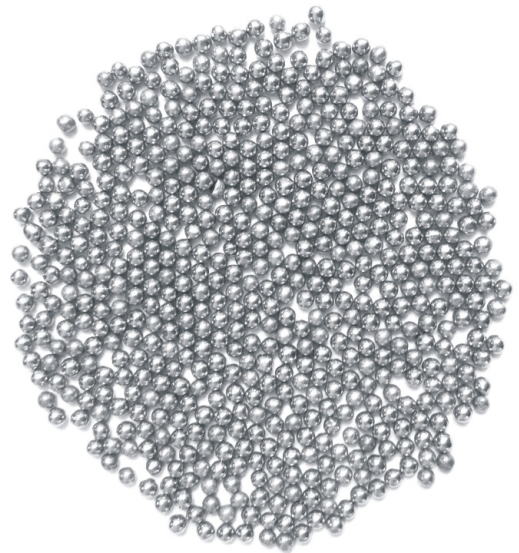




VINAYAKA SHOT



CUT WIRE SHOT

Stainless Steel Shot
Low Carbon Steel Shot,
High Carbon Steel Shot,
Aluminum Shot, Lead Shot,
Copper Shot, Zinc Shot,
Brass Shot, Nickel Shot,
All Ferrous and
Non Ferrous Metal Shot

ABRASIVES

Steel Shot,
Steel Grit,
Aluminum Oxide,
Emery Powder,
Emery Grit,
Carborandum,
Glass Beads,
Garnet

INGOTS

Lead Ingots,
Aluminum Ingots,
Zinc Ingots

FIBER

Stainless
Steel Fiber,
Steel Fiber.
Available in
Crimped,
corrugated and
straight

BALLS

Copper Balls,
Ferrous and
Non Ferrous
Precision Balls,
Stainless Steel Balls,
MS Balls
Zinc Ball,
SS Grinding
Media Balls

CUT-WIRE SHOT is produced by cutting wire into lengths equal to the wire diameter. Quality is assured by control of the chemical and physical properties inherent in the wire and accurate sizing to length. Every piece is 100% solid. Cut-wire is available in "As-Cut" (Cylindrical) form as well as in conditioned (Spherical) shape.



As Cut cylindrical Shot



G1 Condition



G2 Condition



G3 Condition

Advantages Of Cut Wire Shot

1. More life span, till completely reduced to smallest tiny particle.
2. Most economical and lowest consumption
3. Increase the fatigue life of the blasted components.
4. Less dust formation during shot blasting.
5. Cleans the product faster.
6. Cuts down the maintenance cost of shot blasting machine.
7. No dust or health hazard during operation.

CARBON STEEL CUT WIRE SHOT is available in two types High carbon shot and Low Carbon Shot with Density 7.8gcm³, also available in both shapes "As-Cut" (Cylindrical) form as well as in conditioned (Spherical) shape.

Shot Available Specifications : SAE J441, IS-5873-1970
Available Sizes : 0.30mm to 3.20mm

CHEMICAL COMPOSITION AND HARDNESS

Chemical Element	C%	MN % MAX	S% MAX	SI% MAX	P% MAX	HRC Hardness	HV Hardness
Grade3	0.80-0.85	0.72	0.40	0.19	0.04	54-58	580-660
Grade-2	0.60-0.80	0.72	0.40	0.19	0.04	50-54	520-570
Grade-1	0.40-0.60	0.72	0.40	0.19	0.04	40-50	400-500
Mild Steel	0.08-0.14	0.72	0.40	0.19	0.04	25-32	270-320



High Carbon Cut Wire Shot



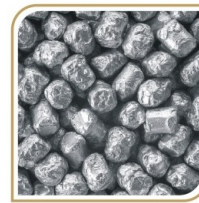
Low Carbon Cut Wire Shot

STAINLESS STEEL SHOT is used on subjects for which ferrous contamination is harmful. For example Stainless Steel Shot used for blasting on stainless steel, titanium, aluminum, or other non-ferrous work objects. It is also used in peening these metals (stainless steel, titanium, brass or aluminum) in work objects that are subject to stress, corrosion and cracking. it is available in grades AISI 304, 316, 202, 201, 430, 410.

Available Specifications : Available in conditioned form SAE J441, IS-5873-1970, AMS 2431/4 MILS 13165C and aerospace specification. Stainless Steel Cut Wire Shot has a Rockwell C hardness of 30 - 58 HRC



As-Cut SS



Condition Shot G2



Condition Shot G3

Advantages of Stainless Steel Shot

- It has a significantly longer shots life than cast steel shot or grit and carbon cut wire shot .
- Dust generation is significantly lower - blasting operations are much cleaner
- It produces excellent surface results because of its uniformity and strength
- It will make you a "Greener" organization because disposal of spent media will be significantly reduced. (You won't need as much shot, inventory requirements will be lower, and inbound freight will cost less.)
- You will NOT introduce ferrous contamination to non-ferrous castings or work objects as occurs with the use of cast steel or carbon cut wire shot

COPPER CUT WIRE SHOT is made through Commercial or Virgin Grade Copper Wire 99.9% .

