

Steel Shot and Grit Media Screening Coverage and Impact

Steel Media Screen Analysis Chart

STEEL SHOT

Size	Stack	All Pass	ASTME	Nomina	ASTME	Work Mix Cut Off Points		
						De-Sand	De-Scal	Peening
S780	B	2.8mm	7 mesh	2.00mm	10 mesh	0.71mm	0.50mm	1.00mm
S660	A	2.36mm	8 mesh	1.70mm	12 mesh	0.60mm	0.425mm	0.85mm
S550	B	2.0mm	10 mesh	1.40mm	14 mesh	0.425mm	0.355mm	0.71mm
S460	A	2.0mm	10 mesh	1.18mm	16 mesh	0.425mm	0.30mm	0.60mm
S390	B	1.70mm	12 mesh	1.00mm	18 mesh	0.355mm	0.30mm	0.50mm
S330	A	1.40mm	14 mesh	0.85mm	20 mesh	0.30mm	0.18mm	0.425mm
S280	B	1.18mm	16 mesh	0.71mm	25 mesh	0.30mm	0.18mm	0.355mm
S230	A	1.00mm	18 mesh	0.60mm	30 mesh	0.18mm	0.125mm	0.30mm
S170	A	0.85mm	20 mesh	0.425mm	40 mesh	0.125mm	0.125mm	0.18mm
S110	A	0.60mm	30 mesh	0.30mm	50 mesh	n/a	n/a	0.125mm
S 70	A	0.425mm	40 mesh	0.18mm	80 mesh	n/a	n/a	0.075mm

STEEL GRIT

Size	Stack	All Pass	ASTME	Nomina	ASTME	Work Mix Cut Off Points		
						De-Sand	De-Scal	Peening
G10	B	2.8mm	7 screen	2.00mm	10 mesh	0.71mm	0.50mm	n/a
G12	A	2.36mm	8 screen	1.70mm	12 mesh	0.60mm	0.425mm	n/a
G14	B	2.0mm	10 scree	1.40mm	14 mesh	0.425mm	0.355mm	n/a
G16	A	1.70mm	12 scree	1.18mm	16 mesh	0.425mm	0.30mm	n/a
G18	B	1.40mm	14 scree	1.00mm	18 mesh	0.355mm	0.30mm	n/a
G25	A	1.18mm	16 scree	0.71mm	25 mesh	0.30mm	0.18mm	n/a
G40	B	1.00mm	18 scree	0.425mm	40 mesh	0.125mm	0.18mm	n/a
G50	A	0.71mm	25 scree	0.30mm	50 mesh	n/a	n/a	n/a
G80	A	0.425mm	40 mesh	0.18mm	80 mesh	n/a	n/a	n/a
G120	A	0.30mm	50 mesh	0.125mm	120 mes	n/a	n/a	n/a

Stack A	1.70mm	1.18mm	0.85mm	0.60mm	0.425mm	0.30mm	0.18mm
ASTME	12 mesh	16 mesh	20 mesh	30 mesh	40 mesh	50 mesh	80 mesh
Stack B	2.00mm	1.40mm	1.00mm	0.71mm	0.50mm	0.355mm	0.18mm

CAST STEEL SHOT RELATIONSHIP OF PARTICLE SIZE TO COVERAGE

SAE Shot Sizes	Nominal particle size in inches	Shot Particles per lb
S780	0.078	17,600
S660	0.066	30,800
S550	0.055	57,200
S460	0.046	99,000
S390	0.039	143,000
S330	0.033	242,000
S280	0.028	462,000
S230	0.023	792,000
S170	0.017	1,144,000
S110	0.011	3,740,000
S70	0.007	13,200,000

In a balanced Work Mix

Note: SAE means Society of Automotive Engineers**CAST STEEL SHOT - RELATIONSHIP OF PARTICLE SIZE TO IMPACT VALUE**

SAE Shot Sizes	Nominal particle size in inches	Relative 'Impact' Value
S780	0.078	800
S660	0.066	500
S550	0.055	300
S460	0.046	165
S390	0.039	100
S330	0.033	60
S280	0.028	36
S230	0.023	22
S170	0.017	12
S110	0.011	5
S70	0.007	1

Example: S110 steel shot has 5 x more impact than S170 when thrown at the same speed by a blast wheel or nozzle**Note:** SAE means Society of Automotive Engineers