

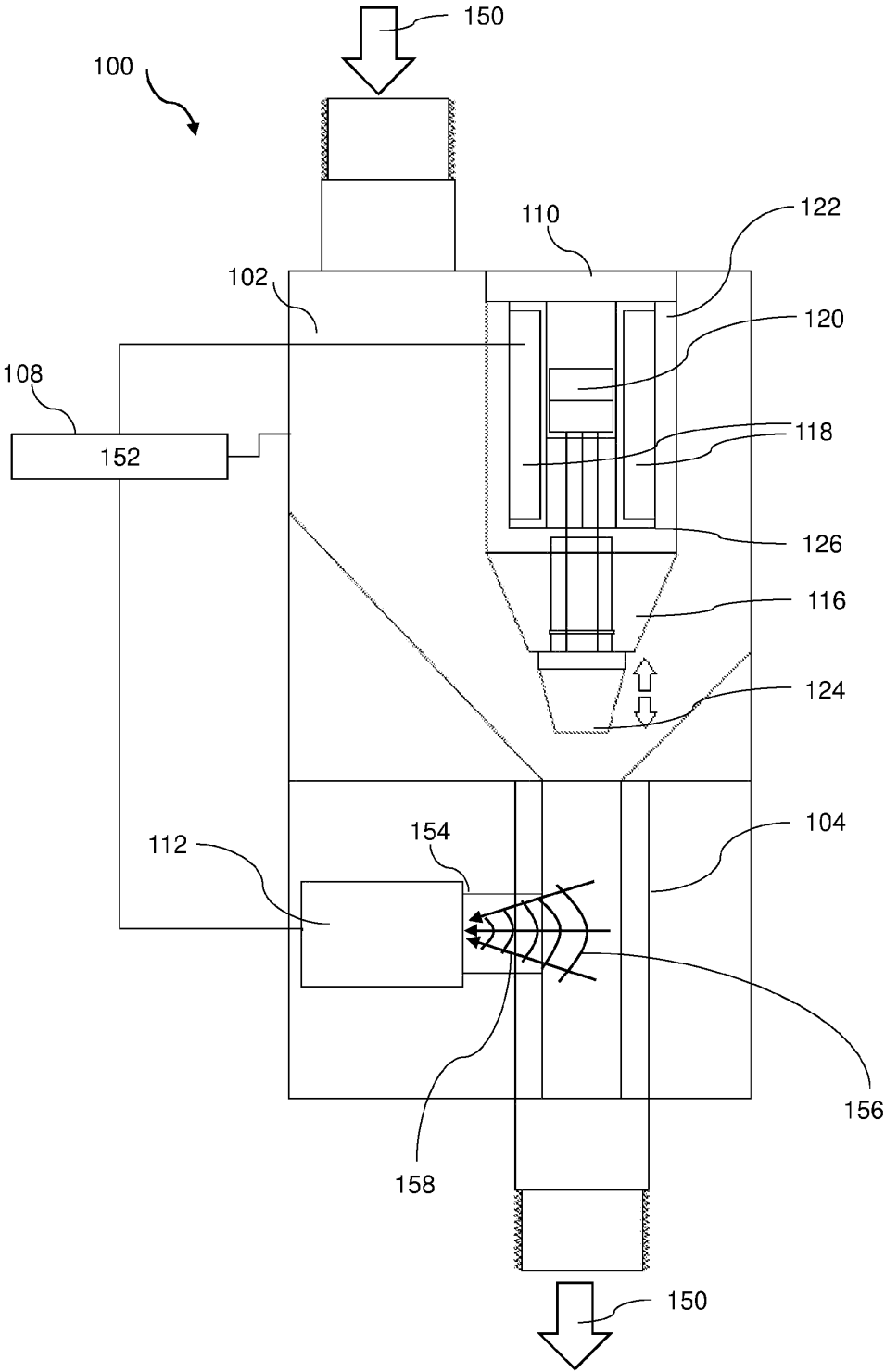


Fig. 1

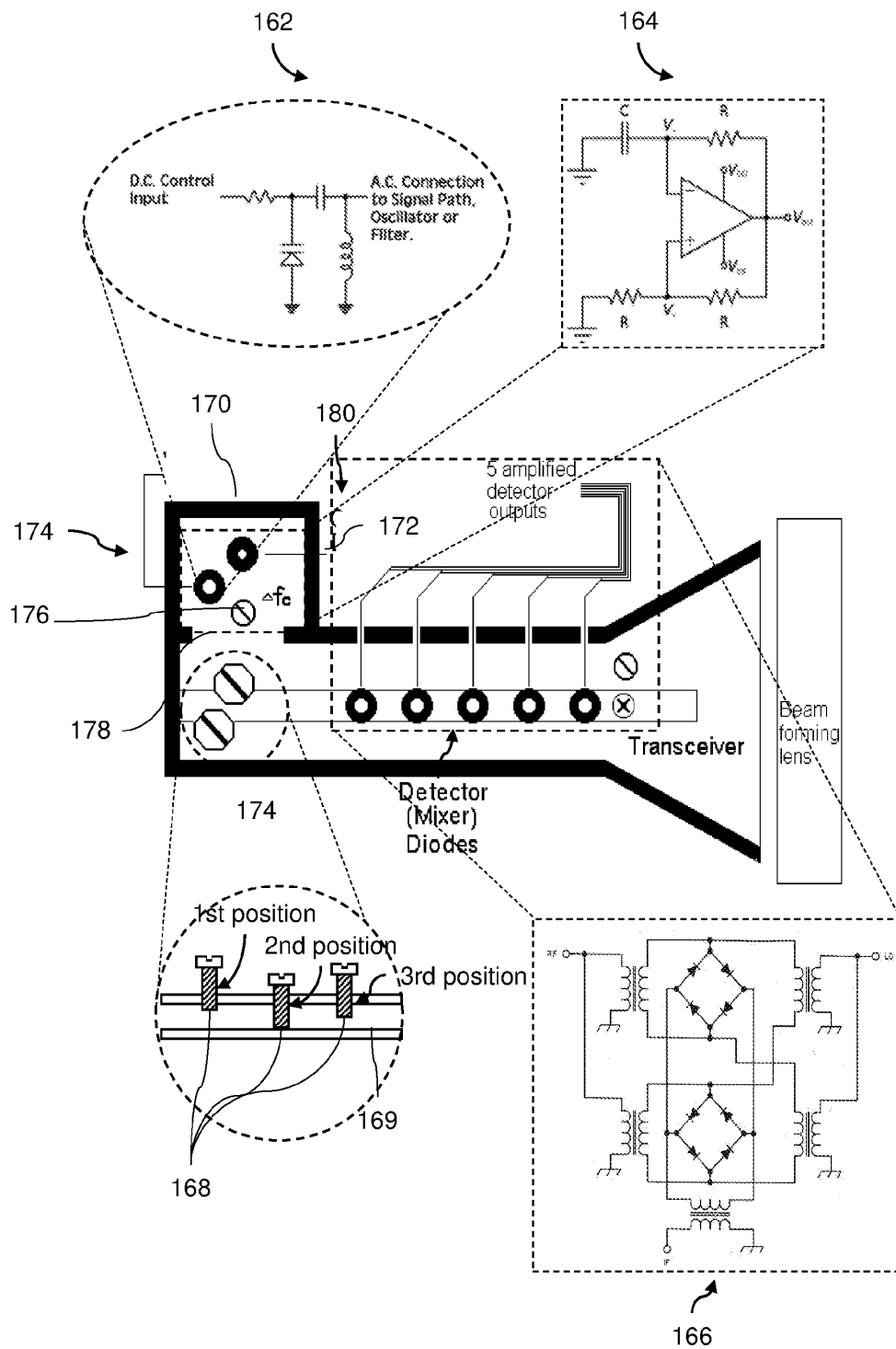


Fig. 2

Regular Hardness					High Hardness				
SHAPE REQUIREMENTS					SHAPE REQUIREMENTS				
Shot Size	Area per Field Square Inch (mm ²)	Number of Fields Viewed	Number of Marginal Particles max (1)	Number of Unacceptable Particles max (2)	Shot Size	Area per Field Square Inch (mm ²)	Number of Fields Viewed	Number of Marginal Particles All Fields (1) max	Number of Unacceptable Particles, All Fields (2) max
ASR 900	1 (645)	1	6	2	ASH 900	1 (645)	1	6	2
ASR 780	1 (645)	1	12	2	ASH 780	1 (645)	1	12	2
ASR 660	1 (645)	1	16	3	ASH 660	1 (645)	1	16	3
ASR 550	1 (645)	1	20	4	ASH 550	1 (645)	1	20	4
ASR 460	1 (645)	1	28	5	ASH 460	1 (645)	1	28	5
ASR 390	1 (645)	1	39	7	ASH 390	1 (645)	1	39	7
ASR 330	0.25 (161)	1	14	3	ASH 330	0.25 (161)	1	14	3
ASR 260	0.25 (161)	1	20	4	ASH 260	0.25 (161)	1	20	4
ASR 230	0.25 (161)	1	14	5	ASH 230	0.25 (161)	1	14	5
ASR 190	0.25 (161)	1	20	7	ASH 190	0.25 (161)	1	20	7
ASR 170	0.25 (161)	1	28	10	ASH 170	0.25 (161)	1	28	10
ASR 130	0.0625 (40)	1	10	4	ASH 130	0.0625 (40)	1	10	4
ASR 110	0.0625 (40)	1	14	5	ASH 110	0.0625 (40)	1	14	5
