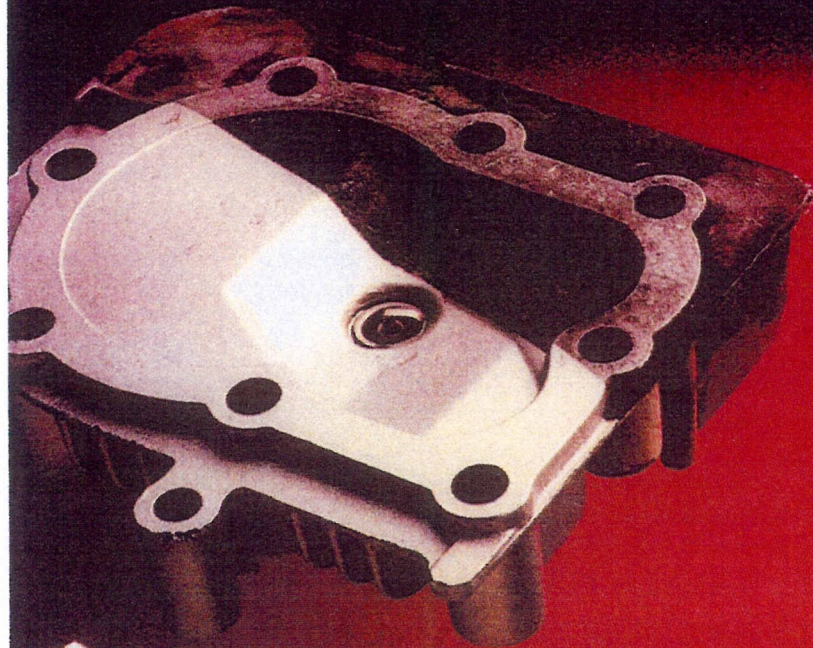
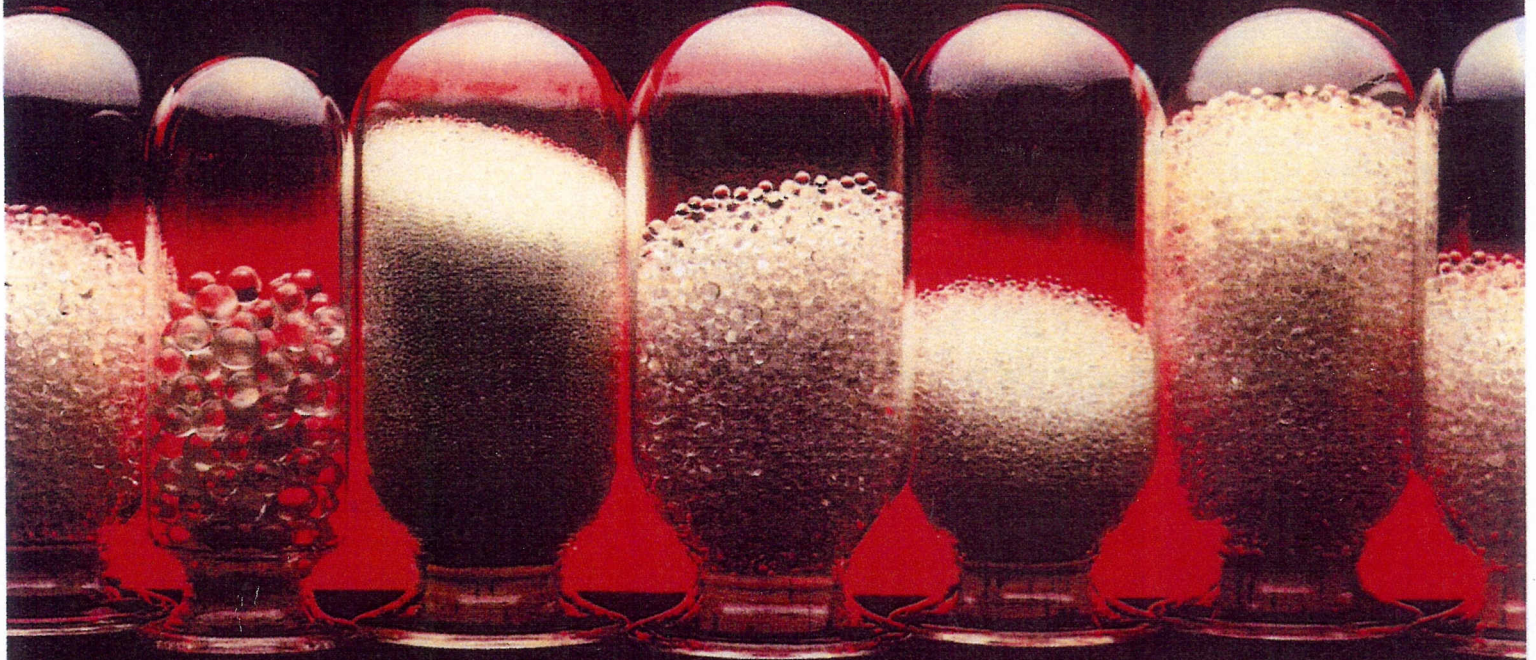


