

C.D.S. CONSULTANTS

CDS SHOT/CDS GRIT - STEEL ABRASIVES SUMMARY OF REQUIREMENTS

The requirements contained within CDS internal specification SP1 are summarised below. Unless specifically agreed otherwise within the Contract of Sale, all supplies will be manufactured against SP1 requirements.

<u>PROPERTY</u>	<u>REQUIREMENT</u>		
Chemical Composition	Carbon	0.85 - 1.2%	
	Manganese		
	S-70 - S-110	0.35 - 1.2%	
	S-170	0.50 - 1.2%	
	S-230 and Larger	0.60 - 1.2%	
	Silicon	0.40 - 1.5%	
	Sulphur	0.05% maximum	
	Phosphorus	0.05% maximum	
Grade Size	a) CDS Shot	-	See Table 1
	b) CDS Grit	-	See Table 2
Hardness	90% of the particles tested shall have a hardness value within one of the ranges specified below:		
	CDS Shot	:	40 - 50 HRC 390 - 510 - VPN
	CDS Grit - SG	:	40 - 50 HRC 390 - 510 - VPN
	LG	:	55 - 60 HRC 630 - 730 - VPN
	HG	:	60 - HRC min 730 - min - VPN
Apparent Density	7.0g/cm³min		
Particle Shape	a) CDS Shot	:	Max 5% Non-round
	b) CDS Grit	:	Max 10% shot or greater than half round in shape.
Defects	Void	:	Max 10%
	Shrinkage	:	Max 10%
	Cracks	:	
	a) CDS Shot	:	Max 15%

Table 2**CDS GRIT
SAE J444 SPECIFICATION**

Mesh App mm	G12	G14	G16	G18	G25	G40	G50	G80
3.35								
2.80								
2.36	Nil							
2.00		Nil						
1.70	80 Min		Nil					
1.40	90 Min	80 Min		Nil				
1.18		90 Min	75 Min		Nil			
1.00			85 Min	75 Min		Nil		
0.85								
0.71				15 Max	70 Min		Nil	
0.60				Nil				
0.50								
0.425					80 Min	70 Min		Nil
0.355								
0.300						80 Min	65 Min	
0.180							75 Min	65 Min
0.125								75 Min

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