Application

1. Copper Cut Wire Shot used primarily to clean or peen parts and components where conductivity is important and cannot be interfered with.
2. Also used for paint removal on electrical components and tooling.
3. It is used for removing oxidation, eliminating surface defect, removing stress, etching, strengthen, prevention rust before painting of metal die-casting, precision casting, hardware tool, machinery manufacturing, automobile spare parts, pump valve industry and jewelery making etc.



Copper cut Wire Shot



Copper Balls

Comparison of SS Shot SS-304, SS-202, SS-430, Steel Shot, High and Low Carbon Steel Wire Shot

Particulars for Steel Grits	Stainless Steel Shot 304 Grade specification	Stainless Steel Shot 202 Grade specification	Stainless Steel Shot 430 Grade specification	Steel Shot specification as per IS : 4606 - 1983	High Carbon Steel Cut Wire Shot specification as per IS : 5873-1970	Low Carbon Cut Wire Shot
Hardness	45-55 HRc /450-590 HV	45-55 HRc /450-590 HV	32 HRC /300HV Min.	41-49 HRc /400-500HV	45-52 HRc / 450-550 HV	25-32 HRc /250-300HV
Chemical Composition						
Nickel%	8-10%	4-6%	Nil	Nil	Nil	Nil
Chromium%	17-19%	16-18%	16-18%			
Carbon %	0.030 max	0.4%max	0.12%Max	0.6 to 1.25	0.45 to 0.75	0.08 to 0.14
Silicon %	1 Max.	1 Max.	0.75% Max	0.2 to 1.1	0.10 to 0.30	
Manganese %	2 Max	8% Min.		1.25 Max	0.60 to 1.20	
Sulphur %	0.030 Max	0.030 Max	0.030 Max	0.08 Max	0.050 Max	
Phosphorus %	0.045Max	0.06Max	0.040Max	0.08 Max	0.045 Max	
Density In gm/cc	7.8 g/cc	7.8 g/cc	7.8 g/cc	7 g/cc Min	7.4 g/cc	7.4g/cc
Dust Generation	Very Very Less	Very Less	Very Less	Very High	Very Less	Medium
Brightness of Surface	Very Bright	Bright	Less Bright	Average	Above Average	Average
Surface Finishing	Very Smooth, Shiny and Bright Surface due to negligible Carbon % (0.030% Max) and Nickel 8%	Very Smooth and Less Shiny and Bright Surface compare to SS-304 Grade Due to Less% of Nickel 4%	Very Smooth and Dull Surface compare to SS-304 and SS-202 Due to non presence of Nickel 0%	Smooth Surface and Contamination of Carbon (Blackness) on top of Surface due to High % of carbon (0.60-1.25%)	Anker Profile and Carbon residue on surface Very Less compare to Steel Shot, because Carbon % 0.4-0.85%)	Carbon residue on surface Very Very Less compare to Steel Shot, because Carbon % 0.07 0.10%)
Application	Specially used in Food Grade Product, Aluminum components , Alloys Wheels, Profile and tubes, Aluminum Sections, Motor cycle, Automobile Parts, Anti-Rust Aluminum Engines Surface Preparations, Brass Pipe Fittings, Brass wolver, Stainless Utensils, It could be used in many alloy products, like Stainless Steel, Steel, Aluminum, Zinc, copper and so on, make surface bright and anti-rust, Aluminum Engines, die casting, other type of non ferrous components	Aluminum components, Manganese Plate Blasting, Bright Surface required Components, Motor cycle, Automobile Parts, Anti-Rust Aluminum Engines Surface Preparations	Aluminum component and Engine Parts, Automobile Parts, Die Casting, Surface Finishing, other type of Non-Ferrous components	De-scaling, Roughening, Coating Removal, De-burring, casting blasting	Steel plate, Cylinder, Steel Structure, Metallurgy machinery surface improvement, Peening, Surface Finishing of Casting, Forging, Stain Finishing, reconditioning of Automotive Parts, Hardening, De-scaling, Roughening, Coating Removal, De-burring, Cleaning, Rust Removal	MS Plate, MS Products, Where low hardness shot required, Cleaning, Tumbling, Pre painting, De-scaling, Roughening, Coating Removal, De-burring, Cleaning, Rust Removal, Smoothing, Shaping

