

ISO 26910-1:2009-06 (E)

Springs - Shot peening - Part 1: General procedures

Contents	Page
Foreword	iv
Introduction	v
1 Scope	1
2 Normative references	1
3 Terms and definitions	1
4 Strategies for conducting shot peening	3
4.1 General	3
4.2 Mode of shot peening	3
4.3 Conditions of shot peening	3
4.4 Category of shot peening machine	4
4.5 Protection of non-peening surface	4
4.6 Pre- and post-peening treatments	4
5 Peening media	4
6 Almen strip	5
6.1 Class of Almen strip	5
6.2 Selection of the class of Almen strip	5
6.3 Almen strip holder	6
7 Method of measurement	7
7.1 Measurement of Almen arc height	7
7.2 Evaluation of coverage	7
7.3 Determination of saturation time	8
8 Shot peening machine	8
9 Control of shot peening	8
9.1 Almen arc height	8
9.2 Coverage	8
10 Measurement of residual stress	8
11 Report	9
Annex A (normative) Standard photographs of coverage	10
Annex B (normative) Saturation time	11
Annex C (informative) Almen gauge	13
Bibliography	15