ASR 70	0.0625 (40)	1	39	13	ASH 70	0.0625 (40)	1	39	13

Fig. 3

SHAPE REQUIREMENTS				
Shot Size	Area per Field Square Inches (mm ²)	Number of Fields Viewed	Number of Marginal Particles All Fields max(1)	Number of Unacceptable Particles All Fields max(2)
AWCH 116	1 (645)	3	7	2
AWCH 96	1 (645)	2	7	2
AWCH 80	1 (645)	2	10	3
AWCH 62	1 (645)	9	63	2
AWCH 54	1 (645)	7	66	2
AWCH 47	1 (645)	5	68	2
AWCH 41	1 (645)	4	70	2
AWCH 35	0.25 (161)	14	67	2
AWCH 32	0.25 (161)	12	60	2
AWCH 28	0.25 (161)	7	67	2
AWCH 23	0.25 (161)	5	70	2
AWCH 20	0.25 (161)	4	76	2
AWCH 17	0.0625 (40)	11	70	2
AWCH 14	0.0625 (40)	6	60	2
AWCH 12	0.0625 (40)	5	68	2

Fig. 4

SHAPE REQUIREMENTS				
Shot Size	Area per Field Square Inch (mm ²)	Number of Fields Viewed	Number of Marginal Particles All Fields max(1)	Number of Unacceptable Particles All Fields max(2)
AWCR 116	1 (645)	3	7	2
AWCR 96	1 (645)	2	7	2
AWCR 80	1 (645)	2	10	3
AWCR 62	1 (645)	9	63	2
AWCR 54	1 (645)	7	66	2
AWCR 47	1 (645)	5	68	2
AWCR 41	1 (645)	4	70	2
AWCR 35	0.25 (161)	14	67	2
AWCR 32	0.25 (161)	12	60	2
AWCR 28	0.25 (161)	7	67	2
AWCR 23	0.25 (161)	5	70	2
AWCR 20	0.25 (161)	4	76	2
AWCR 17	0.0625 (40)	11	70	2
AWCR 14	0.0625 (40)	6	60	2
AWCR 12	0.0625 (40)	5	68	2

