

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