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Superseding J444 MAY1993

Cast Shot and Grit Size Specifications for Peening and Cleaning

- 1. Scope**—This SAE Recommended Practice pertains to blast cleaning and shot peening and provides for standard cast shot and grit size numbers. For shot, this number corresponds with the opening of the nominal test sieve, in ten thousandths of inches¹, preceded by an S. For grit, this number corresponds with the sieve designation of the nominal test sieve with the prefix G added. These sieves are in accordance with ASTM E 11.

The accompanying shot and grit classifications and size designations were formulated by representatives of shot and grit suppliers, equipment manufacturers, and automotive users.

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

2. References

- 2.1 Applicable Publication**—The following publication forms a part of this specification to the extent specified herein.

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

ASTM E 11—Standard Specifications for Wire Cloth Sieves for Testing Purposes

- 2.2 Related Publications**—The following publications are provided for information purposes only and are not a required part of this document. The latest issue of SAE publications shall apply.

- 2.2.1 SAE PUBLICATIONS—Available from SAE, 400 Commonwealth Drive, Warrendale, PA 15096-0001.

SAE J445—Metallic Shot and Grit Mechanical Testing—For Information on Shot Durability Determination

SAE J827—Cast Steel Shot—For Information on Composition and Shapes

SAE J1993—Cast Steel Grit—For Information on Composition and Shapes

SAE J2175—Low Carbon Steel Shot—For Information on Composition and Shapes

1. Example: S-550 indicates a cast steel shot identified by a nominal sieve opening of 0.0555 in.

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3. Testing Procedure—Sieve Analysis

3.1 Equipment

3.1.1 A rotating and tapping type of testing machine shall be used.

3.1.1.1 The shaking speed shall be 275 to 295 rpm.

3.1.1.2 The taps per minute shall be 145 to 160 when tapping machines are used.

3.2 Sieves

3.2.1 The testing sieves shall be in accordance with ASTM E 11. They shall be of the 203 mm (8 in) diameter series, of either 25 mm (1 in) or 51 mm (2 in) height.

3.3 Procedure

3.3.1 A 100 g sample of the shot or grit shall be obtained from a representative quantity.

3.3.2 The sample shall be placed on the top sieve of a stack of three or four sieves, depending on media and size (Figures 1 and 2). Nest the selected sieves and fit a pan to the bottom sieve.

3.3.3 The sample shall be run in the testing machine for 5 min \pm 5 s for sizes using sieve designation 35 or coarser and 10 min \pm 5 s for sizes using sieve designation finer than 35.

3.3.4 The stack of sieves shall be removed from the testing machine and the percentage of total weight shall be recorded for the media remaining on each sieve.

3.4 Any alternate method agreed upon by the supplier and the user which gives equivalent results will be acceptable.

PREPARED BY THE SAE SURFACE ENHANCEMENT DIVISION OF THE
SAE FATIGUE DESIGN AND EVALUATION EXECUTIVE COMMITTEE