Fig. 5

PEENING BALLS

Nominal Size	Minimum Case Depth Inch Type 1	Minimum Case Depth Millimeters Type 1	Maximum Case Depth Inch Type 1	Maximum Case Depth Millimeters Type 1	Size Tolerance plus and minus Inch Type 1&2	Size Tolerance plus and minus Millimeter Type 1&2
APB 3/32	0.020	0.51	0.025	0.64	0.008	0.20
APB 1/8	0.025	0.64	0.030	0.76	0.010	0.25
APB 3/16	0.030	0.76	0.035	0.89	0.010	0.25
APB 7/32	0.035	0.89	0.040	1.02	0.010	0.25
APB 1/4	0.045	1.14	0.055	1.40	0.010	0.25
APB 3/8	0.055	1.40	0.065	1.65	0.010	0.25
APB 7/16	0.065	1.65	0.075	1.90	0.010	0.25

Fig. 6

GLASS SHOT FOR PEENING

Designation Number	U.S. Sieve	Diameter Inch Max	Diameter Inch Min	Max Trace Retain	U.S. Sieve Size Min 95% Pass	U.S. Sieve Size Max 15% Pass	Max 5% Pass	Min % True Spheres	Max % Sharp Particle	Millimeters Max	Millimeters Min
AGB-200	-8+ 12	0.064	0.066	7	8	12	14	80	0.5	2.39	1.68
AGB-170	-10+ 14	0.079	0.086	8	10	14	16	80	0.5	2.01	1.42
AGB-150	9954A -1	0.066	0.047	10	12	14	20	80	0.5	1.68	1.41
AGB-100	9954A -2	0.0665	0.031	12	14	20	30	65	3.0	1.41	0.841
AGB-70	9954A -3	0.031	0.0234	18	20	30	40	65	3.0	0.841	0.594
AGB-50	9954A -4	0.0234	0.0165	25	30	40	45	70	3.0	0.594	0.419
AGB-35	9954A -5	0.0165	0.0117	35	40	50	60	70	3.0	0.419	0.297
AGB-30	-45+ 60	0.0139	0.0098	40	45	60	70	70	3.0	0.358	0.249
AGB-25	9954A -6	0.0117	0.0083	45	60	70	80	80	3.0	0.297	0.211
AGB-20	9954A -7	0.0098	0.0070	50	60	80	100	80	3.0	0.249	0.179
AGB-18	9954A -8	0.0083	0.0059	60	70	100	120	80	3.0	0.211	0.150
AGB-15	9954A -9	0.0070	0.0049	70	80	120	140	80	3.0	0.179	0.124
AGB-12	9954A -10	0.0059	0.0035	80	100	170	200	85	3.0	0.150	0.089
AGB-10	9954A -11	0.0049	0.0029	100	120	200	230	90	3.0	0.125	0.074
AGB-9	9954A -12	0.0041	0.0025	120	140	230	325	90	3.0	0.104	0.064
AGB-6	9954A -13	0.0025	0.0017	140	170	325	400	90	3.0	0.089	0.043

NOTE: 1. Designation number is mean shot diameter in microns divided by 10.

Fig. 7

CERAMIC SHOT FOR PEENING – SIZES AND SPHERICITY

Designation	Nominal Size, Millimeters	Nominal Size, Inch	Nominal Size, Mesh	Sieve Size, Millimeters Maximum 0.5% Retained	Sieve Size, Millimeters Maximum 5% Retained	Sieve Size, Millimeters Maximum 10% Passing	Sieve Size, Millimeters Maximum 3% Passing	Minimum % of Shot W/Sphericity 0.8 and Above (True Spheres)	Maximum Number of Shot with Sphericity Below 0.5 per Square Centimeter	Number Broken or Angular Beads Acceptable per Square Centimeter
AZB850	0.85/1.18	0.033/0.047	16/20	1.400	1.180	0.850	0.710	85	4	2
AZB800	0.8/0.85	0.024/0.033	20/30	1.000	0.850	0.600	0.425	65	8	4
AZB425	0.425/0.6	0.017/0.024	30/40	0.710	0.600	0.425	0.300	70	14	8
AZB300	0.300/0.425	0.012/0.017	40/50	0.500	0.425	0.300	0.250	70	27	10
AZB210	0.212/0.300	0.008/0.012	50/70	0.355	0.300	0.212	0.180	80	55	25
AZB150	0.150/0.212	0.006/0.008	70/100	0.250	0.212	0.150	0.125	80	300	65
AZB100	0.100/0.150	0.004/0.006	100/140	0.180	0.150	0.100	0.083	80	600	90

