All Pass	All Pass							
14	0.0555	1.40		12% Max	85% Min		5% Max	All Pass						
16	0.0469	1.18			12% Max	85% Min		5% Max	All Pass					
18	0.0394	1.00				11% Max	85% Min		10% Min	All Pass				
20	0.0331	0.85					11% Max	80% Min		10% Max	All Pass			
25	0.028	0.71						11% Max	75% Min		10% Max	All Pass		
30	0.0232	0.60							11% Max	75% Min		10% Max		
35	0.0197	0.50								10% Max	75% Min			
40	0.0165	0.425									10% Max			
45	0.0138	0.355											75% Min	
50	0.0177	0.300											10% Max	
80	0.007	0.18												
120	0.0049	0.125												
200	0.0029	0.75												
325	0.002	0.045												
Pan			3% Max	3% Max	3% Max	4% Max	4% Max	4% Max	4% Max	5% Max	5% Max	10% Max		



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ABRASIVE BLAST MEDIA

ALUMINIUM OXIDE-COMMERCIAL & VIRGIN

ALUMINIUM OXIDE GRIT COMMERCIAL (As per IS: 3178 - 1965)

Abrasive Material : Emery, Synthetic (Commercial Quality)
 Aluminum Oxide content : 60 % Min. Magnetic Material : 15 % Max.
 Hardness on Moh's scale : 8 Min. Specific Gravity : 3.6 Min.

ALUMINIUM OXIDE GRIT (As per IS: 0.40 mm)

Aluminium Oxide



**Recommended for both
ferrous and non ferrous
components**

ALUMINIUM OXIDE - VIRGIN

B. ALUMINIUM OXIDE GRIT (As per FEPA Standard)

Abrasive Material : Corundum (Virgin Grade)
 Aluminium Oxide content : 90 % Min.
 Hardness On Moh's Scale : 09 Min.
 Specific Gravity : 3.9 Min.

Other Impurities:

SiO ₂	CaO	Fe ₂ O ₃	TiO ₂	Free Iron
1.00% Max.	1.00%Max.	0.50%Max.	2.2.-3.0%	0.40% Max

S. NO	IS GRIT NO.	PARTICLE SIZE RANGE, MM	EQUIVALENT BS SIEVE RANGE	RETENTION MIN. BY
1.	16	1.40 - 1.00	14 - 16	50 %
2.	20	1.00 - 0.710	18 - 22	50 %
3.	24	0.710 - 0.425	25 - 36	50 %
4.	36	0.500 - 0.300	36 - 52	50 %
5.	60	0.355 - 0.180	60 - 85	50 %
6.	80	0.250 - 0.150	72 - 100	50 %
7.	100	0.212 - 0.125	85 - 120	50 %
8.	120	0.180 - 0.106	100 - 150	50 %
9.	220	0.090 - 0.045	240 - 350	50 %

GLASS BEADS



For both dry and wet process to gently clean,
descale, deflash, deburr or shot peen at low intensity



S. NO.	DESCRIPTION	B.S. MESH	MICRON SIZE
1	Coarse I 'O'	-18+25	600-800
2	Coarse II 'BL'	-18+60	400-600
3	Medium 'C'	-36+60	250-425
4	Fine 'AD'	-72+150	106-212
5	Superfine I 'AF'	-100+200	75-150
6	Superfine II 'AQ'	-300+350	04-45



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ABRASIVE BLAST MEDIA

STEEL CUT WIRE SHOTS

SHAPE	DESCRIPTION	SPECIFICATION
As Cut (-U)	Cylindrical with Sharp Edge	SAE J441/IS 5873-1970

Steel Cut Wire



For cleaning, descaling, deburring, deflasing, shot peening on components of iron & steel

Hardness: 45-55 HRC

S.No.	Cast Shot Size (Equivalent SAE No.)	Cut Wire Designation (Inches)	Cut Wire Designation (MM)
1	S-170	CW-13	0.40
2	S-200	CW-15	0.50
3	S-230	CW-17	0.60
4	S-280	CW-20	0.70
5	S-330	CW-23	0.80
6	S-360	CW-28	1.00
7	S-460	CW-32	1.20

Copper Slag



Size mm : 1.00 - 1.80
For Obtaining consistent surface roughness

Plastic Grit Acrylic



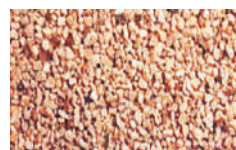
Mesh Size : 8 - 120
Size mm : 2.00 - 0.09
For fast cleaning of heavy contamination

Plastic Grit Urea



Mesh Size : 18 - 36
Size mm : 0.85 - 0.42
For precise descaling, deflashing deburring, shining of removal of old paint, varnish etc.

DF Grit



Mesh Size : 8 - 60
Size mm : 2.00 - 0.09
For fast cleaning of heavy contamination



NATIONAL ENTERPRISES

MANUFACTURERS OF : Industrial Blast Rooms, Airless & Air Operated Abrasive Blasting Machines, Shot Peening Plants, Industrial Dust Collectors, Painting Equipments & Booths



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