# **BALLOTINI<sup>®</sup> METAL FINISHING BEADS**

**FOR CLEANING, FINISHING, PEENING AND DEBURRING APPLICATIONS**



- **IMPART A CONTROLLED, CLEAN FINISH ON A VARIETY OF METALS.**
- **CLEAN QUICKLY WITHOUT SIGNIFICANT METAL REMOVAL.**
- **CLEAN, FINISH, PEEN AND DEBURR IN ONE OPERATION.**
- **PROVIDE A UNIQUE SURFACE FINISH.**
- **CAN BE RECYCLED MANY TIMES.**
- **CONTAINS NO FREE SILICA.**
- **ENVIRONMENTALLY SAFE.**
- **BACKED BY POTTERS EXTENSIVE TECHNICAL KNOWLEDGE AND SUPPORT.**



**Potters Industries Inc.**  
an affiliate of PQ Corporation

## BALLOTINI® METAL FINISHING BEADS FOR CLEANING AND CONDITIONING METAL SURFACES

### GLASS BEAD IMPACT MEDIA:

- are consumed at a slow rate and can survive multiple impacts, allowing for continuous recycling of the media.
- are chemically inert and will not leave ferrous or other undesirable residues on the surface of the workpiece.
- impart a controlled, clean finish on a variety of metals.
- clean quickly without significant metal removal.

### TYPICAL APPLICATIONS FOR GLASS BEAD BLASTING:

#### Cleaning:

- cleans and preps the surface of metal parts without changing tolerances, or imparting ferrous pollutants.
- combines cleaning, finishing and peening in one operation.

#### Finishing:

- creates a wide range of unique surface finishes that are easy to reproduce.
- blends machine marks, seals pores and the results offer the advantages of glass bead peening.

#### Peening:

- reduces the tensile stress in metal parts, increasing the fatigue limit.
- reduces stress corrosion cracking.

#### Deburring:

- removes burrs without damaging the parts and offers a peened surface in one operation.

### GLASS BEAD FACTS:

#### Coarse Beads

Remove larger, tougher soils; Peen to more intense levels; Peen to deeper zones in surface; Produce higher surface RA; Produce brighter surface; Consume faster at same pressure as fine beads; In practice, may consume slower than fine beads.

#### Fine Beads

Remove smaller, lighter soil; More impacts per pound; Clean faster; Peen to less intense levels; Peen outer zones of surfaces; Reach into keyways, fillets and small areas; Produce lower surface RA; Produce matte finish; Consume slower at same pressure as coarse beads; In practice, may consume faster than coarse beads.