Fig. 8

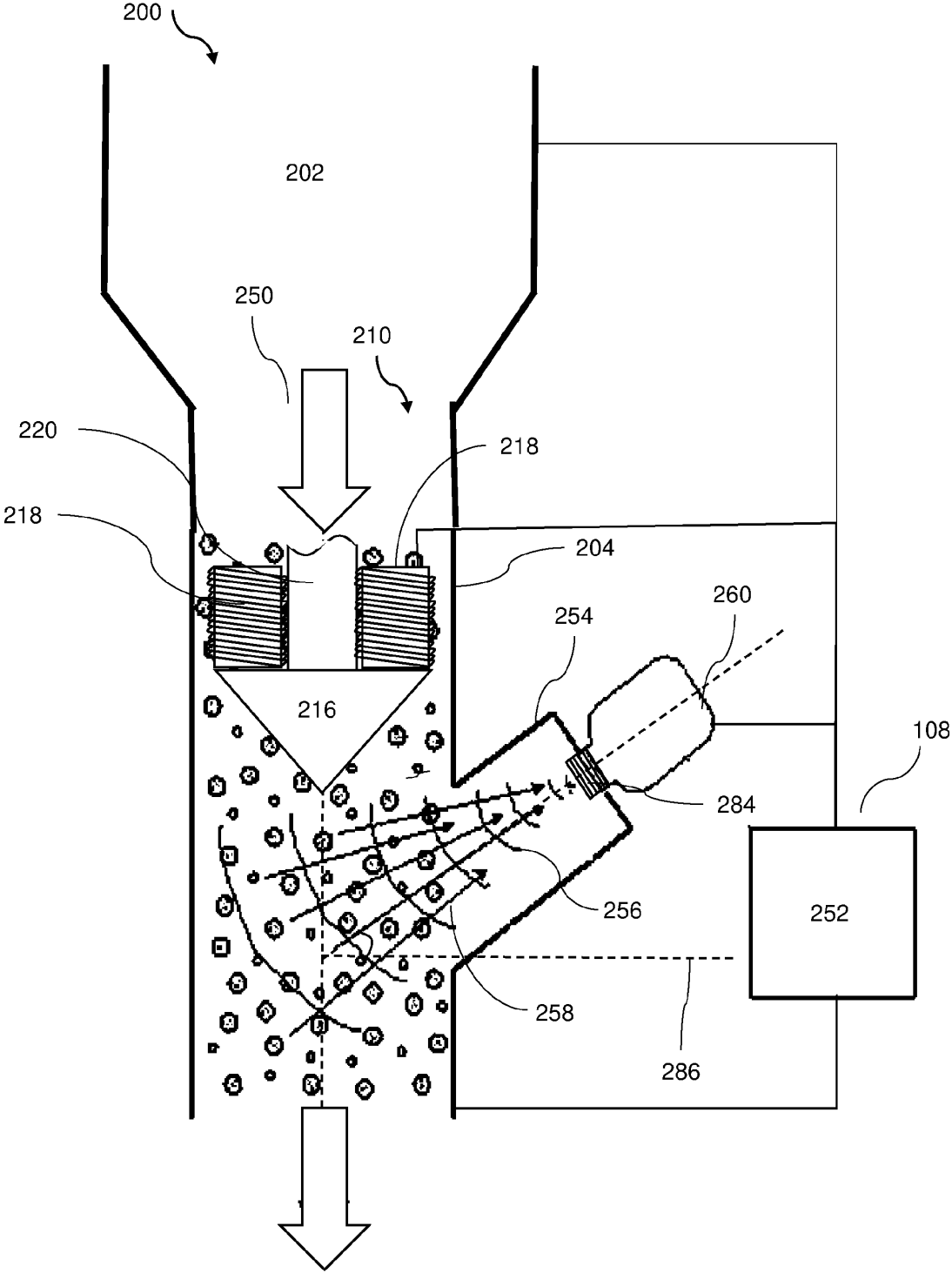


Fig. 9

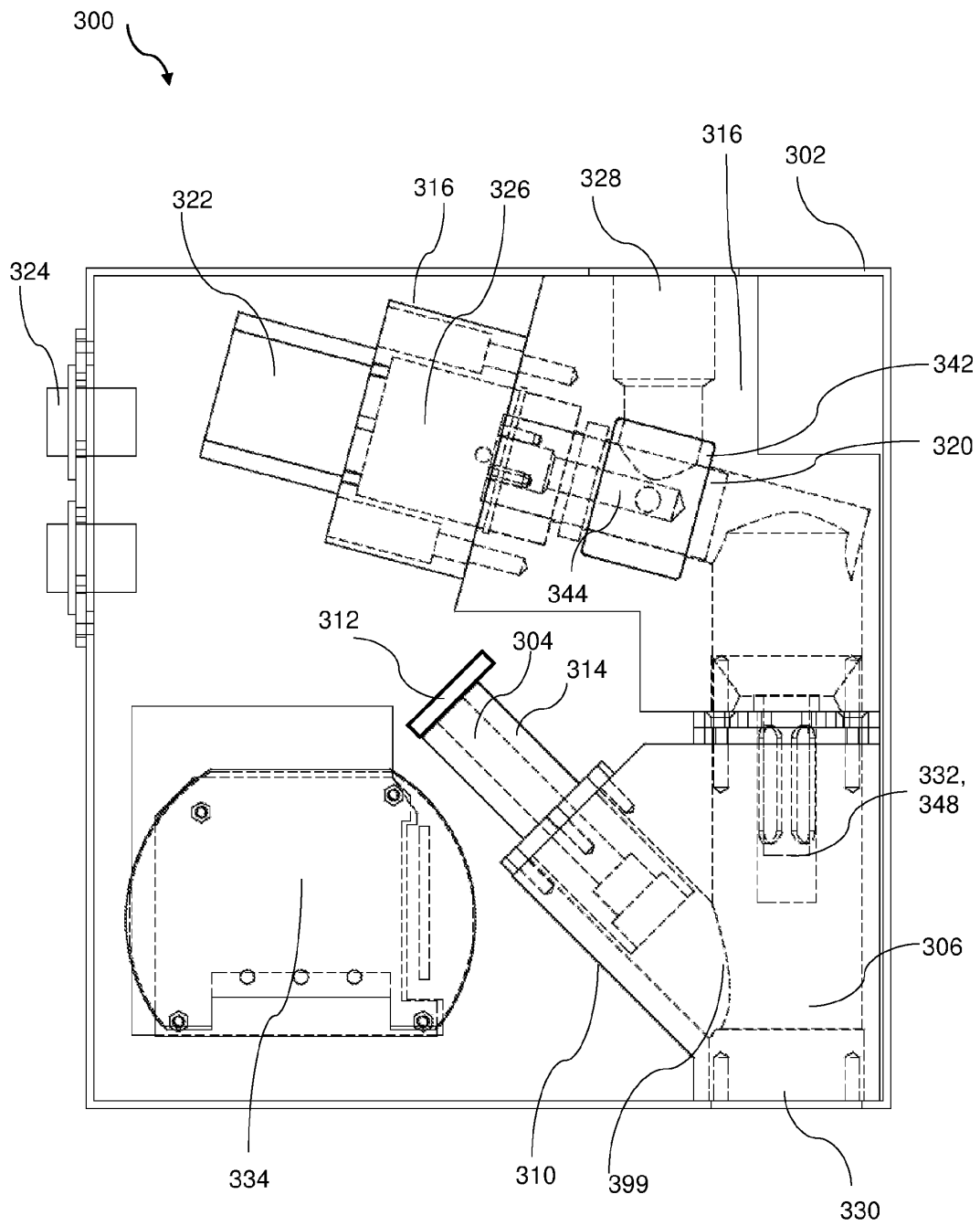


Fig. 10

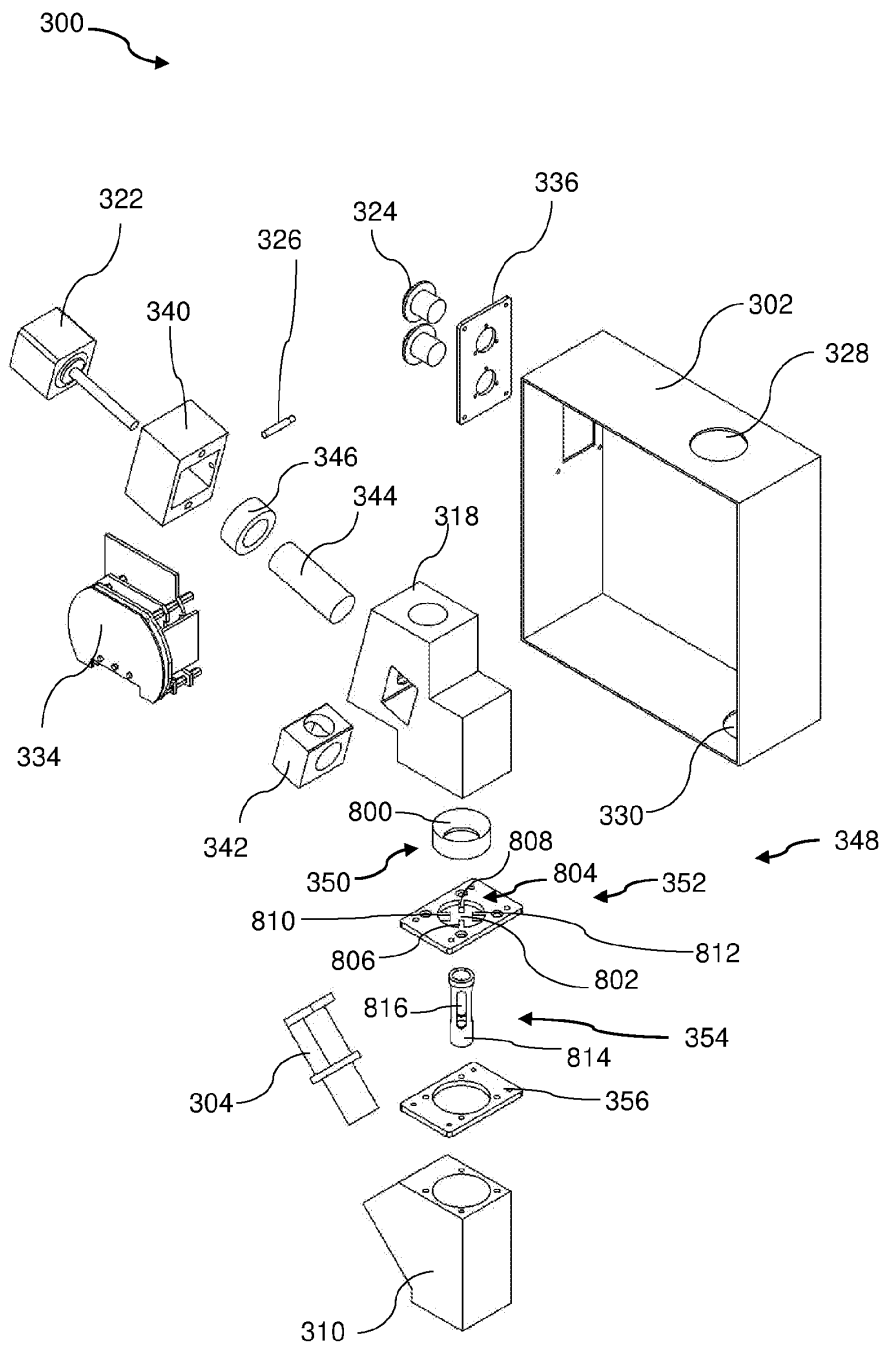


