



SURFACE VEHICLE RECOMMENDED PRACTICE

J1993™

FEB2019

Issued 1993-03
Reaffirmed 2019-02

Superseding J1993 JUL2005

High-Carbon Cast-Steel Grit

RATIONALE

J1993 has been reaffirmed to comply with the SAE five year review policy.

1. Scope—This SAE Recommended Practice describes the chemical composition, and physical characteristic requirements for high-carbon cast-steel grit, to be used for blast cleaning and etching operations.

1.1 Rationale—This document has been reaffirmed to comply with the SAE 5-Year Review policy.

2. References

2.1 Applicable Publications—The following publications form a part of this specification to the extent specified herein. Unless otherwise indicated, the latest issue of SAE publications shall apply.

2.1.1 SAE PUBLICATION—Available from SAE, 400 Commonwealth Drive, Warrendale, PA 15096-0001.

SAE J444—Cast Shot and Grit Size Specifications for Peening and Cleaning
SAE J445—Metallic Shot and Grit Mechanical Testing

2.1.2 ASTM PUBLICATIONS—Available from ASTM, 100 Barr Harbor Drive, West Conshohocken, PA 19428-2959.

ASTM B 215—Method B—Methods of Sampling Finished Lots of Metal Powders
ASTM E 140—Hardness Conversion Tables for Metals (Relationship Between Brinell Hardness, Vickers Hardness, Rockwell Hardness, Rockwell Superficial Hardness, and Knoop Hardness)
ASTM E 384—Test Methods for Microhardness of Materials

2.1.3 ISO PUBLICATIONS—Available from ANSI, 25 West 43rd Street, New York, NY 10036-8002.

ISO 11124 Part 3—High-carbon cast-steel shot and grit
ISO 11125 Part 1—Preparation of steel substrates before application of paints and related products—Test methods for metallic abrasives—Part 1: Sampling
ISO 11125 Part 2—Preparation of steel substrates before application of paints and related products—Test methods for metallic abrasives—Part 2: Determination of particle size distribution
ISO 11125 Part 3—Preparation of steel substrates before application of paints and related products—Test methods for metallic abrasives—Part 3: Determination of hardness
ISO 11125 Part 4—Preparation of steel substrates before application of paints and related products—Test methods for metallic abrasives—Part 4: Determination of apparent density
ISO 11125 Part 5—Preparation of steel substrates before application of paints and related products—Test methods for metallic abrasives—Part 5: Determination of percentage defective particles and microstructure

SAE Technical Standards Board Rules provide that: "This report is published by SAE to advance the state of technical and engineering sciences. The use of this report is entirely voluntary, and its applicability and suitability for any particular use, including any patent infringement arising therefrom, is the sole responsibility of the user."

SAE reviews each technical report at least every five years at which time it may be revised, reaffirmed, stabilized, or cancelled. SAE invites your written comments and suggestions.

Copyright © 2019 SAE International

All rights reserved. No part of this publication may be reproduced, stored in a retrieval system or transmitted, in any form or by any means, electronic, mechanical, photocopying, recording, or otherwise, without the prior written permission of SAE.

TO PLACE A DOCUMENT ORDER: Tel: 877-606-7323 (inside USA and Canada)
Tel: +1 724-776-4970 (outside USA)
Fax: 724-776-0790
Email: CustomerService@sae.org
<http://www.sae.org>

SAE WEB ADDRESS:

**SAE values your input. To provide feedback on this
Technical Report, please visit
http://standards.sae.org/J1993_201902**