

ISO 26910-1:2023-10 (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.....	4
6.1	Class of Almen strip.....	4
6.2	Selection of the class of Almen strip.....	5
6.3	Almen strip holder.....	5
7	Method of measurement.....	6
7.1	Measurement of Almen arc height.....	6
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.....	8
Annex A (informative)	Standard photographs of coverage.....	9
Annex B (informative)	Saturation time.....	10
Annex C (informative)	Almen gauge.....	12
Bibliography.....		14