Fig. 11

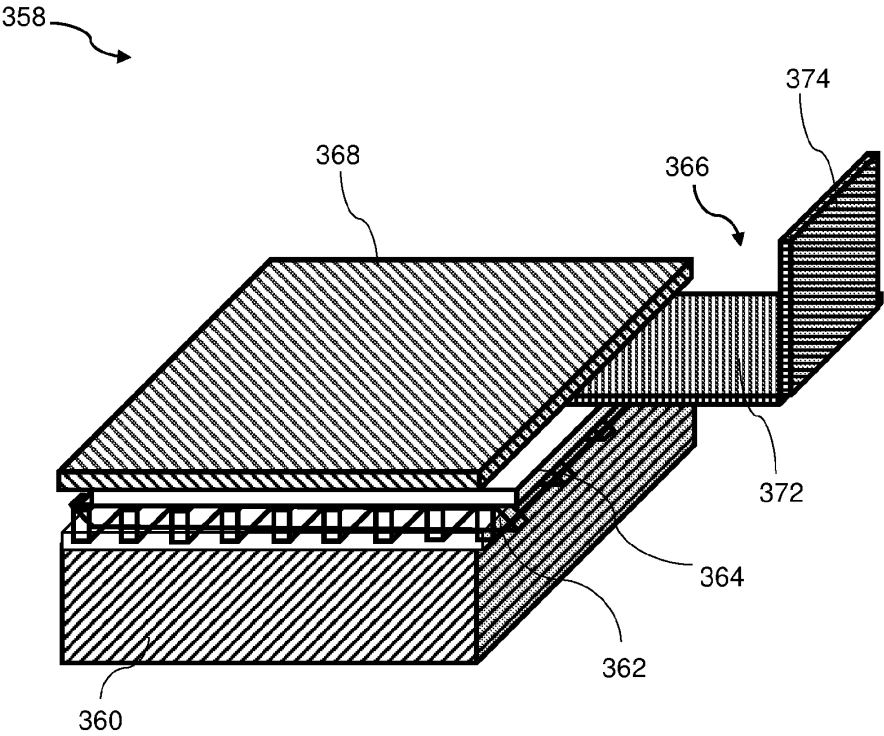


Fig. 12

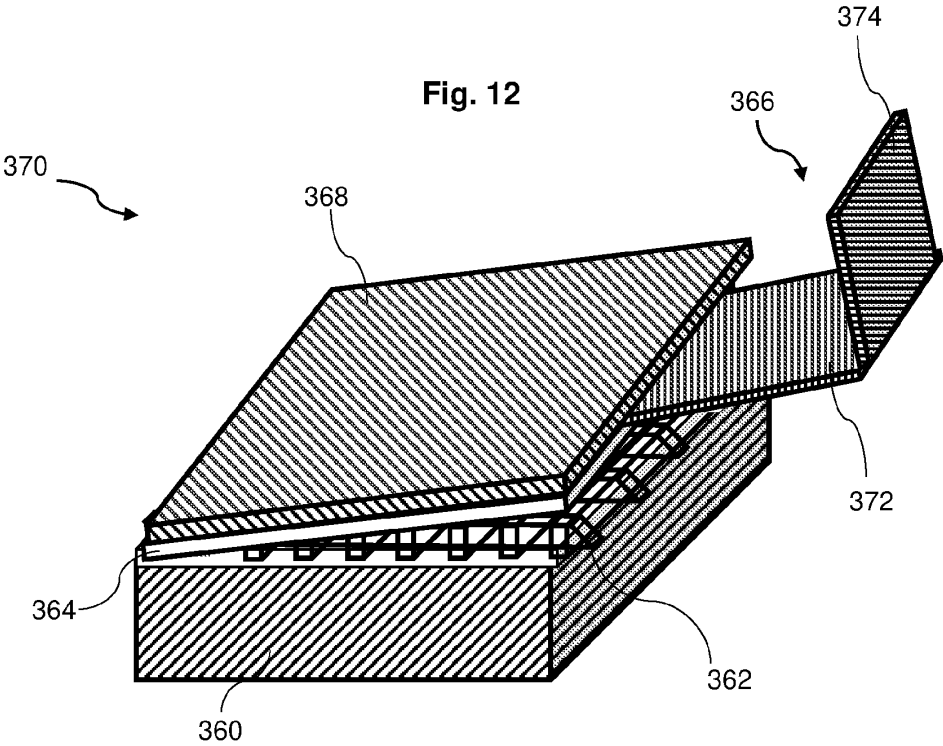


Fig. 13

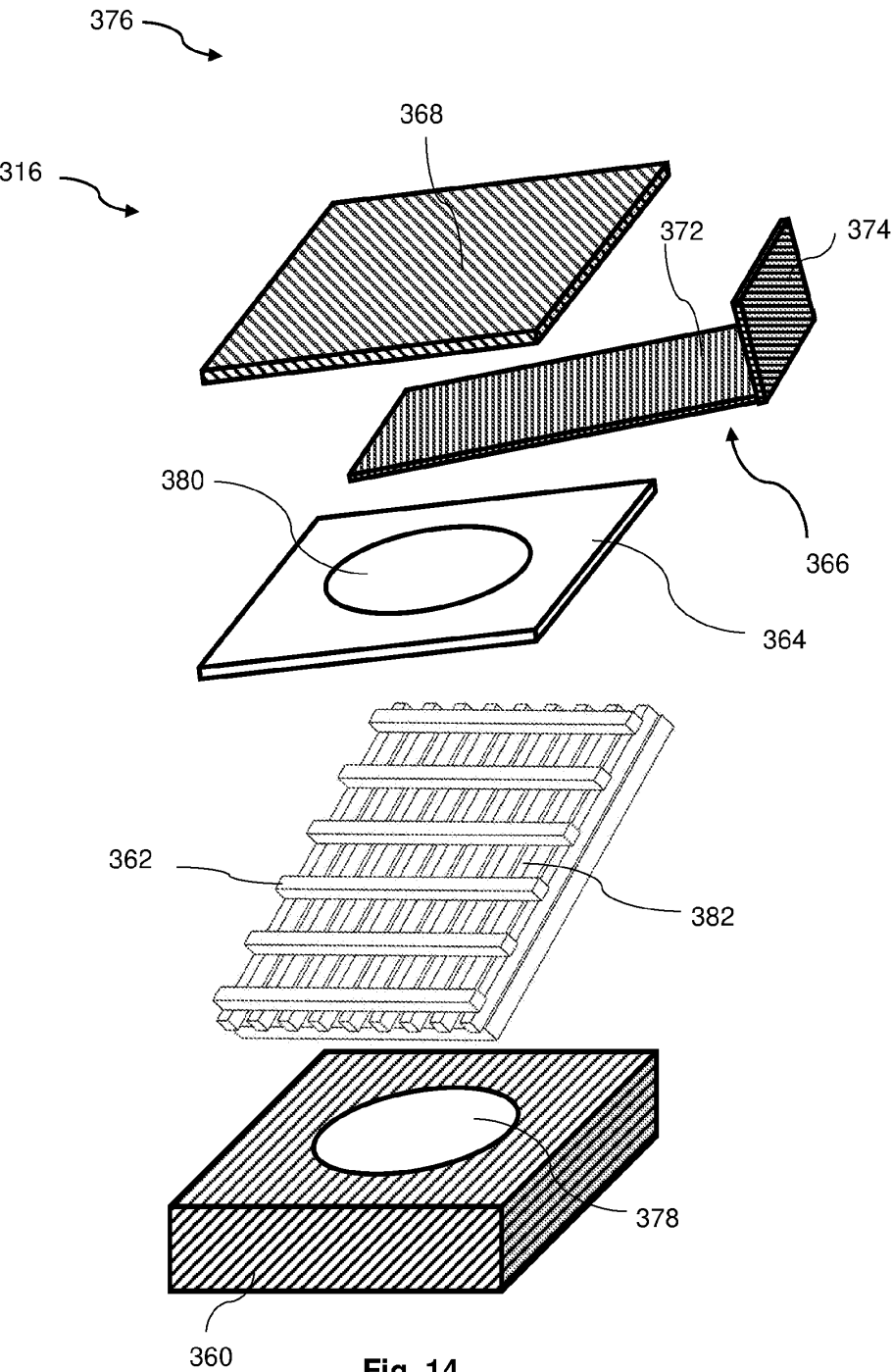