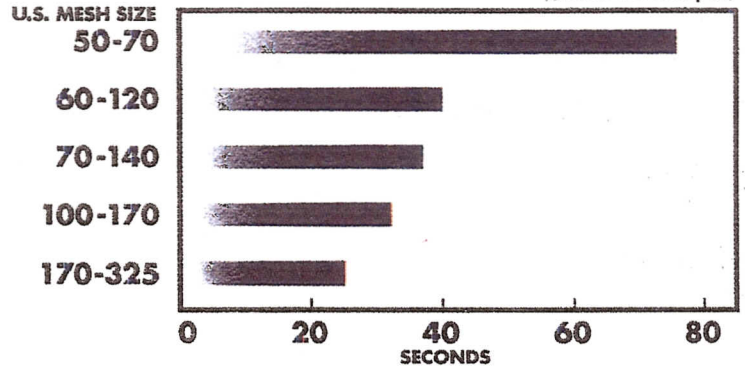
#### All Beads

Contain no free silica (environmentally friendly); Recycle many times; Clean efficiently at 45° - 60° nozzle angle.

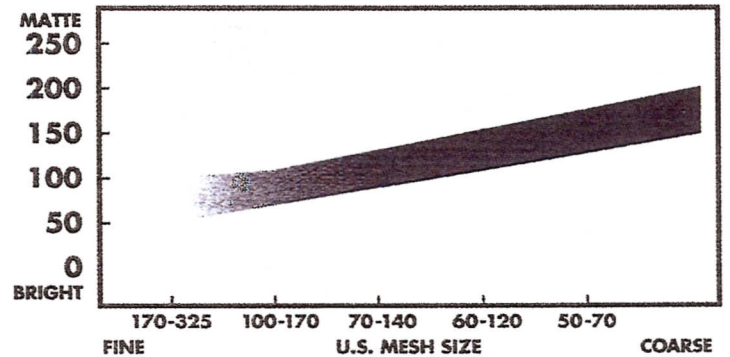
Bead size, shape of workpiece, angle of nozzle, distance of nozzle to surface area, air pressure, and type of delivery system (suction versus direct pressure blast) are factors affecting final surface appearance and media consumption parameters.

The technical information and suggestions for use and applications presented herein represent the best information available to us and are believed to be reliable. They should not, however, be construed as controlling suggestions. Potters Industries Inc. makes no warranties, either expressed or implied, with respect to our materials, including the warranties of merchantability or fitness for any particular purpose. We urge that users of our materials conduct confirmatory tests to determine final suitability for their specific end uses.

**SPEED OF CLEANING** Target – 2024-T351 Aluminum (Time to clean 12 sq. in.)



**SURFACE PROFILE** Target – 2024-T351 Aluminum, Surface Finish (Microinches RMS/Ra)



POTTERS DESIGNATION	U.S. SIEVE	NOMINAL DIAMETER				MIN % ROUND
		INCHES		MICRONS		
		MAX	MIN	MAX	MIN	
A	20-30	.0331	.0234	850	600	65
AAA	25-45	.0278	.0139	710	355	65
B	30-40	.0234	.0165	600	425	65
C	40-60	.0165	.0098	425	250	75
AA	40-70	.0165	.0083	425	212	70
D	50-70	.0117	.0083	300	212	75
AB	50-80	.0117	.0070	300	180	70
AC	60-120	.0098	.0049	250	125	80
AD	70-140	.0083	.0041	212	106	80
AE	100-170	.0059	.0035	150	90	85
AG	120-270	.0049	.0021	125	53	85
AH	170-325	.0035	.0017	90	45	85

DESIGNATION	U.S. SIEVE	NOMINAL DIAMETER				MIN % ROUND
		INCHES		MICRONS		
		MAX	MIN	MAX	MIN	
3	20-30	.0331	.0234	850	600	65
4	30-40	.0234	.0165	600	425	70
5	40-50	.0165	.0117	425	300	70
6	50-70	.0117	.0083	300	212	80
7	60-80	.0098	.0070	250	180	80
8	70-100	.0083	.0059	212	150	80
9	80-120	.0070	.0049	180	125	80
10	100-170	.0059	.0035	150	90	90
11	120-200	.0049	.0029	125	75	90
12	140-230	.0041	.0025	106	63	90
13	170-325	.0035	.0017	90	45	95