Sieve Analysis for Shot Mesuring As Per IS SAE J444

SAE NO.	BIS NO.	SIZE IN MM	2.80 MM	2.40 MM	2.00 MM	1.70 MM	1.40 MM	1.18 MM	1.00 MM	0.850 MM	0.710 MM	0.600 MM	0.500 MM	0.425 MM	0.355 MM	0.180 MM	0.125 MM
S-70	SS-180	0.180															
S-110	SS-300	0.300										All Pass	5% Min		80% Min	90% Min	
S-170	SS-425	0.425								All Pass	10% Min			85% Min	97% Min		
S-230	SS-600	0.600							All Pass	10% Min		85% Min	97% Min				
S-280	SS-710	0.710						All Pass	5% Min		85% Min	96% Min					
S-330	SS-850	0.850					All Pass	5% Min		85% Min	96% Min						
S-390	SS-1000	1.00				All Pass	5% Min		85% Min	96% Min							
S-460	SS-1180	1.180			All Pass	5% Min		85% Min	96% Min								
S-550	SS-1400	1.400			All Pass		85% Min	97% Min									
S-660	SS-1700	1.700		All Pass		85% Min	97% Min										
S-780	SS-2000	2.00	All Pass		85% Min	97% Min											
S-930	SS-2400	2.400		90% Min	97% Min												
RETAINSION IN SEIVE			2.80 MM	2.40 MM	2.00 MM	1.70 MM	1.40 MM	1.18 MM	1.00 MM	0.850 MM	0.710 MM	0.600 MM	0.500 MM	0.425 MM	0.355 MM	0.180 MM	0.125 MM

LEAD SHOTS/ BALLS : are normally used for radiation protection by filling and melting into hollow spaces and gaps in Lead shields where other Lead products like Lead sheet or Lead bricks are not approachable.

- The material has a low melting point and can be processed easily and fast into a homogenous barrier layer. The standard program comprises of diameters from 0.50 to 10mm. Further dimensions can be produced on request.
- Available in 99% and above as per customer specification

Lead Shot Application :

- Stress testing - Providing variable weights in strength-of-materials stress-testing systems
- Hydrometers: use a weight made of Lead balls
- Split Balls: a larger type of lead balls where each pellet is cut partway through the diameter.
- The heads of some dead blow hammers are filled with balls to minimize rebound off the struck surface.
- Shot belts: scuba diving, cycling and swimming.
- Model rocketry: to add weight to the nose of the rocket, increasing the stability factor.
- Lead balls are used for a regenerator in Stirling engines and thermo acoustic crycoolers.
- Lead balls for wall construction suitable for radiation shielding applications.
- It is used to attenuate radiation, especially X-rays and gamma rays in Medical and nuclear industry.
- For free casting steel / free machinery steel.
- Ballast for counter balance, bridge construction & building
- Cored Wire Manufacturing



Lead Shot



Aluminum Shot



Aluminum Cut Wire Shot

ALUMINUM CUT WIRE SHOTS are produced by cutting Aluminum wire into lengths equal to the wire. Aluminum being a soft a metal is ideal for blast cleaning, shot peening and shot blasting on Aluminum Castings, Aluminum components. Aluminum being a non ferrous metal is also widely used on Stainless Steel Components.

ALUMINUM SHOT making by melting Process. The Aluminum Shot use for De-oxidation as well as pellets are used in steel plants for the purpose of de-oxidation.

CHEMICAL COMPOSITION AND APPLICATION

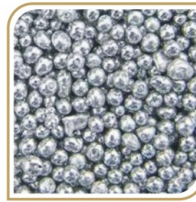
Grades	Al%	Hardness	Sizes	Purpose
Al Cut Wire Shot	99.9%	95-130 mpa	0.80- 3.20mm	Shot Blasting
Aluminum Shot	99% +		5 to 15mm	De-oxidation
Aluminum Shot	98% +		5 to 15mm	De-oxidation
Aluminum Shot	96-98 %		5 to 15mm	De-oxidation

ZINC SHOT : The softness of zinc shot is suitable for operation in deburring die castings, and removing impregnated sand from sand castings. It can remove coatings from soft alloy cast parts without damage, and leaves a thin film of zinc, which provide corrosion resistance, on the work pieces.

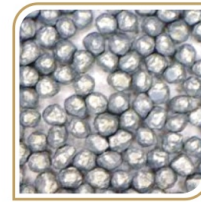
Applications: De-burring aluminum die castings (removing flash up to .020"), stripping paint and removing powder coatings without damaging substrates (tooling, paint hooks, etc.). fine film layer on work objects, zinc provides additional corrosion resistance.

CHEMICAL COMPOSITION AND HARDNESS

Sizes	Wire	HRC Hardness	Density
0.30 - 3.20mm	Commercial Quality Pure Zinc Special High Grade Zinc 99.99%	20-30 B	7.1g/cm3



Zinc Casted Shot



Zinc Condition Shot



Zinc Cut Wire Shot

Why Vinayaka Shot ?

- Pan India Presence
- ISO Certified
- Capacity to process 1500 MT/year
- Largest manufacturer of Condition SS Shots and Cut Wire Shots
- 40% of export sale
- Dedicated Sales and Technical Team
- Full technical support
- Fully integrated plant



BEFORE



AFTER

AN ISO 9001:2015 CERTIFIED COMPANY

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