Fig. 14

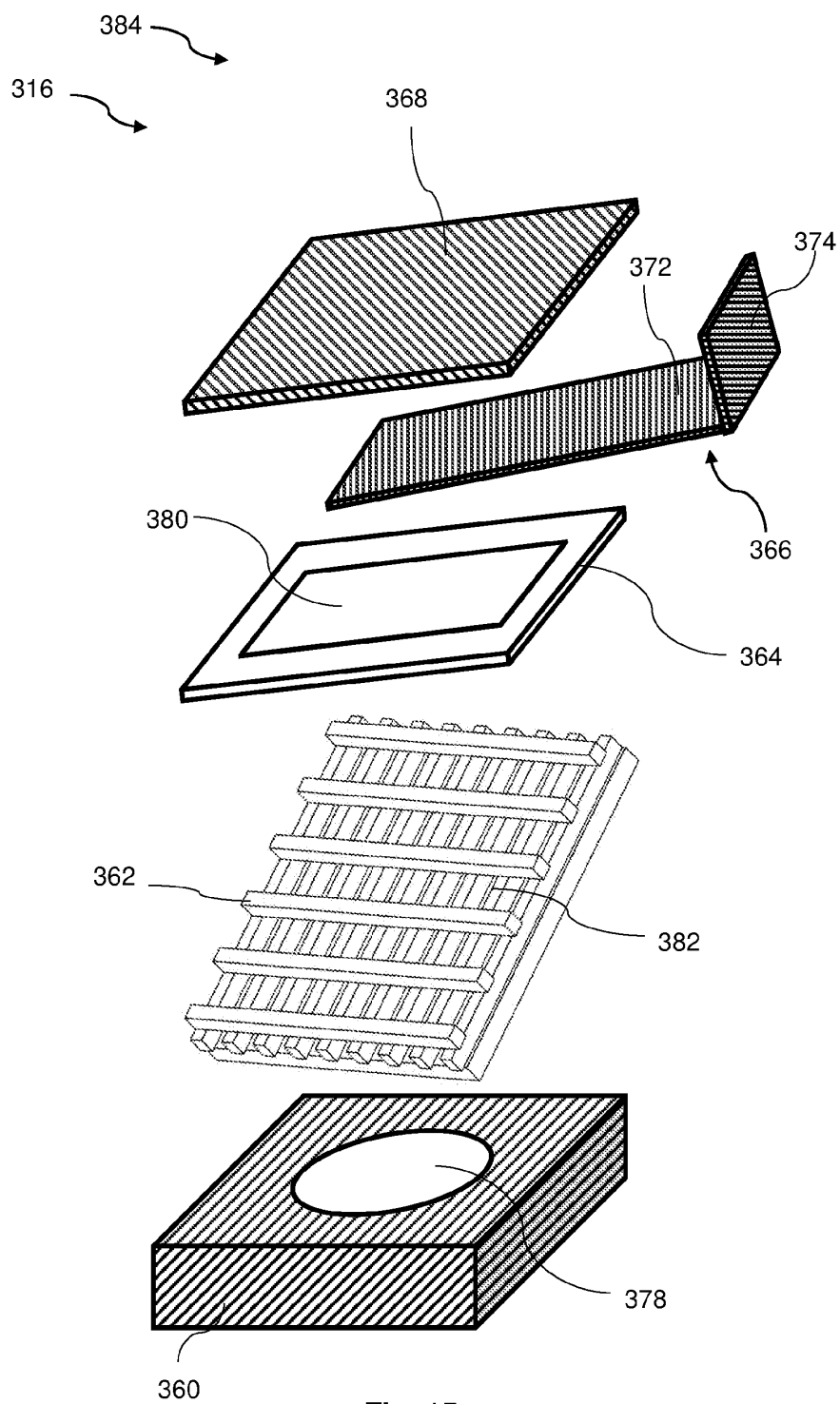


Fig. 15

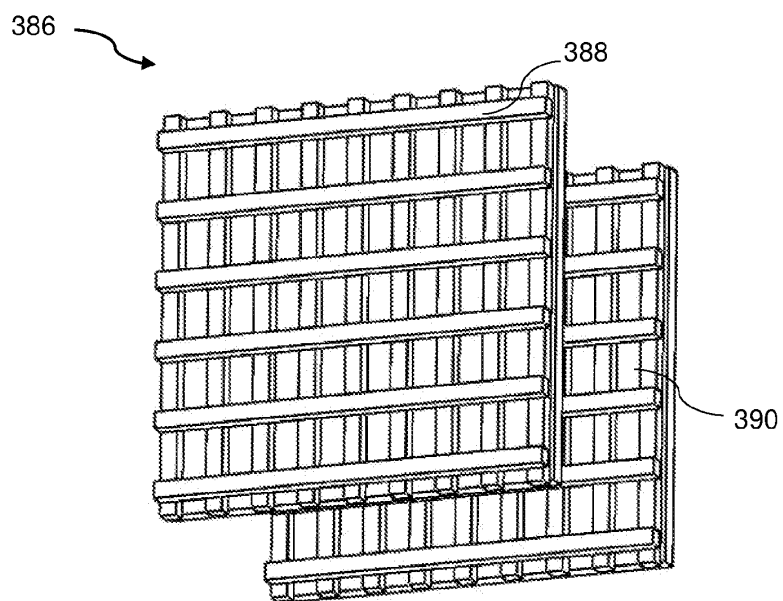


Fig. 16

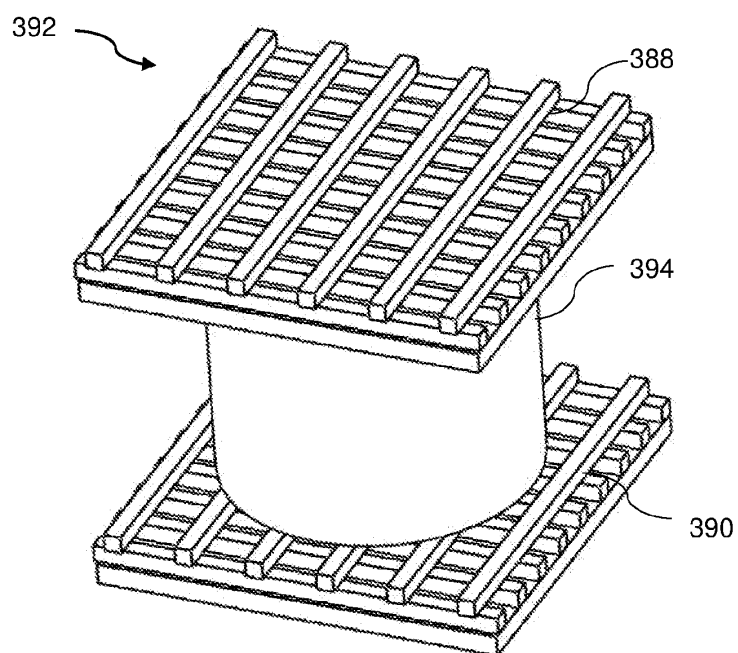


