

# ISO 26910-1:2023-10 (E)

## Springs - Shot peening - Part 1: General procedures

---

<b>Contents</b>		<b>Page</b>
Foreword.....		iv
Introduction.....		v
<b>1</b>	<b>Scope.....</b>	<b>1</b>
<b>2</b>	<b>Normative references.....</b>	<b>1</b>
<b>3</b>	<b>Terms and definitions.....</b>	<b>1</b>
<b>4</b>	<b>Strategies for conducting shot peening.....</b>	<b>3</b>
	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
<b>5</b>	<b>Peening media.....</b>	<b>4</b>
<b>6</b>	<b>Almen strip.....</b>	<b>4</b>
	6.1 Class of Almen strip.....	4
	6.2 Selection of the class of Almen strip.....	5
	6.3 Almen strip holder.....	5
<b>7</b>	<b>Method of measurement.....</b>	<b>6</b>
	7.1 Measurement of Almen arc height.....	6
	7.2 Evaluation of coverage.....	7
	7.3 Determination of saturation time.....	8
<b>8</b>	<b>Shot peening machine.....</b>	<b>8</b>
<b>9</b>	<b>Control of shot peening.....</b>	<b>8</b>
	9.1 Almen arc height.....	8
	9.2 Coverage.....	8
<b>10</b>	<b>Measurement of residual stress.....</b>	<b>8</b>
<b>11</b>	<b>Report.....</b>	<b>8</b>
	<b>Annex A (informative) Standard photographs of coverage.....</b>	<b>9</b>
	<b>Annex B (informative) Saturation time.....</b>	<b>10</b>
	<b>Annex C (informative) Almen gauge.....</b>	<b>12</b>
	<b>Bibliography.....</b>	<b>14</b>