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Springs — Shot peening —

Part 1:

General procedures

*Ressorts — Grenailage de précontrainte —
Partie 1: Modes opératoires généraux*



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Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular, the different approval criteria needed for the different types of ISO document should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see www.iso.org/directives).

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This document was prepared by Technical Committee ISO/TC 227, *Springs*.

This second edition cancels and replaces the first edition (ISO 26910-1:2009), of which it constitutes a minor revision. It also incorporates the Amendment ISO 26910-1:2009/Amd. 1:2017.

The changes compared to the previous edition are as follows:

- the Normative reference has been updated to ISO 80000-1;
- "or less" has been deleted from the sentence of [3.5](#) saturation time;
- "and size" has been added to the sentence of a) of [4.3](#) Conditions of shot peening;
- "Type A" has been added to the last sentence of [6.2](#) Selection of the class of Almen strip;
- the statuses of [Annexes A](#) and [B](#) have been changed to informative.

A list of all parts in the ISO 26910 series can be found on the ISO website.

Any feedback or questions on this document should be directed to the user's national standards body. A complete listing of these bodies can be found at www.iso.org/members.html.

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Introduction

Shot peening is widely applied to various mechanical and structural elements in a wide range of industrial fields, because of its effective improvement in the strength and life properties at moderate costs. It is also used in some cases for other purposes such as to form thin sheet products, to increase wear resistance, or to assist lubrication effect, deburring and so on. It is, however, especially important for spring industries, as it is indispensable for the achievement of the required fatigue strength and to decrease stress corrosion cracking.

The important effects of shot peening are known to be due mainly to the compressive residual stresses introduced near the shot peened surface, and helped sometimes by the work hardening of the surface layers. Various processing methods have been developed and practised together with diverse materials for shot peening.

This document serves to establish smooth technical communication between the spring manufacturers and industry related to shot peening, including peening machine manufacturers, peening media suppliers and shot peening processors, as well as users of those springs in various industrial sectors.