Fig. 17



Fig. 18

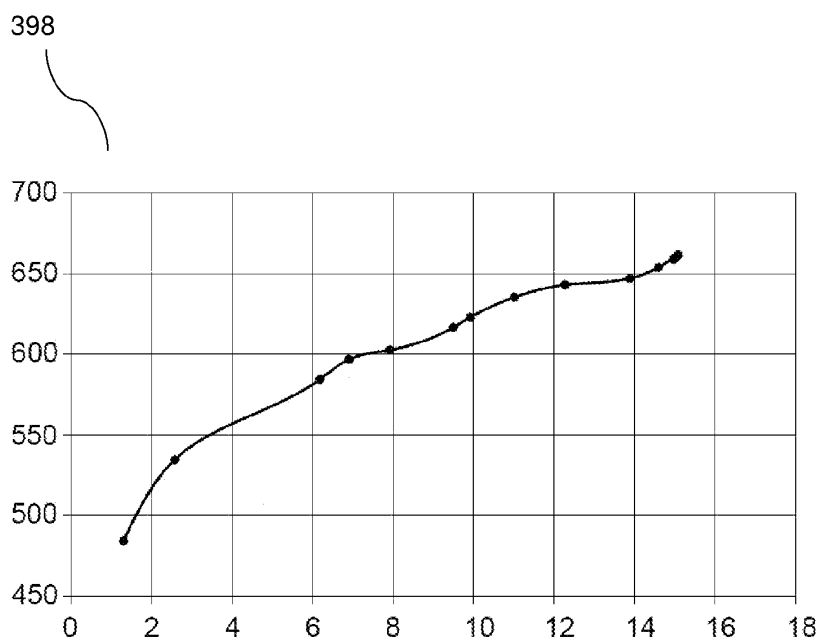
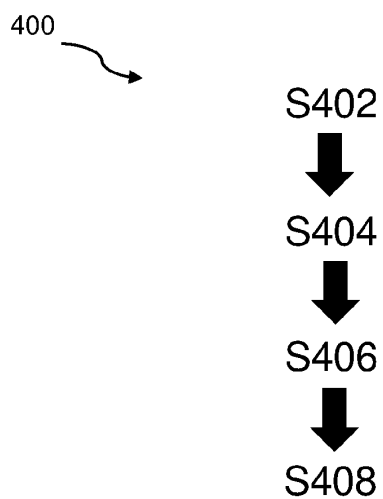
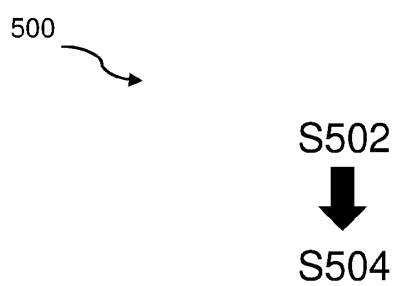


Fig. 19

**Fig. 20****Fig. 21**

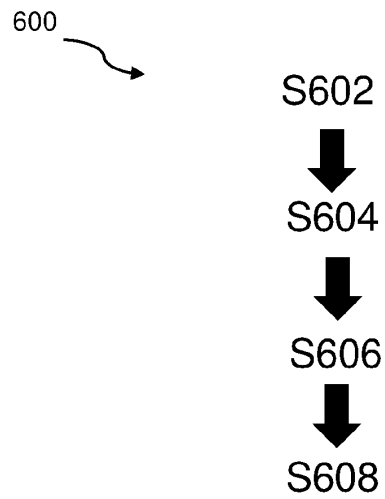


Fig. 22

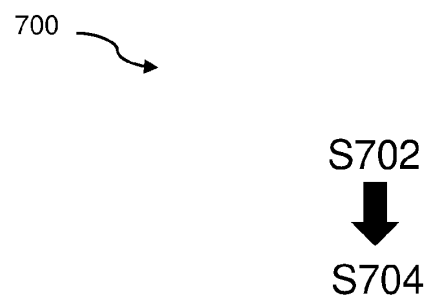


Fig. 23